



Precision Clamping Solutions

Unlock the hidden capacity of your machining centre



REDUCE SET-UP TIMES



IMPROVE CYCLE TIMES



REDUCE SCRAP PARTS



FREE WORKHOLDING AUDIT

TECHNICAL SUPPORT

For all workholding projects, with custom turnkey solutions available, tailored to your exact machining requirements.



AUTOWELL



WÜLF

☎ 03330 389849 ✉ sales@cutwel.net 🔍 cutwel.co.uk

**PERFORMANCE.
DELIVERED.**



Unlock hidden capacity with smarter workholding

With over 20 years of hands-on industry expertise, Cutwel specialises in workholding and toolholding solutions. We help manufacturers unlock hidden capacity within their machine tools by reviewing existing workholding concepts and identifying opportunities to improve efficiency, productivity and output.

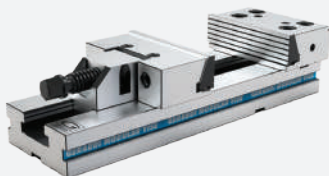
From one-off components to complex turnkey and modelling projects, Cutwel works alongside market-leading partners worldwide to deliver effective, tailored solutions.

Our specialists will review your current set-up and identify practical ways to reduce set-up times, improve cycle times, minimise scrap and maximise your machining capacity.



Scan to request your free workholding audit

STANDARD SERIES MODULAR MACHINE VICES



Gerardi's original modular vice system, available in jaw widths 100-300mm. Accurate, rigid and fully interchangeable for clamping a wide range of workpiece sizes with reduced set-up time.

STANDARD SERIES XL MODULAR MACHINE VICES

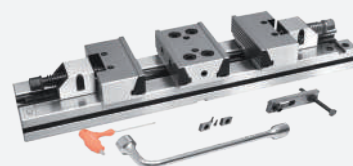
Up to 1100mm opening
Jaw widths from 100-300mm



Long base modular vices for larger components and wider openings. Can be changed from single to double clamping, helping maximise table space and improve productivity.

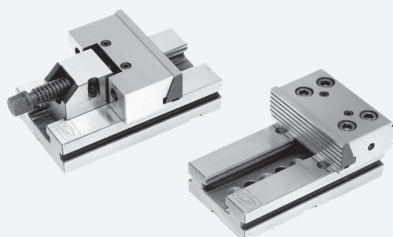
STANDARD SERIES DOUBLE XL MACHINE VICES

2x components up to 460mm each



Extra long double clamping vices for machining more workpieces across the full machine bed. Ideal for increasing output on long tables while keeping Gerardi modular accuracy.

STANDARD SERIES MODULAR ELEMENTS VICES



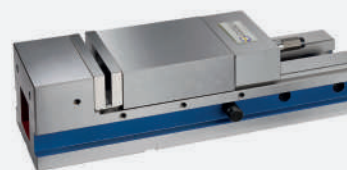
Independent fixed and movable vice sections for large or awkward workpieces. Use the machine table as the clamping surface for heavy machining with $\pm 0.02\text{mm}$ accuracy.

AUTOWELL TRADITIONAL MACHINE VICES



Economical solution for general machining. Suitable for use on conventional or CNC mills, they are simple to use and offer good clamping forces, repeatability and durability.

HYDRAULIC MACHINE VICES



High force clamping vices for demanding machining where secure, repeatable holding is essential. Ideal for tougher applications needing consistent pressure and rigidity.

COMPACTGRIP SELF-CENTRING VICES & ZERO POINT PLATES

Workpiece clamping up to 333mm



Compact 5-axis self-centring vices for machining on 5 sides of the workpiece. Space saving, highly rigid and compatible with popular pallet and Zero Point systems.

COMPACTGRIP SECOND OP SELF-CENTRING VICES



Compact self-centring 5-axis vice with machinable solid jaws for custom workholding, secure clamping and accurate multi-sided machining.

WULF GRIP SELF-CENTRING VICES & ZERO POINT PLATES



Modular quick change clamping system with Zero Point plates & tombstones, self-centring vices, 3 jaw chucks, dovetail fixtures & ER collet clamps. Ideal for 3, 4 or 5-axis machining.

MULTIFLEX MODULAR MACHINE VICES

Jaw widths include 50, 75 and 100mm
Base lengths from 300-1000mm



A modular clamping system for holding several workpieces at the same time. Designed to maximise machine table capacity and reduce changeover times.

MULTIFLEX HORIZONTAL MODULAR MACHINE VICE TOWERS



MultiFlex tower set-ups help load more parts into each cycle. Ideal for increasing machine utilisation and reducing downtime between workpiece changes.

MULTIFLEX 4TH AXIS MODULAR MACHINE VICE TOWERS



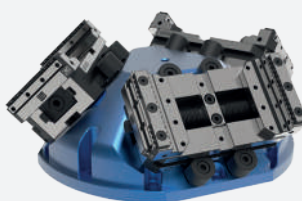
4th-axis modular towers for clamping multiple parts around the fixture. Built to improve access, reduce repeated set-ups and get more from rotary machining.

GRIPMATIC AUTOMATED SELF-CENTRING VICES



Automatic self-centring vices ready for CNC control, with pneumatic or hydraulic activation. Designed for robotic loading, 5-side machining and reliable repeatability.

5-AXIS PYRAMIDS



Tower workholding for loading multiple vices or workpieces in one set-up. Helps increase 5-axis machine capacity while keeping parts accessible from multiple faces.

MULTITASKING HEAVY DUTY 5-AXIS VICE



Heavy duty 5-axis vices for machining on 5 workpiece sides with strong rigidity, reduced deflection and excellent alignment. Built for demanding multi-face machining.

5G LARGE CAPACITY 5-AXIS VICE



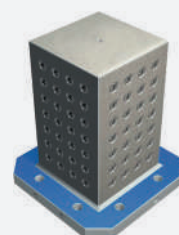
Advanced 5-axis vice with quick-change jaws, multiple base lengths and jaw heights. Offers up to 534mm opening and 190mm clamping height for varied workpiece sizes.

PNEUMATIC ZERO POINT



Fast positioning and clamping for vices, fixtures and workpieces. Pneumatic release with spring locking gives repeatability within 0.005mm and can reduce set-up time by up to 95%.

TOMBSTONES & CUBES



Rigid modular tombstones, cubes and sub-plates for horizontal and multi-pallet machining. Made from solid G30 cast iron with around 40mm wall thickness and stress-relieved construction.



Standard Series Modular Machine Vices



For workshops that demand better.

Gerardi Standard Series vices are the original modular machine vice system, built for accurate, rigid and repeatable clamping. With jaw widths ranging from **100mm** to **300mm**, the system accommodates a broad spectrum of workpiece dimensions while significantly reducing set-up time.

Featuring fully interchangeable components, matched vice bodies, and an extensive selection of jaws, bases, and accessories, the Standard Series provides a versatile workholding platform that scales with your evolving machining requirements.

✓ **100MM TO 300MM JAW WIDTHS**

✓ **HIGH ACCURACY $\pm 0.02\text{MM}$**

✓ **FULLY INTERCHANGEABLE SYSTEM**

✓ **RIGID MODULAR CLAMPING**

ONE MODULAR SYSTEM

With multiple clamping options. Interchangeable jaws, bases and accessories allow you to quickly adapt your vice to suit different workpiece sizes and machining applications, reducing set-up time and increasing output.



Accuracy
 $\pm 0.02\text{mm}$



Hardened
HRC 60 ± 2

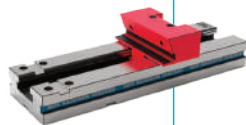
Supplied with each Standard Series Machine Vice:
1x workstop **ART. 370**
1x pair of positioning key-nuts for 16 mm slot **ART. 297**
1x box wrench **ART. 375**
1x T wrench **ART. 376**



PRISMATIC JAW

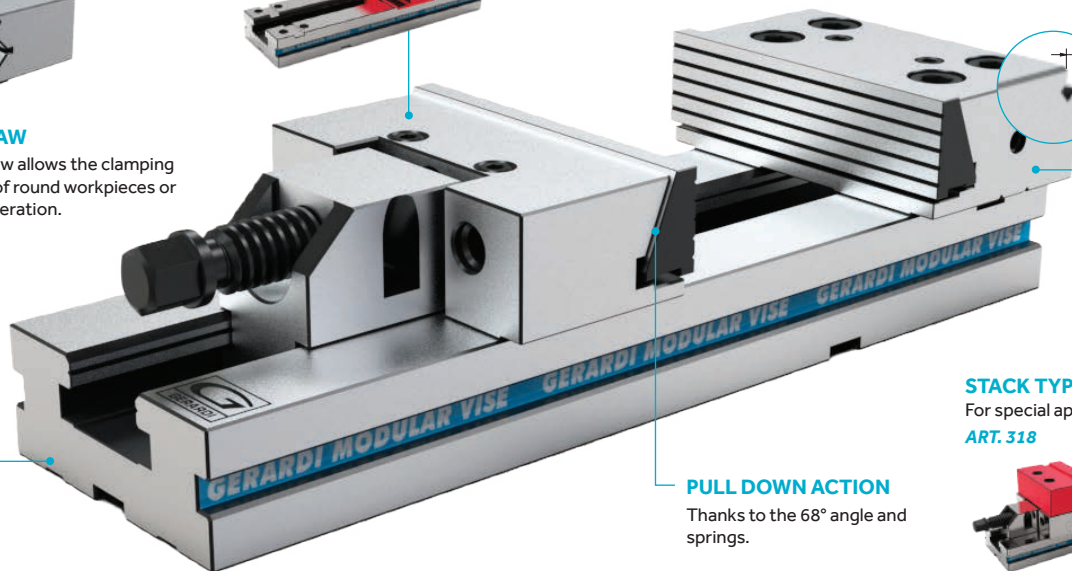
The prismatic jaw allows the clamping and machining of round workpieces or drill-through operation.

ART. 217



SOLID GUIDED JAWS

Both jaw bodies are built in one solid piece in order to guarantee higher rigidity & no bending. Both jaw plates are manufactured with a pull down angle.



5 mm

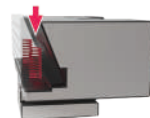
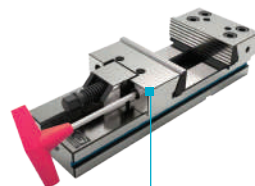
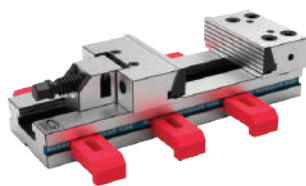
STACK TYPE JAW

For special applications.
ART. 318



PULL DOWN ACTION

Thanks to the 68° angle and springs.



HIGHEST

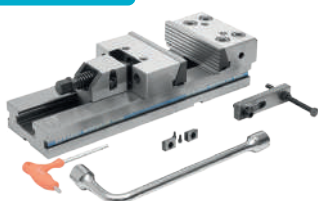
ACCURACIES $\pm 0.02\text{mm}$

Solid vice base. Every sliding and coupling surface is ground. Centred tolerances are guaranteed by checking cycles with CNC measuring machine.

Release the screw so the jaw plate will draw the workpiece downward.

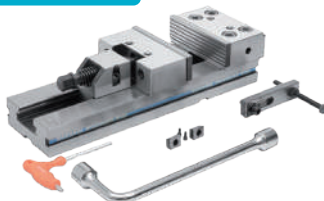
JAW CLAMPING & BASE OPTIONS

STANDARD BASE



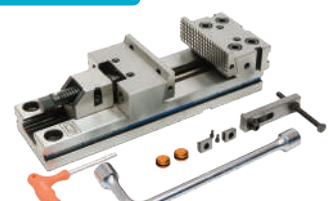
With Pull Down Jaws

STANDARD BASE



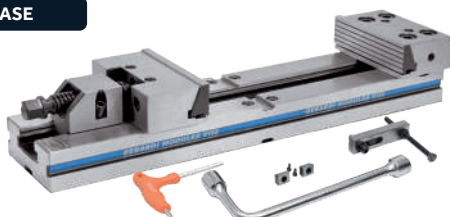
With Straight Plate Jaws

STANDARD BASE



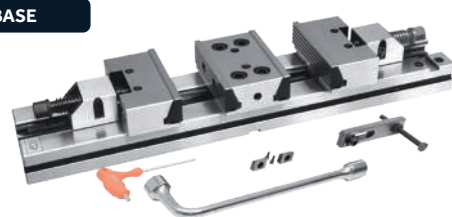
Quick Change With Pull Down Jaws

XL BASE



Single Clamping With Pull Down Jaws

XL BASE



Double Clamping With Pull Down Jaws



ART.1 STANDARD SERIES MODULAR MACHINE VICE - PULL DOWN

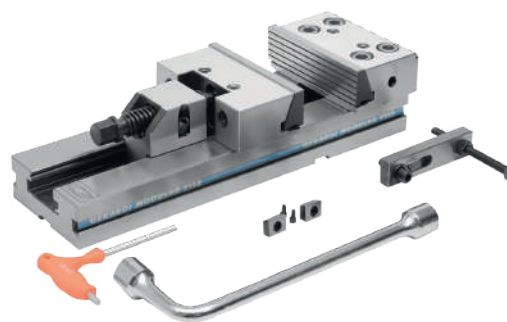
With Pull Down Serrated Hard Jaws

- Hardened to HRC60
- Fast & easy alignment with machine bed
- All working surfaces ground within 0.02mm



SUPPLIED WITH EACH VICE

- 1 workstop **ART.370**
- 4 table clamps
- 1 box wrench **ART.375**
- 1 T-wrench **ART.376**
- **ART.1:** Pair of positioning key-nuts **ART.297** (16mm)



Size	Jaw Width	Max Opening	Base Length	Base Width	Base Height	Jaw Height	kg	Order Code
1 (16kN)	100mm (4")	100	270	75	35	30	6.8	3.01.00000
2 (25kN)	125mm (5")	150	345	95	40	40	12.9	3.02.10000
3 (30kN)	150mm (6")	200	420	125	50	50	25.5	3.03.20000
		300	520				29	3.03.30000
4 (30kN)	175mm (7")	200	455	145	58	60	37	3.04.20000
		300	555				42	3.04.30000
		400	655				47	3.04.40000
		500	755				52	3.04.50000
5 (40kN)	200mm (8")	200	495	170	70	65	64	3.05.20000
		300	595				69	3.05.30000
		400	695				74	3.05.40000
		500	795				79	3.05.50000
6 (40kN)	300mm (12")	600	895	195	78	80	84	3.05.60000
		200	535				95	3.06.20000
		300	635				105	3.06.30000
		400	735				115	3.06.40000
		500	835				125	3.06.50000
		600	935				135	3.06.60000
		700	1035				145	3.06.70000
		800	1135				155	3.06.80000

ALL ACCESSORIES ARE SUITABLE FOR THE FOLLOWING VICES: ART.1, ART.1Z, ART.21. ART.30

ART.234

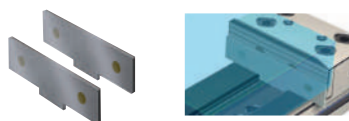
Soft jaw plates



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	1.65.10200	1.65.20200	1.65.30200	1.65.40200	1.65.50200	1.65.60200

ART.313

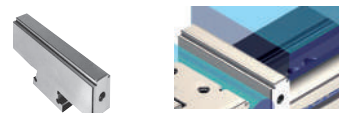
Magnetic parallel plates.
Available in different heights (pair)



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	4.31.31000	4.31.32000	4.31.33000	4.31.34000	4.31.35000	4.31.36000

ART.212

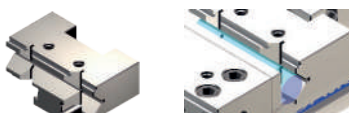
Intermediate movable jaw with step



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	1.21.21000	1.21.22000	1.21.23000	1.21.24000	1.21.25000	1.21.26000

ART.217

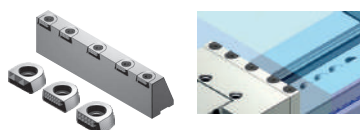
Prismatic movable jaw with step



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	2.21.71000	2.21.72000	2.21.73000	2.21.74000	2.21.75000	2.21.76000

ART.242G

Jaw plate with GRIP inserts (choose soft, std or hard material inserts)



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	1.24.2G100	1.24.2G200	1.24.2G300	1.24.2G400	1.24.2G500	1.24.2G600

ART.257

Clamping support with hydraulic cylinder



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	-	-	2.25.73000	2.25.74000	2.25.75000	2.25.76000



ART.1A STANDARD FLEX VICE - QUICK CHANGE JAWS

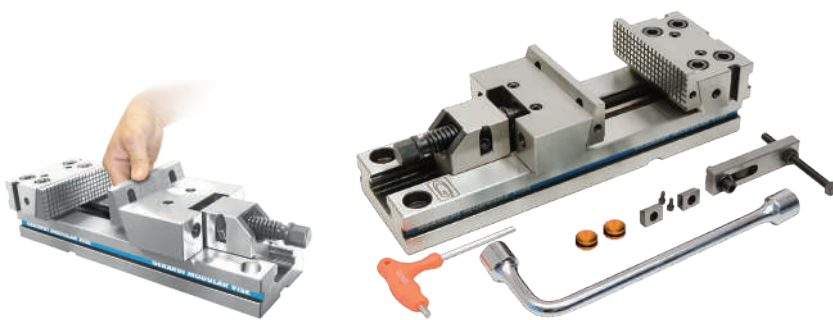
Quick Change Pull Down Jaws

- Hardened to HRC60
- Quick hand change jaws
- Fast & easy alignment with machine bed
- All working surfaces ground within 0.02mm



SUPPLIED WITH EACH VICE

- 1 workstop **ART.370**
- 4 table clamps
- 1 box wrench **ART.375**
- 1 T-wrench **ART.376**
- **ART.1:** Pair of positioning key-nuts **ART.297** (16mm)



Size	Jaw Width	Max Opening	Base Length	Base Width	Base Height	Jaw Height	kg	Order Code
1 (16kN)	96mm (4")	100	270	75	35	28	6.8	1.1A.10000
2 (25kN)	121mm (5")	150	345	95	40	38	12.9	1.1A.20000
3 (30kN)	146mm (6")	200	420	125	50	48	25.5	1.1A.32000
		300	520				29	1.1A.33000
4 (30kN)	171mm (7")	200	455	145	58	58	37	1.1A.42000
		300	555				42	1.1A.43000
		400	655				47	1.1A.44000
		500	755				52	1.1A.45000
		600	855				64	1.1A.52000
5 (40kN)	196mm (8")	300	595	170	70	63	69	1.1A.53000
		400	695				74	1.1A.54000
		500	795				79	1.1A.55000
		600	895				84	1.1A.56000
		700	995				95	1.1A.62000
6 (40kN)	296mm (12")	300	635	195	78	78	105	1.1A.63000
		400	735				115	1.1A.64000
		500	835				125	1.1A.65000
		600	935				135	1.1A.66000
		700	1035				145	1.1A.67000
		800	1135				155	1.1A.68000

ALL ACCESSORIES BELOW ARE SUITABLE FOR THE FOLLOWING VICES: ART.1A, ART.20A, ART.30A

ART.230B

Soft jaw plates



Size (W mm)	1 (96)	2 (121)	3 (146)	4 (171)	5 (196)	6 (296)
Order Code	4.23.0B101	4.23.0B201	4.23.0B301	4.23.0B401	4.23.0B501	4.23.0B601

ART.230E

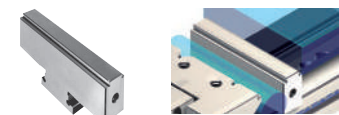
Step jaw (available in different step heights)



Size (W mm)	1 (96)	2 (121)	3 (146)	4 (171)	5 (196)	6 (296)
Order Code	4.23.0E101	4.23.0E201	4.23.0E301	4.23.0E401	4.23.0E501	4.23.0E601

ART.212

Intermediate movable jaw with step



Size (W mm)	1 (96)	2 (121)	3 (146)	4 (171)	5 (196)	6 (296)
Order Code	1.21.21000	1.21.22000	1.21.23000	1.21.24000	1.21.25000	1.21.26000

ART.230F

Prismatic jaw plate



Size (W mm)	1 (96)	2 (121)	3 (146)	4 (171)	5 (196)	6 (296)
Order Code	4.23.0F101	4.23.0F201	4.23.0F301	4.23.0F401	4.23.0F501	4.23.0F601

ART.230G

Stop jaw plate



Size (W mm)	1 (96)	2 (121)	3 (146)	4 (171)	5 (196)	6 (296)
Order Code	4.23.0G101	4.23.0G201	4.23.0G301	4.23.0G401	4.23.0G501	4.23.0G601

ART.257

Clamping support with hydraulic cylinder



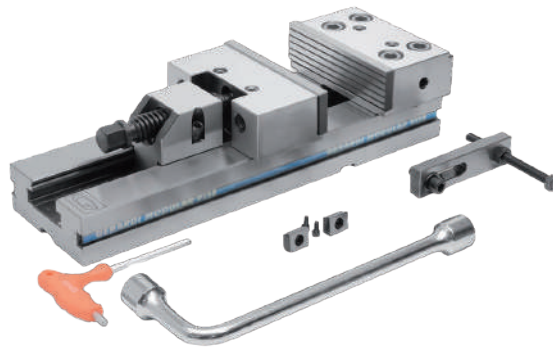
Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	-	-	2.25.73000	2.25.74000	2.25.75000	2.25.76000



ART.14 STANDARD SERIES VICE - STRAIGHT JAWS

With Straight Plate Jaws

- Hardened to HRC60
- Fast & easy alignment with machine bed
- All working surfaces ground within 0.02mm
- Straight jaw plates - Not pull down



Scan to Watch

SUPPLIED WITH EACH VICE

- 1 workstop **ART.370**
- 4 table clamps
- 1 box wrench **ART.375**
- 1 T-wrench **ART.376**
- Pair of positioning key-nuts **ART.297** (16mm)

Size	Jaw Width	Max Opening	Base Length	Base Width	Base Height	Jaw Height	kg	Order Code
1 (16kN)	100mm (4")	100	270	75	35	30	6.8	1.14.10000
2 (25kN)	125mm (5")	150	345	95	40	40	12.9	1.14.20000
3 (30kN)	150mm (6")	200	420	125	50	50	25.5	1.14.32000
		300	520				29	1.14.33000
4 (30kN)	175mm (7")	200	455	145	58	60	37	1.14.42000
		300	555				42	1.14.43000
		400	655				47	1.14.44000
		500	755				52	1.14.45000
5 (40kN)	200mm (8")	200	495	170	70	65	64	1.14.52000
		300	595				69	1.14.53000
		400	695				74	1.14.54000
		500	795				79	1.14.55000
		600	895				84	1.14.56000
6 (40kN)	300mm (12")	200	535	195	78	80	95	1.14.62000
		300	635				105	1.14.63000
		400	735				115	1.14.64000
		500	835				125	1.14.65000
		600	935				135	1.14.66000
		700	1035				145	1.14.67000
		800	1135				155	1.14.68000

