

2

*To clamp workpieces  
of unusual dimension!*

**XL - XLFLEX**

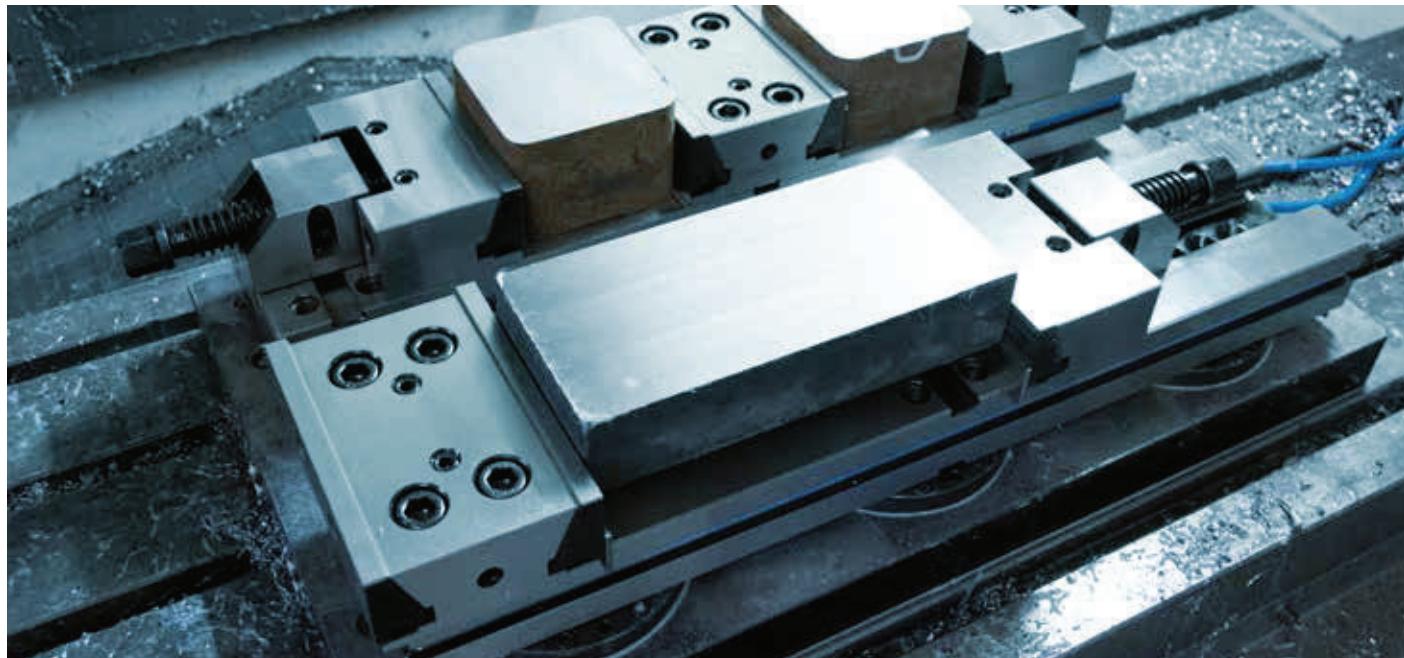
**Morse e Cubi / Vises & Vise Towers**

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2

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## SIMBOLOGIA DATI TECNICI TECHNICAL DATA ICONS

<b>GANASCE JAWS</b>						
	Fissa Fixed	Mobile Movable	Intermedia Intermediate	Fissa con piastra doppia liscia Fixed with double straight plate	Fissa con piastra singola Fixed with single plate	Fissa con piastra doppia Fixed with double plate
<b>PIASTRE GANASCE JAW PLATES</b>						
		Discendente Pull down	Piana Straight	Cambio rapido manuale Quick manual change	GRIP integrale Integral GRIP	Inserti GRIP Insert GRIP
<b>POSSIBILITÀ POSSIBILITY</b>						
		Serraggio di 1 particolare Clamping only 1 piece	Serraggio di 2 particolare Clamping 2 pieces	Montaggio sul fianco o in serie Side mounting or gang operation	Predisposizione Zero Point Zero Point ready	Cubi-morsa Vise tower
<b>PAGINE PAGES</b>						
				Accessori & Ricambi Accessories & Spare Parts	Istruzioni corretto utilizzo Instruction for a proper use	Diagrammi forze di serraggio Clamping force diagrams

## Morse / Vises

# XL EXTRA LONG BASES

**Come le morse Standard, ma con la base moooooo lunga!**  
**As the Standard vises but with a loooonger base**



Precisione / Accuracy  
 $\pm 0,02\text{mm}$



Durezza / Hardened  
**HRC 58±2**

### USURA INESISTENTE / NO WEAR

Grazie all'accurata scelta dei materiali impiegati ed allo studio dimensionale computerizzato dei componenti. Costruzione completamente in speciali leghe di acciaio ad alta resistenza, normalizzato, cementato e temprato con durezza  $58 \pm 2$  HRC. Tutto ciò al fine di conferire massima rigidità, elevate prestazioni e usura inesistente. A riprova di tutto ciò assicuriamo **5 ANNI DI GARANZIA** su tutto il programma morse e organi meccanici in genere.

Thanks to the manufacturing with only the most suitable materials and to the structure of the vise components (developed using computer customised softwares and the experience gained during many years spent working on the specific field). High alloyed quality resistance steel, case hardened HRC  $58 \pm 2$ , is used in manufacturing all the Gerardi vises and accessories in order to give maximum rigidity, high performances and no wear. As evidence we give **5 YEARS WARRANTY** on all the vises and mechanical components.

### MODULARITÀ / MODULARITY

Tutte le morse ed accessori sono elementi componibili, intercambiabili e perfettamente allineabili fra loro e con i quali è possibile ottenere differenti soluzioni di bloccaggio. Secondo tale principio l'unico elemento che differenzia le attrezzature con identica larghezza di presa è la base (la cui lunghezza determina la massima apertura della morsa), mentre gli altri componenti sono identici. Mediante l'aggiunta o semplice sostituzione di alcuni particolari si può variare la tipologia di bloccaggio secondo le proprie esigenze utilizzando la stessa attrezzatura acquistata in un primo momento (bloccaggi singoli, con base girevole, doppi, verticali, di pezzi piani, tondi, piatti e grezzi, manuali, idraulici o pneumatici).

All vises and accessories are modular and components of all our vises will interchange with perfect alignment to provide different workholding solutions. With this basic principle the only difference between fixtures with the same width of clamping is the base (whose length determines the maximum opening of the vise), while the rest of components have same dimensions. Through the simple addition or substitution of some particulars You can change the type of clamping as Your needs require using the same fixture purchased before (single clamping, swivel base, double, vertical, smooth or round or flat or rough workpieces, manual, hydraulic or pneumatic).

### DESIGN COMPATTO / SPACE SAVING DESIGN

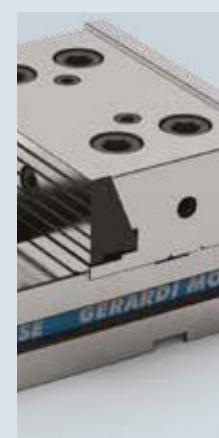
La semplicità nonché la compattezza costruttiva consentono un'apertura notevole rispetto all'ingombro totale dell'attrezzatura. Inoltre lo stesso peso (solo 25 kg per una morsa da 150 mm di larghezza ganascia) è tale da consentire un facile trasferimento da una macchina all'altra.

The space saving design and solid construction allow a maximum blocking ratio to total overall dimension of the vise. Furthermore the weight (only 25 kg for a 150 mm jaw width vise) allows a simple moving from one machine to another.

### SERRAGGI RAPIDI / QUICK CLAMPING

Grazie allo scorrimento del gruppo di serraggio nella guida della base (a cremagliera) fino in prossimità del pezzo da lavorare dove si adatterà automaticamente alla nicchia più vicina. L'operazione di serraggio si conclude agendo sulla vite di bloccaggio. Oltre a quello manuale meccanico, sono disponibili 4 ulteriori sistemi di serraggio intercambiabili e indipendenti: 1 - Idraulici / 2 - Pneumatici / 3 - Idraulici manuali / 4 - Idraulici elettrici. L'operazione è in termini di secondi.

Thanks to the clamping device sliding in the vise base slide (compact rack type) till the proximity of the workpiece. The clamping is completed with the main screw. Besides the manual mechanic system, 4 further interchangeable and independent clamping systems are available: 1- Hydraulic / 2- Pneumatic / 3- Manual hydraulic / 4- Electrical hydraulic. The change needs only few seconds.



#### Ganasce fisse doppie

Double fixed jaws

Ganasce fisse doppie posizionabili sia al centro (per serraggi doppi), sia all'estremità della base (per serraggi singoli di particolari di grosse dimensioni). La morsa XL doppia permette la lavorazione di un numero maggiore di pezzi sfruttando al massimo la lunghezza della tavola della macchina utensile.

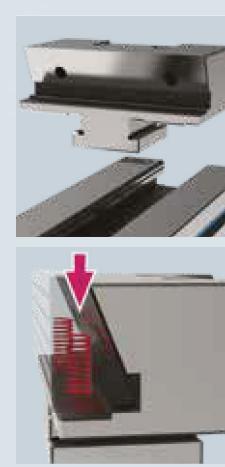
Double fixed jaw position both in the center of the vise base (for double clamping) and at the end (for single big workpieces Clamping). Double XL vise allows to machine more workpieces using the total length of the machine tool, this means to increase productivity of the workcycle and of the machine



#### Serraggi indipendenti

Independent clamping

Due Gruppi di serraggio indipendenti  
 Two independent clamping devices



#### Ganascia monoblocco

Solid guided jaw

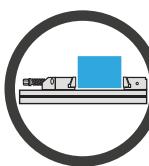
Entrambe le ganasce sono costruite in corpo unico (non esistono slitte o tasselli di fissaggio) per garantire una maggiore rigidità e nessuna flessione. Entrambe le piastre ganasca sono costruite con un angolo di spinta verso il basso. Ciò assicura, nel momento della chiusura, una trazione del pezzo contro la base della morsa (per trascinamento) e di conseguenza un bloccaggio sicuro e preciso.

Both jaws bodies are built in one solid piece (no slides or key-nuts): in order to guarantee higher rigidity & no bendings. Both jaw plates are manufactured with a pull down angle. This ensures, during the clamping operation, a downward run of the workpiece against the vise base (by dragging) and thus a precise and safety clamping.

Quando lo spazio sulla tavola della macchina è limitato le morse XL sono la risposta per avere due morse in una trasformandosi rapidamente da morsa a doppio serraggio a morsa singola aumentando l'apertura di serraggio. La morsa XL doppia permette la lavorazione di un numero maggiore di pezzi sfruttando al massimo la lunghezza della tavola della macchina utensile, ciò significa aumentare la produttività delle fasi attive del ciclo e di macchina stessa in quanto abbiamo

La versione XL singola permette il serraggio di pezzi di dimensioni insolite e di piastre (con le appropriate ganasce). La notevole gamma di dimensioni e lunghezze delle basi garantisce il soddisfacimento delle più svariate necessità nonché una rigidità notevole dell'attrezzatura. A richiesta tutte le morse sono fornibili con tasselli di riferimento di varie grandezze o con fori calibrati.

Space on the machine table is sometimes limited: XL vises enable to have 2 vises in 1 because they can quickly change from double vise to single vise with very large opening. Double XL vise allows to machine more workpieces using the total length of the machine tool, this means to increase productivity of the workcycle and of the machine. Single XL vise allows to clamp pieces of unusual dimensions and plates (with the right jaws). The very wide range of widths and lengths of bases guarantees the satisfaction of the widest variety of works and a big rigidity of the fixture too. In conclusion all this allows to reduce to a minimum dead times/interruptions and consequently faster payback period of machines and fixtures. On request all vises can be supplied with key-nuts of different sizes or with ground holes.



*Ideali per particolari  
di grandi dimensioni!*

*To clamp workpieces of  
unusual dimension!*

**Art. 30**

**Art. 20**

**Due serie di chiavette**  
*Two keyways on the top side*

Due serie di chiavette per due posizioni alternative delle ganasce fisse doppie

Two different keyways for two alternative positions of the double fixed jaw

**Precisione / Highest accuracies**  
**±0,02mm**

Slittone base con tutte le superfici di scorrimento ed accoppiamento rettificate. L'allineamento agli assi della macchina avviene grazie alle chiavette longitudinali e trasversali (16H7) o fori di posizionamento (Ø16 mm F7), a richiesta, previsti sulla base di ciascuna morsa. Naturalmente tutto ciò consente oltre alle precisioni dichiarate tempi di installazione ristretti.

Solid base vise. Every sliding and coupling surface is ground. Centesimal tolerances are guaranteed by checking cycles with CNC measuring machine. The perfect alignment with the machine axis is given by longitudinal and cross keyways (16H7) or positioning holes (Ø16 mm F7), upon specific request, on the vise base. Of course this allows minimum of set up times and gang operations.