ALL ACCESSORIES BELOW ARE SUITABLE FOR THE FOLLOWING VICES: ART.14, ART.24, ART.34

ART.246

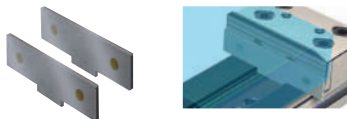
Soft jaw plates



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	1.65.16200	1.65.26200	1.65.36200	1.65.46200	1.65.56200	1.65.66200

ART.313

Magnetic parallel plates.
Available in different heights (pair)



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	4.31.31000	4.31.32000	4.31.33000	4.31.34000	4.31.35000	4.31.36000

ART.212

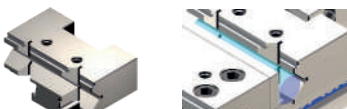
Intermediate movable jaw with step



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	1.21.21000	1.21.22000	1.21.23000	1.21.24000	1.21.25000	1.21.26000

ART.217

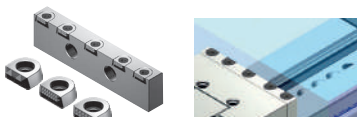
Prismatic movable jaw with step



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	2.21.71000	2.21.72000	2.21.73000	2.21.74000	2.21.75000	2.21.76000

ART.246G

Jaw plate with GRIP inserts (choose soft, std or hard material inserts)



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	1.24.6G100	1.24.6G200	1.24.6G300	1.24.6G400	1.24.6G500	1.24.6G600

ART.257

Clamping support with hydraulic cylinder



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	-	-	2.25.73000	2.25.74000	2.25.75000	2.25.76000



ART.21/ART.30 STANDARD SERIES XL & XL DOUBLE MODULAR MACHINE VICE - PULL DOWN

With Pull Down Jaws

- Hardened to HRC60
- Fast & easy alignment with machine bed
- All working surfaces ground within 0.02mm
- XL base



SUPPLIED WITH EACH VICE

- 1 workstop **ART.370** (2 with **ART.30**)
- Pair of positioning key-nuts **ART.297** (16mm)
- 1 box wrench **ART.375** - 1 T-wrench **ART.376**
- 8 table clamps

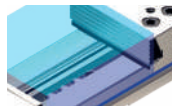
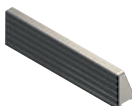


Size	Jaw Width	Base Length	Base Width	Base Height	Jaw Height	ART.21 (XL)			ART.30 (XL Double)		
						Max Opening	kg	Order Code	Max Opening	kg	Order Code
1 (16kN)	100mm (4")	460	75	35	30	290	10	2.21.12900	2x 90	14.5	3.31.00600
2 (25kN)	125mm (5")	520	95	40	40	320	17	2.21.23200	2x 100	21	3.32.10600
3 (30kN)	150mm (6")	580	125	50	50	360	32	2.21.33600	2x 110	39	3.33.20600
		680				460	35	2.21.34600	2x 160	43	3.33.30600
4 (30kN)	175mm (7")	666	145	58	60	400	47	2.21.44000	2x 120	59	3.34.20600
		766				500	52	2.21.45000	2x 170	64	3.34.30600
		866				600	56	2.21.46000	2x 220	69	3.34.40600
		966				700	61	2.21.47000	2x 270	74	3.34.50600
5 (40kN)	200mm (8")	805	170	70	65	500	64	2.21.55000	2x 150	96	3.35.20600
		905				600	69	2.21.56000	2x 200	102	3.35.30600
		1005				700	74	2.21.57000	2x 250	108	3.35.40600
		1105				800	79	2.21.58000	2x 300	114	3.35.50600
		1205				900	84	2.21.59000	2x 350	120	3.35.60600
6 (40kN)	300mm (12")	900	195	78	80	500	95	2.21.65000	2x 160	155	3.36.20600
		1000				600	105	2.21.66000	2x 210	163	3.36.30600
		1100				700	115	2.21.67000	2x 260	171	3.36.40600
		1200				800	125	2.21.68000	2x 310	179	3.36.50600
		1300				900	135	2.21.69000	2x 360	187	3.36.60600
		1400				1000	145	2.21.61000	2x 410	195	3.36.70600
		1500				1100	155	2.21.61100	2x 460	213	3.36.80600

ALL ACCESSORIES BELOW ARE SUITABLE FOR THE FOLLOWING VICES: ART.1, ART.1Z, ART.21, ART.30

ART.230

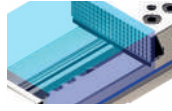
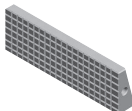
Hardened grooved jaw plates



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	1.65.10000	1.65.20000	1.65.30000	1.65.40000	1.65.50000	1.65.60000

ART.230S

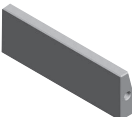
Hardened serrated jaw plates



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	4.23.0S100	4.23.0S200	4.23.0S300	4.23.0S400	4.23.0S500	4.23.0S600

ART.232

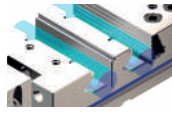
Hardened smooth jaw plates



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	1.65.10100	1.65.20100	1.65.30100	1.65.40100	1.65.50100	1.65.60100

ART.214

Prismatic intermediate jaw with step



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	1.21.41000	1.21.42000	1.21.43000	1.21.44000	1.21.45000	1.21.46000

ART.314

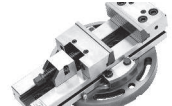
Magnetic angle plates (pair) 20°, 25°, 30°, 35°, 40° or 45°, please specify when ordering



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	4.31.41000	4.31.42000	4.31.43000	4.31.44000	4.31.45000	4.31.46000

ART.105

Swivel base



Size (W mm)	1 (100)	2 (125)	3 (150)	4 (175)	5 (200)	6 (300)
Order Code	2.10.51000	2.10.52000	2.10.53000	2.10.54000	2.10.55000	2.10.56000

Machine Vices

Perfect for everyday machining.

AutoWell machine vices offer an economical solution for general machining. Suitable for use on conventional or CNC mills, they are simple to use and offer good clamping forces, repeatability and durability.



'ATD/ATW SERIES' WELL-LOCK MACHINE VICE

With Straight Plate Jaws

- Pull down jaws
- Ductile iron FCD-60 base, flame-hardened to HRC65
- Hardened steel jaw plates
- 4 different clamping positions
- For manual or CNC machines
- High clamping forces
- 0.01mm accuracy



Jaw Width	Max Opening	Base Length	Base Width	Base Height	Jaw Height	kg	Order Code
102 (4")	153	321	160	57.15	35	13	ATD-460
126 (5")	178	368	194	63.5	38.1	21	ATD-570
151 (6")	192	432	235	73.02	44.5	36	ATW-675A
151 (6")	226	437	222	73.02	44.5	36	ATW-689A
206 (8")	265	555	295	84.07	56	68	ATW-810A



'MG SERIES' WELL-LOCK CNC MACHINE VICE

- Pull down jaws
- Chip guard on base ensures easy maintenance
- Ductile iron FCD-60 base, flame-hardened to HRC65
- Hardened steel jaw plates
- Vertical or horizontal positioning
- High clamping forces
- 0.01mm accuracy



Jaw Width	Max Opening	Base Length	Base Width	Base Height	Jaw Height	kg	Order Code
102 (4")	130	316	104	63.5	35	20	MG-40
151 (6")	163	385	152.45	81	44.5	31	MG-60G



'TLD SERIES' DOUBLE-LOCK CNC MACHINE VICE

- Pull down jaws
- Double station can clamp two different-sized workpieces at the same time
- Ductile iron FCD-60 base, flame-hardened to HRC65
- Hardened steel jaw plates
- 6 clamping positions
- High clamping forces
- 0.01mm accuracy



Jaw Width	Max Opening	Base Length	Base Width	Base Height	Jaw Height	kg	Order Code
102 (4")	90x2 / 235x1	405	104	63.5	38	20	TLD-40G
151 (6")	125x2 / 316x1	520	154	82.55	44.5	52	TLD-60G

Hydraulic Machine Vices

Consistent & repeatable clamping.

Hydraulic vices offer an advantage over traditional mechanical vices due to their ability to use pressurised fluid to generate immense, consistent clamping force.

cutwel **PRO**

HYDRAULIC MACHINE VICE

Camlock Mount

- Cast iron base with steel jaws
- 1 year guarantee



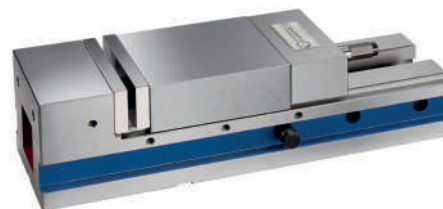
Jaw Width	Max Opening	Length With Wrench	Base Length	Jaw Height	Body Width	Base Width	Overall Height	Base Height	Order Code
105	170	525	440	36	135	170	95	58	HV-100
130	220	670	550	48	175	207	120	70.5	HV-130
150	300	800	620	53	182	225	135	82.5	HV-150
200	300	900	680	62	260	280	162	100	HV-200

cutwel **PRO**

HYDRAULIC MACHINE VICE

Standard Model

- Vice body is made of ductile iron FCD60, vice bed hardened to HRC45 to maintain accuracy
- Vice can side-lock to work (Perpendicular of side lock 90° = 0.015/100mm)
- 1 year guarantee



Jaw Width	Max Opening	Base Length	Base Height	Jaw Height	Overall Height	kg	Order Code
105	170	404	62	42	102	22	MHA-100
152	300	507	85	57	140	52	MHA-150A
200	300	606	95	62	162	80	MHA-200

cutwel **PRO**

HYDRAULIC MACHINE VICE

Pre-Settable High End Model

- Vice body is made of ductile iron FCD60, vice bed hardened to HRC45 to maintain accuracy
- Hydraulic or mechanical operation
- Clamping force can be pre-set
- Vice can side-lock to work. (Perpendicular of side lock 90° = 0.015/100mm)
- 1 year guarantee



Jaw Width	Max Opening	Overall Length	Base Height	Base Length	Overall Height	kg	Order Code
102	125	475	85	340	130	27	MHV-100
132	200	558	95	423	147	40	MHV-130
162	240	632	105	497	160	60	MHV-160



Modular Elements

For extra-large, wide or long workpieces.

Gerardi Modular Elements reduce set-up times and improve clamping accuracy for large workpieces that exceed standard vice capacity. Their precision-ground cross keyways enable fast, accurate machine table positioning, delivering quicker, more repeatable set-up.



Powerful, Durable & Rigid

- ✓ 30kN clamping force with a 1/4 final turn of the wrench (size 3 vice, 150mm jaw width).
- ✓ Manufactured from 60 Rockwell case hardened alloy steel with no wear. Extreme rigidity & the most secure clamping.

Speed

- ✓ Ground cross keyways on the base enable accurate positioning on the machine bed in seconds.

Modular

- ✓ With dozens of accessories including jaws, parallel plates and automated clamping systems, standard series vices are capable of clamping almost anything.

Precision

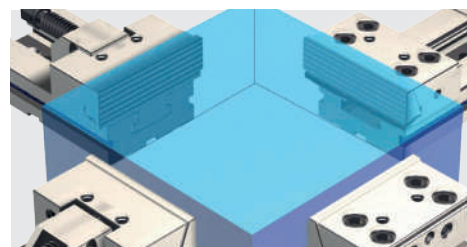
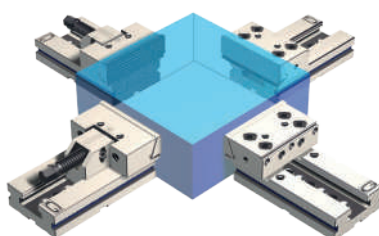
- ✓ All working surfaces ground within +0.01mm (overall accuracy +0.02mm). Market leading repeatability for a mechanical clamping vice.

STANDARD SERIES MODULAR ELEMENTS APPLICATION EXAMPLES

EXAMPLE 1

Clamping large workpiece on 4 sides, clamped directly on machine table using:

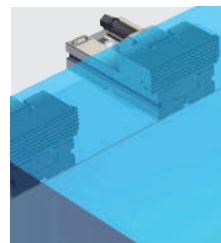
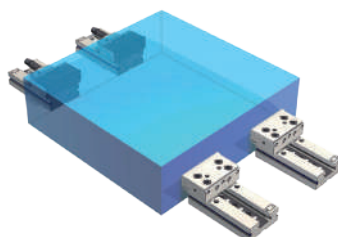
2x ART102 & 2x ART103



EXAMPLE 2

Clamping large workpiece on 2 sides, clamped directly on machine table using:

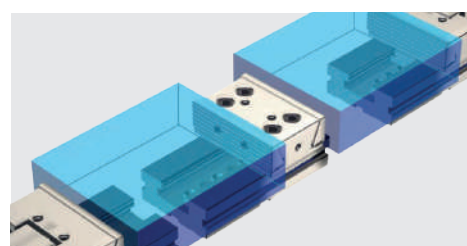
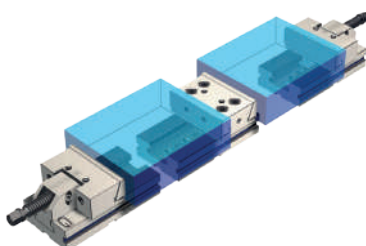
2x ART102 & 2x ART103



EXAMPLE 3

Clamping 2 workpieces using 3 modular elements, raised above the bed & sat on top of the vice base:

2x ART102 & 1x ART104





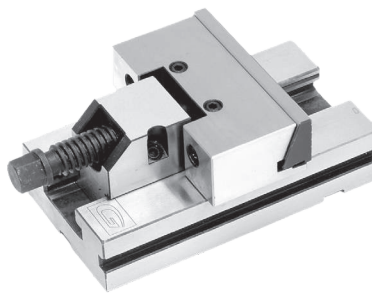
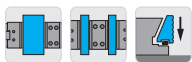
ART.102 MODULAR ELEMENT MOVABLE JAW

Section with Pull Down Jaws

- Hardened to HRC60
- Fast & easy alignment with machine bed through ground cross keyways and positioning keys (no need to clock jaws!)
- All working surfaces ground within 0.02mm
- Ideal for extra large, wide or long workpieces

SUPPLIED WITH EACH VICE

- Pair of positioning key-nuts **ART.297** (16mm)



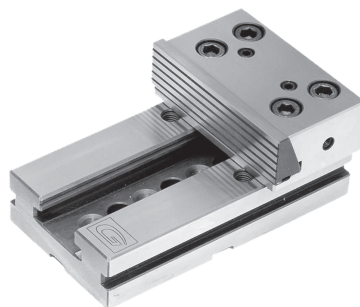
Size	Jaw Width	Base Length	Base Width	Base Height	Jaw Height	kg	Order Code
1 (16kN)	100 (4")	140	75	35	30	3.4	2.10.21000
2 (25kN)	125 (5")	160	95	40	40	6.3	2.10.22000
3 (30kN)	150 (6")	230	125	50	50	14.2	2.10.23000
4 (30kN)	175 (7")	240	145	58	60	20.8	2.10.24000
5 (40kN)	200 (8")	300	170	70	65	35	2.10.25000
6 (40kN)	300 (12")	350	195	78	80	60	2.10.26000



ART.103 MODULAR ELEMENT FIXED JAW SECTION

With Pull Down Jaws

- Hardened to HRC60
- Fast & easy alignment with machine bed through ground cross keyways and positioning keys (no need to clock jaws!)
- All working surfaces ground within 0.02mm
- Ideal for extra large, wide or long workpieces



Size	Jaw Width	Jaw Length	Base Length	Base Width	Base Height	Jaw Height	kg	Order Code
1	100 (4")	77.9	140	75	35	30	3.3	2.10.31000
2	125 (5")	77.9	160	95	40	40	5.8	2.10.32000
3	150 (6")	89.4	230	125	50	50	12.6	2.10.33000
4	175 (7")	96.9	240	145	58	60	17.8	2.10.34000
5	200 (8")	113.4	300	170	70	65	29.8	2.10.35000
6	300 (12")	120.4	350	195	78	80	50.5	2.10.36000



ART.104 MODULAR ELEMENT FIXED DOUBLE JAW SECTION

With Pull Down Jaws

- Hardened to HRC60
- Fast & easy alignment with machine bed through ground cross keyways and positioning keys (no need to clock jaws!)
- All working surfaces ground within 0.02mm
- Ideal for extra large, wide or long workpieces



Size	Jaw Width	Jaw Length	Base Length	Base Width	Base Height	Jaw Height	kg	Order Code
1	100 (4")	84.8	140	75	35	28	3.4	2.10.41000
2	125 (5")	84.8	160	95	40	38	6	2.10.42000
3	150 (6")	101.8	230	125	50	48	13.3	2.10.43000
4	175 (7")	110.8	240	145	58	58	18.8	2.10.44000
5	200 (8")	132.8	300	170	70	63	30	2.10.45000
6	300 (12")	146.8	350	195	78	78	52.5	2.10.6000

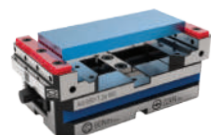


CompactGrip Vice

Zero point quick change clamping system for maximising machine tool up-time.



- ✓ Space saving design
- ✓ Secure clamping
- ✓ Fast changeovers

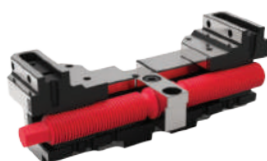


TOP GRIP JAW INSERTS

Easy to replace and usable on both sides. A wide range available for any type of clamping.

HIGHEST CLAMPING FORCE

Significantly higher clamping power compared to existing vices, with a more compact and lighter design. This is due to the clamping screw design, positioned closer to the workpiece, and the integrated design of the slides and jaws.



QUICK CHANGE PLATE

A mechanical system for the quick positioning and clamping of fixtures for securing workpieces that stands out for its wide range of variations, offering a solution suitable for every type of machine tool.



FRONT THROUGH HOLES

For customised applications (frontal jaw plates, inserts, spacers, etc.).

REVERSIBLE JAWS

Allow the clamping of smaller workpieces.



Direct vice set-up or through vice clamps.

System compatible with standard pitch 52 and 96.



CG COMPACT GRIP

ZERO POINT READY

COMPACTGRIP QUICK CLAMPING TABLE

The system allows immediate positioning of the vice on the machine table, tombstone, 4th/5th axis or fixture - saving hours on set-up times. Vices can be replaced on the table in seconds with 5µm accuracy, switching from job to job with minimal machine downtime.

- Immediate positioning with 5µm repeatability
- Mechanical clamping (no air or hydraulics needed)
- Supplied with 4 pull studs
- Vices & bases compatible with other manufacturer's systems



ZERO POINT READY

Compatible with the most popular pallet change systems, as well as Gerardi Zero Point Size 1 and 2.

- No need for adapter plates
- Supplied with pull stud
- Zero Point can be integrated in risers



VERSATILE JAWS

Reversible solid jaws with modular jaw plates for different materials and operations.

- No need for workpiece stamping
- Hardened & ground
- Superior rigidity





Scan to Watch



1

Hardened & Ground

HRC60 hardened steel base, jaws and lead screw, overall accuracy $\pm 0.02\text{mm}$.

2

Self-centring Reversible Step Jaws

High clamping accuracy, power and pull down action. Self-centring jaws can be adjusted.

3

Modular Jaw Plates

With different teeth profiles for specific materials, rough or finish machining.

4

Highest & Most Consistent Clamping Forces

12-32kN clamping forces easily achievable due to the lead screw design.

5

Multiple Ways To Locate The Vice

Vice can be positioned with ground keyways (with tenons), quick clamping plates (with 4 pull studs), zero point (1-2 pull studs) or with centring pin (for 5-axis table).

6

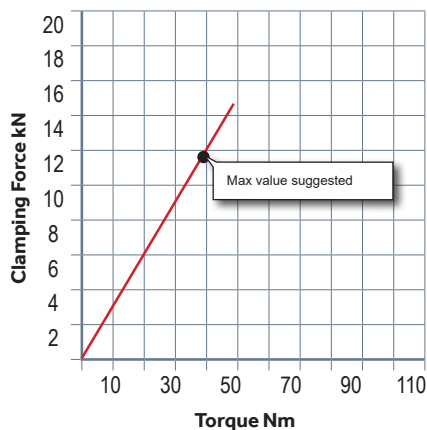
Single Or Double Clamping

With additional fixed jaw (ART650X), 2 workpieces can be clamped with 1 vice.

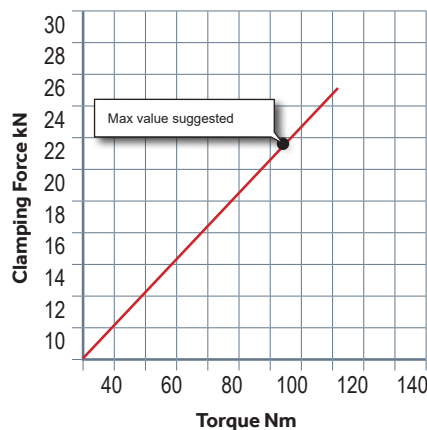
THE HIGHEST CLAMPING FORCES WITH MECHANICAL CLAMPING ART. 650/950

■ No workpiece 'stamping' or dovetailing required - **DOUBLE** the clamping force of competitor vices

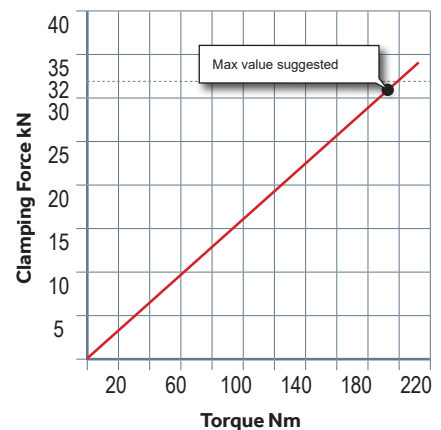
Size 1



Size 2



Size 3





ART.650 COMPACTGRIP VICE WITH REVERSIBLE HARD JAWS

- Self-centring
- Wide range of jaw plates for different materials
- Compact design with excellent clearance for 5-axis machining
- High clamping forces & solid jaws, also ideal 3 or 4-axis machining

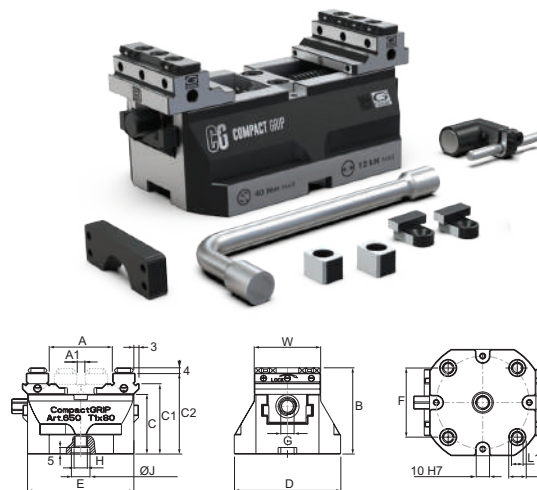
SOLID FIXED JAW SPARES

Jaw Type	Vice Size	A1	B	B1	C	Order Code
Solid Fixed Jaw ART650X	1	24	8	20	50	7.65.0X1000
	2	28	13	23	88	7.65.0X2000
	3	29	18	28	123	7.65.0X3000

SUPPLIED WITH EACH VICE

- Pair of positioning nuts ART.650G
- 1 workstop ART.370EM
- Pair of Self-centring key nuts ART.297
- 1 box wrench ART.375
- 1 Calibrated centring and orientation pin ART.79 or 1 pull stud for zero point ART.115 or 1 calibrated centring pin ART.604P*

*(to be chosen when ordering)



Vice Size	Jaw Width W	A	A1	B	C	C1	C2	D	E	F	H	J	K	L	L1	kg	Order Code	Intermediate Jaw For Double Clamping
1 (12kN)	50	54	6	65	45	53	61	80	80							1.8	7.65.01080	
		94	6	65	45	53	61	80	120	52	M10	14 H7	10 H7	12	M8	2.6	7.65.01120	7.65.0X1000
		134	6	65	45	53	61	80	160							3.4	7.65.01160	
2 (22kN)	88	96	10	65	38	51	61	90	120							3.6	7.65.02120	
		136	10	65	38	51	61	90	160	52	M12	14 H7	16 H7	12	M8	4.4	7.65.02160	7.65.0X2000
		176	10	65	38	51	61	90	200							5.2	7.65.02200	
3 (32kN)	123	216	10	65	38	51	61	90	240							5.8	7.65.02240	
		126	10	89	57	75	85	125	160							9.1	7.65.03160	
		176	10	89	57	75	85	125	210							10.9	7.65.03210	
		226	10	89	57	75	85	125	260	96	M16	20 H7	16 H7	16	M10	12.8	7.65.03260	7.65.0X3000
		276	10	89	57	75	85	125	310							14.8	7.65.03310	
		326	10	89	57	75	85	125	360							17	7.65.03360	



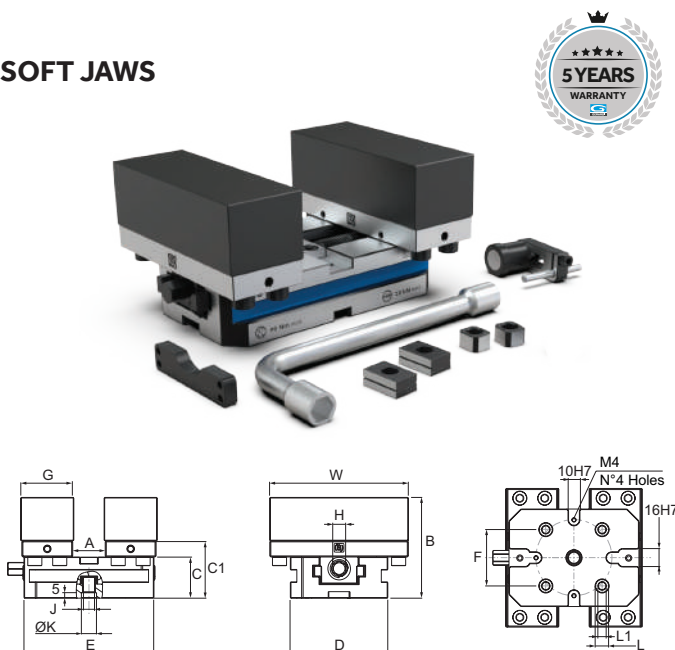
ART.950 COMPACTGRIP VICE WITH MACHINABLE SOFT JAWS

- Self-centring
- Machinable soft jaws for irregular workpiece clamping
- Compact design with excellent clearance for 5-axis machining
- Hardened to HRC60

SUPPLIED WITH EACH VICE

- 1 workstop ART.370EM
- Centring pin ART.79 or ART.115
- 1 box wrench: ART.375
- Pair of Self-centring key-nuts ART.650G
- Pair of positioning key-nuts ART.297
- 1 Calibrated centring and orientation pin ART.79 or 1 pull stud for zero point ART.115 or 1 calibrated centring pin ART.604P*

*(to be chosen when ordering)



Size (Clamping Force)	Jaw Width W	A	B	C	C1	D	E	F	G	H	J	K	L	L1	kg	Order Code
2 (22kN)	128	48					120								7.9	7.95.02120
		85					160								8.7	7.95.02160
		125	93	38	53	90	200	52	49	CH.12	M10	14 H7	12 H7	M8	9.5	7.95.02200
		165					240								10.1	7.95.02240
		71					160								16.9	7.95.03160
3 (32kN)	160	121					210								18.7	7.95.03210
		171	124	57	77	125	260	96	59	CH.16	M16	20 H7	16 H7	M10	20.6	7.95.03260
		221					310								22.6	7.95.03310
		271					360								24.8	7.95.03360



COMPACTGRIP TOP JAW PLATES (SOLD IN PAIRS)

- Jaw plates for clamping to the top of the jaw
- 4mm high x 3mm deep step
- Hardened & ground

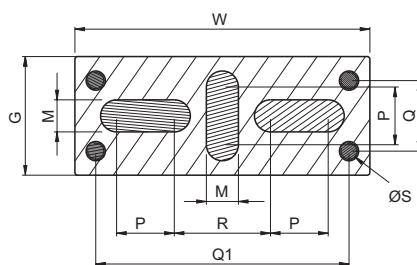
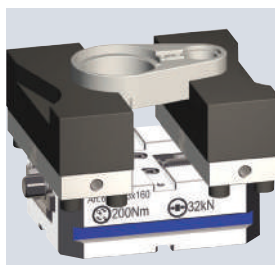


Jaw Plate Type		Application	Vice Size	Order Code
Smooth & Rough Jaw Plate   ART650S		1 side serrated for rough machining of soft-medium hardness metals, 1 side smooth for finishing	1	7.65.0S100
			2	7.65.0S200
			3	7.65.0S300
Dovetail Jaw Plate   ART650R		60° dovetail for the most secure clamping, ideal for heavy roughing when the most secure clamping is needed.	1	7.65.0R1000
			2	7.65.0R200
			3	7.65.0R300
STD Grip Jaw Plate 1.5mm Pitch   ART650T-G01		Designed for clamping low to medium hardness materials	1	7.65.0T100/G01
			2	7.65.0T200/G01
			3	7.65.0T300/G01
Hard Material Grip Jaw Plate 2mm Pitch   ART650T-G02		Designed for clamping hardened materials	1	7.65.0T100/G02
			2	7.65.0T200/G02
			3	7.65.0T300/G02
Soft Material Grip Jaw Plate 11mm Pitch   ART650T-G11		Extra coarse pitch for soft material clamping	1	7.65.0T100/G11
			2	7.65.0T200/G11
			3	7.65.0T300/G11



JAWS & SLIDES FOR ART.950*

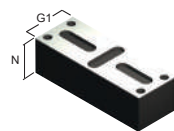
*Sold individually. Also suitable for ART.650. Solid soft jaws can be used by adding right and left slides ART.950B and ART.950C.



Size	2	3
W	128	160
G	49	59
M	10 H7	14 H7
P	30	36
Q	23	36
Q1	110	142
R	40	50
Ø S	9	11

ART.950D

Machinable steel solid soft jaw



Size N	2 (30)	3 (47)
Order Code	7.95.0D2000	7.95.0D3000

ART.950B

Solid hardened slide right hand with positioning key nuts



Size N	2 (15)	3 (20)
Order Code	7.95.0B2000	7.95.0B3000

ART.950C

Solid hardened slide left hand with positioning key nuts



Size N	2 (15)	3 (20)
Order Code	7.95.0C2000	7.95.0C3000



5-Axis Pyramids & Quick Change Plates

Maximise your machining productivity and flexibility.

CompactGrip 5-axis pyramids enable the simultaneous machining of up to three workpieces, reducing tool-change time and minimising downtime associated with workpiece changes.

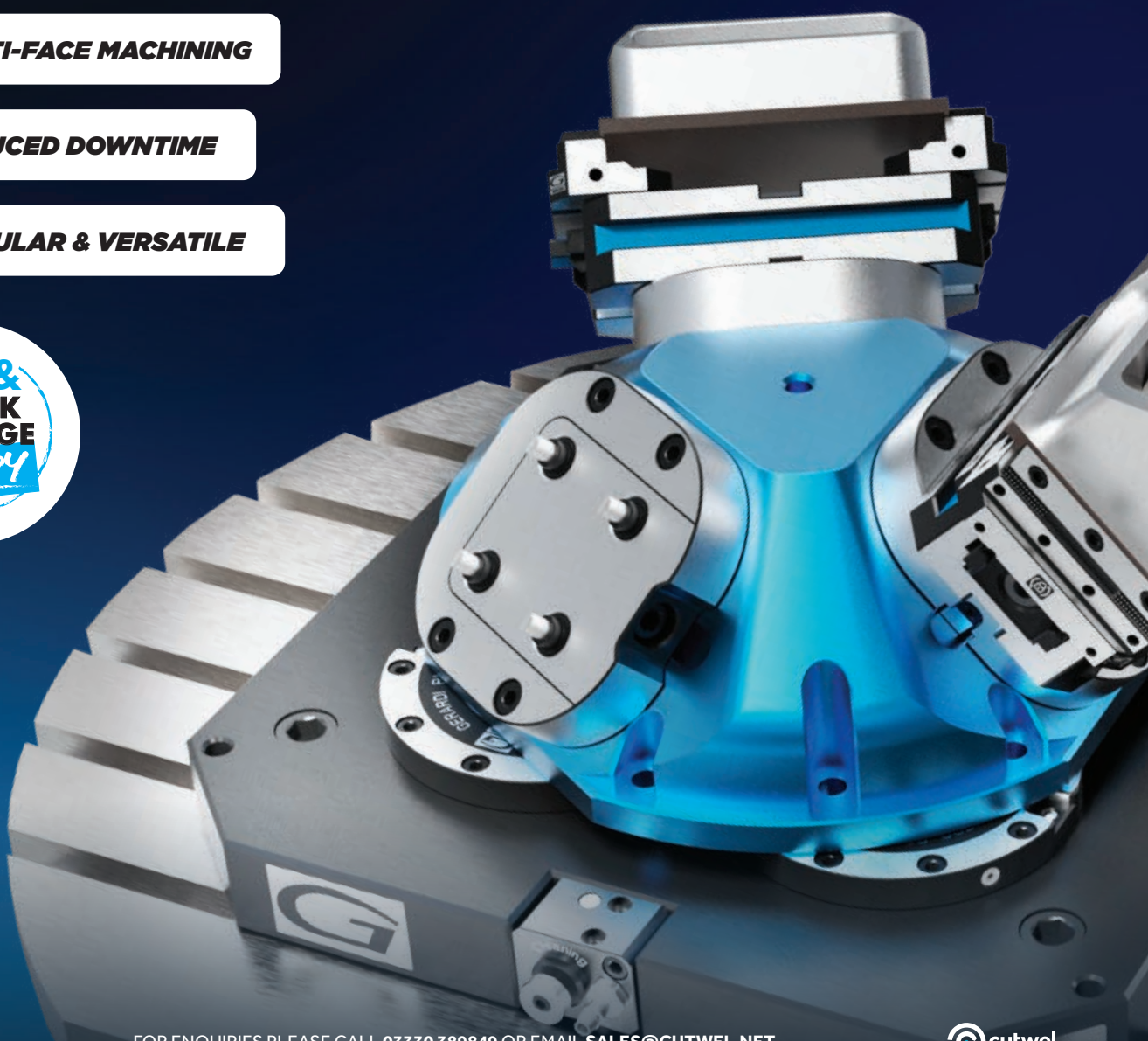
Custom configurations, including 15° options, are available for machines that cannot accommodate standard angles. For maximum productivity, the pyramids can be used with vices mounted directly to the pyramid or with **Zero Point Quick Change Plates** for rapid workpiece and vice changes.

✓ **3 WORKPIECES IN ONE SET-UP**

✓ **MULTI-FACE MACHINING**

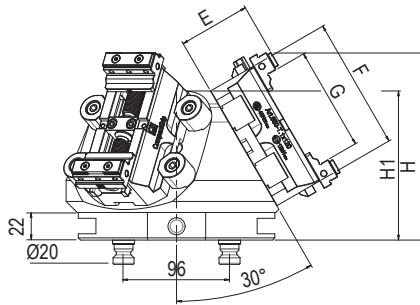
✓ **REDUCED DOWNTIME**

✓ **MODULAR & VERSATILE**



ART.643H-1 PYRAMID RISER - 30°

- Triple positioning 30° support
- For size 1 CompactGrip vices with 80 or 120mm base length
- Special design on request
- Zero Point & Quick Change Table compatible

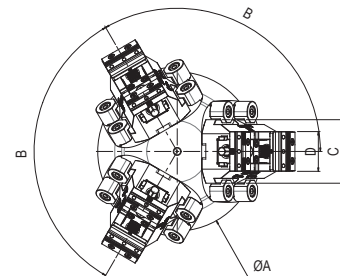


KIT #1 ART. 643H + N°3 ART.650 T.1x120



Order Code

6501120-G11-643H1-60



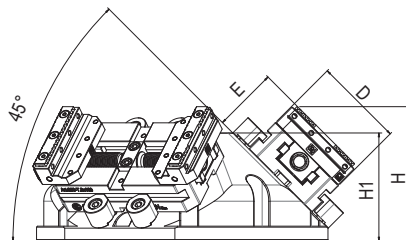
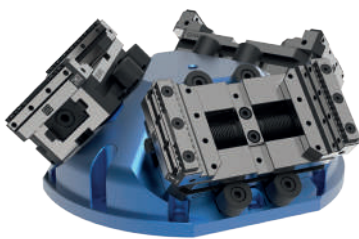
SUPPLIED WITH EACH PYRAMID:

- 12 vice holding clamps **ART.298** CGR with M8 screws
- 1 Eyebolt
- 4 pull studs **ART.660B T2**

Ø A	B	C	D	E	F	G	H	H1	kg	Suitable Vices	Pyramid	Order Code Pyramid Kit
200	120°	80	50	65	120	94	169.4	135	6.8	7.65.01080 / 7.65.01120	7.64.1H200	6501120-G11-643H1-60

ART.643H-2 PYRAMID RISER - 45°

- Triple positioning 45° support
- For size 2 CompactGrip vices with 120, 160 or 200mm base length
- Special design on request
- Zero Point compatible

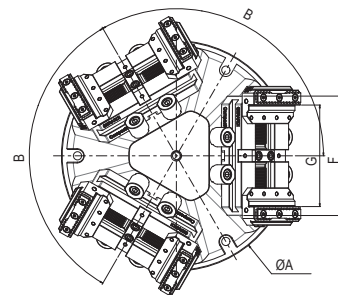


KIT #2 ART. 643H + N°3 ART.650 T.2x200



Order Code

6502200-G11-643H2-30/45



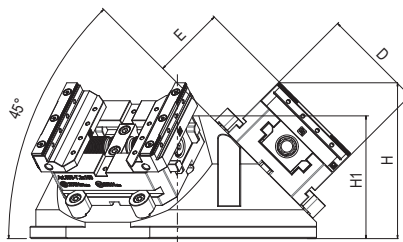
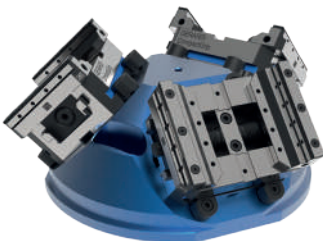
SUPPLIED WITH EACH PYRAMID:

- 12 vice holding clamps **ART.298** CGR with M8 screws
- 1 Eyebolt
- 1 Centring pin
- Pair of keynuts **ART.287**

Ø A	B	D	E	F	G	H	H1	kg	Suitable Vices	Pyramid	Order Code Pyramid Kit
308	120°	90	65	160	136	135.5	109	11.9	7.65.02120 / 7.65.02160 / 7.65.02200 7.95.02120 / 7.95.02160 / 7.95.02200	7.64.3H200	6502200-G11-643H2-30/45

ART.643H-3 PYRAMID RISER - 45°

- Triple positioning 45° support
- For size 3 CompactGrip vices with 120, 160 or 200mm base length
- Special design on request
- Zero Point compatible

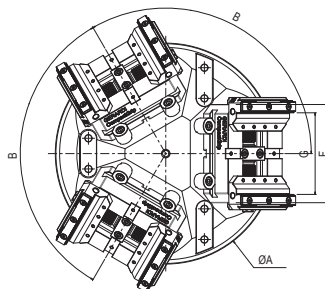


KIT #3 ART. 643H + N°3 ART.650 T.3x210



Order Code

6503210-G11-643H3-45



SUPPLIED WITH EACH PYRAMID:

- 12 vice holding clamps **ART.298** CGR with M8 screws
- 1 Eyebolt
- 1 Centring pin
- Pair of keynuts **ART.287**

Ø A	B	D	E	F	G	H	H1	kg	Suitable Vices	Pyramid	Order Code Pyramid Kit
360	120°	125	89	160	133	190.5	150	20.8	7.65.03160 / 7.65.03210 7.95.03160 / 7.95.03210	7.64.3H300	6503210-G11-643H3-45



RECTANGULAR ZERO POINT QUICK CHANGE PLATE - HARDENED

- Zero Point mechanical clamping (± 0.02 mm positioning accuracy)
- Ideal for reducing set-up times and maximising uptime
- 52 or 96mm pitch with keyways and calibrated holes
- Supplied with 4 Zero Point pull studs



ART. 660

Pitch	52	96
Compatible Vice Size	1-2	3
Height	27	27
Width	116	156
Length	150	190
Order Code	9.66.05200	9.66.09600



RECTANGULAR ZERO POINT QUICK CHANGE PLATE - MACHINABLE

- Zero Point mechanical clamping (± 0.02 mm positioning accuracy)
- Ideal for reducing set-up times and maximising uptime
- 52 or 96mm pitch, machinable outer area
- Supplied with 4 Zero Point pull studs



ART. 660S*

Pitch	52	96
Compatible Vice Type	1-2	3
Height	27	27
Width	116	156
Length	150	190
Order Code	9.66.05520	9.66.05960



RECTANGULAR ZERO POINT QUICK CHANGE REDUCTION PLATE - HARDENED

- Zero Point mechanical clamping (± 0.02 mm positioning accuracy)
- 52 or 96mm pitch, machinable outer area
- Reduction plate enables clamping of 52 pitch workholding on 96 pitch plates
- Supplied with 4 Zero Point pull studs



ART. 660R

Pitch	52
Compatible Vice Type	1-2-3
Height	27
Width	126
Length	150
Order Code	9.66.0R210



SQUARE ZERO POINT QUICK CHANGE PLATE, DOUBLE PITCH - MACHINABLE

- Zero Point mechanical clamping (± 0.02 mm positioning accuracy)
- 52 or 96mm pitch, machinable outer area
- Supplied with 8 Zero Point pull studs



ART. 662D

Pitch	52 / 96
Compatible Vice Type	1-2-3
Length x Width	27
Height	116
Order Code	9662D5296



ROUND ZERO POINT QUICK CHANGE PLATE, DOUBLE PITCH - MACHINABLE

- Zero Point mechanical clamping (± 0.02 mm positioning accuracy)
- 52 or 96mm pitch, machinable outer area
- Supplied with 8 Zero Point pull studs



ART. 661D

Pitch	52 / 96
Compatible Vice Type	1-2-3
Outer Dia Ø	196
Height	27
Order Code	9661D5296



ROUND ZERO POINT QUICK CHANGE PLATE WITH BAR PASSAGE - MACHINABLE

- Zero Point mechanical clamping (± 0.02 mm positioning accuracy)
- 52 or 96mm pitch, machinable outer area
- Supplied with 8 Zero Point pull studs



ART. 661SPB

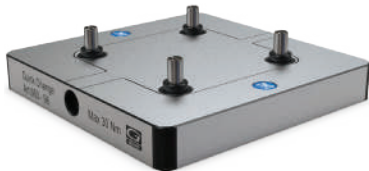
Pitch	52	96	96
Inner Dia Ø	52	52	110
Outer Dia Ø	158	196	196
Order Code	9661SPB52-52	9661SPB96	9661SPB96-110

All quick change plates are compatible with Gerardi CompactGrip & MaxiGrip vices (also compatible with Lang, HWR & 5th Axis workholding)



SQUARE ZERO POINT QUICK CHANGE PLATE - MACHINABLE

- Zero Point mechanical clamping (+/-0.02mm positioning accuracy)
- Ideal for reducing set-up times and maximising uptime
- 96mm pitch, machinable outer area
- Supplied with 4 Zero Point pull studs


ART. 662S

Pitch	96
Compatible Vice Size	3
Height	27
Width	191.5
Order Code	9662S960



RECTANGLE ZERO POINT QUICK CHANGE PLATE, DOUBLE - MACHINABLE

- Zero Point mechanical clamping (+/-0.02mm positioning accuracy)
- Ideal for reducing set-up times and maximising uptime
- 96mm pitch, machinable outer area
- Supplied with 4 Zero Point pull studs



2 Drives

ART. 662S

Pitch	96
Compatible Vice Size	3
Height	27
Width	191.5
Length	383.5
Order Code	9662S962



SQUARE ZERO POINT QUICK CHANGE PLATE, QUAD - MACHINABLE

- Zero Point mechanical clamping (+/-0.02mm positioning accuracy)
- Ideal for reducing set-up times and maximising uptime
- 96mm pitch, machinable outer area
- Supplied with 16 Zero Point pull studs



4 Drives

ART. 662S

Pitch	96
Compatible Vice Size	3
Height	27
Width	383.5
Order Code	9662S964



ROUND ZERO POINT QUICK CHANGE PLATE - HARDENED

- Zero Point mechanical clamping (+/-0.02mm positioning accuracy)
- Ideal for reducing set-up times and maximising uptime
- 52 or 96mm pitch with keyways and calibrated holes
- Supplied with 4 Zero Point pull studs


ART. 661

Pitch	52	96
Compatible Vice Size	1-2	3
Outer Dia	158	196
Height	27	27
Order Code	9.66.15200	9.66.19600



ROUND ZERO POINT QUICK CHANGE PLATE - MACHINABLE

- Zero Point mechanical clamping (+/-0.02mm positioning accuracy)
- Ideal for reducing set-up times and maximising uptime
- 52 or 96mm pitch, machinable outer area
- Supplied with 4 Zero Point pull studs


ART. 661S

Pitch	52	96	96	96
Compatible Vice Size	1-2	3	3	3
Outer Dia	158	196	250	300
Height	27	27	27	27
Order Code	9.66.15200	9.66.15960	9.66.15960-250	9.66.15960-300



ROUND ZERO POINT QUICK CHANGE REDUCTION PLATE - HARDENED

- Zero Point mechanical clamping (+/-0.02mm positioning accuracy)
- Ideal for reducing set-up times and maximising uptime
- Reduction plate enables clamping of 52 pitch workholding on 96 pitch plates
- Supplied with 4 Zero Point pull studs


ART. 661R

Pitch	52
Compatible Vice Size	1-2-3
Outer Dia	158
Height	27
Order Code	9.66.1R210

All quick change plates are compatible with Gerardi CompactGrip & MaxiGrip vices (also compatible with Lang, HWR & 5th Axis workholding)



Start machining, stop handling

WULF Grip Quick Change Zero Point Workholding System

Modular quick change clamping system with Zero Point plates & tombstones, self-centring vices, 3 jaw chucks, dovetail fixtures & ER collet clamps.