## Staffe d'ancoraggio / Vise holding clamps



# XL extra long bases

**Coppia staffe di fissaggio Art.296, complete di vite e dado a "T"**

**Pair of vise holding clamps Art.296 complete of screw and "T" nuts**

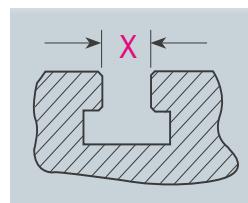
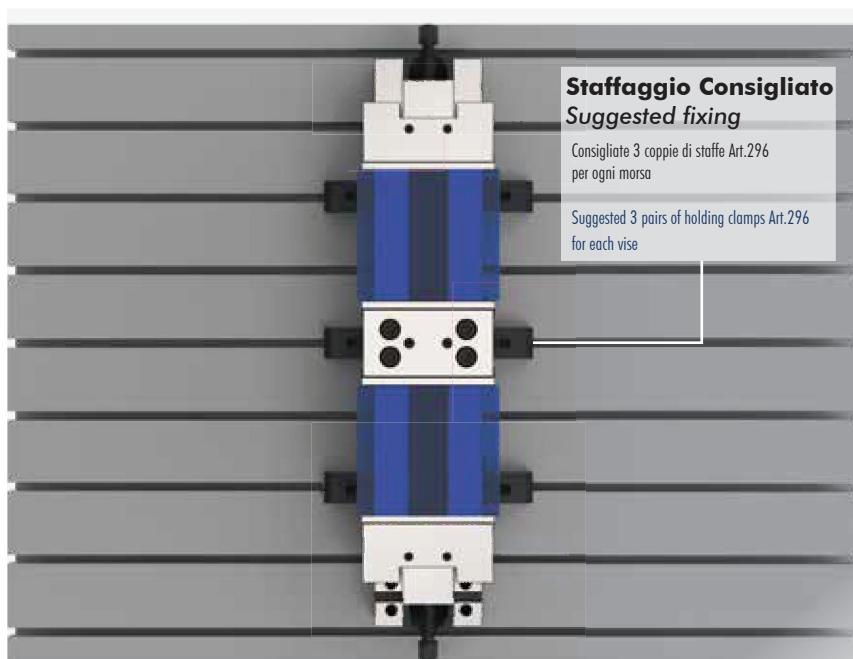


Esempio d'ordine per morsa tipo 3 su macchina con cave a T da 18mm: Art.296 T.3 X=18mm

Ottore con codice: **2.29.6300 X=18mm**

Order example for Type 3 vise on machine with 18mm T-slots: Art.296 T.3 X=18mm

Also with code: **2.29.6300 X=18mm**



### Cava a T

#### T Slot

Specificare sempre la cava della vostra macchina

Always specify the machine T-slot dimension



### Art.287 (Pag. 4.34)

#### Dadi a T - T Nuts

Per fissaggio morsa alle cave a T della macchina

For vise clamping on the machine T-slots



### Art.296

(Art.298 + Art.287)

Consigliate 3 coppie di staffe Art.296 per ogni morsa

Suggested 3 pairs of holding clamps Art.296 for each vise

Tipo (grandezza) morsa Vise type (size)		1				1 - 2				3 - 4				5 - 6				
<b>Art. 296</b> <b>Coppia di staffe</b> <b>Holding clamps pair</b>		Cava a T slot X	12	14	16	18	12*	14	16	16	18	20	18*	20	22	16	18	
		T-nuts Ref. N°	8	9	10	11	12	13	14	20	21	22	32	33	34	20	21	
		Filetto vite Screw thread	<b>M8</b>		<b>M10</b>		<b>M12 *</b>		<b>M16</b>		<b>M12 *</b>		<b>M16</b>		<b>M12</b>		<b>M16 *</b>	
<b>1 X M8</b> 	A	50		50		50		50		76		76		86		86		
	B	24		24		24		24		30		30		40		40		
	C	6		6		6		6		6		6		10		10		
	Ø D	8,5		11		13		17		13		17		13		17		
	E	10		10		10		10		13		13		15		15		
	Ø F	14		-		-		-		-		-		-		-		
	G	14		16		17,5		19		17		16		26		26		
	G1	17		15		13		9		22		15		27		27		
	H	34		34		34		34		42		42		50		50		
	I	8		10		10		10		-		-		-		-		
	J	4		4		4		4		10		10		10		10		
T ± 0,1		15		15		15		15		20		20		26		26		
Cod.		2.29.61000 / M8		2.29.61000 / M10		2.29.61000 / M12		2.29.61000 / M16		2.29.63000 / M12		2.29.63000 / M12		2.29.65000 / M12		2.29.65000 / M16		

\* Scelta consigliata - Suggested choice

\* Scelta NON consigliata - NO Suggested choice

## Soluzioni personalizzate / Customized solutions

# XL extra long bases

**Soluzioni personalizzate a tutti i vostri problemi di serraggio**

*Customized solutions for all your clamping problems*



### Morse XL

XL Vises

**Morse XL montate orizzontalmente per lavorazioni su centro verticale**

XL modular vises horizontally assembled for vertical machining centre



### Morse XL

XL Vises

**Morse XL montate verticalmente su cubo portapezzi per lavorazioni su centro orizzontale**

XL Vises vertically assembled on a tombstone for horizontal machining centre.



### Morse XL

XL Vises

**Morse XL doppie montate su spalla in orizzontale**

XL double vises horizontally assembled on a 2 sides tombstone



### Versione singola

Single version

**La versione XL singola permette il serraggio anche di pezzi di dimensioni insolite**

Single XL vise allows to clamp also pieces of unusual dimensions



### Morse modulari

Modular Vises

**Tutte le morse ed accessori sono componibili fra loro e con tali accessori è possibile trasformare o reconfigurare la morsa per ottenere differenti soluzioni di serraggio**

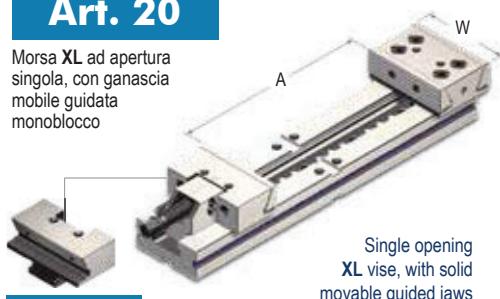
All vises and accessories are modular and components of all our vises will interchange with perfect alignment to upgrade your vise and provide different workholding solutions



Tipo (grandezza) morsa / Vise type (size)	kN	1	2	3	4				
		16 kN	25 kN	30 kN					
Apertura massima / Maximum spread	A	290	320	360	460	400	500	600	700
	W	100	125	150			175		
	B	30	40	50			60		
	C	35	40	50			58		
	D	460	520	580	680	666	766	866	966
	G	75	95	125			145		
	kg	10	17	32	35	47	52	56	61
	Cod.	3.21.0000	3.22.1000	3.23.2000	3.23.3000	3.24.2000	3.24.3000	3.24.4000	3.24.5000

**Art. 20**

Morsa XL ad apertura singola, con ganascia mobile guidata monoblocco

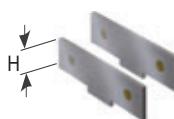


Single opening  
XL vise, with solid  
movable guided jaws

Monoblocco - Solid

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !****Art. 313**

Coppia di Parallele magnetiche  
Pair of magnetic parallel plates



Cod.	4.31.3100C	4.31.3200C	4.31.3300C	4.31.3400C
H	23	33	43	53

**Art. 212**

Ganascia mobile intermedia  
(da usare con Art. 313)  
Intermediate movable jaw (to be used with Art. 313)



Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000
H				

**Art. 217**

Ganascia mobile prismatica  
Prismatic movable jaw



Cod.	2.21.71000	2.21.72000	2.21.73000	2.21.74000
H				

**Art. 242G**

Piastra ganascia con inserti GRIP  
completa di parallela magnetica  
Jaw plate with GRIP inserts with magnetic parallel



Cod.	1.24.2G100	1.24.2G200	1.24.2G300	1.24.2G400
H				

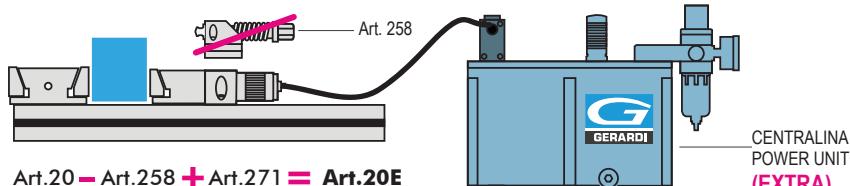
**Art. 20E**

Morsa modulare StandardMatic  
con cilindro idraulico a  
SINGOLO effetto



StandardMatic  
precision modular vise  
with SINGLE effect  
hydraulic cylinder

Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41
H	

**MORSE StandardMatic**

Art.20 + Art.258 + Art.271 = Art.20E

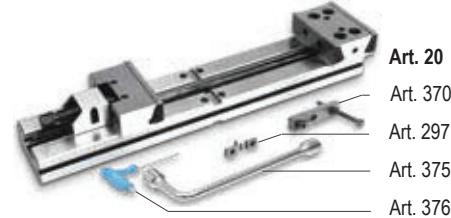
CENTRALINA  
POWER UNIT  
(EXTRA)

Dotazione standard:

- 1 arresto laterale Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (toleranza F7)

Extra per ogni chiavetta (toleranza H7)

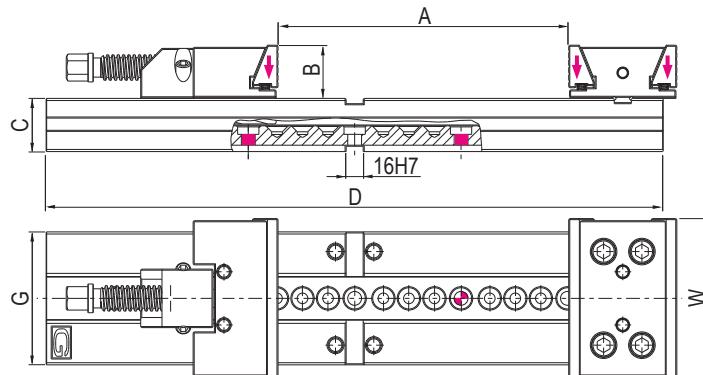


Standard equipment:

- 1 workstop Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)

Extra charge for each calibrated key nut (H7 tolerance)



Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories



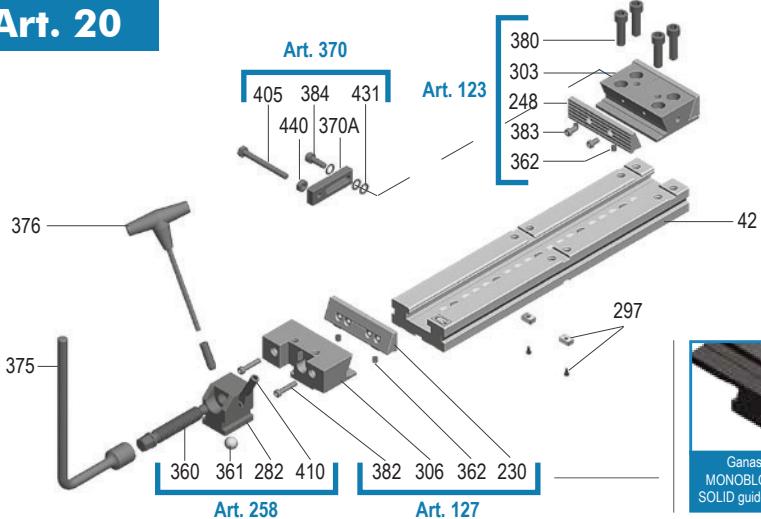
	5 40 kN					6 40 kN						
A	500	600	700	800	900	500	600	700	800	900	1000	1100
W			200						300			
B			65						80			
C			70						78			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G			170						195			
kg	64	69	74	79	84	95	105	115	125	135	145	155
Cod.	3.25 .20000	3.25.30000	3.25.40000	3.25.50000	3.25.60000	3.26.20000	3.26.30000	3.26.40000	3.26.50000	3.26.60000	3.26.70000	3.26.80000

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3500C	Art. 313	53		4.31.3600C	
				68	
1.21.25000	Art. 212			1.21.26000	
2.21.75000	Art. 217			2.21.76000	
1.24.2G500	Art. 242G			1.24.2G600	
Cod.				Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41	

**StandardMatic VISES**


**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)


**Art. 20**


Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>375</b>	4.35
<b>230</b>	4.9	<b>376</b>	4.35
<b>248</b>	4.9	<b>380</b>	4.28
<b>282</b>	4.36	<b>382</b>	4.28
<b>297</b>	4.34	<b>383</b>	4.28
<b>303</b>	4.29	<b>384</b>	4.28
<b>306</b>	4.29	<b>405</b>	4.35
<b>360</b>	4.36	<b>410</b>	4.36
<b>361</b>	4.36	<b>431</b>	4.28
<b>362</b>	4.28	<b>440</b>	4.28
<b>370A</b>	4.35	-	-

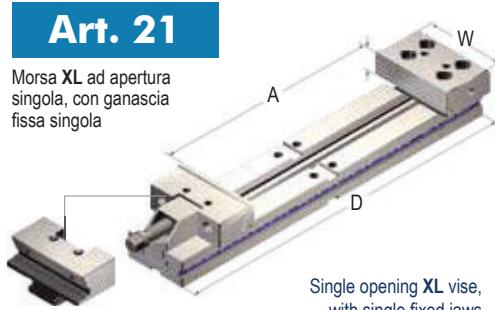


2

Tipo (grandezza) morsa / Vise type (size)	kN	1	2	3	4				
		16 kN	25 kN	30 kN	30 kN				
Apertura massima / Maximum spread	A	290	320	360	460	400	500	600	700
	W	100	125	150			175		
Morsa XL ad apertura singola, con ganascia fissa singola	B	30	40	50			60		
	C	35	40	50			58		
Single opening XL vise, with single fixed jaws	D	460	520	580	680	666	766	866	966
	G	75	95	125			145		
	kg	10	17	32	35	47	52	56	61
	Cod.	2.21.12900	2.21.23200	2.21.33600	2.21.34600	2.21.44000	2.21.45000	2.21.46000	2.21.47000
Monoblocco - Solid									

## Art. 21

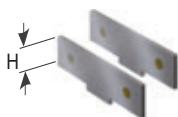
Morsa XL ad apertura singola, con ganascia fissa singola



Single opening XL vise, with single fixed jaws

## AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !

## Art. 313

Coppia di Parallele magnetiche  
Pair of magnetic parallel plates

Cod.	4.31.3100C	4.31.3200C	4.31.3300C	4.31.3400C
H	23	33	43	53

## Art. 212

Ganascia mobile intermedia  
(da usare con Art. 313)  
Intermediate movable jaw (to be used with Art. 313)

Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000
H				

## Art. 217

Ganascia mobile prismatica  
Prismatic movable jaw

Cod.	2.21.71000	2.21.72000	2.21.73000	2.21.74000
H				

## Art. 242G

Piastra ganascia con inserti GRIP  
completa di parallela magnetica  
Jaw plate with GRIP inserts with magnetic parallel

Cod.	1.24.2G100	1.24.2G200	1.24.2G300	1.24.2G400
H				

## Art. 21E

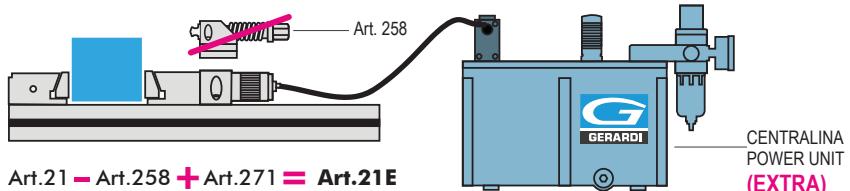
Morsa modulare StandardMatic  
con cilindro idraulico a  
SINGOLO effetto

NEW 2021

StandardMatic  
precision modular vise  
with SINGLE effect  
hydraulic cylinder

Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

## MORSE StandardMatic

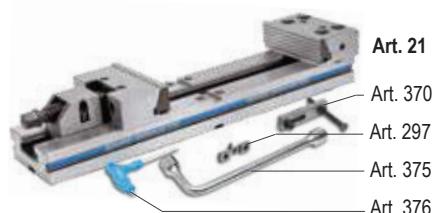


Dotazione standard:

- 1 arresto laterale Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (toleranza F7)

Extra per ogni chiaffetta (toleranza H7)

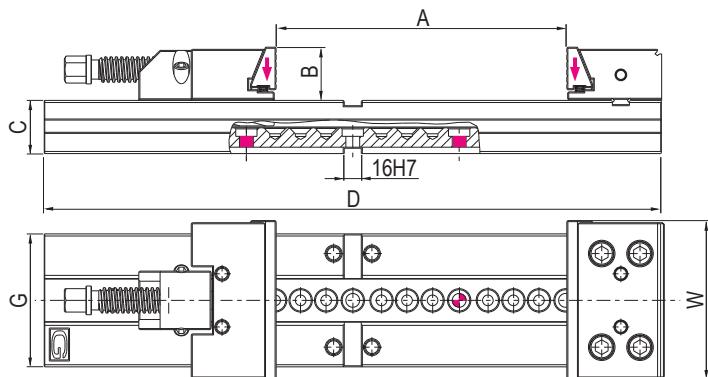


Standard equipment:

- 1 workstop Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)

Extra charge for each calibrated key nut (F7 tolerance)

Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories

	5 40 kN					6 40 kN						
A	500	600	700	800	900	500	600	700	800	900	1000	1100
W			200						300			
B			65						80			
C			70						78			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G			170						195			
kg	64	69	74	79	84	95	105	115	125	135	145	155
Cod.	2.21.55000	2.21.56000	2.21.57000	2.21.58000	2.21.59000	2.21.65000	2.21.66000	2.21.67000	2.21.68000	2.21.69000	2.21.61000	2.21.61100

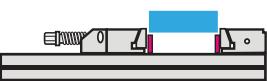
**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3500C

4.31.3600C

Art. 313

53

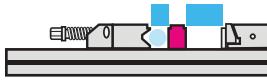


68

1.21.25000

1.21.26000

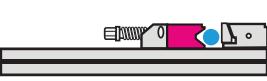
Art. 212



2.21.75000

2.21.76000

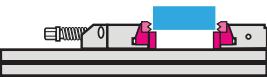
Art. 217



1.24.2G500

1.24.2G600

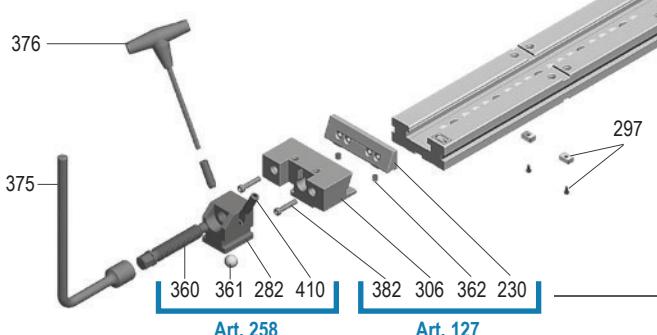
Art. 242G



Cod.