ULTRA FAST SET-UPS



FOR 3, 4 & 5-AXIS MACHINING



ZERO POINT READY



QUICK CHANGE EXPLAINED

The WULF quick change clamping system uses zero point quick change plates and various clamping elements like vices and chucks to secure workpieces and reduce set-up time. Modular clamping elements attach to the plates in seconds with under 5 microns accuracy. It works for vertical, horizontal, and 5-axis positioning.

Quick Change Zero Point System



Set jobs offline and position vices in seconds



Quick change plates compatible with 4 different top tooling options



Quick and accurate changeover



Large bearing area, suitable for heavy cutting



Reduce fixture replacement & adjustment time by 80%



Repeatability accuracy within 0.005mm



QUICK CHANGE ZERO POINT SELF-CENTRING MACHINE VICE

- Repeatability: 0.005mm
- Compatibility with 52/96mm quick change tables
- Precise, flexible, compact and lightweight design



Jaw Width	Base Width	Base Height	Jaw Height	Overall Height	Max Clamping	Base Length	Max Clamping Forces	Repeatability	Weight kg	Order Code
75	75	35	21.1	56.1	76	100	60Nm/14KN	0.01	2.5	WC75100
					126	150			3	WC75150
130	130	41.3	32.3	73.6	150	155	75Nm/26KN	0.02	7	WC130155
					254	250			10	WC130250



QUICK CHANGE ZERO POINT SELF-CENTRING MACHINE VICE

- Material: Hardened steel
- Anti-rust surface
- Weight: 2.5kg
- Serrated dovetail grip jaws for maximum clamping security



Zero Point Pitch	Clamping Diameter	Order Code
52	0-80	WC52-D80
96	0-125	WC96-D125



QUICK CHANGE ZERO POINT ER32 ADAPTER

- Material: Hardened steel
- Weight: 2.5kg



Zero Point Pitch	Clamping Diameter	Order Code
52	3-25	WC-ER32-52
96		WC-ER32-96



QUICK CHANGE ZERO POINT DOVETAIL ADAPTER

- Made from ground stainless steel to ensure accuracy and stability



Zero Point Pitch	Clamping Range	Order Code
52	12-25	WC-YW12-52
	25-70	WC-YW25-52
96	12-25	WC-YW12-96
	25-70	WC-YW25-96



SPARE JAWS FOR SELF-CENTRING MACHINE VICES



Type	Jaw Width	Order Code
Steel (Soft) Jaws	75	WC-SL75
	130	WC-SL130
Aluminium Jaws	75	WC-AL75
	130	WC-AL130
Hard Jaws	75	WC-STD-75
	130	WC-STD-130



SINGLE STATION QUICK CHANGE ZERO POINT BASE PLATE

- Mechanically actuated
- Repeatability: 0.005mm
- Material: Steel
- Weight: 2kg
- Plates come supplied with 4 pull studs



Zero Point Pitch	Max Clamping Force kN	Dimensions	Style	Vice Compatibility	Order Code
52	18	106x106x25	Rounded Corners	WC75	WC52-120
		106x106x25	Square Corners	WC75	WC52-145
96	22	150x150x30	Rounded Corners	WC130	WC96-190
		150x128x30	Square Corners	WC130	WC96-195



DOUBLE STATION QUICK CHANGE ZERO POINT BASE PLATE

- Mechanically actuated
- Repeatability: 0.005mm
- Material: Steel
- Weight: 4kg
- Plates come supplied with 8 pull studs



Zero Point Pitch	Max Clamping Force kN	Dimensions	Vice Compatibility	Order Code
52	18	208x106x25	WC75	WC52-230
96	22	348x163x25	WC130	WC96-S379



QUICK CHANGE ZERO POINT RISER

- Repeatability: 0.005mm
- Material: Steel
- Weight: 10kg



Zero Point Pitch	Dimensions	Order Code
96	Ø275x100	WC96-275



QUICK CHANGE ZERO POINT RIGHT ANGLE PLATE

- Repeatability: 0.008mm
- Material: Aluminium & steel
- Weight: 5.5kg



Zero Point Pitch	Dimensions	Order Code
96	150x149x199	WC96-90A



QUICK CHANGE ZERO POINT 3-SIDED TOMBSTONE

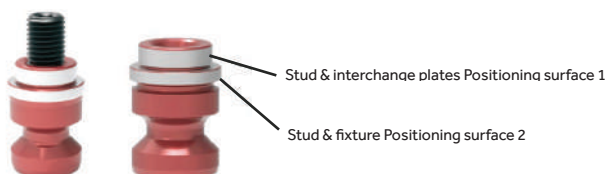
- Material: Aluminium & steel
- Weight: 7kg



Zero Point Pitch	Dimensions	Order Code
96	Ø160x167	WC52-S160-3



QUICK CHANGE ZERO POINT PULL STUDS



Thread	Dimensions	Order Code
M8	Ø12xØ16x20	WC1216
M10	Ø20xØ16x24	WC1620

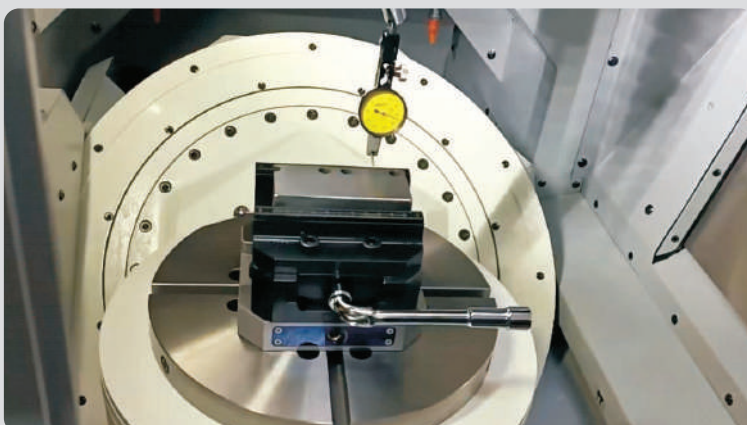
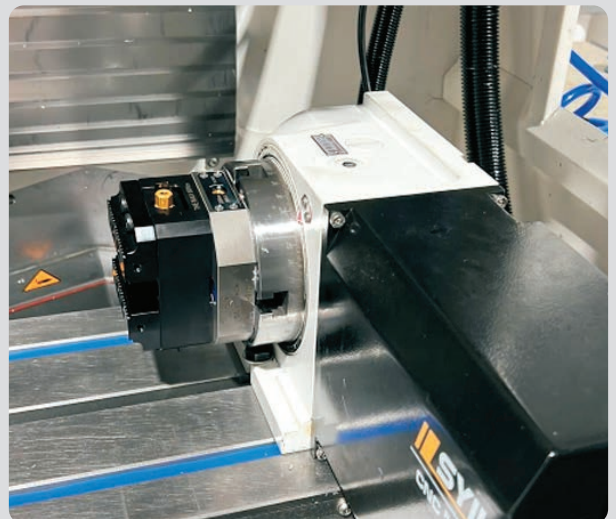
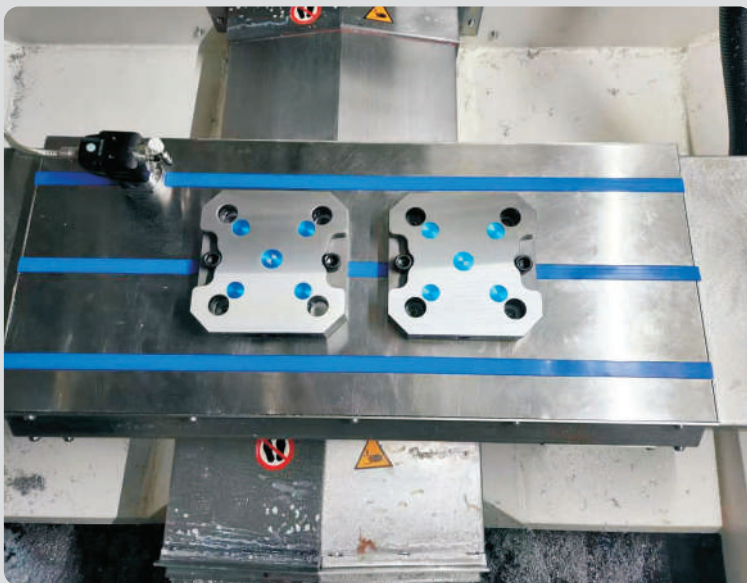
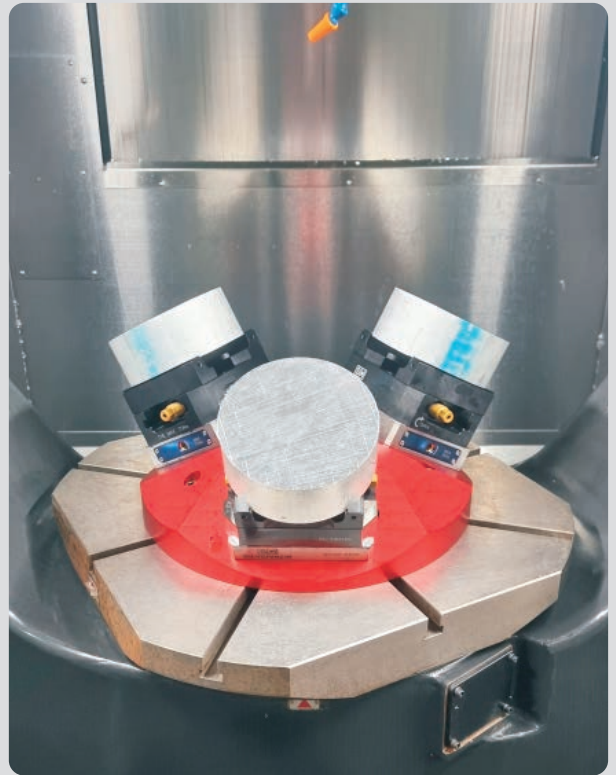
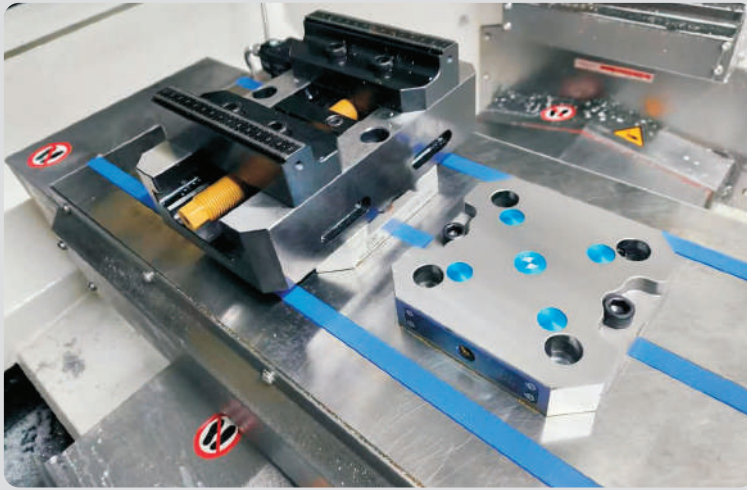


THREE SIDED PYRAMID

- Tailored to your 5-axis machine
- Available on request



Please enquire





Multitasking Vices

Powerful 5-axis self-centring modular machine vices for expert precision.

Modular

- ✓ Optional jaws including GRIP, solid soft and prismatic jaws for round workpieces.

Powerful & Rigid

- ✓ Extra thick base and solid jaws provides market leading power and clamping rigidity.

Precision

- ✓ All working surfaces ground within +0.01mm, overall accuracy $\pm 0.02\text{mm}$.
- ✓ Self-centring clamping.

Immediate Clamping

- ✓ No need to stamp or dovetail the workpiece, Gerardi's lead screw technology delivers 100% more clamping force than the leading German 5-axis vice brand. Just clamp on as little as 4mm using grip jaws and start machining



MULTITASKING VICE SIZE OPTIONS

SIZE 1

Jaw Width **74mm**
Max Opening **65mm**



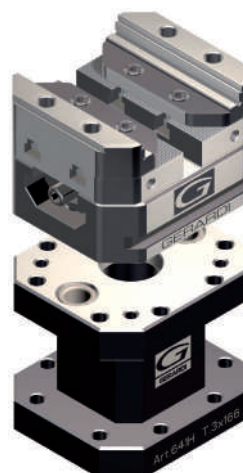
SIZE 2

Jaw Width **99mm**
Max Opening **95mm**



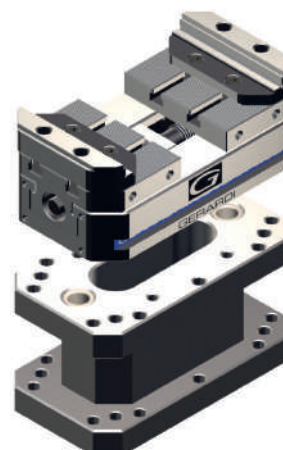
SIZE 3

Jaw Width **138mm**
Max Opening **108mm**



SIZE 3

Jaw Width **138mm**
Max Opening **208mm**





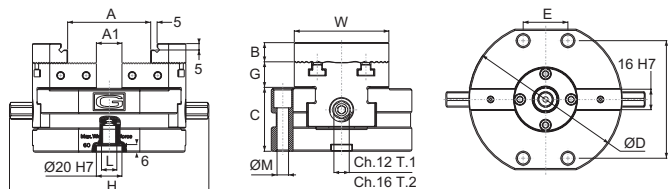
ART.640 MULTITASKING VICE SIZE 1 & 2

- Self-centring or eccentric clamping
- Extra thick base for ultimate rigidity
- Clamp on just 5mm with step jaws or 4mm with GRIP jaws
- Compact design with excellent all-round clearance for 5-axis machining
- Hardened and ground riser blocks available in different heights



SUPPLIED WITH EACH VICE

- 4 workstops **ART.370**
- Centring pin **ART.640P**
- 1 box wrench **ART.375**
- Pair of positioning key nuts **ART.297** (16mm)



Base Size (Clamping Force)	Jaw Width	Max Open A	A1	B	C	ØD	E	F	G	H	L	M	kg	Order Code	
														Vice	Riser 100mm High
1 (16kN)	74	65	20	15	50	120	35	92	20	156	M12	9	4.9	6.64.01000	7.64.1H100/100
2 (20kN)	99	95	40	20	70	160	35	120	25	208	M16	11	11	6.64.02000	



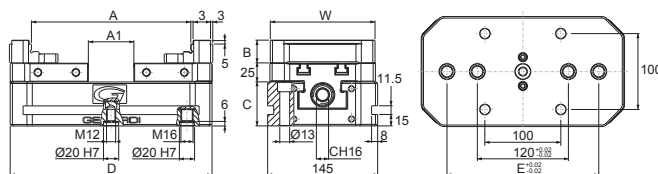
ART.640 MULTITASKING VICE SIZE 3

- Self-centring or eccentric clamping
- Extra thick base for ultimate rigidity
- Clamp on just 5mm with step jaws or 4mm with GRIP jaws
- Compact design with excellent all-round clearance for 5-axis machining
- Hardened and ground riser blocks available in different heights



SUPPLIED WITH EACH VICE

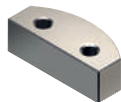
- 4 workstops **ART.370**
- Centring pin **ART.640P**
- 1 box wrench **ART.375**
- Pair of positioning key nuts **ART.297** (16mm)



Base Size (Clamping Force)	Jaw Width	Max Opening A	A1	B	C	D	E	kg	Order Code	
									Vice	Riser 100mm High
3 (30kN)	138	108	20	30	58	166	-	13	7.64.03166	7.64.1H3166/100
		208	60	30	58	266	200	20	7.64.03266	7.64.1H3266/100

ART.645B

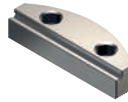
Soft jaw



Size (W mm)	1 (74)	2 (99)	3 (138)
Order Code	6.64.5B100	6.64.5B200	7.64.5B300

ART.645E

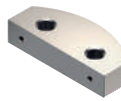
Step jaw (5x 5mm)



Size (W mm)	1 (74)	2 (99)	3 (138)
Order Code	6.64.5E100	6.64.5E200	7.64.5E300

ART.645C

Hard smooth jaw



Size (W mm)	1 (74)	2 (99)	3 (138)
Order Code	6.64.5C100	6.64.5C200	7.64.5C300

ART.645F

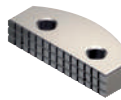
Prismatic jaw



Size (W mm)	1 (74)	2 (99)	3 (138)
Order Code	6.64.5F100	6.64.5F200	7.64.5F300

ART.645D

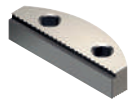
Serrated jaw



Size (W mm)	1 (74)	2 (99)	3 (138)
Order Code	6.64.5D100	6.64.5D200	7.64.5D300

ART.645T

Grip jaw



Size (W mm)	1 (74)	2 (99)	3 (138)
Order Code	6.64.5T100	6.64.5T200	7.64.5T300



5G Large Capacity Machine Vice



Built to solve the challenges of 5-axis machining. Less re-clamping, faster set-ups and better tool access.

The Gerardi 5G machine vice delivers maximum rigidity, repeatability and versatility so you can machine more faces, reduce set-up time and increase profitability.

- ✓ **CLAMPS VARIED
WORKPIECE SIZES**
- ✓ **MACHINE MORE FACES
IN ONE SET-UP**
- ✓ **QUICK CHANGE JAWS
REDUCE DOWNTIME**
- ✓ **ZERO POINT READY FOR
FAST REPEAT SET-UPS**



LIFT THE WORKPIECE

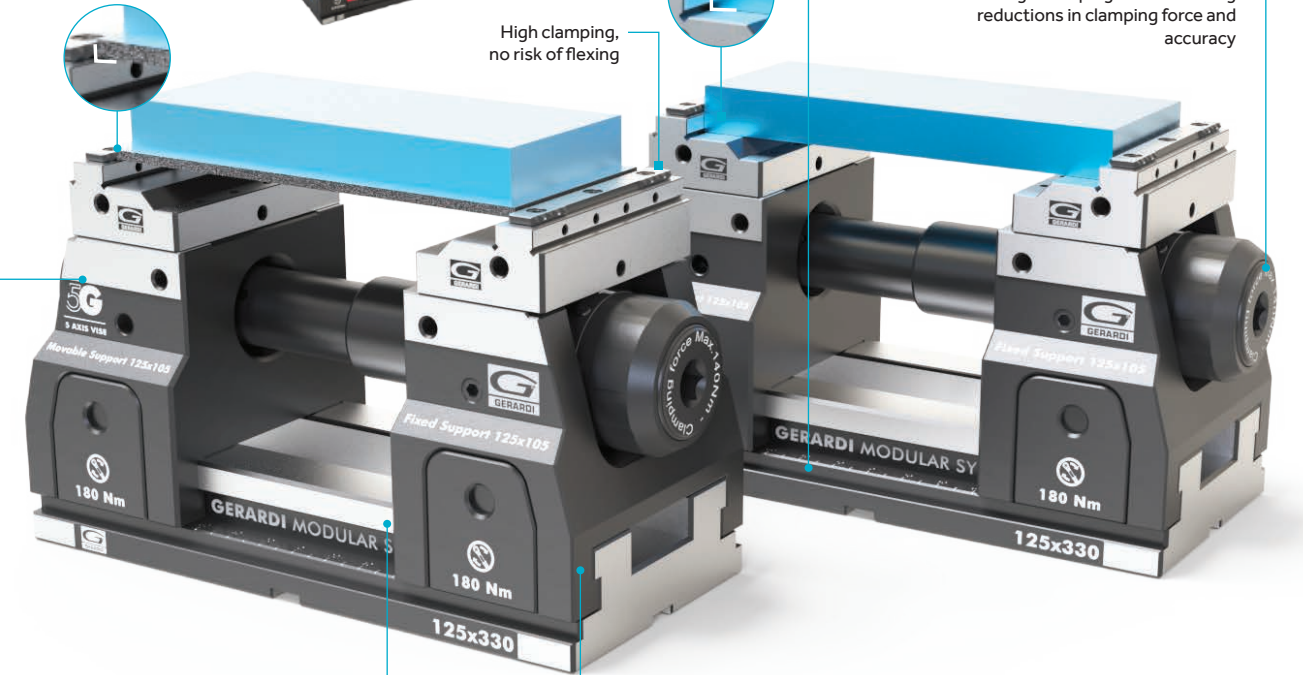
Various jaw body heights for machining at any level, made of high-strength hardened steel

100% ZERO POINT READY

Compatible with Quick Change plate

HIGH SCREW SYSTEM

The screw assembly positioned close to the clamping surface allows for high clamping without having reductions in clamping force and accuracy

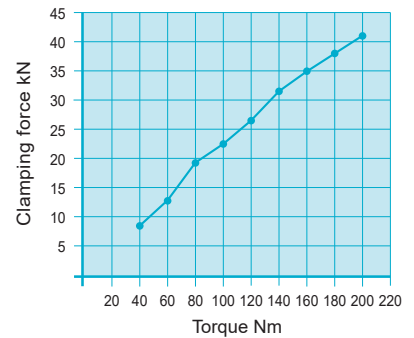


LENGTH MATTERS

You can choose different base lengths depending on the size of the parts to be clamped. The base of the 5G vice is integral and highly rigid, compatible with all positioning and quick-change systems such as zero point and tablets

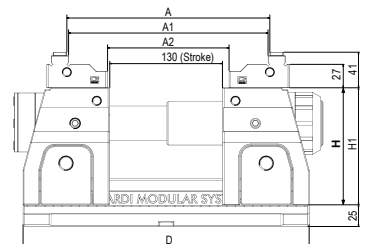
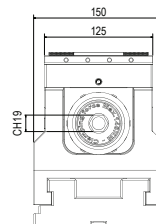
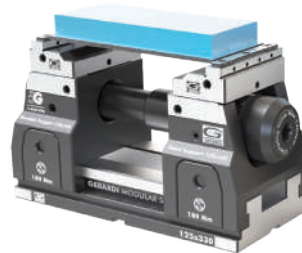
FROM MOBILE TO FIXED

The vice holding clamps transform the two mobile slides into fixed supports, in order to strengthen the structure and minimize flexion during the clamping



ART5G 5-AXIS MACHINE VICE WITH QUICK-CHANGE JAWS

- High precision self-centring clamping across all workpiece faces
- Rigid design to help reduce deflection during machining
- High clamping force with efficient force transfer to the workpiece
- Quick-change jaws for fast set-up between different component types
- Range of base lengths and jaw heights for different part sizes
- Modular design for easy reconfiguration between jobs
- Compatible with zero-point systems for repeatable set-up
- Optional anchoring system for added stability during machining



Max Torque: 200 Nm
Max Clamping Force: 40 kN

Recommended Torque: 120 Nm
Recommended Force: 26.5 kN

Jaw Size	H	H1	D	A	A1	A2	Order Code
125x105	105	135	330	234	230	140	5G-125-330
			430	334	330	240	5G-125-430
			500	404	400	310	5G-125-500
125x150	150	185	430	334	330	240	5G-125H-430
			500	404	400	310	5G-125H-500
			630	534	530	440	5G-125H-630



Gripmatic Vices

Self-centring machine vices with automated clamping for robot loading automation.

Pneumatic or hydraulic activation suitable for fully automatic unattended machining.

Precision

- ✓ All working surfaces ground within +0.01mm, with overall accuracy +0.02mm.
- ✓ Self-centring with 100% consistent clamping pressure.

Fully Automatic or User Operated

- ✓ Possible to operate using machine control.
- ✓ Use with robot loading for fully unattended operation.
- ✓ Also suitable for use with hand/foot switch.

No Wear

- ✓ Made from heat treated HRC60 alloy steel.

Modular

- ✓ Optional jaws including solid soft jaws, hard jaws and steel jaws.



Pneumatic double effect or hydraulic

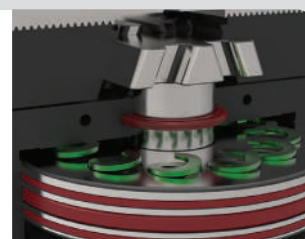


GERARDI
AUTOMATION

HYDRAULIC OR PNEUMATIC CLAMPING

- The pneumatic vice offers 5.1-22kN clamping force (depending on vice size)
- The hydraulic model offers 15-43kN clamping force (depending on vice size)

Vice Size	Pneumatic Clamping Force	Hydraulic Clamping Force
2	5.1 kN	15 kN
3	16 kN	32 kN
4	22 kN	43 kN



ZERO POINT & ROBOT LOADING

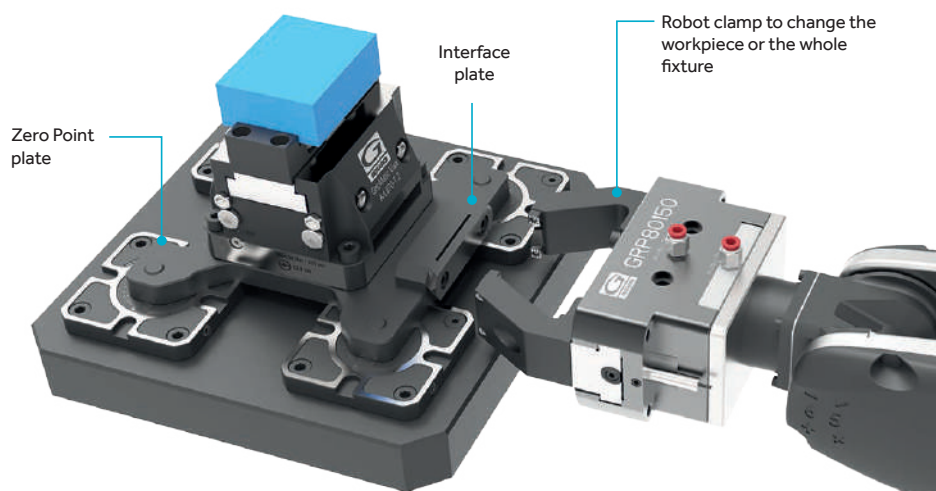
The vice can be located using robot loading and clamped to the machine table using Zero Point.

This can be fully automated for unattended operation.

Zero Point can also be used for manual loading of the vice.

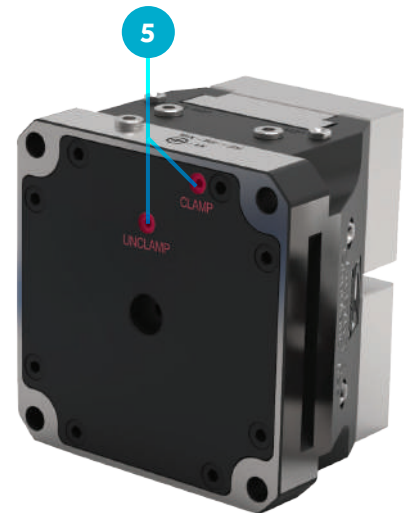


GERARDI
AUTOMATION





Scan to Watch



1

Hardened & Ground

HRC60 hardened steel base, jaws and lead screw, overall accuracy $\pm 0.02\text{mm}$.

2

Self-centring Automated Clamping

Highest clamping power by hydraulic or pneumatic operation.

3

Modular Jaws

Solid soft jaws for clamping irregular workpieces, hard jaws and grip jaws.

4

Highest & Most Consistent Clamping Forces

<43kN regulated clamping forces.

5

Full Or Semi-Automatic Clamping

CNC controlled or operator controlled clamping.

JAWS & JAW PLATES

Soft narrow jaws



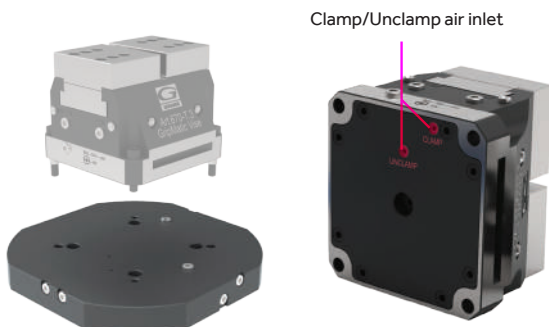
Solid soft jaws



Hard jaw inserts

FULLY AUTOMATIC - ART670AP

The GRIPMATIC vice + interface plate (ART.670PN), with air input through the machine table, enables clamping to be 100% controlled directly by the CNC. This plate can be fully tailored according to the characteristics of the machine.

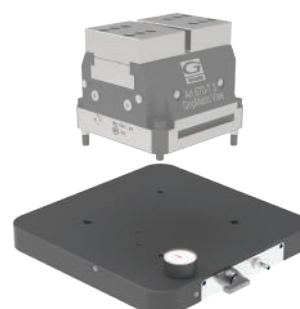


100% CUSTOMISABLE PLATE

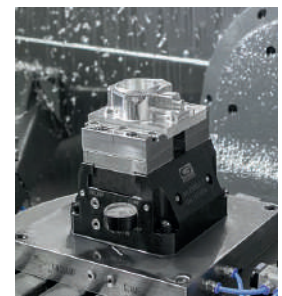
Please contact our technical team for more information.

SEMI AUTOMATIC - ART670CP

The GRIPMATIC vice + interface plate (ART.670PN), with air input through a quick coupling air input and manual system control through a selector.



STANDARD PLATE



Please contact our technical team for more information.



ART.104 MODULAR ELEMENT FIXED DOUBLE JAW SECTION

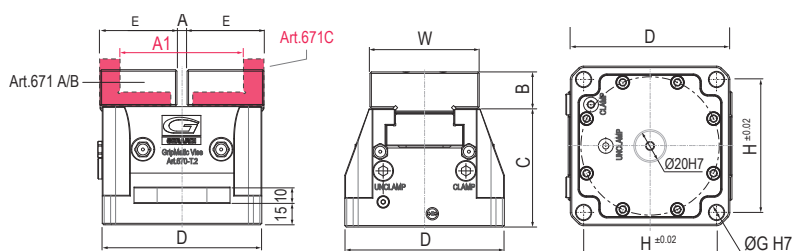
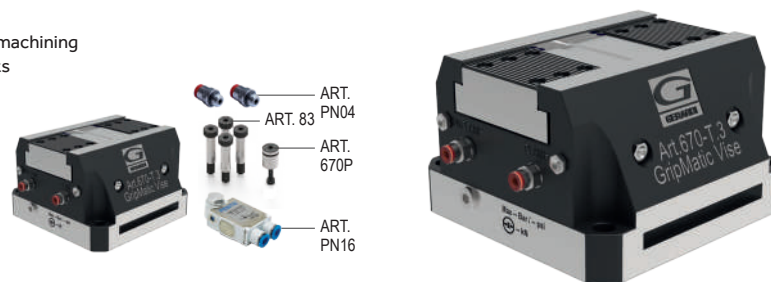
With Pull Down Jaws

- Self centring or eccentric clamping
- Extra thick base for ultimate rigidity
- Clamp on just 5mm with step jaws or 4mm with GRIP jaws
- Compact design with excellent all-round clearance for 5 axis machining
- Hardened and ground riser blocks available in different heights

Vice Size	Clamping Force
2	5.1 kN
3	16 kN
4	22 kN

SUPPLIED WITH EACH VICE

- 1 centring pin **ART.640P**
- Shoulder screw **ART.83**
- No return valve **ART.PN16**
- Straight male adaptor **ART.PN04**



Vice Size	Jaw Width W	Stroke A	A1	B	C	D	E	G	H	kg	Order Code
2	74	6.4	58.8	25	80	106	52	10	90	6.5	7.67.OPN20
3	99	8.5	106.5	30	105	166	78	12	140	20	7.67.OPN30
4	124	12	124.5	35	130	206	96	16	170	38	7.67.OPN40



ART.670ID GRIPMATIC VICE BASE

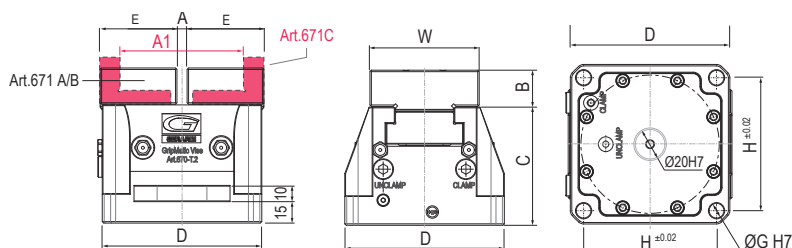
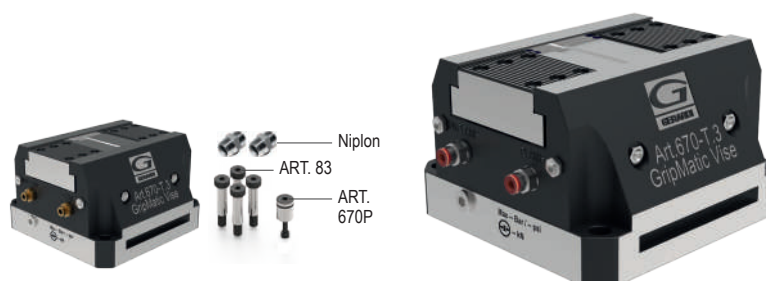
Hydraulic Clamping System

- Self-centring
- Jaw actuation controlled by hydraulic pressure (MAX 30BAR)
- Semi or fully automatic operation
- Compact design with excellent clearance for 5-axis machining
- Supplied without jaws

Vice Size	Clamping Force
2	15 kN
3	32 kN
4	43 kN

SUPPLIED WITH EACH VICE

- 1 Centring pin **ART.640P**
- Shoulder screw **ART.83**
- Niplon



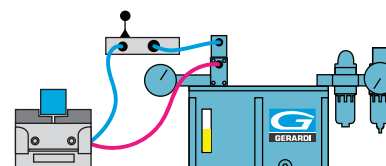
Vice Size	Jaw Width W	Stroke A	A1	B	C	D	E	G	H	kg	Order Code
2	74	6.4	58.8	25	80	106	52	10	90	6.5	7.67.0ID20
3	99	8.5	106.5	30	105	166	78	12	140	20	7.67.0ID30
4	124	12	124.5	35	130	206	96	16	170	38	7.67.0ID40

GRIPMATIC POWER UNITS

Pneumatic Or Electric Control

- Up to 4 vices can be controlled with 1 power unit
- Automatic retention and reset of desired power
- Max pressure 33BAR

Please contact our technical team for more information.





GRIPMATIC VICE JAWS



Narrow Soft Jaws



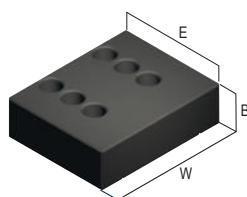
Solid Soft Jaws



Hard GRIP Jaw Plates

ART. 671A

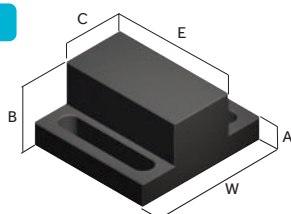
Soft movable jaw



Size	2	3	4
W	74	99	124
B	25	30	35
E	49	79	96
Order Code	7.67.1A200	7.67.1A300	7.67.1A400

ART. 671B

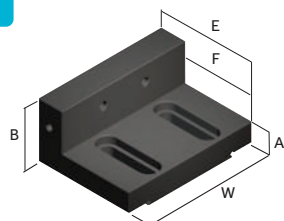
Soft narrow movable jaw



Size	2	3	4
W	40	65	81
A	10	10	15
B	25	30	35
C	15	28	38
E	40	65	81
Order Code	7.67.1B200	7.67.1B300	7.67.1B400

ART. 671C

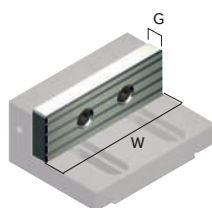
Soft movable jaw for standard jaw plates



Size	2	3	4
W	74	94	124
A	13.5	18	18
B	38	48	58
E	45	70	87
F	30	51	62
Order Code	7.67.1C200	7.67.1C300	7.67.1C400

ART. 243

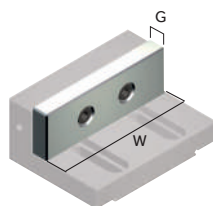
Hardened grooved straight jaw plate



Size	2	3	4
W	74	94	124
G	19	19	19
Order Code	1.65.17000	1.65.27000	1.65.37000

ART. 245

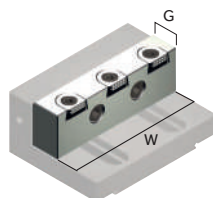
Hardened smooth straight jaw plate



Size	2	3	4
W	74	94	124
G	19	19	19
Order Code	4.24.51000	4.24.52000	4.24.53000

ART. 247G

Straight jaw plate with GRIP inserts



Size	2	3	4
W	74	94	124
G	20	20	20
Order Code	1.24.7G100	1.24.7G200	1.24.7G300



Multiflex Modular Clamping System



From multiple small parts to extra large or long parts, Multiflex offers perfect flexibility for the most productive machine shops.

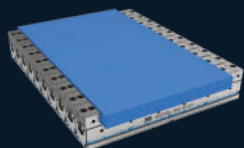
Designed for engineers looking to maximise machine tool capacity, cut set-up and cycle times and eliminate scrap, Multiflex is the ultimate clamping solution for boosting productivity.

Each vice clamps between 1 and 16 workpieces, from extra large to ultra small. Ideal for vertical and horizontal machining centres, or with a 4th axis (integral tower).

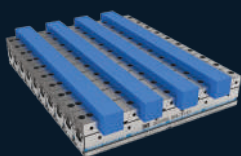
CLAMPING APPLICATIONS

PARALLEL MOUNTING

10 vices - 1 workpiece clamped

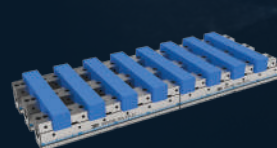


10 vices - 4 workpieces clamped



IN LINE MOUNTING

6 vices - 8 workpieces clamped



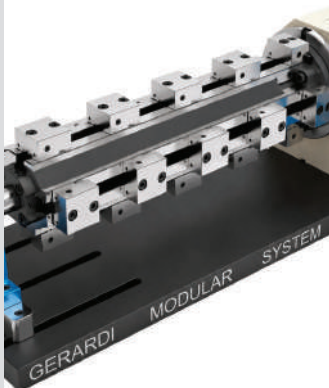
6 vices - 24 workpieces clamped



MULTIFLEX - VERTICAL MACHINING CENTRE CLAMPING EXAMPLES

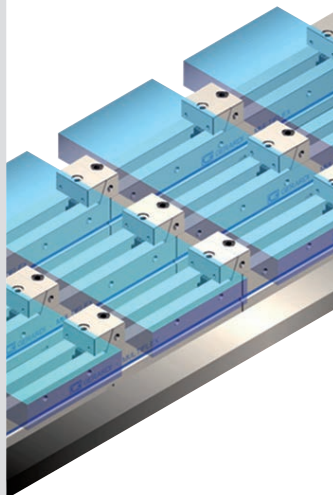
4TH AXIS

16 workpieces clamped with integral vice tower.



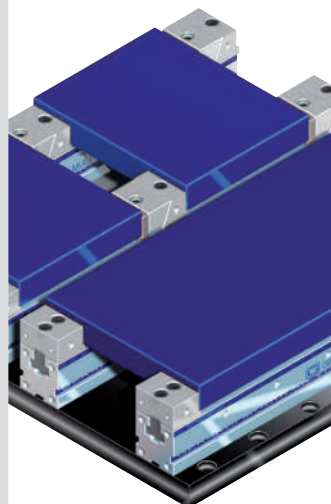
PLATES

4 plates clamped in line with 3 vices.



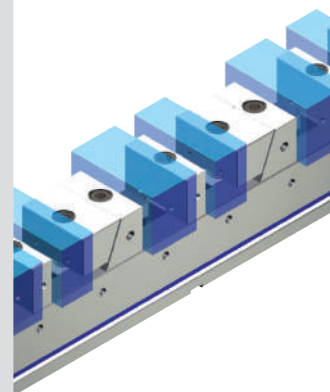
MIXED PLATES

3 plates clamped in line with 4 vices.



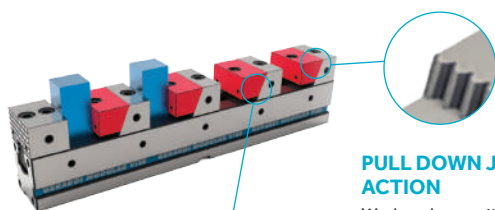
INTERMEDIATE JAWS

Increased clamping capacity through use of intermediate movable jaws.





Scan to Watch

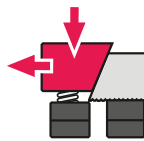


PULL DOWN JAW ACTION

Wedge clamp with guided pull-down law action thanks to the ground comb-teeth and the 68° angle

FIXED & MOVABLE JAWS

For workpieces clamped directly on vice base



ART.600

Fixed & Movable Hard Jaws

Supplied with Multiflex Vice:

4x workstops **ART. 370**

1x T wrench **ART.376**

1x pair of positioning key-nuts for 16 mm slot **ART. 297**

ART.606

Fixed & Movable Step Jaws

ART.611

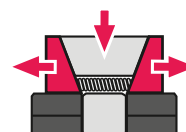
Double Clamping Jaws

HIGHEST ACCURACY

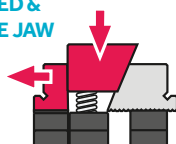
Guaranteed precision ($\pm 0,02$ mm) in positioning and alignment, thanks to the ground rack teeth on the base and fixed jaws

CLAMPING WEDGE

Allows double clamping

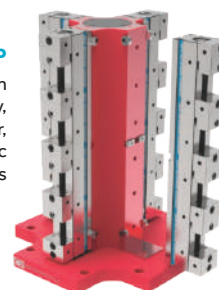


STEP FIXED & MOVABLE JAW



VERTICAL SET-UP

Multiflex vices can be stacked vertically, connected together, or mounted on specific workholding structures



MULTIFLEX - HORIZONTAL MACHINING CENTRE CLAMPING EXAMPLES

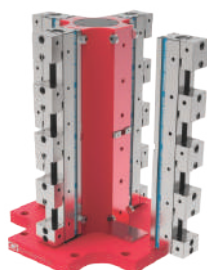
CUBE 48 MIXED PARTS

48 mixed parts clamped with 12 Multiflex vices arranged on a cube.



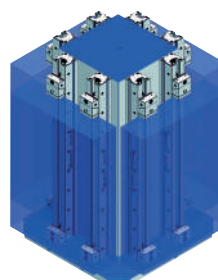
CROSS CUBE 4 VICES

4 Multiflex vices on Gerardi CROSS CUBE, interference free 3 sided machining.



CUBE 4x PLATES

4 large plates clamped with 8 Multiflex vices on Gerardi Cube, interference free machining.



MULTIFLEX TOWER

Multiflex tower complete with jaws for clamping up to 16 parts.





GERARDI ART.600/600S MULTIFLEX MODULAR MACHINE VICE

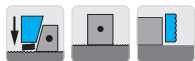
With Smooth or Serrated Fixed & Movable Jaws

- Ideal for workpieces clamped directly on the base
- Option of smooth jaws ART.600 or serrated jaws ART.600S
- Supplied with 1 fixed jaw and 4 movable jaws
- Suitable for clamping up to 4 workpieces with jaws supplied
- Jaws can be added for extra workpieces or removed for larger workpieces



SUPPLIED WITH EACH VICE

- 4 workstops **ART. 370**
- 6 table clamps
- 1 T-wrench **ART. 376**
- Pair of positioning key-nuts (16mm) **ART. 297**



ART. 600S



ART. 600



Available as an integral vice tower for horizontal or 4th axis machining.



Base Size (Clamping Force)	Jaw Height mm	Base Height mm	Length mm	Jaw Width mm	Spread	Order Code	
						ART.600 With Smooth Jaws	ART.600S With Serrated Jaws
1 (20kN)	32/25	50	300	49	4 x 8	6.60.01300	6.60.0S130
			400		4 x 33	6.60.01400	6.60.0S140
			500		4 x 58	6.60.01500	6.60.0S150
			600		4 x 83	6.60.01600	6.60.0S160
			700		4 x 108	6.60.01700	6.60.0S170
2 (30kN)	40	75	400	74	4 x 12	6.60.02400	6.60.0S240
			500		4 x 37	6.60.02500	6.60.0S250
			600		4 x 62	6.60.02600	6.60.0S260
			700		4 x 87	6.60.02700	6.60.0S270
			800		4 x 112	6.60.02800	6.60.0S280
3 (40kN)	60	100	900	99	4 x 137.5	6.60.02900	6.60.0S290
			700		4 x 59	6.60.03700	6.60.0S370
			800		4 x 84	6.60.03800	6.60.0S380
			900		4 x 109	6.60.03900	6.60.0S390
			1000		4 x 134	6.60.03100	6.60.0S310



GERARDI ART.611 MULTIFLEX MODULAR MACHINE VICE

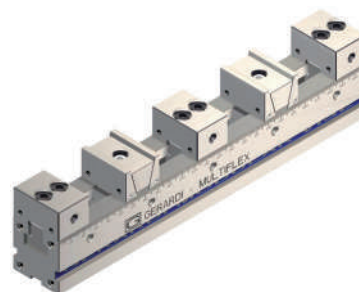
With Double Jaws

- Ideal for workpieces clamped directly on the base or raised up with parallels
- The most flexible Multiflex vice
- Supplied with 3 fixed jaws and 2 double jaws
- Suitable for clamping up to 4 workpieces with jaws supplied
- Jaws can be added for extra workpieces or removed for larger workpieces
- Jaw plates can be attached to main jaws



SUPPLIED WITH EACH VICE

- 4 workstops **ART. 370**
- 6 table clamps
- 1 T-wrench **ART. 376**
- Pair of positioning key-nuts (16mm) **ART. 297**

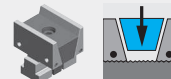


Available as an integral vice tower for horizontal or 4th axis machining.



DOUBLE JAW BENEFITS

The jaw pushes the clamping force in 2 directions, meaning just 1 jaw requires tightening for 2 workpieces, which also creates more consistent clamping forces.