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**

**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)
**Art. 21****Art. | Pag.****42** 2.32**230** 4.9**248** 4.9**282** 4.36**297** 4.34**300** 4.29**306** 4.29**360** 4.36**361** 4.36**362** 4.28**370A** 4.35**Art. | Pag.****375** 4.35**376** 4.35**380** 4.28**382** 4.28**383** 4.28**384** 4.28**405** 4.35**410** 4.36**431** 4.28**440** 4.28**-** -



Tipo (grandezza) morsa / Vise type (size)	kN	1	2	3	4
		16 kN	25 kN	30 kN	30 kN
Apertura massima / Maximum spread	A	290	320	360	460
	W	75	95	125	145
Morsa XL ad apertura singola con ganasce ridotte rettificate. (Maggior Pressione)	B	30	40	50	60
	C	35	40	50	58
	D	460	520	580	680
	G	75	95	125	145
Monoblocco - Solid	kg	9.4	15.8	29.8	44.8
	Cod.	3.21.00220	3.22.10220	3.23.20220	3.24.20220
					3.24.30220
					3.24.40220
					3.24.50220

**Art. 22**

Morsa XL ad apertura singola con ganasce ridotte rettificate.  
(Maggior Pressione)



	5 40 kN					6 40 kN						
A	500	600	700	800	900	500	600	700	800	900	1000	1100
W			170						195			
B			65						80			
C			70						78			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G			170						195			
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	3.25.20220	3.25.30220	3.25.40220	3.25.50220	3.25.60220	3.26.20220	3.26.30220	3.26.40220	3.26.50220	3.26.60220	3.26.70220	3.26.80220

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3R50C

Art. 313R

53

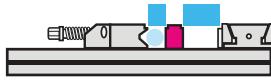


4.31.3R60C

68

1.21.35000

Art. 213



1.21.36000

Art. 218

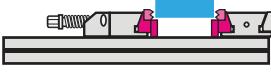
2.21.85000



2.21.86000

Art. 243G

1.24.3G500



1.24.3G600

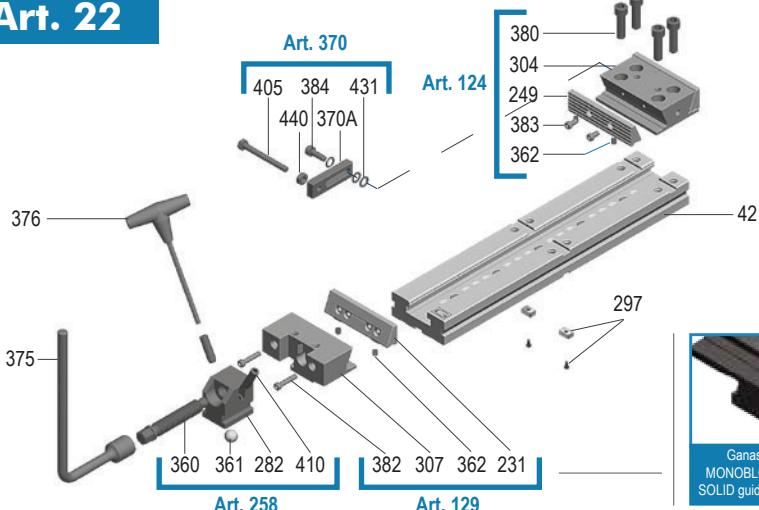
Cod.

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**


Centralina Pneumoidraulica Art.393/394/395 (EXTRA)

Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

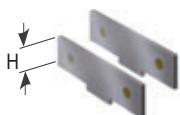
**Art. 22****Art. | Pag.****42** 2.32**231** 4.9**249** 4.9**282** 4.36**297** 4.34**304** 4.29**307** 4.29**360** 4.36**361** 4.36**362** 4.28**370A** 4.35**Art. | Pag.****375** 4.35**376** 4.35**380** 4.28**382** 4.28**383** 4.28**384** 4.28**405** 4.35**410** 4.36**431** 4.28**440** 4.28**-** -



Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4			
		16 kN	25 kN	25 kN	30 kN	30 kN					
Apertura massima / Maximum spread	A	290	320	360	460	400	500	600	700		
	W	100	125		150				175		
Art. 24	A	30	40		50				60		
Morsa XL con ganasce a piastre piane	C	35	40		50				58		
	D	460	520	580	680	666	766	866	966		
	G	75	95		125				145		
	kg	9.4	15.8	29.8	32.8	44.8	49.8	54.8	59.8		
	Cod.	2.24.12900	2.24.23200	2.24.33600	2.24.34600	2.24.44000	2.24.45000	2.24.46000	2.24.47000		
Monoblocco - Solid											

## AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !

## Art. 313

Coppia di Parallele magnetiche  
Pair of magnetic parallel plates

Cod.	4.31.3100C	4.31.3200C	4.31.3300C	4.31.3400C
H	23	33	43	53

## Art. 212

Ganasca mobile intermedia  
(da usare con Art. 313)  
Intermediate movable jaw (to be used with Art. 313)

Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000
H				

## Art. 246

Piastra piana in acciaio lavorabile  
Machinable steel straight jaw plate

Cod.	1.65.16200	1.65.26200	1.65.36200	1.65.46200
H				

## Art. 246G

Piastra ganasca con inserti GRIP  
completa di parallela magnetica  
Jaw plate with GRIP inserts with magnetic parallel

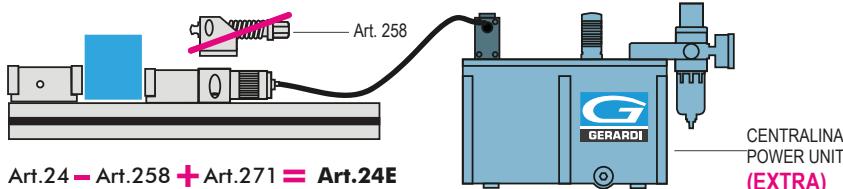
Cod.	1.24.6G100	1.24.6G200	1.24.6G300	1.24.6G400
H				

## Art. 24E

Morsa modulare StandardMatic  
con cilindro idraulico a  
SINGOLO effettoNEW  
2021StandardMatic  
precision modular vise  
with SINGLE effect  
hydraulic cylinder

Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41
H	

## MORSE StandardMatic

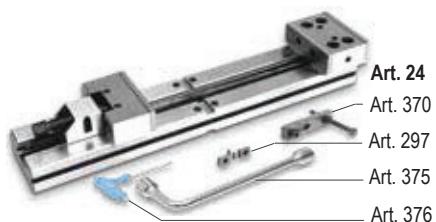


Art.24 + Art.258 + Art.271 = Art.24E

CENTRALINA  
POWER UNIT  
(EXTRA)

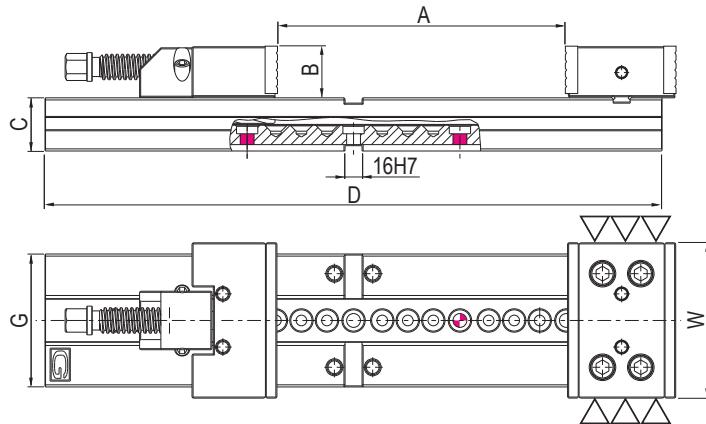
Dotazione standard:

- 1 arresto laterale Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (tolleranza F7)  
Extra per ogni chiaffetta (tolleranza H7)

Standard equipment:

- 1 workstop Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)  
Extra charge for each calibrated key nut (F7 tolerance)Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories



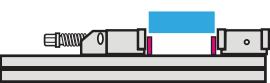
	5 40 kN					6 40 kN						
A	500	600	700	800	900	500	600	700	800	900	1000	1100
W			200						300			
B			65						80			
C			70						78			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G			170						195			
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	2.24.55000	2.24.56000	2.24.57000	2.24.58000	2.24.59000	2.24.65000	2.24.66000	2.24.67000	2.24.68000	2.24.69000	2.24.61000	2.24.61100

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3500C

Art. 313

53

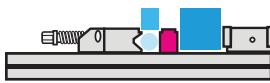


4.31.3600C

68

1.21.25000

Art. 212



1.21.26000

Art. 246

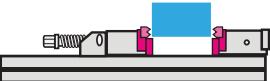
1.65.56200



1.65.66200

Art. 246G

1.24.6G500



1.24.6G600

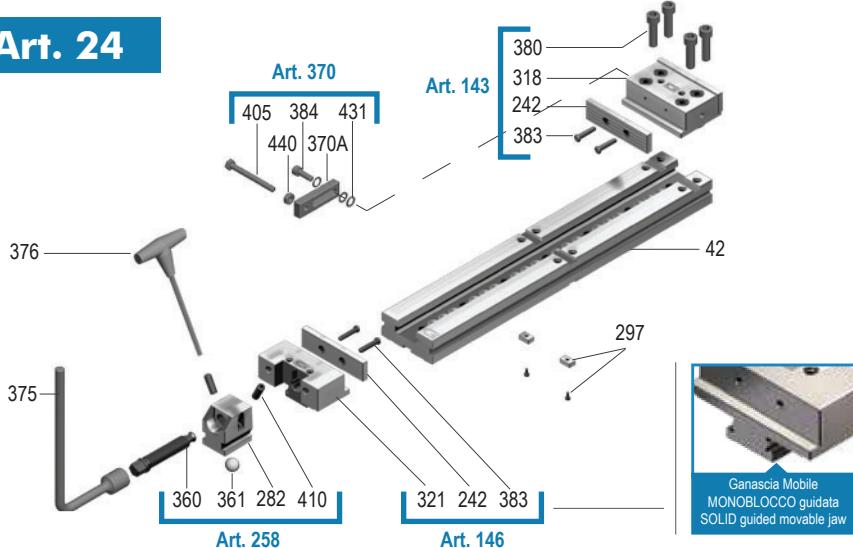
Cod.

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**


Centralina Pneumoidraulica Art.393/394/395 (EXTRA)

Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 24****Art. | Pag.****42** 2.32**242** 4.11**282** 4.36**297** 4.34**318** 4.30**321** 4.30**360** 4.36**361** 4.36**370A** 4.35**375** 4.35**376** 4.35**Art. | Pag.****380** 4.28**383** 4.28**384** 4.28**405** 4.35**410** 4.36**431** 4.28**440** 4.28**-** -**-** -**-** -**-** -



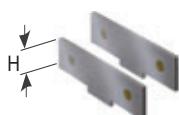
Tipo (grandezza) morsa Vise type (size)	kN	1	2	3	4				
		16 kN	25 kN	30 kN					
Apertura massima / Maximum spread	A	290	320	360	460	400	500	600	700
Art. 25	W	75	95	125			145		
Morsa XL con ganasce a piastre GRIP a forte serraggio (ridotte rettificate)	B	30	40	50			60		
	C	35	40	50			58		
	D	460	520	580	680	666	766	866	966
	G	75	95	125			145		
	kg	9.4	15.8	29.8	32.8	44.8	49.8	54.8	59.8
	Cod.	2.25.12900	2.25.23200	2.25.33600	2.25.34600	2.25.44000	2.25.45000	2.25.46000	2.25.47000
Monoblocco - Solid									

XL vise with  
GRIP jaw-plates  
for strongest clamping  
(narrow width ground)

## AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !

## Art. 313R

Coppia di Parallele magnetiche  
Pair of magnetic parallel plates



Cod.	4.31.3R10C	4.31.3R20C	4.31.3R30C	4.31.3R40C
H	23	33	43	53

## Art. 218

Ganasca mobile prismatica  
Prismatic movable jaw



Cod.	2.21.81000	2.21.82000	2.21.83000	2.21.84000

## Art. 247

Piastra piana in acciaio lavorabile  
Machinable steel straight jaw plate



Cod.	1.65.17200	1.65.27200	1.65.37200	1.65.47200

## Art. 247G

Piastra ganasca ridotta con inserti GRIP completa di parallela magnetica  
Narrow width jaw plate with GRIP inserts with magnetic parallel



Cod.	1.24.7G100	1.24.7G200	1.24.7G300	1.24.7G400

## Art. 25E

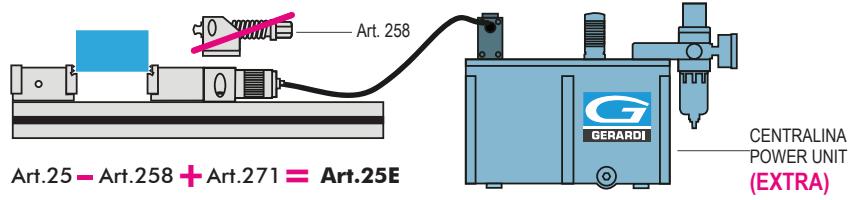
Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto

NEW  
2021

StandardMatic  
precision modular vise  
with SINGLE effect  
hydraulic cylinder

Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

## MORSE StandardMatic



Art.25 - Art.258 + Art.271 = Art.25E

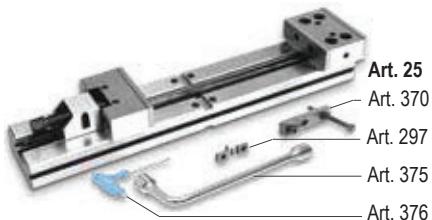
CENTRALINA  
POWER UNIT  
(EXTRA)

Dotazione standard:

- 1 arresto laterale Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (tolleranza F7)

Extra per ogni chiaffetta (tolleranza H7)

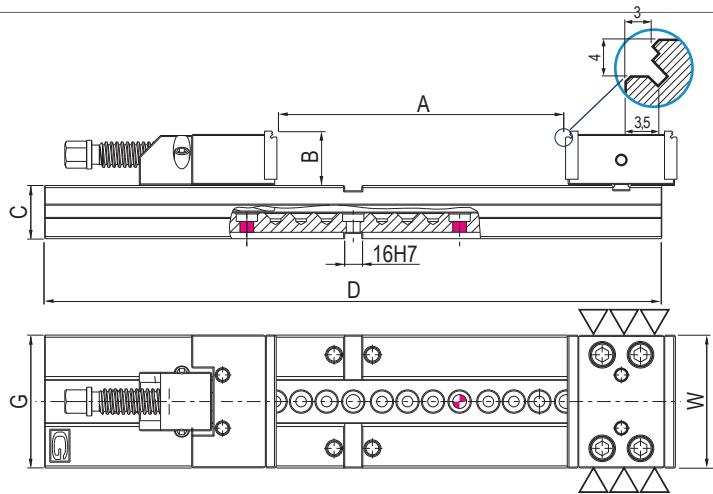


Standard equipment:

- 1 workstop Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)

Extra charge for each calibrated key nut (F7 tolerance)



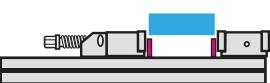
Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories



	5 40 kN					6 40 kN						
A	500	600	700	800	900	500	600	700	800	900	1000	1100
W			170						195			
B			65						80			
C			70						78			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G			170						195			
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	2.25.55000	2.25.56000	2.25.57000	2.25.58000	2.25.59000	2.25.65000	2.25.66000	2.25.67000	2.25.68000	2.25.69000	2.25.61000	2.25.61100

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3R50C



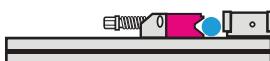
Art. 313R

53

4.31.3R60C

68

2.21.85000



Art. 218

2.21.86000

1.65.57200



Art. 247

1.65.67200

1.24.7G500



Art. 247G

1.24.7G600

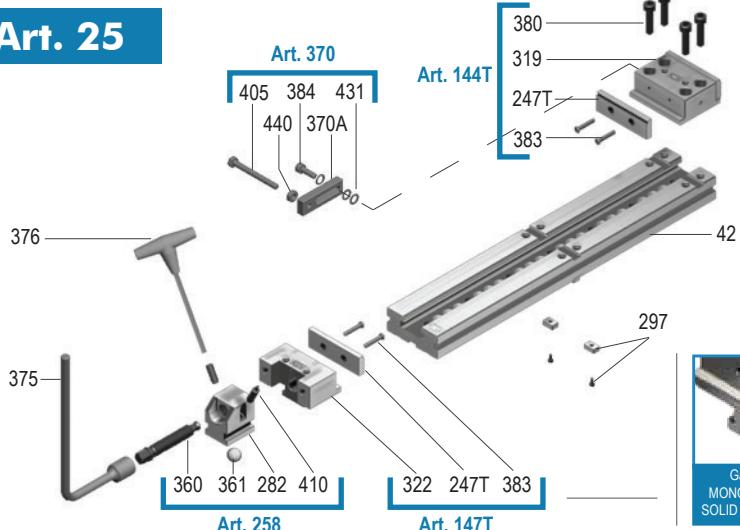
Cod.

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**


Centralina Pneumoidraulica Art.393/394/395 (EXTRA)

Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 25**

Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>380</b>	4.28
<b>247T</b>	4.11	<b>383</b>	4.28
<b>282</b>	4.36	<b>384</b>	4.28
<b>297</b>	4.34	<b>405</b>	4.35
<b>319</b>	4.30	<b>410</b>	4.36
<b>322</b>	4.30	<b>431</b>	4.28
<b>360</b>	4.36	<b>440</b>	4.28
<b>361</b>	4.36	<b>-</b>	-
<b>370A</b>	4.35	<b>-</b>	-
<b>375</b>	4.35	<b>-</b>	-
<b>376</b>	4.35	<b>-</b>	-

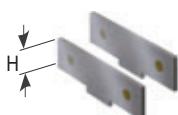
Tipo (grandezza) morsa / Vise type (size)	kN	1	2	3	4
		16 kN	25 kN	30 kN	30 kN
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 160
<b>Art. 30</b>	W	100	125	150	175
Morsa XL a doppia apertura con ganascia mobile guidata monoblocco	B	30	40	50	60
	C	35	40	50	58
	D	460	520	580	680
	G	75	95	125	145
Monoblocco - Solid	kg	14.5	21	39	43
	Cod.	3.31.00600	3.32.10600	3.33.20600	3.33.30600
					3.34.20600
					3.34.30600
					3.34.40600
					3.34.50600



## AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !

**Art. 313**

Coppia di Parallele magnetiche  
Pair of magnetic parallel plates



Cod.	4.31.3100C	4.31.3200C	4.31.3300C	4.31.3400C
H	23	33	43	53

**Art. 212**

Ganascia mobile intermedia  
(da usare con Art. 313)  
Intermediate movable jaw (to be used with Art. 313)



Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000
H	23	33	43	53

**Art. 217**

Ganascia mobile prismatica  
Prismatic movable jaw



Cod.	2.21.71000	2.21.72000	2.21.73000	2.21.74000
H	23	33	43	53

**Art. 242G**

Piastra ganascia con inserti GRIP completa di parallela magnetica  
Jaw plate with GRIP inserts with magnetic parallel



Cod.	1.24.2G100	1.24.2G200	1.24.2G300	1.24.2G400
H	23	33	43	53

**Art. 30E**

Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto

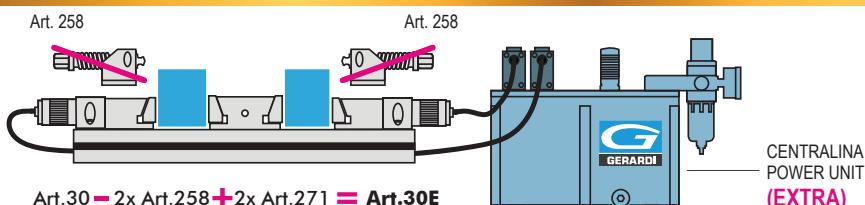


**NEW 2021**

StandardMatic precision modular vise with SINGLE effect hydraulic cylinder

Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41			
	Art. 258	Art. 258	Art. 258	Art. 258

## MORSE StandardMatic

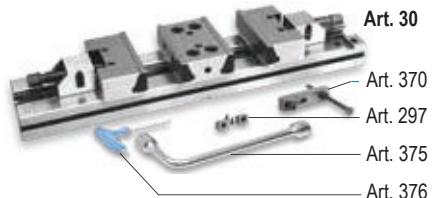


Dotazione standard:

- 2 arresti laterali Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (tolleranza F7)

Extra per ogni chiaffetta (tolleranza H7)

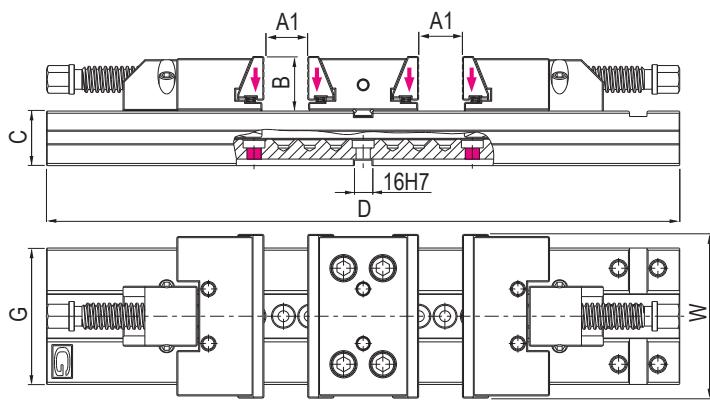


Standard equipment:

- 2 workstops Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)

Extra charge for each calibrated key nut (F7 tolerance)

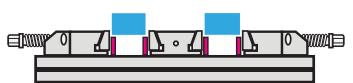


Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories

2

UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !

4.31.3500C



4.31.3600C

1.21.25000

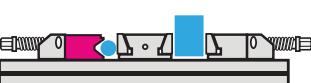
Art. 212



1.21.26000

2.21.75000

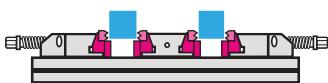
Art. 217



2.21.76000

1.24.2G500

Art. 242G



1.24.2G600

Cod.

Vedi paq. 4.40 - 4.41 - See paq. 4.40 - 4.41

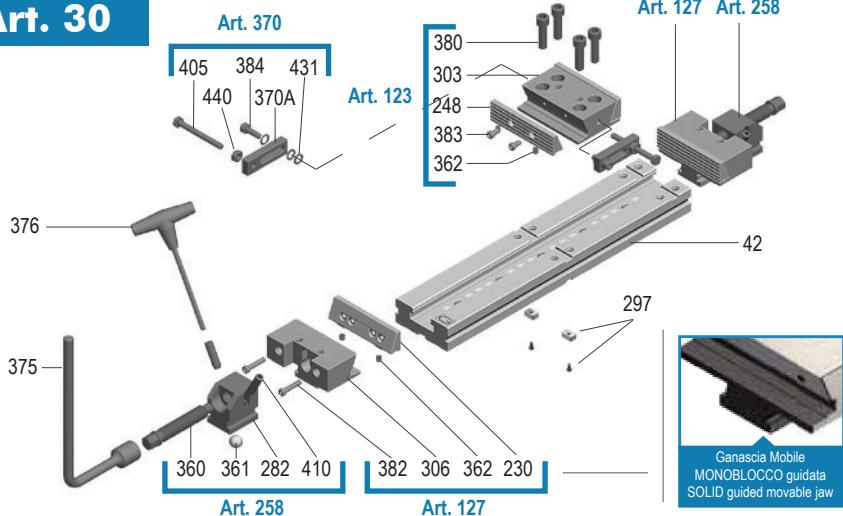
## StandardMatic VISES



Centralizing Pneumoidraulicq Art.393/394/395 (EXTRA)

Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

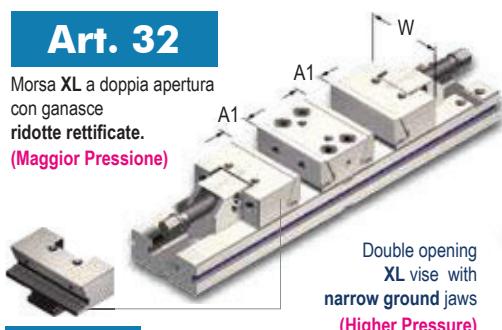
**Art. 30**



<b>Art.</b>	<b>Pag.</b>	<b>Art.</b>	<b>Pag.</b>
<b>42</b>	2.32	<b>375</b>	4.35
<b>230</b>	4.9	<b>376</b>	4.35
<b>248</b>	4.9	<b>380</b>	4.28
<b>282</b>	4.36	<b>382</b>	4.28
<b>297</b>	4.34	<b>383</b>	4.28
<b>303</b>	4.29	<b>384</b>	4.28
<b>306</b>	4.29	<b>405</b>	4.35
<b>360</b>	4.36	<b>410</b>	4.36
<b>361</b>	4.36	<b>431</b>	4.28
<b>362</b>	4.28	<b>440</b>	4.28
<b>370A</b>	4.35	-	-



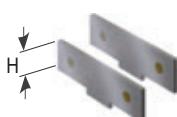
Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4			
		16 kN	25 kN	25 kN	30 kN	30 kN					
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 160	2 x 120	2 x 170	2 x 220	2 x 270		
<b>Art. 32</b>											
Morsa XL a doppia apertura con ganasce ridotte rettificate. (Maggior Pressione)	W	75	95		125				145		
	B	30	40		50				60		
	C	35	40		50				58		
	D	460	520	580	680	666	766	866	966		
	G	75	95		125				145		
	kg	13.5	19.5	36	40	56	61	66	71		
	Cod.	3.31.00720	3.32.10720	3.33.20720	3.33.30720	3.34.20720	3.34.30720	3.34.40720	3.34.50720		
Monoblocco - Solid											



## AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !

**Art. 313R**

Coppia di Parallele magnetiche  
Pair of magnetic parallel plates



Cod.	4.31.3R10C	4.31.3R20C	4.31.3R30C	4.31.3R40C
H	23	33	43	53

**Art. 213**

Ganasca mobile intermedia  
(da usare con Art. 313R)  
Intermediate movable jaw (to be used with Art. 313R)



Cod.	1.21.31000	1.21.32000	1.21.33000	1.21.34000
H				

**Art. 218**

Ganasca mobile prismatica  
Prismatic movable jaw



Cod.	2.21.81000	2.21.82000	2.21.83000	2.21.84000
H				

**Art. 243G**

Piastra ganasca ridotta con inserti GRIP completa di parallela magnetica  
Narrow width jaw plate with GRIP inserts with magnetic parallel



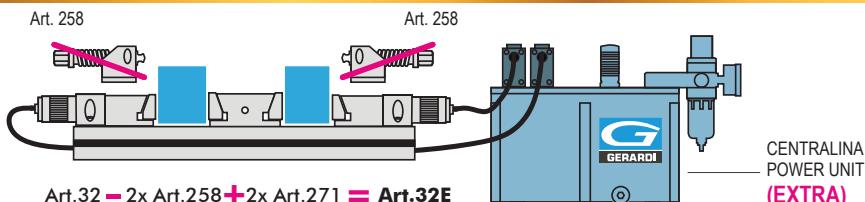
Cod.	1.24.3G100	1.24.3G200	1.24.3G300	1.24.3G400
H				

**Art. 32E**

Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto



Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

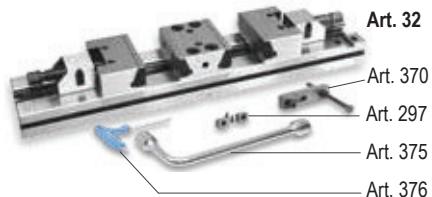
**MORSE StandardMatic**

Dotazione standard:

- 2 arresti laterale Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (toleranza F7)

Extra per ogni chiaffetta (toleranza H7)