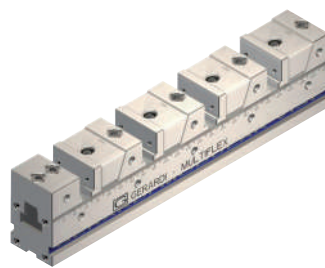
Base Size (Clamping Force)	Jaw Height mm	Base Height mm	Length mm	Jaw Width mm	Spread	Order Code
1 (20kN)	25	50	300	49	4x 21	6.61.11300
			400		4x 46	6.61.11400
			500		4x 71	6.61.11500
			600		4x 96	6.61.11600
			700		4x 121	6.61.11700
2 (30kN)	40	75	400	74	4x 34	6.61.12400
			500		4x 59	6.61.12500
			600		4x 84	6.61.12600
			700		4x 109	6.61.12700
			800		4x 134	6.61.12800
3 (40kN)	60	100	900	99	4x 158.5	6.61.12900
			700		4x 77	6.61.13700
			800		4x 102	6.61.13800
			900		4x 127	6.61.13900
			1000		4x 152	6.61.13100



GERARDI ART.606 MULTIFLEX MODULAR MACHINE VICE

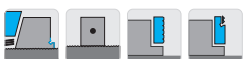
With Movable Step Jaws

- Ideal for raised workpieces for through holes
- Supplied with 1 fixed jaw and 4 (*3) movable jaws
- Suitable for clamping up to 4 workpieces with jaws supplied
- Jaws can be added for extra workpieces or removed for larger workpieces
- Jaw plates can be attached to main jaws



SUPPLIED WITH EACH VICE

- 4 workstops ART. 370
- 6 table clamps
- 1 T-wrench ART. 376
- Pair of positioning key-nuts (16mm) ART. 297



Available as an integral vice tower for horizontal or 4th axis machining.



STEP JAW BENEFITS

The large step jaw has the double benefit of raising the workpiece off the base for through hole work and acting as a modular jaw for 5 different jaw plates (ART.610 below).



Base Size (Clamping Force)	Jaw Height mm	Base Height mm	Length mm	Jaw Width mm	Spread	Order Code
1 (20kN)	32/25	50	300*	49	3x 19	6.60.61300
			400		4x 23	6.60.61400
			500		4x 48	6.60.61500
			600		4x 73	6.60.61600
			700		4x 97	6.60.61700
2 (30kN)	40	75	400*	74	3x 28	6.60.62400
			500		4x 24	6.60.62500
			600		4x 49	6.60.62600
			700		4x 74	6.60.62700
			800		4x 99	6.60.62800
3 (40kN)	60	100	900	99	4x 124.5	6.60.62900
			700		4x 44	6.60.63700
			800		4x 69	6.60.63800
			900		4x 94	6.60.63900
			1000		4x 119	6.60.63100



ALL ACCESSORIES BELOW ARE SUITABLE FOR THE FOLLOWING VICES

ART.600, 600s, 606, 611, 606T

FIXED JAWS



SMOOTH
ART.604G



SERRATED
ART.604



GRIP
ART.604T



STEP
ART.608



DOUBLE STEP
ART.614T

Fixed Jaws	Vice Size W		
	1 (49)	2 (74)	3 (99)
Smooth ART.604G	6.60.4G100	6.60.4G200	6.60.4G300
Serrated ART.604	6.60.41000	6.60.42000	6.60.43000
Grip ART.604T	6.60.4T100	6.60.4T200	6.60.4T300
Step ART.608	6.60.81000	6.60.82000	6.60.83000
Double Step ART.614T	6.61.4T100	6.61.4T200	6.61.4T300

MOVABLE JAWS



SMOOTH
ART.605



SERRATED
ART.605S



GRIP
ART.609T



STEP
ART.609



DOUBLE
ART.613

Movable Jaws	Vice Size W		
	1 (49)	2 (74)	3 (99)
Smooth ART.605	6.60.51000	6.60.52000	6.60.53000
Serrated ART.605S	6.60.5S100	6.60.5S200	6.60.5S300
Grip ART.609T	6.60.9T100	6.60.9T200	6.60.9T300
Step ART.609	6.60.91000	6.60.92000	6.60.93000
Double ART.613	6.61.31000	6.61.32000	6.61.33000

JAW PLATES



SOFT
ART.610B



SMOOTH HARD
ART.610C



SERRATED
ART.610D



PARALLEL
ART.610E



PRISMATIC
ART.610F

Jaw Plates	Vice Size W		
	1 (49)	2 (74)	3 (99)
Soft ART.610B	6.61.0B100	6.61.0B200	6.61.0B300
Smooth Hard ART.610C	6.61.0C100	6.61.0C200	6.61.0C300
Serrated ART.610D	6.61.0D100	6.61.0D200	6.61.0D300
Parallel ART.610E	6.61.0E100	6.61.0E200	6.61.0E300
Prismatic ART.610F	6.61.0F100	6.61.0F200	6.61.0F300



Tombstones & Cubes

The most accurate, rigid & durable horizontal machining clamping solution. Always cast, never fabricated.

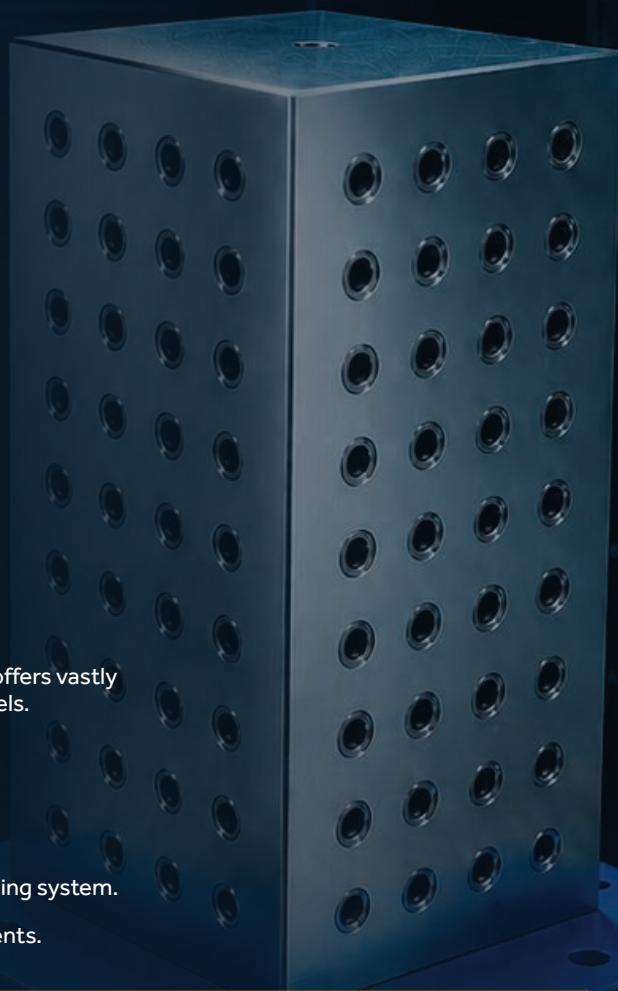
Solid G30 cast iron casting with 40mm wall thickness, perfect squareness, highest precision & rigidity.

One Piece Casting

- ✓ All Gerardi tombstones and cubes are made from a single casting which offers vastly improved accuracy, squareness and rigidity compared to fabricated models.
- ✓ Double stress relieved.

Modular

- ✓ Combine with Gerardi vices, zero point or clamps for a modular workholding system.
- ✓ Reduce set-up times and bespoke fixtures with standard clamping elements.



VARIOUS SHAPES



Grid Cube



Cross Cube



Grid angle with bushing



5 GEOMETRIES AVAILABLE ROUGH MILLED, FULLY MACHINED OR BESPOKE



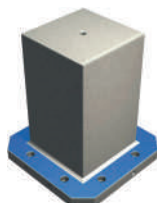
TYPE A ROUGH MILLED

Integral G30 cast iron casting rough milled with double stress relieving heat treatment. Wall thickness 43-45mm (10mm stock).



TYPE B BASE FINISHED

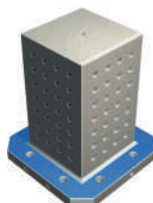
Rough milled casting with base face machined and hand scraped for direct clamping on European or Japanese standard pallets. Base includes 4 precision holes Ø20F7 with M16 threads and precise pitch dimensions for use with our Zero Point system or other pallets/head plates.



TYPE C COMPLETELY MACHINED

Cube completely finished with wall thickness roughly between 38-40mm.

Tolerance ± 0.02 mm.

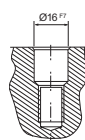


TYPE E GRID CUBE

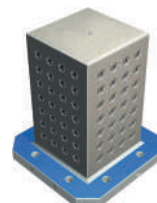
Integral cube with calibrated holes & solid threads.

Tolerance ± 0.02 mm

Holes and threads are made in the casting itself.



Type E Available On Request



TYPE F GRID CUBE WITH BUSHINGS

Integral cube with hardened bushings 100Cr6 and stainless steel helicoils.

Tolerance ± 0.02 mm

Centring bushings are in special hardened alloy steel 100 Cr6 - DIN 179C.

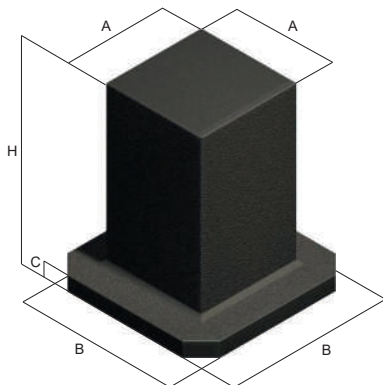
Type F Available On Request



ART.53A SQUARE CUBE

Rough Milled

- General tolerance ± 2 mm
- Wall thickness 43-45mm (10mm stock)



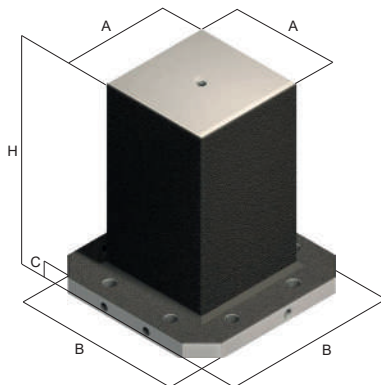
A	B	C	H	kg	Order Code
90	260	45	410	44	8.53.A00009
170	260	50	300	66	8.53.A00020
210	325	50	310	96	8.53.A00030
210	360	50	380	119	8.53.A00040
210	360	50	535	153	8.53.A00045
210	510	50	610	217	8.53.A00050
260	410	50	460	179	8.53.A00060
260	460	50	460	195	8.53.A00070
260	410	50	560	207	8.53.A00080
260	410	50	670	239	8.53.A00081
260	510	50	620	258	8.53.A00090
260	510	50	660	270	8.53.A00100
260	510	50	760	298	8.53.A00105
260	640	50	710	337	8.53.A00106
260	510	50	1010	368	8.53.A00107
280	410	50	520	210	8.53.A00110
310	510	50	610	293	8.53.A00111
310	510	50	760	345	8.53.A00113
310	510	50	910	397	8.53.A00115
340	510	50	670	335	8.53.A00120
360	510	50	420	252	8.53.A00140
360	510	50	460	268	8.53.A00150
360	510	50	560	310	8.53.A00160
360	510	50	620	334	8.53.A00170
360	510	50	710	372	8.53.A00171
360	640	50	710	425	8.53.A00172
360	640	50	830	496	8.53.A00180
360	510	50	830	420	8.53.A00181
360	640	50	960	529	8.53.A00185
460	640	50	560	431	8.53.A00190
460	640	50	660	486	8.53.A00200
510	640	50	870	655	8.53.A00211
560	760	50	860	763	8.53.A00220
510	810	50	810	704	8.53.A00230



ART.53B SQUARE CUBE

Rough Milled & Base Finished

- General tolerance ± 2 mm
- Wall thickness 43-45mm (10mm stock)
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet



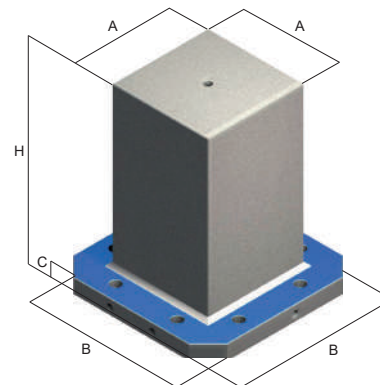
A	B	C	H	kg	Order Code
90	250	40	400	40	8.53.B00009
170	250	45	290	61	8.53.B00020
210	315	45	300	89	8.53.B00030
210	350	45	370	112	8.53.B00040
210	350	45	525	147	8.53.B00045
210	500	45	600	203	8.53.B00050
260	400	45	450	169	8.53.B00060
260	450	45	450	183	8.53.B00070
260	400	45	550	197	8.53.B00080
260	400	45	660	228	8.53.B00081
260	500	45	610	244	8.53.B00090
260	500	45	650	255	8.53.B00100
260	500	45	750	284	8.53.B00105
260	630	45	700	316	8.53.B00106
260	500	45	1000	355	8.53.B00107
280	400	45	510	198	8.53.B00110
310	500	45	600	278	8.53.B00111
310	500	45	750	330	8.53.B00113
310	500	45	900	383	8.53.B00115
340	500	45	660	321	8.53.B00120
360	500	45	410	236	8.53.B00140
360	500	45	450	253	8.53.B00150
360	500	45	550	294	8.53.B00160
360	500	45	610	319	8.53.B00170
360	500	45	700	356	8.53.B00171
360	630	45	700	403	8.53.B00172
360	630	45	820	452	8.53.B00180
360	500	45	820	403	8.53.B00181
360	630	45	950	508	8.53.B00185
460	630	45	550	409	8.53.B00190
460	630	45	650	463	8.53.B00200
510	630	45	860	631	8.53.B00211
560	750	45	850	732	8.53.B00220
510	800	45	800	671	8.53.B00230



ART.53C SQUARE CUBE

Completely Machined

- General tolerance ± 0.02 mm
- Cube completely finished with wall thickness roughly 38-40mm
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet



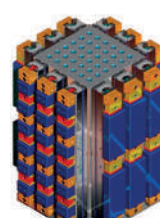
A	B	C	H	kg	Order Code
80	250	35	400	33	8.53.C00009
160	250	40	290	54	8.53.C00020
200	315	40	300	79	8.53.C00030
200	350	40	370	99	8.53.C00040
200	350	40	525	128	8.53.C00045
200	500	40	600	179	8.53.C00050
250	400	40	450	150	8.53.C00060
250	450	40	450	164	8.53.C00070
250	400	40	550	174	8.53.C00080
250	400	40	660	201	8.53.C00081
250	500	40	610	215	8.53.C00090
250	500	40	650	225	8.53.C00100
250	500	40	750	249	8.53.C00105
250	630	40	700	279	8.53.C00106
250	500	45	1000	310	8.53.C00107
270	400	40	510	176	8.53.C00110
300	500	40	600	247	8.53.C00111
300	500	40	750	293	8.53.C00113
300	500	40	900	338	8.53.C00115
330	500	40	660	287	8.53.C00120
350	500	40	410	212	8.53.C00140
350	500	40	450	226	8.53.C00150
350	500	40	550	263	8.53.C00160
350	500	40	610	284	8.53.C00170
350	500	40	700	317	8.53.C00171
350	630	40	700	359	8.53.C00172
350	630	40	820	402	8.53.C00180
350	500	40	820	358	8.53.C00181
350	630	40	950	450	8.53.C00185
450	630	40	550	367	8.53.C00190
450	630	40	650	415	8.53.C00200
500	630	40	860	565	8.53.C00211
550	750	40	850	656	8.53.C00220
500	800	40	800	600	8.53.C00230

Custom Design & Turnkey Solutions

From simple modifications to tombstones, to fully integrated clamping solutions and automation projects.

Our team of technical engineers will support you from concept to delivery of your custom workholding project.

Please contact our technical team on 01924 869615 or email techsupport@cutwel.net with your enquiry.

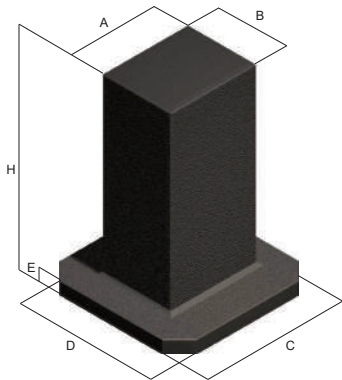




ART.54A RECTANGLE CUBE

Rough Milled

- General tolerance $\pm 2\text{mm}$
- Wall thickness 43-45mm (10mm stock)



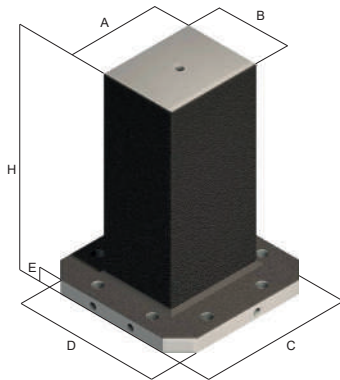
A	B	C	D	E	H	kg	Order Code
310	210	460	310	50	370	142	8.54.A00010
360	260	410	410	50	560	241	8.54.A00040
360	260	510	510	50	760	344	8.54.A00070
310	210	410	410	50	560	206	8.54.A00080
460	360	640	640	50	560	397	8.54.A00100
460	360	640	640	50	660	450	8.54.A00110
560	360	640	640	50	660	484	8.54.A00120



ART.54B RECTANGLE CUBE

Rough Milled & Base Finished

- General tolerance $\pm 2\text{mm}$
- Wall thickness 43-45mm (10mm stock)
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet



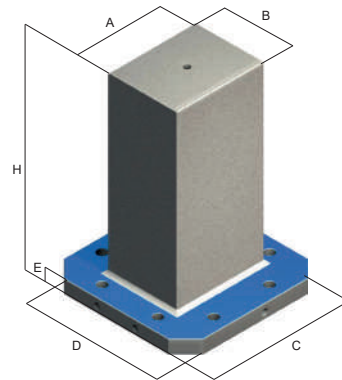
A	B	C	D	E	H	kg	Order Code
310	210	450	300	45	360	134	8.54.B00010
360	260	400	400	45	550	230	8.54.B00040
360	260	500	500	45	750	329	8.54.B00070
310	210	400	400	45	550	196	8.54.B00080
460	360	630	630	45	550	375	8.54.B00100
460	360	630	630	45	650	428	8.54.B00110
560	360	630	630	45	650	461	8.54.B00120



ART.54C RECTANGLE CUBE

Completely Machined

- General tolerance $\pm 0.02\text{mm}$
- Cube completely finished with wall thickness roughly 38-40mm
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet

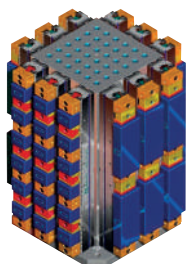


A	B	C	D	E	H	kg	Order Code
300	200	450	300	45	360	127	8.54.C00010
350	250	400	400	45	550	205	8.54.C00040
350	250	500	500	45	750	292	8.54.C00070
300	200	400	400	45	550	174	8.54.C00080
450	350	630	630	45	550	336	8.54.C00100
450	350	630	630	45	650	340	8.54.C00110
550	350	630	630	45	650	413	8.54.C00120

GET MORE OUT OF YOUR HORIZONTAL MACHINING CENTRE WITH GERARDI CLAMPING SOLUTIONS

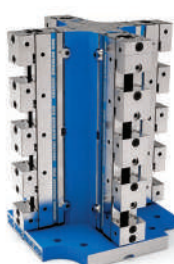
CUBE 48 MIXED PARTS

48 mixed parts clamped with 12 Multiflex vices arranged on a cube.



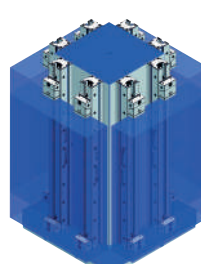
CROSS CUBE 4 VICES

4 Multiflex vices on Gerardi CROSS CUBE - interference free 3 SIDED machining.



CUBE 4x PLATES

4 large plates clamped with 8 Multiflex vices on Gerardi Cube - interference free machining.



MULTIFLEX TOWER

Multiflex tower complete with jaws for clamping up to 16 parts.