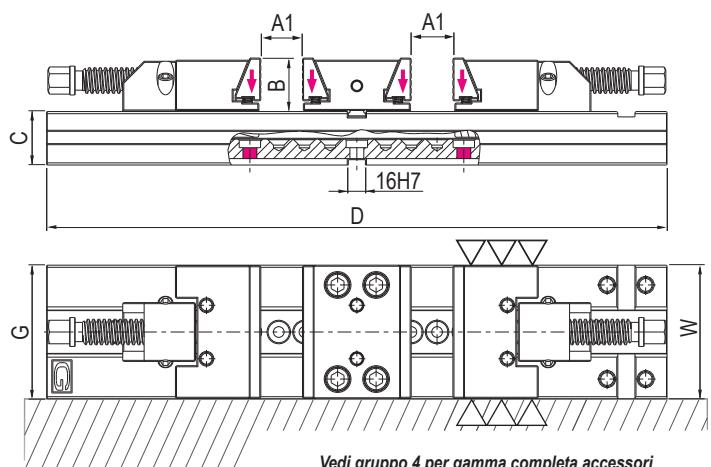


Standard equipment:

- 2 workstops Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)

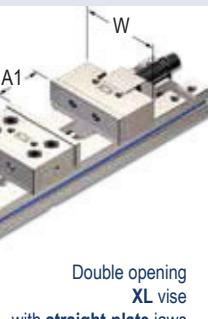
Extra charge for each calibrated key nut (F7 tolerance)



Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories



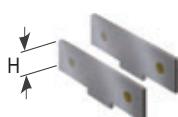
Tipo (grandezza) morsa / Vise type (size)	kN	1	2	3	4
		16 kN	25 kN	30 kN	30 kN
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 120
	W	100	125	150	175
<b>Art. 34</b>	B	30	40	50	60
Morsa XL a doppia apertura con ganasce a piastre piane	C	35	40	50	58
	D	460	520	580	680
	G	75	95	125	145
	kg	9.4	15.8	29.8	44.8
	Cod.	2.34.19000	2.34.21000	2.34.31100	2.34.31600
					2.34.41200
					2.34.41700
					2.34.42200
					2.34.42700
<b>Monoblocco - Solid</b>					



### AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !

#### Art. 313

Coppia di Parallele magnetiche  
Pair of magnetic parallel plates



Cod.	4.31.3100C	4.31.3200C	4.31.3300C	4.31.3400C
H	23	33	43	53

#### Art. 212

Ganasca mobile intermedia  
(da usare con Art. 313)  
Intermediate movable jaw (to be used with Art. 313)



Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000

#### Art. 246

Piastra piana in acciaio lavorabile  
Machinable steel straight jaw plate



Cod.	1.65.16200	1.65.26200	1.65.36200	1.65.46200

#### Art. 246G

Piastra ganasca con inserti GRIP  
completa di parallela magnetica  
Jaw plate with GRIP inserts with magnetic parallel



Cod.	1.24.6G100	1.24.6G200	1.24.6G300	1.24.6G400

#### Art. 34E

Morsa modulare StandardMatic  
con cilindro idraulico a  
SINGOLO effetto

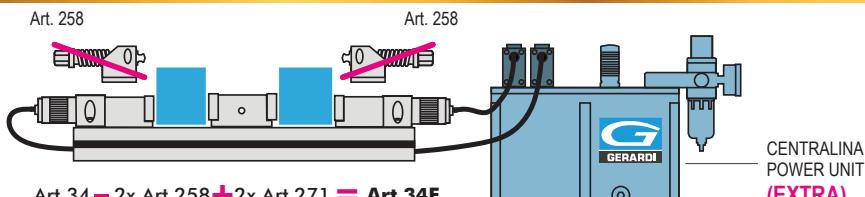


**NEW 2021**

StandardMatic  
precision modular vise  
with SINGLE effect  
hydraulic cylinder

Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41			
	Art. 258	Art. 258	Art. 271	CENTRALINA POWER UNIT (EXTRA)

#### MORSE StandardMatic



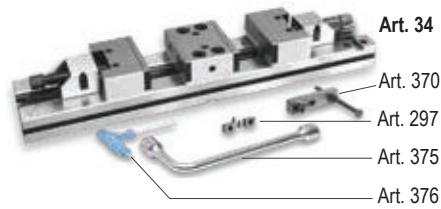
Art.34 - 2x Art.258 + 2x Art.271 = Art.34E

Dotazione standard:

- 2 arresti laterali Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (toleranza F7)

Extra per ogni chiaffetta (toleranza H7)

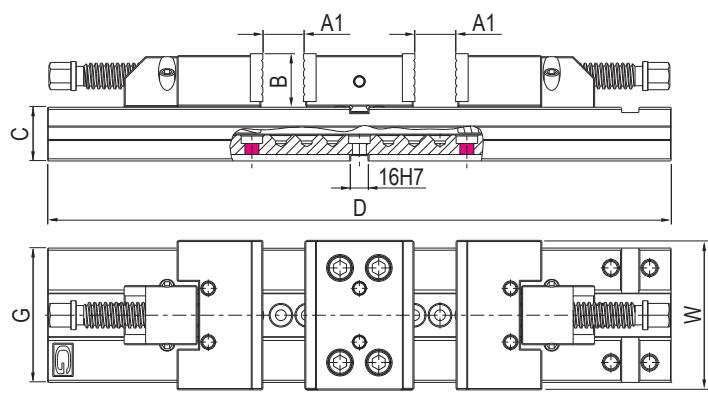


Standard equipment:

- 2 workstops Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)

Extra charge for each calibrated key nut (H7 tolerance)



Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories

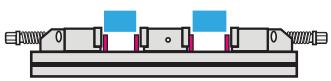


	5 40 kN					6 40 kN						
A1	2 x 150	2 x 200	2 x 250	2 x 300	2 x 350	2 x 160	2 x 210	2 x 260	2 x 310	2 x 360	2 x 410	2 x 460
W		200							300			
B			65						80			
C			70						78			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G			170						195			
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	2.34.51500	2.34.52000	2.34.52500	2.34.53000	2.34.53500	2.34.61600	2.34.62100	2.34.62600	2.34.63100	2.34.63600	2.34.64100	2.34.64600

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3500C

53

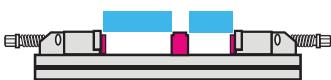


4.31.3600C

68

1.21.25000

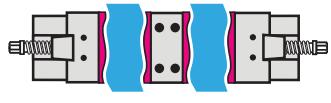
Art. 212



1.21.26000

Art. 246

1.65.56200



1.65.66200

Art. 246G

1.24.6G500



1.24.6G600

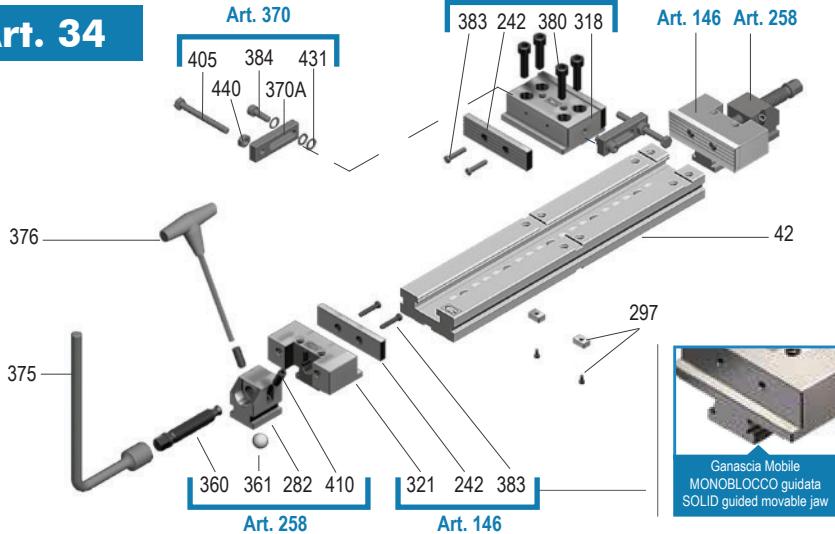
Cod.

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**


Centralina Pneumoidraulica Art.393/394/395 (EXTRA)

Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 34**


Art. | Pag.

42 2.32

242 4.11

282 4.36

297 4.34

318 4.30

321 4.30

360 4.36

361 4.36

370A 4.35

375 4.35

376 4.35

Art. | Pag.

380 4.28

383 4.28

384 4.28

405 4.35

410 4.36

431 4.28

440 4.28

-

-

-

-



Tipo (grandezza) morsa Vise type (size)	kN	1	2	3	4
		16 kN	25 kN	30 kN	30 kN
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 160
	W	75	95	125	145
Morsa XL a doppia apertura con piastre ganasce GRIP a forte serraggio (ridotte rettificate)	B	30	40	50	60
	C	35	40	50	58
	D	460	520	580	680
	G	75	95	125	145
Double opening XL vise with GRIP jaw-plates for strongest clamping (narrow with ground)	kg	9.4	15.8	29.8	32.8
	Cod.	2.35.19000	2.35.21000	2.35.31100	2.35.31600
Monoblocco - Solid				2.35.41200	2.35.41700
				2.35.42200	2.35.42700

### Art. 35

Morsa XL a doppia apertura con piastre ganasce GRIP a forte serraggio (ridotte rettificate)

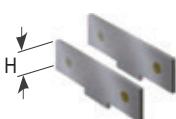


Double opening XL vise with GRIP jaw-plates for strongest clamping (narrow with ground)

## AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !

### Art. 313R

Coppia di Parallele magnetiche  
Pair of magnetic parallel plates



Cod. 4.31.3R10C 4.31.3R20C 4.31.3R30C 4.31.3R40C

H 23 33 43 53

### Art. 218

Ganasca mobile prismatica  
Prismatic movable jaw



Cod. 2.21.81000 2.21.82000 2.21.83000 2.21.84000

### Art. 247

Piastra piana in acciaio lavorabile  
Machinable steel straight jaw plate



Cod. 1.65.17200 1.65.27200 1.65.37200 1.65.47200

### Art. 247G

Piastra ganasca ridotta con inserti GRIP completa di parallela magnetica  
Narrow width jaw plate with GRIP inserts with magnetic parallel



Cod. 1.24.7G100 1.24.7G200 1.24.7G300 1.24.7G400

### Art. 35E

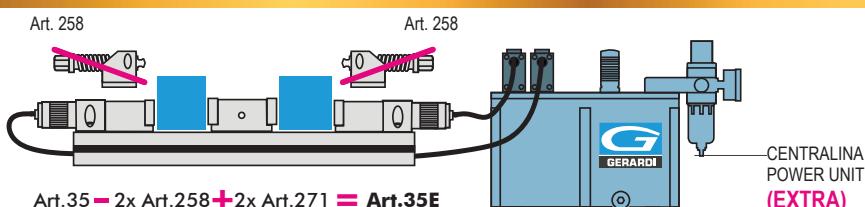
Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto



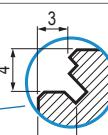
StandardMatic precision modular vise with SINGLE effect hydraulic cylinder

Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

### MORSE StandardMatic



Art. 258 Art. 258  
Art. 35E = 2x Art. 258 + 2x Art. 271 = Art. 35E

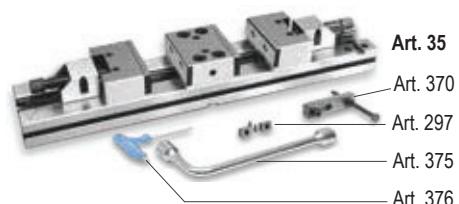


Dotazione standard:

- 2 arresti laterale Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (toleranza F7)

Extra per ogni chiaffetta (toleranza H7)

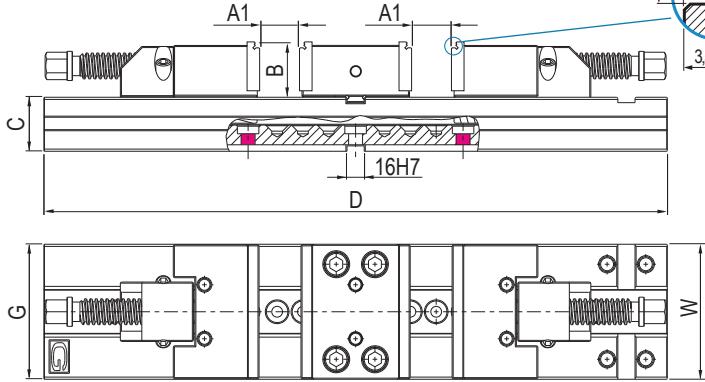


Standard equipment:

- 2 workstops Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)

Extra charge for each calibrated key nut (F7 tolerance)



Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories



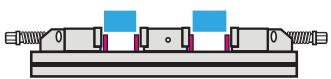
	5 40 kN					6 40 kN						
A1	2 x 150	2 x 200	2 x 250	2 x 300	2 x 350	2 x 160	2 x 210	2 x 260	2 x 310	2 x 360	2 x 410	2 x 460
W				170					195			
B				65					80			
C				70					78			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G				170					195			
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	2.35.51500	2.35.52000	2.35.52500	2.35.53000	2.35.53500	2.35.61600	2.35.62100	2.35.62600	2.35.63100	2.35.63600	2.35.64100	2.35.64600

### UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !

4.31.3R50C

Art. 313R

53

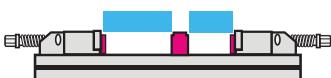


4.31.3R60C

68

2.21.85000

Art. 218



2.21.86000

Art. 247

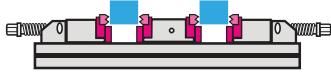
1.65.57200



1.65.67200

Art. 247G

1.24.7G500



1.24.7G600

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

Cod.

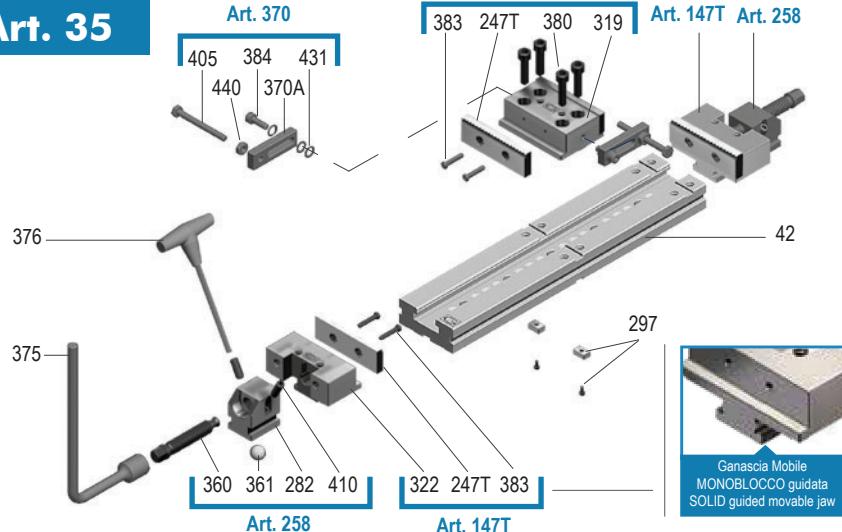
### StandardMatic VISES



Centralina Pneumoidraulica Art.393/394/395 (EXTRA)

Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 35**



**Art.** **Pag.**

**42** 2.32

**247T** 4.11

**282** 4.36

**297** 4.34

**319** 4.30

**322** 4.30

**360** 4.36

**361** 4.36

**370A** 4.35

**375** 4.35

**376** 4.35

**Art.** **Pag.**

**380** 4.28

**383** 4.28

**384** 4.28

**405** 4.35

**410** 4.36

**431** 4.28

**440** 4.28

**-** -

**-** -

**-** -

**-** -

## Morse e Cubi / Vises & Vise Towers

# XL (flex)



Precisione / Accuracy  
**±0,02mm**



Durezza / Hardened  
**HRC 58±2**

**Basi extra lunghe e piastre ganasce a cambio rapido!**  
**Extra long bases and quick interchangeable jaw plate !**

### USURA INESISTENTE / NO WEAR

Grazie all'accurata scelta dei materiali impiegati ed allo studio dimensionale computerizzato dei componenti. Costruzione completamente in speciali leghe di acciaio ad alta resistenza, normalizzato, cementato e temprato con durezza  $58 \pm 2$  HRC. Tutto ciò al fine di conferire massima rigidità, elevate prestazioni e usura inesistente. A riprova di tutto ciò assicuriamo **5 ANNI DI GARANZIA** su tutto il programma morse e organi meccanici in genere.

Thanks to the manufacturing with only the most suitable materials and to the structure of the vise components (developed using computer customised softwares and the experience gained during many years spent working on the specific field). High alloyed quality resistance steel, case hardened HRC  $58 \pm 2$ , is used in manufacturing all the Gerardi vises and accessories in order to give maximum rigidity, high performances and no wear. As evidence we give **5 YEARS WARRANTY** on all the vises and mechanical components.

### MODULARITÀ / MODULARITY

Tutte le morse ed accessori sono elementi componibili, intercambiabili e perfettamente allineabili fra loro e con i quali è possibile ottenere differenti soluzioni di bloccaggio. Secondo tale principio l'unico elemento che differenzia le attrezature con identica larghezza di presa è la base (la cui lunghezza determina la massima apertura della morsa), mentre gli altri componenti sono identici. Mediante l'aggiunta o semplice sostituzione di alcuni particolari si può variare la tipologia di bloccaggio secondo le proprie esigenze utilizzando la stessa attrezzatura acquistata in un primo momento (bloccaggi singoli, con base girevole, doppi, verticali, di pezzi piani, tondi, piatti e grezzi, manuali, idraulici o pneumatici).

All vises and accessories are modular and components of all our vises will interchange with perfect alignment to provide different workholding solutions. With this basic principle the only difference between fixtures with the same width of clamping is the base (whose length determines the maximum opening of the vise), while the rest of components have same dimensions. Through the simple addition or substitution of some particulars You can change the type of clamping as Your needs require using the same fixture purchased before (single clamping, swivel base, double, vertical, smooth or round or flat or rough workpieces, manual, hydraulic or pneumatic).

### DESIGN COMPATTO / SPACE SAVING DESIGN

La semplicità nonché la compattezza costruttiva consentono un'apertura notevole rispetto all'ingombro totale dell'attrezzatura. Inoltre lo stesso peso (solo 25 kg per una morsa da 150 mm di larghezza ganascia) è tale da consentire un facile trasferimento da una macchina all'altra.

The space saving design and solid construction allow a maximum blocking ratio to total overall dimension of the vise. Furthermore the weight (only 25 kg for a 150 mm jaw width vise) allows a simple moving from one machine to another.

### SERRAGGI RAPIDI / QUICK CLAMPING

Grazie allo scorrimento del gruppo di serraggio nella guida della base (a cremagliera) fino in prossimità del pezzo da lavorare dove si adatterà automaticamente alla nicchia più vicina. L'operazione di serraggio si conclude agendo sulla vite di bloccaggio. Oltre a quello manuale meccanico, sono disponibili 4 ulteriori sistemi di serraggio intercambiabili e indipendenti: 1 - Idraulici / 2 - Pneumatici / 3 - Manuali / 4 - Idraulici elettrici. L'operazione è in termini di secondi.

Thanks to the clamping device sliding in the vise base slide (compact rack type) till the proximity of the workpiece. The clamping is completed with the main screw. Besides the manual mechanic system, 4 further interchangeable and independent clamping systems are available: 1- Hydraulic / 2- Pneumatic / 3- Manual hydraulic / 4- Electrical hydraulic. The change needs only few seconds.



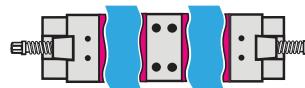
### Portapiastre / The Rack

Completo di piastre ganasce a cambio rapido a gradino Art.230E

Complete of quick change step jaw plates Art.230E

Vedi Pag. 4.21 - See Page.4.22

### PIASTRE GANASCE DISCENDENTI INTERCAMBIABILI MANUALMENTE PULL DOWN JAW PLATES INTERCHANGEABLE BY HAND



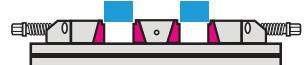
**Art. 230B**  
Dolce  
Soft



**Art. 230C**  
Liscia  
Smooth



**Art. 230D**  
Zigrinata  
Serrated



**Art. 230E**  
Con gradino  
With step



**Art. 230F**  
Prismatica  
Prismatic



**Art. 230G**  
Con arresto a 90°  
With 90° stop



**Art. 230H**  
Bombata  
Round



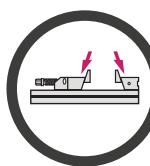
**Art. 230M**  
Angolo di 30° o 45°  
30° or 45° angle



La morsa Gerardi XL come le sorelle più corte StandardFLEX, possono essere dotate di piastre ganasca a cambio rapido permettendo in questo modo oltre la lavorazione di un numero maggiore di pezzi sfruttando al massimo la lunghezza della tavola della macchina utensile anche la sostituzione rapida delle piastre ganasca che avviene manualmente e senza l'ausilio di alcun utensile, questo è possibile grazie al sistema Perno-molla, che consente un diverso utilizzo della morsa in tempi ridottissimi.

Grazie al sistema a Pettine di rigatura prismatica delle piastre ganascia, risulta migliorato anche l'effetto discendente che durante la fase di serraggio, trascina il pezzo contro lo slittone garantendo anche una notevolissima precisione di riposizionamento.

The Gerardi XL vises as the StandardFLEX series, can be equipped with the pull down jaw plates allowing to machine more workpieces using the total length of the machine tool and the quickest jaw plate hand substitution without any tool. This is possible thanks to the new design with pin with spring which increases the standard vise versatility while the prismatic grooves allow a perfect repositioning accuracy (within microns !!).



*Dotata del geniale sistema a pettine per sostituire rapidamente la piastra ganascia discendente*

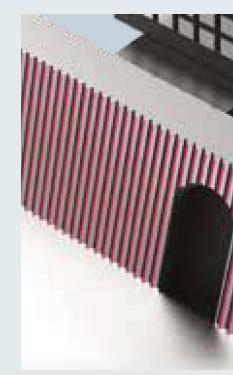
*Innovative Comb system for quick pull-down jaw plate change*



### Riconfigurazione Rapidissima Quickest Vise Resetting

grazie alla piastra ganascia intercambiabile manualmente tramite sistema a pettine

Thanks to the quick interchangeable jaw plate through ground comb system



### Altissima ripetibilità di posizionamento Highest repositioning accuracy **±0,005mm**

Veloce e preciso grazie alla forma rettificata del sistema a pettine

Quick and accurate jaw plate thanks the grid shape of the comb system



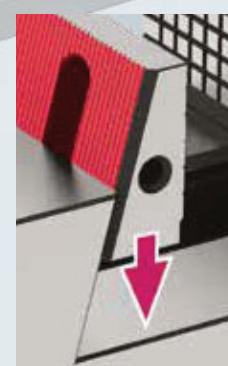
Ganascia Fissa Doppia  
Double Fixed Jaw



Due serie di chiavette per due posizioni alternative delle ganasce fisse doppie

Two different keyways for two alternatives positions of the double fixed jaw

**Art.30A**



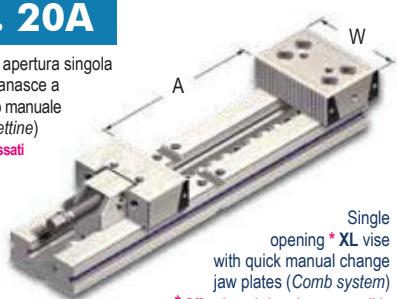
### Effetto discendente Pull Down Action

Effetto discendente ampliato e migliorato e migliore protezione dai trucioli grazie al sistema a pettine

Increased and better pull down action and better protection from chips thanks to the comb system



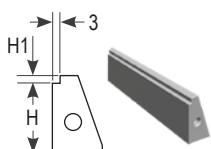
Tipo (grandezza) morsa / Vise type (size)	kN	1	2	3	4
		16 kN	25 kN	30 kN	30 kN
Apertura massima / Maximum spread	A	290	320	360	460
	W	96	121	146	171
<b>Art. 20A</b>	B	28	38	48	58
Morsa *XL a apertura singola con piastre ganascia a cambio rapido manuale (Sistema a pettine) * Serraggi disassati lateralmente non possibili	C	35	40	50	58
Single opening *XL vise with quick manual change jaw plates (Comb system) * Offset lateral clamping not possible	D	460	520	580	680
	G	75	95	125	145
	kg	6.8	12.9	25.5	29
	Cod.	2.20.A1290	2.20.A2320	2.20.A3360	2.20.A3460
				2.20.A4400	2.20.A4500
				2.20.A4600	2.20.A4700



## AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !

**Art. 230E**

Piastra ganascia intercambiabile  
Interchangeable jaw plate  
Vedi pagina 4.21 per altezze disponibili  
See page 4.21 for available height



Cod. 4.23.0E101 4.23.0E201 4.23.0E301 4.23.0E401

H	23	33	43	53
H1	5	5	5	5

**Art. 212**

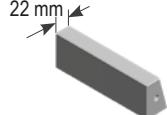
Ganascia mobile intermedia  
(da usare con Art. 230E)  
Intermediate movable jaw (to be used with Art. 230E)



Cod. 1.21.21000 1.21.22000 1.21.23000 1.21.24000

**Art. 230B**

Piastra ganascia intercambiabile dolce  
Soft interchangeable jaw plate



Cod. 4.23.0B101 4.23.0B201 4.23.0B301 4.23.0B401

**Art. 230F**

Piastra ganascia intercambiabile prismatica  
Prismatic interchangeable jaw plate



Cod. 4.23.0F101 4.23.0F201 4.23.0F301 4.23.0F401

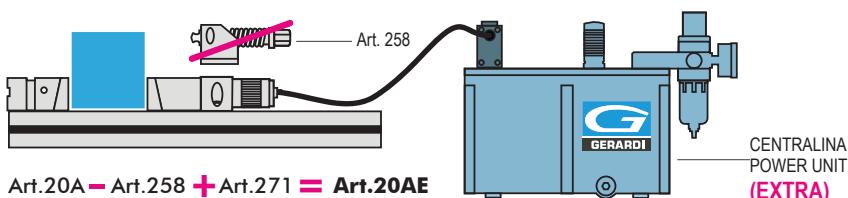
**Art.20AE**

Morsa modulare StandardMatic  
con cilindro idraulico a  
SINGOLO effetto



StandardMatic  
precision modular vise  
with SINGLE effect  
hydraulic cylinder

Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

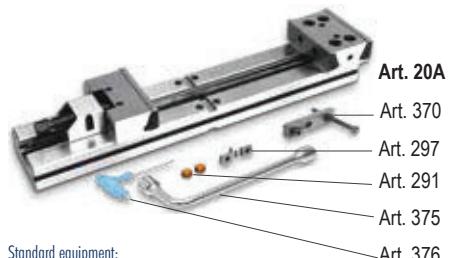
**MORSE StandardMatic**

Dotazione standard:

- 1 arresto laterale Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 2 tappi Art. 291 ■ 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (toleranza F7)

Extra per ogni chiaffetta (toleranza H7)



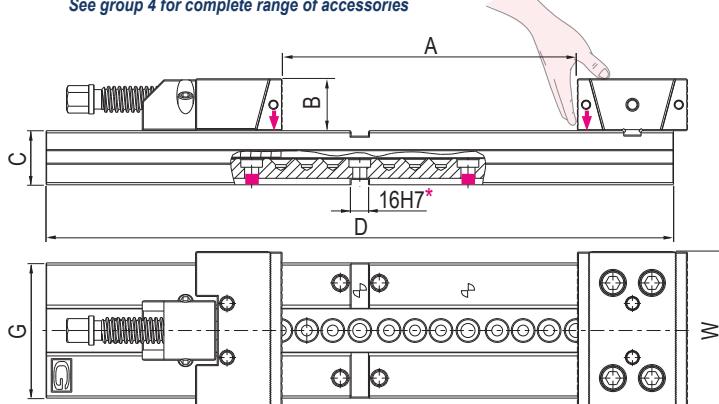
Standard equipment:

- 1 workshop Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 2 inserts Art. 291 ■ 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)

Extra charge for each calibrated key nut (F7 tolerance)

Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories



\* Versione normale: Cave da 16H7 e fori calibrati Ø8F7 (t.1) - Ø16F7 (t.2 - 3 - 4 - 5 - 6)

\* Normal version: 16H7 slot and calibrated holes Ø8F7 (t.1) - Ø16F7 (t.2 - 3 - 4 - 5 - 6)



	<b>5</b> <b>40 kN</b>					<b>6</b> <b>40 kN</b>						
A	500	600	700	800	900	500	600	700	800	900	1000	1100
W			196						296			
B			63						78			
C			70						78			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G			170						195			
kg	64	69	74	79	84	95	105	115	125	135	145	155
Cod.	2.20.A5500	2.20.A5600	2.20.A5700	2.20.A5800	2.20.A5900	2.20.A6500	2.20.A6600	2.20.A6700	2.20.A6800	2.20.A6900	2.20.A6100	2.20.A6110

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.23.0E501

**Art. 230E**

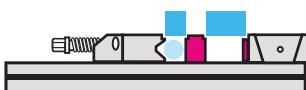
4.23.0E601

| H | 53 |
| H1 | 10 |

68

10

1.21.25000

**Art. 212**

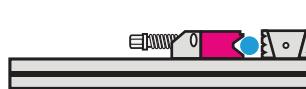
1.21.26000

4.23.0B501

**Art. 230B**

4.23.0B601

4.23.0F501

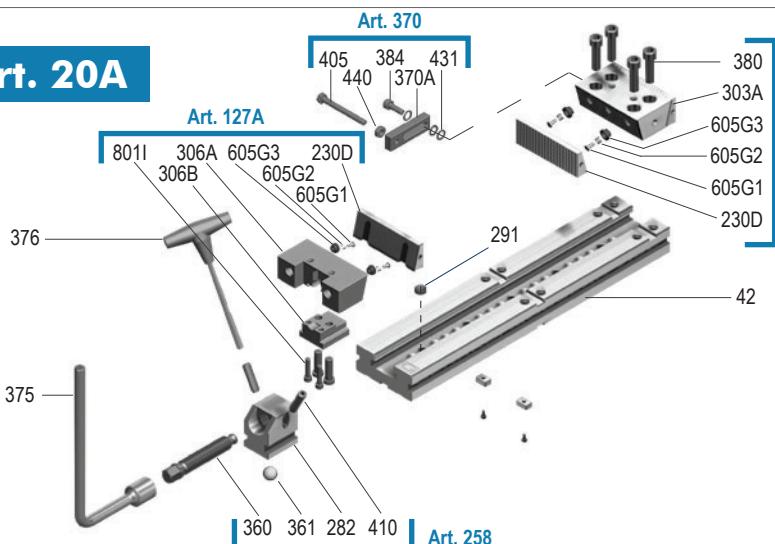
**Art. 230F**

4.23.0F601

Cod.