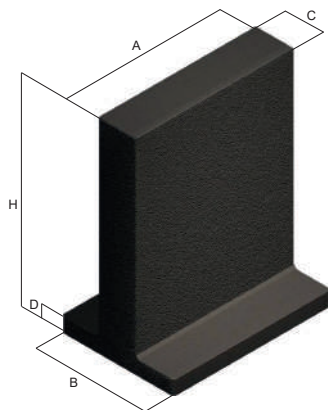
Scan for
Application
Ideas



ART.55A 2 SIDED TOMBSTONE

Rough Milled

- General tolerance ± 2 mm
- Wall thickness 43-45mm (10mm stock)



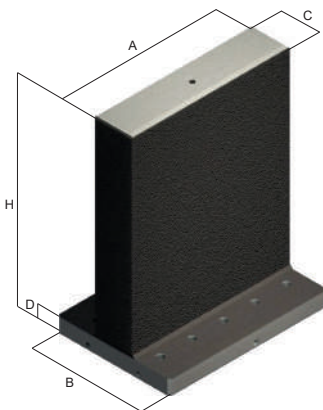
A	B	C	D	H	kg	Order Code
170	210	80	55	235	31	8.55.A00010
360	260	90	60	425	124	8.55.A00040
410	360	110	60	535	221	8.55.A00050
410	410	160	60	510	215	8.55.A00051
410	410	160	55	670	262	8.55.A00052
510	510	160	55	710	350	8.55.A00053
510	510	210	60	610	340	8.55.A00054
510	510	270	50	635	360	8.55.A00055
460	360	110	60	535	241	8.55.A00060
460	360	110	60	630	283	8.55.A00070
560	360	110	70	660	368	8.55.A00080
510	360	160	60	660	307	8.55.A00090
460	360	160	60	620	289	8.55.A00120
460	360	160	60	760	316	8.55.A00125
560	360	160	70	680	352	8.55.A00150
560	460	160	60	830	430	8.55.A00160
640	460	160	60	830	486	8.55.A00170
640	460	260	70	910	589	8.55.A00171
640	640	210	60	870	579	8.55.A00172
640	640	260	60	710	521	8.55.A00173
360	460	160	70	660	250	8.55.A00180
810	460	160	70	860	632	8.55.A00190
810	810	310	60	810	782	8.55.A00191
810	810	210	60	1010	855	8.55.A00192



ART.55B 2 SIDED TOMBSTONE

Rough Milled & Base Finished

- General tolerance ± 2 mm
- Wall thickness 43-45mm (10mm stock)
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet



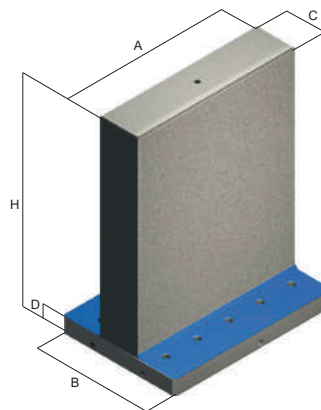
A	B	C	D	H	kg	Order Code
160	200	80	50	225	29	8.55.B00010
350	250	90	55	415	114	8.55.B00040
400	350	110	55	525	207	8.55.B00050
400	400	160	55	500	199	8.55.B00051
400	400	160	50	660	244	8.55.B00052
500	500	160	50	700	331	8.55.B00053
500	500	210	55	600	316	8.55.B00054
500	500	270	45	625	336	8.55.B00055
450	350	110	55	525	227	8.55.B00060
450	350	110	55	620	267	8.55.B00070
550	350	110	65	650	350	8.55.B00080
500	350	160	55	650	289	8.55.B00090
450	350	160	55	610	271	8.55.B00120
450	350	160	55	750	297	8.55.B00125
550	350	160	65	670	332	8.55.B00150
550	450	160	55	820	406	8.55.B00160
630	450	160	55	820	460	8.55.B00170
630	450	260	65	900	564	8.55.B00171
630	630	210	55	850	545	8.55.B00172
630	630	260	55	700	485	8.55.B00173
350	450	160	65	650	232	8.55.B00180
800	450	160	65	850	604	8.55.B00190
800	800	310	55	800	732	8.55.B00191
800	800	210	55	1000	820	8.55.B00192



ART.55B 2 SIDED TOMBSTONE

Rough Milled & Base Finished

- General tolerance ± 2 mm
- Wall thickness 43-45mm (10mm stock)
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet

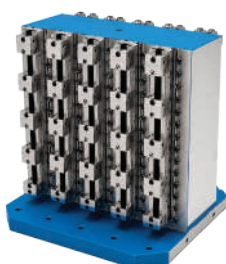


A	B	C	D	H	kg	Order Code
160	200	70	45	225	24	8.55.C00010
350	250	80	50	415	103	8.55.C00040
400	350	100	50	525	190	8.55.C00050
400	400	150	50	500	193	8.55.C00051
400	400	150	45	660	222	8.55.C00052
500	500	150	45	700	290	8.55.C00053
500	500	200	50	600	287	8.55.C00054
500	500	260	40	625	310	8.55.C00055
450	350	100	50	525	208	8.55.C00060
450	350	100	50	620	245	8.55.C00070
550	350	100	60	650	321	8.55.C00080
500	350	150	50	650	263	8.55.C00090
450	350	150	50	610	250	8.55.C00120
450	350	150	50	750	271	8.55.C00125
550	350	150	60	670	303	8.55.C00150
550	450	150	50	820	369	8.55.C00160
630	450	150	50	820	418	8.55.C00170
630	450	250	60	900	513	8.55.C00171
630	630	200	50	850	504	8.55.C00172
630	630	250	50	700	447	8.55.C00173
350	450	150	60	650	213	8.55.C00180
800	450	150	60	850	548	8.55.C00190
800	800	300	50	800	674	8.55.C00191
800	800	200	50	1000	814	8.55.C00192

GET MORE OUT OF YOUR HORIZONTAL MACHINING CENTRE WITH GERARDI CLAMPING SOLUTIONS

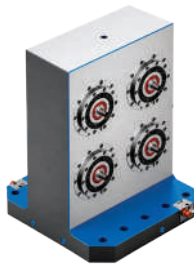
TOMBSTONE & MULTIFLEX VICES

2 sided tombstone and 10 Multiflex vices for 40 workpieces.



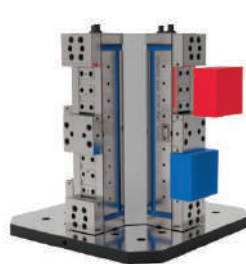
ZERO POINT TOMBSTONE

Tombstone with integral zero point clamping for rapid workpiece positioning



FMS VICES

No tombstone required, easier loading, stronger clamping.



ZERO POINT PALLET

For quick changeover of tombstones.

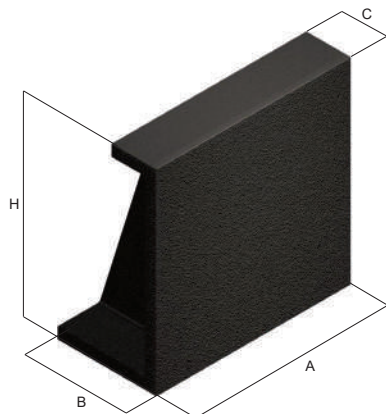




ART.56A 1 SIDED TOMBSTONE

Rough Milled

- General tolerance ± 2 mm
- Wall thickness 43-45mm (10mm stock)



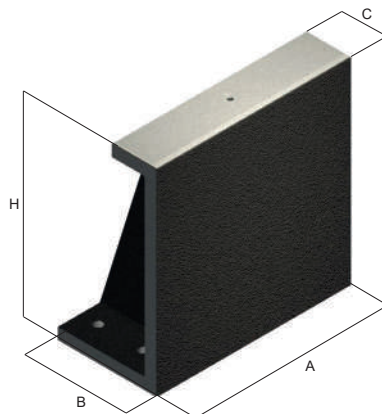
A	B	C	H	kg	Order Code
360	160	65	260	50	8.56.A00008
310	230	105	310	66	8.56.A00009
360	240	105	370	87	8.56.A00010
410	290	105	410	114	8.56.A00011
210	360	40	710	120	8.56.A00012
410	340	155	520	167	8.56.A00030
510	350	155	510	188	8.56.A00031
460	340	155	470	161	8.56.A00040
460	340	155	620	197	8.56.A00050
640	445	155	640	304	8.56.A00051
510	240	105	370	117	8.56.A00060
560	440	205	820	342	8.56.A00080
660	340	155	670	285	8.56.A00100
210	310	55	710	102	8.56.A00101
810	340	155	570	302	8.56.A00110
810	535	205	810	491	8.56.A00111
810	440	205	810	450	8.56.A00120



ART.56B 1 SIDED TOMBSTONE

Rough Milled & Base Finished

- General tolerance ± 2 mm
- Wall thickness 43-45mm (10mm stock)
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet



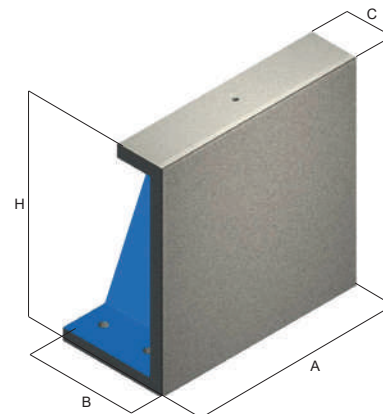
A	B	C	H	kg	Order Code
350	160	65	250	46	8.56.B00008
300	230	105	300	61	8.56.B00009
350	240	105	360	80	8.56.B00010
400	290	105	400	106	8.56.B00011
200	350	35	700	104	8.56.B00012
400	340	155	510	148	8.56.B00030
500	350	155	500	176	8.56.B00031
450	340	155	460	150	8.56.B00040
450	340	155	610	185	8.56.B00050
630	445	155	630	286	8.56.B00051
500	240	105	360	109	8.56.B00060
550	440	205	810	324	8.56.B00080
650	340	155	660	269	8.56.B00100
200	310	55	700	96	8.56.B00101
800	340	155	560	294	8.56.B00110
800	535	205	800	464	8.56.B00111
800	440	205	800	427	8.56.B00120



ART.56C 1 SIDED TOMBSTONE

Completely Machined

- General tolerance ± 0.02 mm
- Cube completely finished with wall thickness roughly 38-40mm
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet



A	B	C	H	kg	Order Code
350	150	60	250	42	8.56.C00008
300	220	100	300	57	8.56.C00009
350	230	100	360	75	8.56.C00010
400	280	100	400	100	8.56.C00011
200	350	35	700	100	8.56.C00012
400	330	150	510	140	8.56.C00030
500	340	150	500	166	8.56.C00031
450	330	150	460	142	8.56.C00040
450	330	150	610	174	8.56.C00050
630	435	150	630	270	8.56.C00051
500	230	100	360	307	8.56.C00060
550	430	200	810	252	8.56.C00080
650	330	150	660	245	8.56.C00100
200	300	50	700	90	8.56.C00101
800	330	150	560	266	8.56.C00110
800	525	200	800	452	8.56.C00111
800	430	200	800	402	8.56.C00120

Custom Design & Turnkey Solutions

From simple modifications to tombstones, to fully integrated clamping solutions and automation projects.

Our team of technical engineers will support you from concept to delivery of your custom workholding project.

Please contact our technical team on 01924 869615 or email techsupport@cutwel.net with your enquiry.



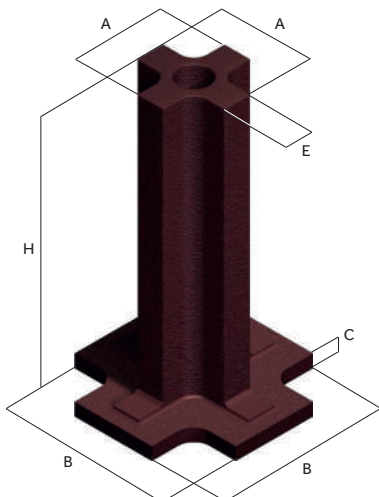


ART.57A CROSS CUBE

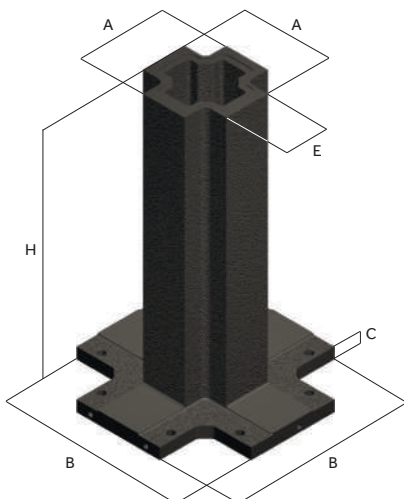
Rough Milled

- General tolerance ± 2 mm
- Wall thickness 43-45mm (10mm stock)

Type 1



Type 2



A	B	C	E	H	kg	Order Code
Type 1						
210	510	45	80	760	172	8.57.A00100
210	510	45	80	660	156	8.57.A00105
260	510	45	80	760	212	8.57.A00106
280	510	45	80	860	254	8.57.A00110
Type 2						
240	510	45	110	860	237	8.57.A00120
310	510	45	150	860	291	8.57.A00130
310	640	45	150	960	357	8.57.A00140
380	510	45	200	960	419	8.57.A00145
410	510	55	100	860	254	8.57.A00150

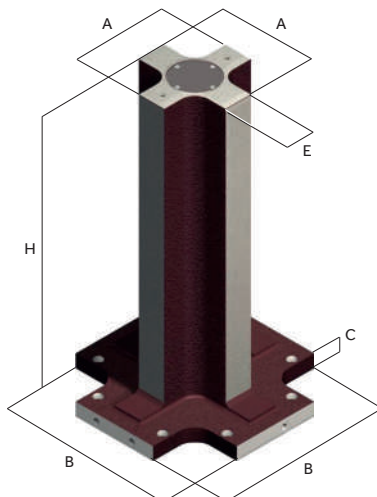


ART.57B CROSS CUBE

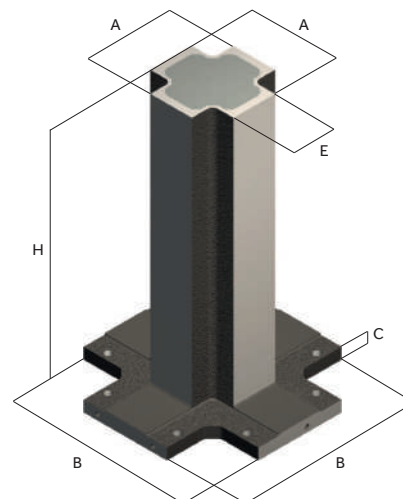
Rough Milled & Base Finished

- General tolerance ± 2 mm
- Wall thickness 43-45mm (10 mm stock)
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet

Type 1



Type 2



A	B	C	E	H	kg	Order Code
Type 1						
203	500	40	80	750	157	8.57.B00100
203	500	40	80	650	142	8.57.B00105
253	500	40	80	750	197	8.57.B00106
273	500	40	80	850	242	8.57.B00110
Type 2						
233	500	40	110	850	218	8.57.B00120
303	500	40	150	850	269	8.57.B00130
303	630	40	150	950	327	8.57.B00140
373	500	40	200	950	400	8.57.B00145
403	500	50	100	850	241	8.57.B00150

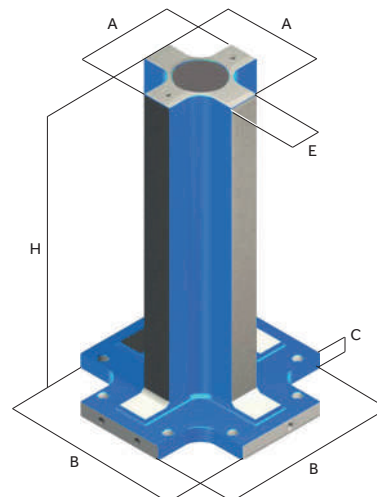


ART.57C CROSS CUBE

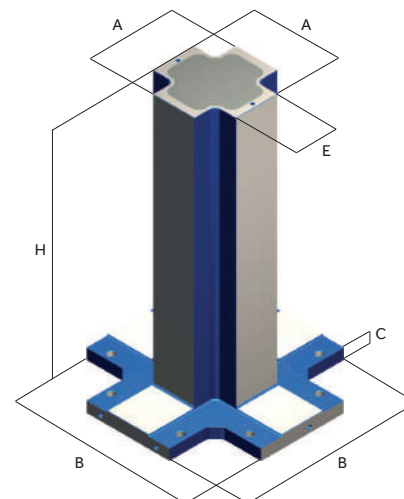
Completely Machined

- General tolerance ± 0.02 mm
- Cube completely finished with wall thickness roughly 38-40mm
- Base face machined and hand scraped for direct clamping on European or Japanese standard pallet

Type 1



Type 2



A	B	C	E	H	kg	Order Code
Type 1						
200	500	40	80	750	154	8.57.C00100
200	500	40	80	650	140	8.57.C00105
250	500	40	80	750	194	8.57.C00106
270	500	40	80	850	240	8.57.C00110
Type 2						
230	500	40	110	850	214	8.57.C00120
300	500	40	150	850	264	8.57.C00130
300	630	40	150	950	322	8.57.C00140
370	500	40	200	950	397	8.57.C00145
400	500	50	100	850	239	8.57.C00150



Zero Point Clamping

The easiest, most cost-effective way to reduce downtime and increase profits on machine beds with interface plates, 5-axis machines or tombstones.

5 Micron Repeatability

- ✓ Zero Point has a positioning accuracy of 0.005mm.
- ✓ Workpieces can be repositioned on the machine tool in seconds with the highest level of accuracy possible.

Immediate Pneumatic Clamping

- ✓ Zero Point modules clamp the workpiece, vice or fixture using high precision pull studs.
- ✓ Clamping pressure is released using pneumatic force and applied by releasing the air pressure, taking just 1-2 seconds to lock or unlock.

Any Machine Tool, Any Workpiece

- ✓ Perfect for vertical, horizontal or 5-axis machining.
- ✓ Use on small, wide, long or extremely large workpieces.



REDUCE YOUR SET-UP TIMES BY UP TO 95%



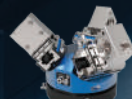
VERTICAL CNC

The Zero Point becomes the interface of all your fixtures and also your workpieces



HORIZONTAL CNC

The Zero Point is also a way to upgrade your existing fixtures

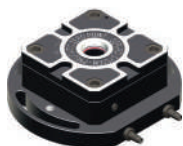


5-AXIS CNC

The same applications are also possible on 5-axis machines.

FLANGE MOUNTING

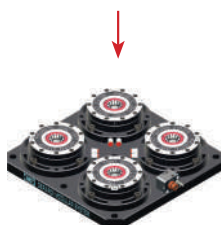
Ideally used for placing the pot straight onto a machine or rotary table. Can be easily moved or arranged for different workpieces. Also ideal for increasing workpiece height.



Single Zero Point clamping with anti-rotation keyway **ART.664S**



Zero Point for multiple Clamping **ART.664**



BUILT IN MOUNTING

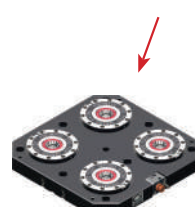
Ideal when used with fixture such as interface plates, tombstone or riser blocks. Zero Point sits almost flush with the fixture.



Single Zero Point clamping with anti-rotation keyway **ART.665S**



Zero Point for multiple clamping **ART.665**



Zero Point

Frequently Asked Questions

WHAT IS ZERO POINT?

Zero Point is a pneumatic clamping solution to reduce machine downtime and increase capacity with relatively small investment. The system positions vices, fixtures or even workpieces immediately on the machine with 0.005mm accuracy.

HOW DOES IT WORK?

- Pneumatic clamping - no hydraulics required
- Job, vice or fixture uses a pull stud which is clamped by the Zero Point pot
- Zero Point cannot let go of the pull stud even in air or power failures
- Possible to clamp small workpieces (with 1 pull stud and Zero Point) or large workpiece (with multiple modules)

WHAT MACHINES CAN USE IT?

- Vertical machining centres
- 5-axis machining centres
- Horizontal machining centres
- CMMs
- Rotary tables

WHAT IS THE RETURN ON INVESTMENT?

Zero Point can pay for itself in as quickly as a few months by decreasing machine downtime by as much as 95%. Customers often roll out Zero Point across the shop floor once they experience the benefits of their first system.

WHAT CAN IT CLAMP?

- Regular machine vices
- 5-axis machine vices (with or without riser blocks)
- Vices on sub plates
- Workpieces directly to the Zero Point modules
- Interface plates
- Tombstones/cubes

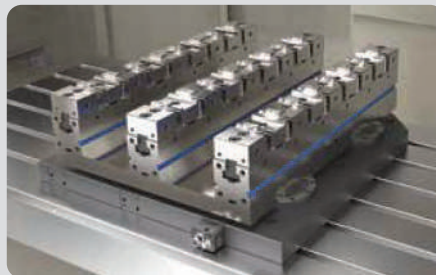
WHAT ARE THE BENEFITS?

- Reduce machine downtime by as much as 95%
- Rework jobs without the need to set up again due to immediate repositioning at almost ZERO microns
- Possible to use existing vices/fixtures through use of sub-plates
- Clamp the most irregular shaped workpieces with ease and power

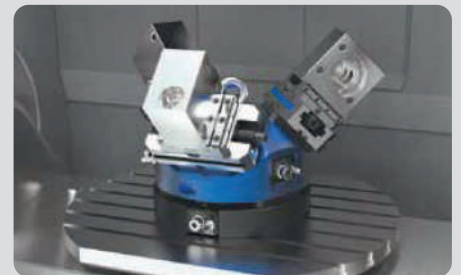
ZERO POINT APPLICATIONS



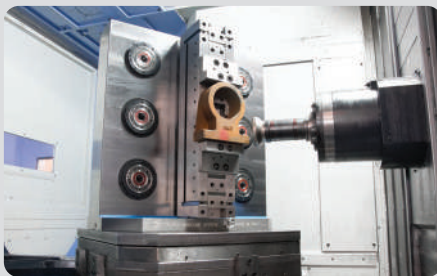
**ZERO POINT PLATE CLAMPING
SINGLE VICE**



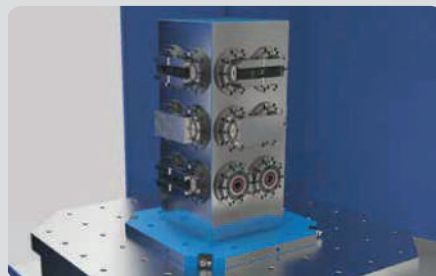
**ZERO POINT PLATE CLAMPING
MULTIFLEX VICES**



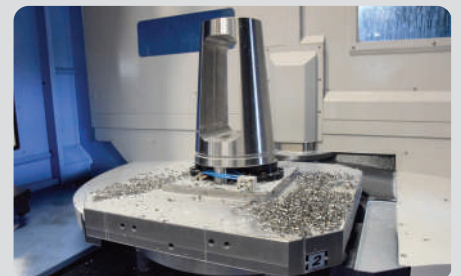
**PYRAMID SUPPORT WITH
5-AXIS COMPACTGRIP**



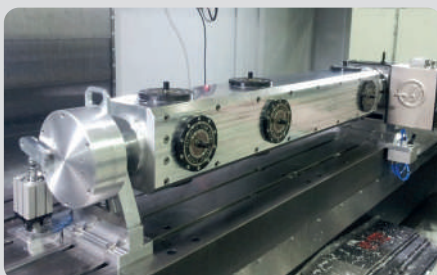
**ZERO POINT TOMBSTONE + FMS
Self-centring VICES**



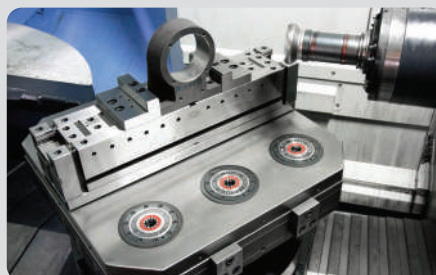
**ZERO POINT TOMBSTONE DIRECT
WORKPIECE CLAMPING**



**WORKPIECE CLAMPED DIRECTLY ONTO
ZERO POINT**



**ALUMINIUM FIXTURE WITH ROTARY
TABLE & ZERO POINT**



**ZERO POINT ON MACHINE PALLET
WITH FMS VICES**



**ZERO POINT FOR 5
AXIS MACHINING**



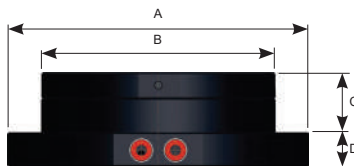
ZERO POINT MODULES (SINGLE TYPE)

Flange Mounted ART.664S

- Pneumatic clamping with 'double effect' clamping force
- Designed to be used for smaller workpieces or vices where only 1 module is required
- Supplied with positioning keyways to prevent the workpiece rotating when machining

STANDARD EQUIPMENT:

- 1 pull stud **ART.10/11A**
- 1 Teflon cap with O-ring **ART.9**



Zero Point Size	Max kN	Opening Pressure Bar	A	B	C	D	kg	Order Code
1	12	4-6	Ø138	Ø90	30	16	2.7	9.66.4S100
2	25	6-5	Ø188	Ø120	45	20	6.5	9.66.4S200
3	41	4-7	Ø215	Ø168	45	25	11.8	9.66.4S300



ZERO POINT MODULES (MULTIPLE TYPE)

Flange Mounted ART.664

- Pneumatic clamping
- Designed to be used for larger workpieces where multiple modules are required
- Extra keyways or calibrated holes available on request

STANDARD EQUIPMENT:

- 1 pull stud **ART.10/11A**
- 1 Teflon cap with O-ring **ART.9**



Zero Point Size	Max kN	Opening Pressure Bar	A	B	C	D	kg	Order Code
1	12	4-6	Ø138	Ø90	30	20	2.7	9.66.41000
2	14	4-14	Ø178	Ø138	35	20	5.7	9.66.42000
3	41	4-7	Ø215	Ø168	45	25	11.2	9.66.43000