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**

**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**
**Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)**


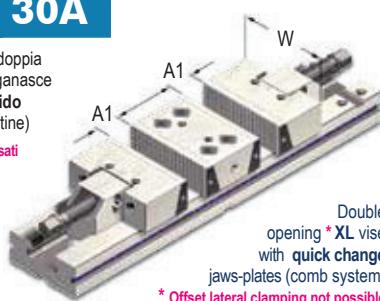
Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>376</b>	4.35
<b>230D</b>	4.21	<b>380</b>	4.28
<b>282</b>	4.36	<b>384</b>	4.28
<b>291</b>	4.35	<b>405</b>	4.35
<b>297</b>	4.34	<b>410</b>	4.36
<b>303A</b>	4.30	<b>431</b>	4.28
<b>306A</b>	4.30	<b>440</b>	4.28
<b>306B</b>	4.30	<b>605G1</b>	4.22
<b>360</b>	4.36	<b>605G2</b>	4.22
<b>361</b>	4.36	<b>605G3</b>	4.22
<b>370A</b>	4.35	<b>8011</b>	5.61
<b>375</b>	4.35	-	-



Tipo (grandezza) morsa / Vise type (size)	kN	1	2	3	4
		16 kN	25 kN	30 kN	30 kN
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 120
	W	96	121	146	171
	B	28	38	48	58
	C	35	40	50	58
	D	460	520	580	680
	G	75	95	125	145
	kg	6.8	12.9	25.5	29
	Cod.	2.30.A1900	2.30.A2100	2.30.A3110	2.30.A3160
				2.30.A4120	2.30.A4170
				2.30.A4220	2.30.A4270

**Art. 30A**

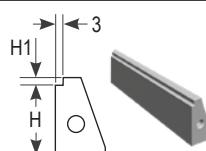
Morsa \*XL a doppia apertura con ganasce a cambio rapido (sistema a pettine)  
\* Serraggi disassati lateralmente non possibili



Double opening \*XL vise with quick change jaws-plates (comb system)  
\* Offset lateral clamping not possible

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !****Art. 230E**

Piastra ganascia intercambiabile  
Interchangeable jaw plate  
Vedi pagina 4.21 per altezze disponibili  
See page 4.21 for available height



Cod. 4.23.0E101 4.23.0E201 4.23.0E301 4.23.0E401

H	23	33	43	53
H1	5	5	5	5

**Art. 212**

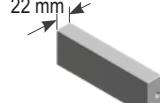
Ganasca mobile intermedia (da usare con Art. 230E)  
Intermediate movable jaw (to be used with Art. 230E)



Cod. 1.21.21000 1.21.22000 1.21.23000 1.21.24000

**Art. 230B**

Piastra ganascia intercambiabile dolce  
Soft interchangeable jaw plate



Cod. 4.23.0B101 4.23.0B201 4.23.0B301 4.23.0B401

**Art. 230F**

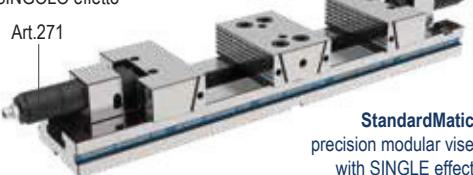
Piastra ganascia intercambiabile prismatica  
Prismatic interchangeable jaw plate



Cod. 4.23.0F101 4.23.0F201 4.23.0F301 4.23.0F401

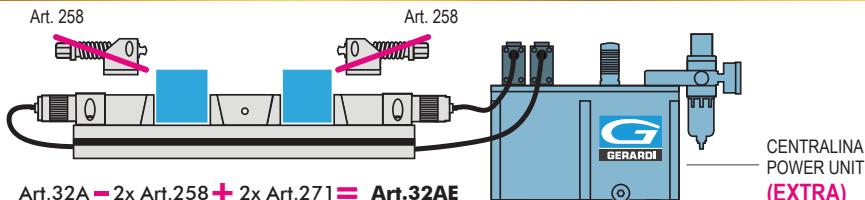
**Art.30AE**

Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto



StandardMatic precision modular vise with SINGLE effect hydraulic cylinder

Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

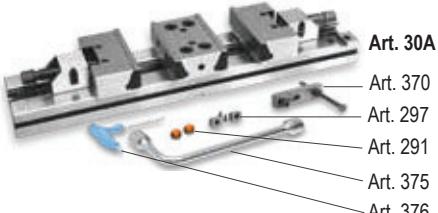
**MORSE StandardMatic**

Dotazione standard:

- 1 arresto laterale Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 2 tappi Art. 291 ■ 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

Extra per ogni foro calibrato (toleranza F7)

Extra per ogni chiaffetta (toleranza H7)



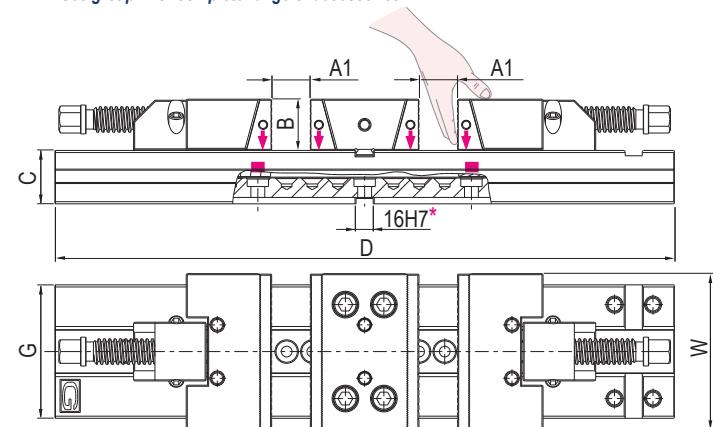
Standard equipment:

- 1 workstop Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 2 inserts Art. 291 ■ 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

Extra charge for each calibrated hole (F7 tolerance)

Extra charge for each calibrated key nut (H7 tolerance)

Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories



\* Versione normale: Cave da 16H7 e fori calibrati Ø8F7 (t.1) - Ø16F7 (t.2 - 3 - 4 - 5 - 6)

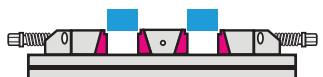
\* Normal version: 16H7 slot and calibrated holes Ø8F7 (t.1) - Ø16F7 (t.2 - 3 - 4 - 5 - 6)



5 40 kN							6 40 kN						
A1	2 x 150	2 x 200	2 x 250	2 x 300	2 x 350	2 x 160	2 x 210	2 x 260	2 x 310	2 x 360	2 x 410	2 x 460	
W		196							296				
B			63						78				
C			70						78				
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500	
G			170						195				
kg	64	69	74	79	84	95	105	115	125	135	145	155	
Cod.	2.30.A5150	2.30.A5200	2.30.A5250	2.30.A5300	2.30.A5350	2.30.A6160	2.30.A6210	2.30.A6260	2.30.A6310	2.30.A6360	2.30.A6410	2.30.A6460	

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.23.0E501

**Art. 230E**

4.23.0E601

H

53

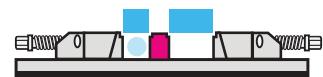
H1

10

68

10

1.21.25000

**Art. 212**

1.21.26000

4.23.0B501

**Art. 230B**

4.23.0B601

4.23.0F501

**Art. 230F**

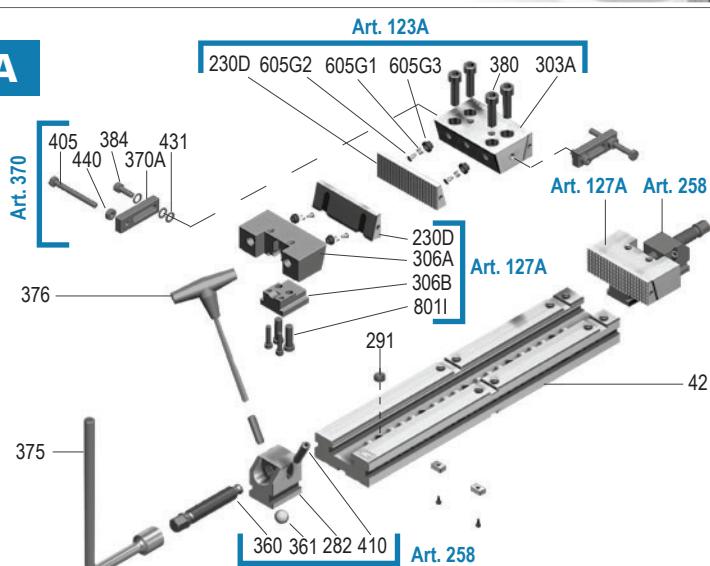
4.23.0F601

Cod.

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**
**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**

Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 30A****Art.****Pag.****42**

2.32

**230D**

4.21

**282**

4.36

**291**

4.35

**297**

4.34

**303A**

4.30

**306A**

4.30

**306B**

4.30

**360**

4.36

**361**

4.36

**370A**

4.35

**375**

4.35

**Art.****Pag.****376**

4.35

**380**

4.28

**384**

4.28

**405**

4.35

**410**

4.36

**431**

4.28

**440**

4.28

**605G1**

4.22

**605G2**

4.22

**605G3**

4.22

**801I**

5.61

**-****-**

## Tipo (grandezza) / Type (size)

1

2

3

4

## Art. 42

Slittone base serie XL  
senza alcuna dotazioneVise base XL series  
supplied without any accessory

D	450	520	580	680	666	766	866	966
kg	6.6	10.7	20.7	24.7	30.2	34.8	39.3	43.8
Cod.	1.80.11460	1.80.21520	1.80.31580	1.80.31680	1.80.41666	1.80.41766	1.80.41866	1.80.41966

Versione normale: Cave da 16 mm (H7)

Versione opzionale: Fori rettificati e calibrati con tolleranza F7

Extra per ogni foro calibrato (Tolleranza F7)

## Art. 42Z

Slittone base serie Zero Point  
senza alcuna dotazioneVise base Zero Point series  
supplied without any accessory

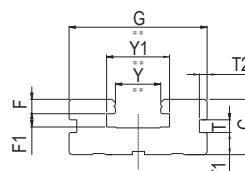
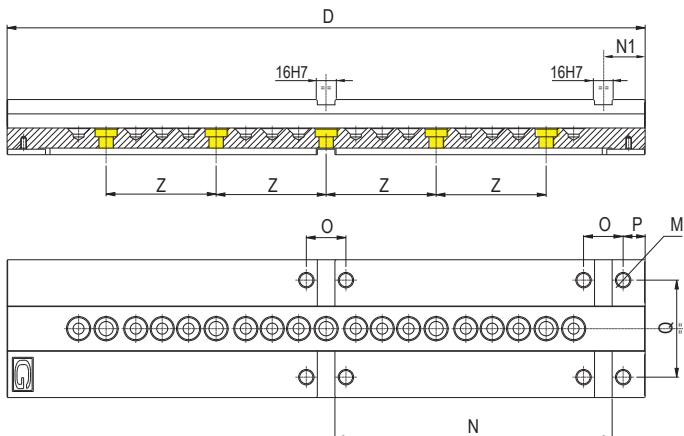
D	450	520	580	680	666	766	866	966
kg	6.4	10.5	20.5	24.5	29.9	34.5	39	43.5
Cod.	2.42.Z1460	2.42.Z2520	2.42.Z3580	2.42.Z3680	2.42.Z4666	2.42.Z4766	2.42.Z4866	2.42.Z4966

## Tolleranza / Tolerance

- 0,02	C	35	40	50			38		
	D	450	520	580	680	666	766	866	966
	F	10	12	13				15	
	F1	10	10	12				18	
	G	75	95	125				145	
	Y	21	28	41				51	
	Y1	31	41	57				70	
	M	M10	M12	M14				M16	
	N	195	225	252	302	293	343	393	443
	N1	35	35	38				40	
	O	32	32	36				36	
	P	19	19	20				22	
	Q	50	62	88				100	
	T	9,5	9,5	11,5				11,5	
	T1	15	15	20				20	
	T2	5	5	7				7	
	Z	100	100	100				100	

## Art. 42

Slittone base serie XL / Vise base XL series



## Dettaglio foro per vite TCEI / TCEI screw hole details

Type	1	2	3	4	5	6
X	4,5	5,5	8	8	17	17
Ø Y	6,5	8,5	13	13	17	17
Ø K	10,5	13,5	19	19	26	26

	5						6					
D	805	905	1005	1105	1205	900	1000	1100	1200	1300*	1400*	1500*
kg	64	69	74	79	84	95	105	115	125	135	145	155
Cod.	1.80.51805	1.80.51905	1.80.51005	1.80.51105	1.80.51205	1.80.61900	1.80.61000	1.80.61100	1.80.61200	1.80.61300	1.80.61400	1.80.61500

Normal version: 16 mm slots (H7)

Optional version: Ground calibrated holes F7 tolerance

Extra for each calibrated hole (F7 tolerance)

\* Base composta da 2 pezzi uniti

Base made of 2 spliced pieces

D	805	905	1005	1105	1205	900	1000	1100	1200	*1300	*1400	*1500
kg	60	65	70	75	80	91	101	111	121	131	141	151
Cod.	2.42.Z5805	2.42.Z5905	2.42.Z5005	2.42Z5105	2.42.Z5205	2.42.Z6900	2.42.Z6100	2.42.Z6110	2.42.Z6120	2.42.Z6130	2.42.Z6140	2.42Z6150

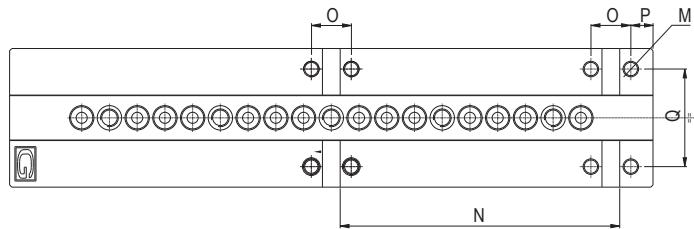
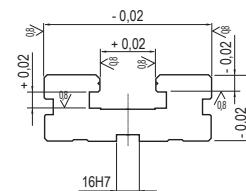
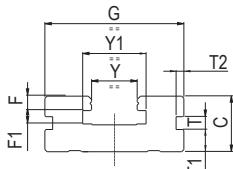
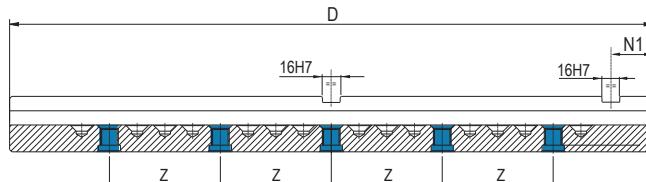
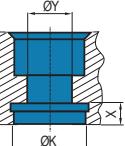
\* Base composta da 2 pezzi uniti  
Base made of 2 spliced pieces

C	70								58			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
F			20						20			
F1			18						18			
G			170						195			
Y			61						71			
Y1			80						90			
M			M20						M20			
N	357,5	407,5	457,5	507,5	557,5	405	455	505	555	605	655	707
N1			45						45			
O			44						44			
P			23						23			
Q			120						133			
T			17,5						17,5			
T1			26						26			
T2			10						10			
Z			100						100			

**Art. 42Z**

Slittone base serie Zero Point / Vise base Zero Point series

Tolleranze generiche per morse XL / XL vise generic tolerances

**Dettaglio foro per Zero Point / Zero Point hole details**

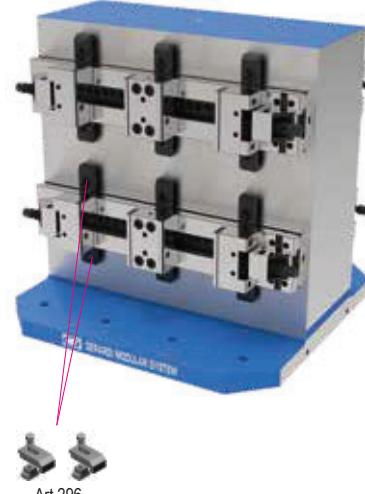
Type	1	2	3	4	5	6
X						6

	Y	M16	M16	M16	M16	M16
Ø K					20	

## PREDISPOSIZIONE e MONTAGGIO MORSE su SPALLE LAVORATE

### TOMBSTONES SET-UP and VISES MOUNTING on 2 SIDE MACHINED TOMBSTONES

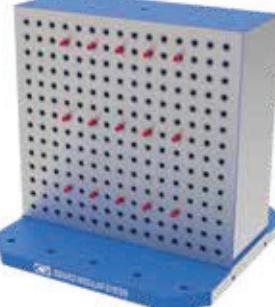
Spalla lavorata Art.55C 2 sides machined tombstone Art.55C	Tipo di morsa Vise type	Predisposizione e montaggio* Set-up & Mounting*	Cubo con morse Cube with vises
<p>Cod. 8.55.C00191 Dim. A=800 / B=800 / C=300 / H=800</p>  <p>A: 800, B: 800, C: 300, H: 800</p>	<p>Art.35 Tipo 4 2x170</p>  <p>n°morse Vises n°</p> <p>x 4</p>	<p>Per morsa / each vise</p>  <p>Importo per lavorazioni necessarie per predisporre ogni faccia del cubo e montaggio più allineamento di ogni morsa. Amount needed for the set-up of each side and mounting + alignment of each vise on it.</p>	 <p>Art.296</p>

\* Predisposizione 4 facce, montaggio ed allineamento morse incluso di viti, chiavette, staffe e quant'altro necessario.  
4 Faces set-up, vises mounting including screws, keyways, holding clamps and all the necessary equipment.

Certificato di collaudo  
Certificate test

## MONTAGGIO e ALLINEAMENTO MORSE su SPALLE a RETICOLO

### ALIGNEMENT and VISES MOUNTING on 2 SIDE GRID TOMBSTONES

Spalla a reticolo Art.55F 2 sides grinded tombstone Art.55F	Tipo di morsa Vise type	Montaggio e allineamento* Mounting & alignment*	Cubo con morse Cube with vises
<p>Cod. 8.55.F00191 Dim. A=800 / B=800 / C=300 / H=800</p>  <p>A: 800, B: 800, C: 300, H: 800</p>	<p>Art.35 Tipo 4 2x170</p>  <p>n°morse Vises n°</p> <p>x 6</p>	<p>Per morsa / each vise</p>  <p>Importo per montaggio ed allineamento di ogni morsa. Amount need for each vise mounting and alignment.</p>	 <p>Art.83</p>

\* Montaggio e allineamento 4 morse incluso di viti, chiavette, staffe e quant'altro necessario.  
4 vises mounting and alignment includes screws, keyways, holding clamps and all the necessary equipment.

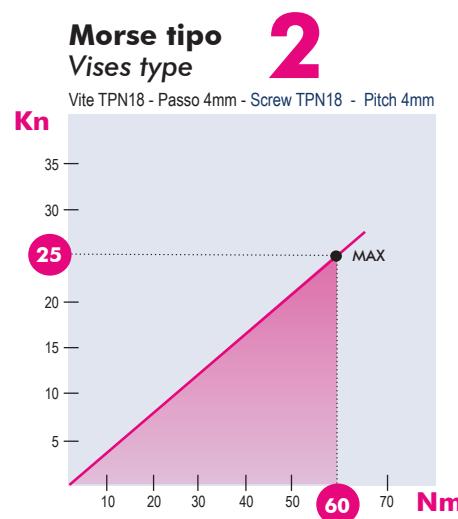
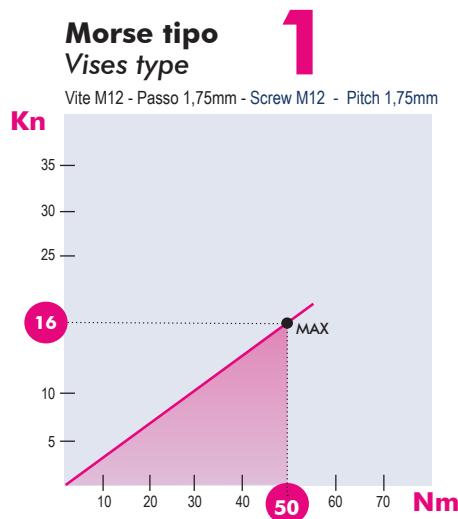
Certificato di collaudo  
Certificate test

# Diagrammi di serraggio / Clamping diagrams

## XL extra long bases

2

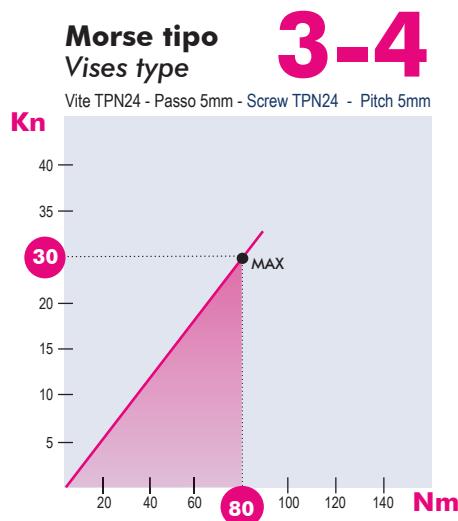
### Diagrammi di serraggio meccanico con chiave dinamometrica Mechanical clamping diagrams with torque wrench



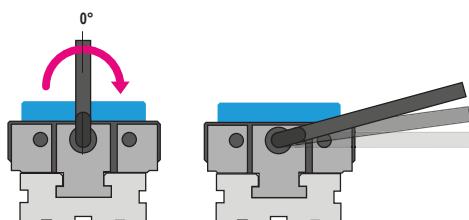
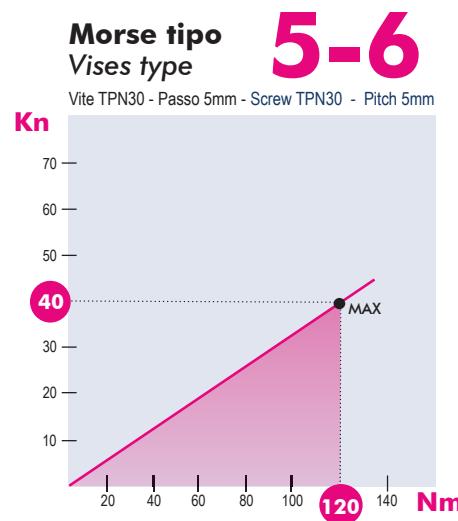
Art. 357

### Gruppi di serraggio meccanici (Art. 258 e simili) / Mechanical clamping devices (Art. 258 and similar)

I diagrammi seguenti consentono di determinare le forze di serraggio ottenibili con le morse di varia grandezza (da 1 a 6), in funzione del momento applicato  
The following diagrams give the clamping force that can be obtained with each vise type (size 1 to 6) depending on the torque



Art. 357



Serrare il pezzo agendo sulla vite di spinta con la chiave in dotazione senza utilizzare tubi o martelli.  
Attenzione: nel serraggio basta 1/4 di giro della chiave dal momento in cui la ganascia tocca il particolare.

Clamp the workpiece turning clockwise the main spindle through the box wrench without using tubes or hammers. Attention: for the right clamping operation 1/4 of a turn of the box wrench is enough

Type (Size)	1	2	3	4	5	6
Kn	12	26	36	46	50	50

Valori indicativi Kn raggiunte a 90°  
Kn indicative values at 90°

NB: Alcuni fattori, come la lubrificazione, lo staffaggio, gli attriti ed altro, possono modificare i valori indicati fino a ± 10%. Per un corretto utilizzo non superare i valori indicati nel grafico  
Some factor as lubrication, clamping on the machine table, frictions and more can modify above values within a ± 10% range. For optimum operation do not exceed chart values.

# CONTROLLO ALLINEAMENTO TRA CAVA TRASVERSALE E GANASCIA FISSA

## ALIGNEMENT BETWEEN THE CROSS KEYWAY AND THE FIXED JAW PLATE



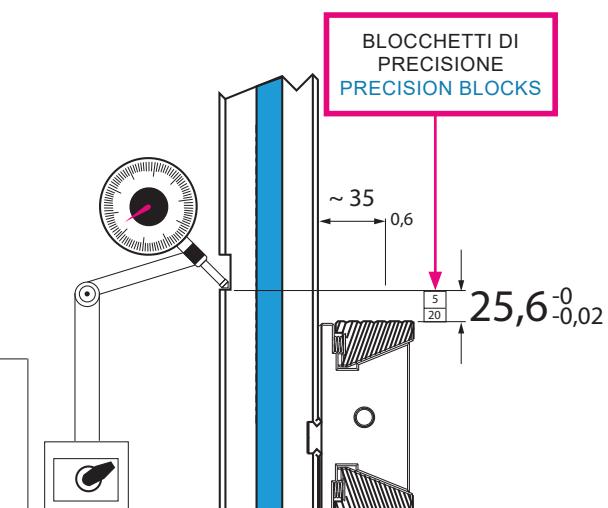
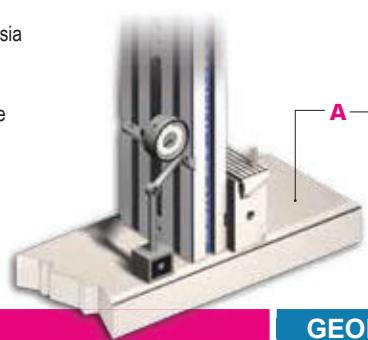
### Libretto Istruzioni / Instruction Book

Scansiona il QR code e scarica le istruzioni complete

Scan the QR code to download the complete instructions

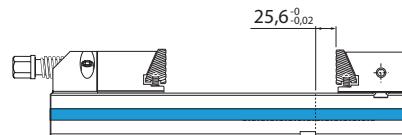
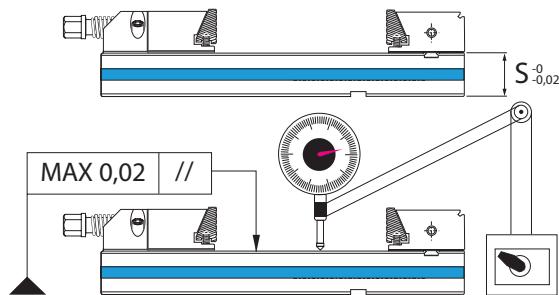
Posizionare la morsa verticalmente assicurandosi che sia perfettamente parallela al piano di appoggio **A** nei due sensi. Successivamente, con un comparatore centesimale, controllare il parallelismo del piano cava e della ganascia fissa.

Set the vise vertically ensuring that it is perfectly at parallel to the table **A** in both sides. Then with an indicator check the parallelism of the keyway and its alignment with the fixed jaw plate.



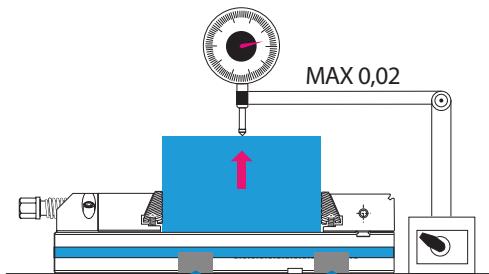
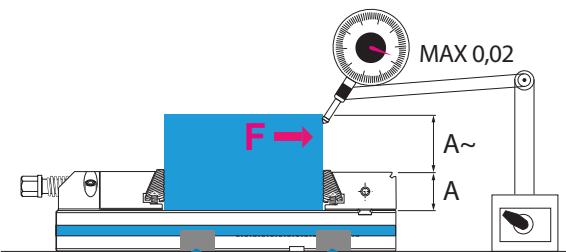
### TOLLERANZE GEOMETRICHE

### GEOMETRIC ACCURACIES



### TOLLERANZE DINAMICHE

### DYNAMIC ACCURACIES

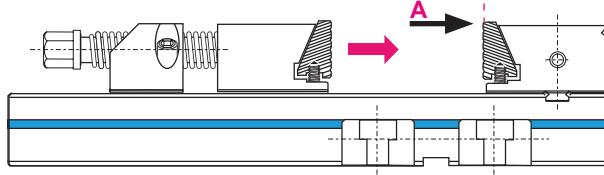


Morsa ancorata con 2 coppie di staffe Art.296 / Vise clamped with n. 2 pairs of Art.296

Valori di flessione nel punto "A" in relazione alle forze di serraggio **PER MORSE TIPO 3**

Deflection values at "A" in relation to clamping powers **FOR TYPE 3 VISES**

$$1 \text{ kgf} \cdot \text{m} = 9.806 \text{ Nm}$$



Kn	mm
60	0.1
50	0.07
40	0.05
30	0.03
20	0.02
10	0.01
5	0.004
2	0.002

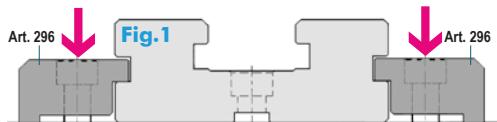
Il sistema consigliato per l'ancoraggio della morsa sulla tavola macchina è tramite STAFFE Art.296. (Fig.1)

E' possibile ancorare la morsa tramite viti centrali, ma in questo caso la quota X potrebbe flettere e compromettere lo scorrimento della ganascia mobile. (Fig.2)

Nella tabella seguente sono riportati i valori di coppia massima applicabile mediante chiave dinamometrica

We recommend to fix the vises to the machine table using clamps Art. 296. (Fig. 1) The vise can be also fixed by means of central screws, but, this way, the X quota may suffer a bending and compromise the sliding of the movable jaws. (Fig. 2)

In the following table you can find the maximum torque values applicable through torque wrench.



Vite / Screw	M8	M10	M12	M16
Torque Nm	40	80	140	345