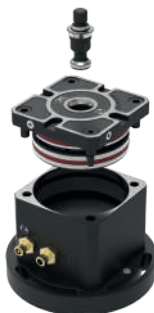
ZERO POINT RISER SINGLE KIT - ART63

ART.664S x1 + ART.63A Riser

- Ideal for 5-axis machining
- Use with vice or direct clamping of workpiece
- Steel base

STANDARD EQUIPMENT:

- 1 pull stud **ART.10/11A**
- 1 Teflon cap with O-ring **ART.9**
- 1 positioning pin **ART.640P**
- 1 shoulder calibrated screw **ART.83**



Zero Point Size	Height	Base Diameter	kg	Order Code
1	100	Ø138	6.1	9.63.10000
2	125	Ø188	8	9.63.20000



ZERO POINT RISER DOUBLE KIT - ART64

ART.664S x2 + ART.64A Riser

- Ideal for 5-axis machining
- Use with vice or direct clamping of workpiece
- Simultaneous clamping

STANDARD EQUIPMENT:

- 1 pull stud **ART.10/11A**
- 1 Teflon cap with O-ring **ART.9**
- 1 positioning pin **ART.640P**
- 2 shoulder calibrated screw **ART.83**



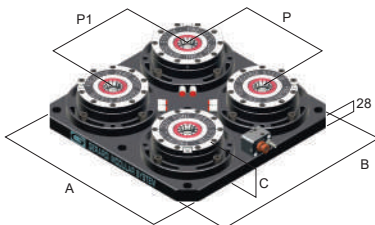
Zero Point Size	Height	Base Size	Pitch	kg	Order Code
1	100	120x270	150	15.5	9.64.10000
2	163	180x360	200	24.3	9.64.20000



ART.70P SQUARE ZERO POINT KIT

Flange Mounted, 4 Modules

- Steel or aluminium base plate with 4 ART.664
- Pneumatic clamping
- Supplied as standard for simultaneous clamping (independent clamping on request)
- Supplied with 4 pull studs ART.11 & 4 Teflon caps ART.9



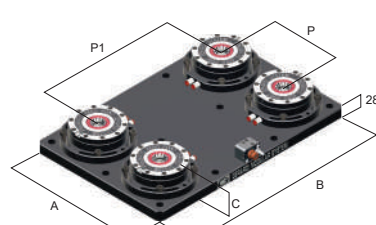
A	B	C	P	kg	Zero Points	Material	Order Code
400	400	79	200	59	4 x ART.664	Steel	9.70.P4040S4-KIT
				34		Aluminium	9.70.P4040A4-KIT
500	500	79	200	78		Steel	9.70.P5050S4-KIT
			250	35		Aluminium	9.70.P5050A4-KIT
			300				
630	630	79	200	110		Steel	9.70.P6363S4-KIT
			250	46		Aluminium	9.70.P6363A4-KIT
			300				
800	800	79	200	163		Steel	9.70.P8080S4-KIT
			300			Aluminium	9.70.P8080A4-KIT
			400	65			



ART.70P SQUARE ZERO POINT KIT

Flange Mounted, 4 Modules

- Steel or aluminium base plate with 4 ART.664
- Pneumatic clamping
- Supplied as standard for simultaneous clamping (independent clamping on request)
- Supplied with 4 pull studs ART.10 & 4 Teflon caps ART.9



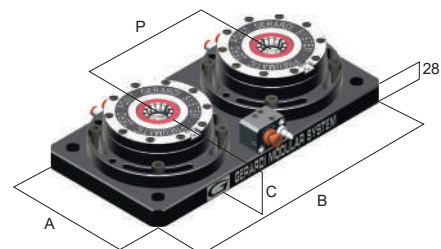
A	B	C	P	P1	kg	Zero Points	Material	Order Code
400	500	79	200	300	67	4 x ART.664-2	Steel	9.71.P4050S4-Kit
					31		Aluminium	9.71.P4050A4-Kit
400	600	79	200	400	76		Steel	9.71.P4060S4-Kit
					34		Aluminium	9.71.P4060A4-Kit
400	700	79	200	500	85		Steel	9.71.P4070S4-Kit
					37		Aluminium	9.71.P4070A4-Kit
400	800	79	200	600	94		Steel	9.71.P4080S4-Kit
					92		Aluminium	9.71.P4080A4-Kit



ART.71P RECTANGULAR ZERO POINT KIT

Flange Mounted, 4 Modules

- Steel or aluminium base plate with 2 ART.664
- Pneumatic clamping
- Supplied as standard for simultaneous clamping (independent clamping on request)
- Supplied with 2 pull studs ART.11 & 2 Teflon caps ART.9



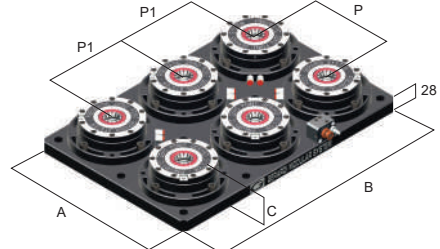
A	B	C	P	kg	Zero Points	Material	Order Code
200	400	79	200	29	2 x ART.664	Steel	9.71.P2040S2-Kit
				15		Aluminium	9.71.P2040A2-Kit
200	500	79	200	35		Steel	9.71.P2050S2-Kit
			250	17		Aluminium	9.71.P2050A2-Kit
			300				
200	600	79	400	42		Steel	9.71.P2060S2-Kit
				25		Aluminium	9.71.P2060A2-Kit



ART.71P RECTANGULAR ZERO POINT KIT

Flange Mounted, 4 Modules

- Steel or aluminium base plate with 6 ART.664
- Pneumatic clamping
- Supplied as standard for simultaneous clamping (independent clamping on request)
- Supplied with 6 pull studs ART.10 & 4 Teflon caps ART.9



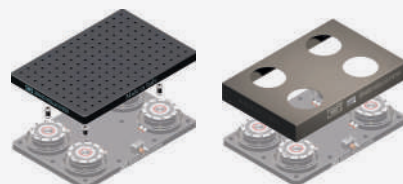
A	B	C	P	P1	kg	Zero Points	Material	Order Code
400	500	79	200	200	79	6 x ART.664-2	Steel	9.71.P4050S6-Kit
					38		Aluminium	9.71.P4050A6-Kit
400	600	79	200	200	88		Steel	9.71.P4060S6-Kit
					41		Aluminium	9.71.P4060A6-Kit
400	700	79	200	250	97		Steel	9.71.P4070S6-Kit
					83		Aluminium	9.71.P4070A6-Kit
400	800	79	200	300	106		Steel	9.71.P4080S6-Kit
					47		Aluminium	9.71.P4080A6-Kit



ZERO POINT ACCESSORIES

- Plain, grid or custom interface plates
- Steel cover plates

Please contact our technical team on 01924 869615 or email techsupport@cutwel.net with your enquiry.





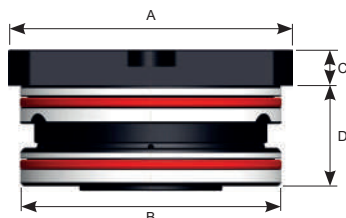
ZERO POINT MODULES (SINGLE TYPE)

Built-In Mounted ART.665S

- Pneumatic clamping with 'double effect' clamping force
- Designed to be used for smaller workpieces or vices where only 1 module is required
- Supplied with positioning keyways to prevent the workpiece rotating when machining

STANDARD EQUIPMENT:

- 1 pull stud ART.10/11A
- 1 Teflon cap with O-ring ART.9



SIZE 1-2



SIZE 3

Zero Point Size	Max kN	Opening Pressure BAR	A	B	C	D	kg	Order Code
1	12	4-6	90x90	Ø84	12	30	1.5	9.66.5S100
2	25	4-6	120x120	Ø110	15	42	2.5	9.66.5S200
3	41	4-7	Ø168	Ø138	15	47	5.8	9.66.5S300



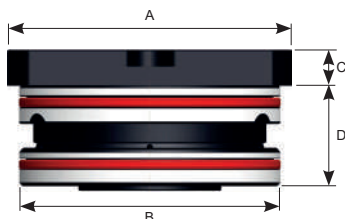
ZERO POINT MODULES (MULTIPLE TYPE)

Built-In Mounted ART.665S

- Pneumatic clamping
- Designed to be used for larger workpieces where multiple modules are required
- Extra keyways or calibrated holes available on request

STANDARD EQUIPMENT:

- 1 pull stud ART.10/11A
- 1 Teflon cap with O-ring ART.9



SIZE 1



SIZE 2-3

Zero Point Size	Max kN	Opening Pressure BAR	A	B	C	D	kg	Order Code
1	12	4-6	90x90	Ø84	12	30	1.5	9.66.51000
2	14	4-14	Ø138	Ø110	15	33	2.7	9.66.52000
3	41	4-7	Ø168	Ø138	15	47	5.8	9.66.53000



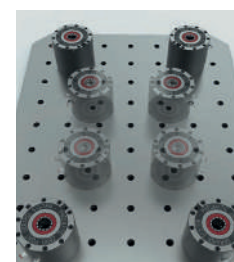
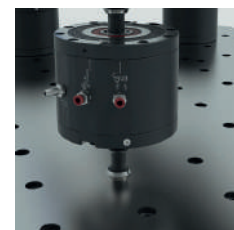
DOUBLE ZERO POINT

Built In Mounted ART.665T

- Pneumatic Clamping
- Contains a Zero Point module on both ends, for immediate positioning of Zero Point on interface grid plate

STANDARD EQUIPMENT:

- 1 pull stud ART.10/11A
- 1 Teflon cap with O-ring ART.9



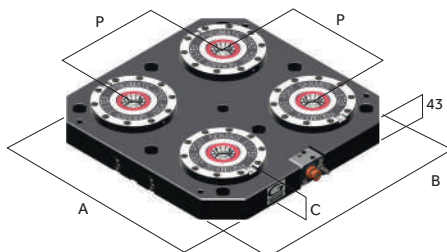
Zero Point Size	kN	Height	kg	Order Code
1	12	106	5.2	9.66.5T100
2	14	112	9.7	9.66.5T200
3	41	142	18.8	9.66.5T300



ART.80P SQUARE ZERO POINT KIT

Built In Type, 4 Modules

- Steel or aluminium base plate with 4 ART.665
- Pneumatic clamping
- Supplied as standard for simultaneous clamping (independent clamping on request)
- Supplied with 4 pull studs ART.10 & 4 Teflon caps ART.9



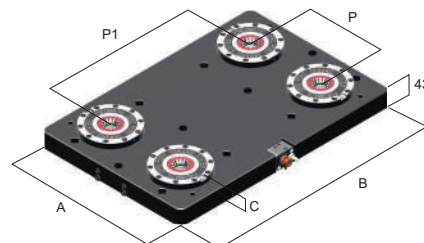
A	B	C	P	kg	Zero Points	Material	Order Code
400	400	58	200	60	4 x ART.665-2	Steel	9.80.P4040S4-KIT
				29		Aluminium	9.80.P4040A4-KIT
				91		Steel	9.80.P5050S4-KIT
500	500	58	250	44		Aluminium	9.80.P5050A4-KIT
				140		Steel	9.80.P6363S4-KIT
630	630	58	300	58		Aluminium	9.80.P6363A4-KIT
				200		Steel	9.80.P8080S4-KIT
800	800	58	300	220		Aluminium	9.80.P8080A4-KIT
				87			
				400			



ART.81P RECTANGULAR ZERO POINT KIT

Built In Type, 4 Modules

- Steel or aluminium base plate with 4 ART.665
- Pneumatic clamping
- Supplied as standard for simultaneous clamping (independent clamping on request)
- Supplied with 4 pull studs ART.10 & 4 Teflon caps ART.9



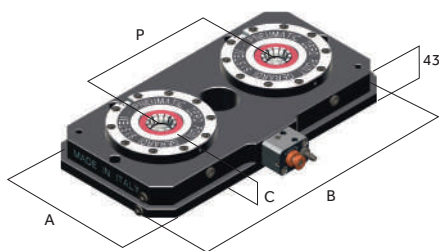
A	B	C	P	P1	kg	Zero Points	Material	Order Code
400	500	58	200	300	74	4 x ART.665-2	Steel	9.81.P4050S4-KIT
					34		Aluminium	9.81.P4050A4-KIT
					87		Steel	9.81.P4060S4-KIT
400	600	58	200	400	39		Aluminium	9.81.P4060A4-KIT
					100		Steel	9.81.P4070S4-KIT
400	700	58	200	500	44		Aluminium	9.81.P4070A4-KIT
					114		Steel	9.81.P4080S4-KIT
400	800	58	200	600	49		Aluminium	9.81.P4080A4-KIT



ART.81P RECTANGULAR ZERO POINT KIT

Built In Type, 2 Modules

- Steel or aluminium base plate with 2 ART.665
- Pneumatic clamping
- Supplied as standard for simultaneous clamping (independent clamping on request)
- Supplied with 2 pull studs ART.10 & 2 Teflon caps ART.9



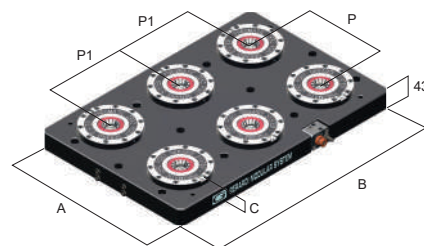
A	B	C	P	kg	Zero Points	Material	Order Code
200	400	58	200	29	2 x ART.665-2	Steel	9.81.P2040S2-KIT
				15		Aluminium	9.81.P2040A2-KIT
				35		Steel	9.81.P2050S2-KIT
200	500	58	250	17		Aluminium	9.81.P2050A2-KIT
				42		Steel	9.81.P2060S2-KIT
200	600	58	300	25		Aluminium	9.81.P2060A2-KIT



ART.81P RECTANGULAR ZERO POINT KIT

Built In Type, 6 Modules

- Steel or aluminium base plate with 6 ART.665
- Pneumatic clamping
- Supplied as standard for simultaneous clamping (independent clamping on request)
- Supplied with 6 pull stud ART.10 & 6 Teflon caps ART.9



A	B	C	P	P1	kg	Zero Points	Material	Order Code
400	500	58	200	150	79	6 x ART.665-2	Steel	9.81.P4050S6-KIT
					39		Aluminium	9.81.P4050A6-KIT
					91		Steel	9.81.P4060S6-KIT
400	600	58	200	200	44		Aluminium	9.81.P4060A6-KIT
					105		Steel	9.81.P4070S6-KIT
400	700	58	200	250	49		Aluminium	9.81.P4070A6-KIT
					118		Steel	9.81.P4080S6-KIT
400	800	58	200	300	54		Aluminium	9.81.P4080A6-KIT



ZERO POINT ACCESSORIES

- Plain, grid or custom interface plates

Please contact our technical team on 01924 869615 or email techsupport@cutwel.net with your enquiry.

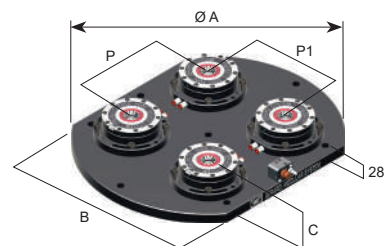




ART.72P ROUNDED HEAD PLATE ZERO POINT KIT

Flange Mounted, Size 2, 1-8 Pots

- Pneumatic Clamping
- Size 2 ART.664 flange mounted zero point
- Supplied as standard for simultaneous clamping (independent clamping on request)
- For 5-axis machining centres
- Tailor-made plate on request



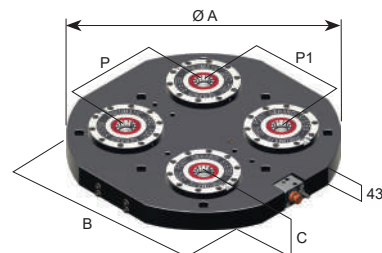
Machine	Zero Point Kit ART.72P								Cover Plate ART.72CP		
	Ø A	B	C	P	P1	No. Zero Points	kg	Material	Order Code	kg	Order Code
Hermule C600U	280	-	79	-	-	1x ART.664	19	Steel	9.72.P2828S1-KIT	1.4	9.72.CP28281
							11	Aluminium	9.72.P2828A1-KIT		
DMG DMU 50 Evo	500	380	79	200	200	4x ART.664	61	Steel	9.72.P5038S4-KIT	2.7	9.72.CP50384
							37	Aluminium	9.72.P5038A4-KIT		
Mazak Variax 500	500	400	79	200	200	4x ART.664	63	Steel	9.72.P5040S4-KIT	2.8	9.72.CP50404
							38	Aluminium	9.72.P5040A4-KIT		
Hermule C40U	420	-	79	200	200	4x ART.664	65	Steel	9.72.P4242S4-KIT	2.2	9.72.CP42424
							35	Aluminium	9.72.P4242A4-KIT		
DMG DMU 50	630	500	79	200 / 250 / 300	200 / 250 / 300	4x ART.664	85	Steel	9.72.P6350S4-KIT	4.4	9.72.CP63504
							46	Aluminium	9.72.P6350A4-KIT		
Mazak Variax 630	630	500	79	200 / 250 / 300	200 / 250 / 300	4x ART.664	85	Steel	9.72.P6350S4-KIT	4.4	9.72.CP63504
							46	Aluminium	9.72.P6350A4-KIT		
DMG DMU 70 Evo	700	500	79	200 / 300 / 400	200 / 300	4x ART.664	94	Steel	9.72.P7050S4-KIT	5	9.72.CP70504
							49	Aluminium	9.72.P7050A4-KIT		
DMG DMC 635V	790	560	79	200 / 250	200 / 250 / 300	6x ART.664	124	Steel	9.72.P7956S6-KIT	5.9	9.72.CP79566
							68	Aluminium	9.72.P7956A6-KIT		
DMG DMC 1035V	1000	560	79	200 / 300 / 350	200 / 300 / 400	8x ART.664	151	Steel	9.72.P1056S8-KIT	7.5	9.72.CP10568
							78	Aluminium	9.72.P1056A8-KIT		
DMG DMU 80P	900	630	79	200 / 250	200 / 300 / 400	6x ART.664	149	Steel	9.72.P9063S6-KIT	7.6	9.72.CP90636
							76	Aluminium	9.72.P9063A6-KIT		



ART.82P ROUNDED HEAD PLATE ZERO POINT KIT

Built In Type, Size 2, 2-8 Pots

- Pneumatic clamping
- Size 2 ART.665 built in mounted zero point
- Supplied as standard for simultaneous clamping (independent clamping on request)
- For 5-axis machining centres
- Tailor made plate on request



Machine	Ø A	B	C	P	P1	No. of Zero Points	kg	Material	Order Code
Hermule C600U	280	-	58	150	-	2x ART.665	30	Steel	9.82.P2828S2-KIT
							17	Aluminium	9.82.P2828A2-KIT
DMG DMU 50 Evo	500	380	58	200 / 250	200	4x ART.665	67	Steel	9.82.P5038S4-KIT
							29	Aluminium	9.82.P5038A4-KIT
Mazak Variax 500	500	400	58	200 / 250	200 / 250	4x ART.665	69	Steel	9.82.P5040S4-KIT
							31	Aluminium	9.82.P5040A4-KIT
Hermule C40U	420	-	58	200	200	4x ART.665	56	Steel	9.82.P4242S4-KIT
							26	Aluminium	9.82.P4242A4-KIT
DMG DMU 50	630	500	58	200 / 250 / 300	200 / 250 / 300	4x ART.665	103	Steel	9.82.P6350S4-KIT
							43	Aluminium	9.82.P6350A4-KIT
Mazak Variax 630	630	500	58	200 / 250 / 300	200 / 250 / 300	4x ART.665	103	Steel	9.82.P6350S4-KIT
							43	Aluminium	9.82.P6350A4-KIT
DMG DMU 70 Evo	700	500	58	200 / 300 / 400	200 / 250 / 300	4x ART.665	116	Steel	9.82.P7050S4-KIT
							48	Aluminium	9.82.P7050A4-KIT
DMG DMC 635V	790	560	58	200 / 250	200 / 300 / 400	6x ART.665	149	Steel	9.82.P7956S6-KIT
							63	Aluminium	9.82.P7956A6-KIT
DMG DMC 1035V	1000	560	58	200 / 250 / 350	200 / 300 / 400	8x ART.665	197	Steel	9.82.P1056S8-KIT
							83	Aluminium	9.82.P1056A8-KIT
DMG DMU 80P	900	630	58	200 / 250 / 350	200 / 300 / 400	6x ART.664	188	Steel	9.82.P9063S6-KIT
							87	Aluminium	9.82.P9063A6-KIT

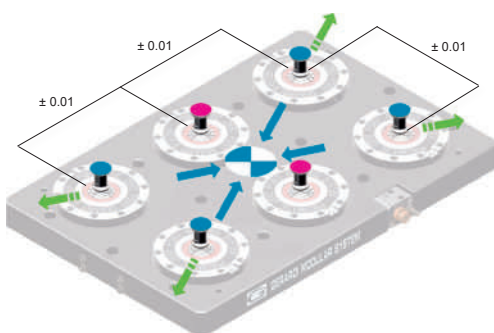
PULL STUD SELECTION GUIDE

FOR MULTIPLE TYPE ZERO POINT POTS
ART.664 & 665

The Zero Point interface plate with **ART.664 & ART.665** MULTIPLE TYPE Zero Point pots is designed for clamping 1 large workpiece or sub-plate over 6 pots.

The multiple type zero-point system has a fixed central reference point & allows lateral translation eliminating centre distance variation caused by temperature. Use a maximum of 4 positioning pull-studs alternated with clamping pull-studs.

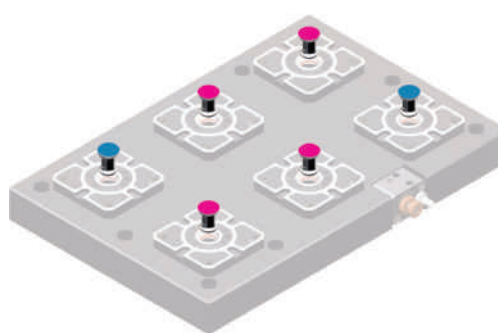
- Positioning & clamping pull-stud
- Clamping pull-stud

FOR INDEPENDENT TYPE ZERO POINT POTS
ART.664S & 665S

Using a Zero Point interface plate with **ART.664S & ART.665S** INDEPENDENT TYPE Zero Point pots allows for dual use of the system, either clamping multiple single workpieces (1 per pot) or larger workpieces (spread over 2 or more pots).

When used for clamping a large work piece with 6 pots, the system requires a maximum of 2 positioning pull-studs, alternated with clamping pull-studs.

- Positioning & clamping pull-stud
- Clamping pull-stud

POSITIONING PULL STUD
ART.10A, FEMALE THREAD

SIZE 1



Order Code

9.10.A1000

CLAMPING PULL STUD
ART.10B, FEMALE THREAD

SIZE 1



Order Code

9.10.B1000

POSITIONING PULL STUD
ART.11A, MALE THREAD

SIZE 1



Order Code

9.11.A1000

CLAMPING PULL STUD
ART.11B, MALE THREAD

SIZE 1



Order Code

9.11.B1000

SIZE 2



Order Code

9.10.A2000

SIZE 2



Order Code

9.10.B2000

SIZE 2



Order Code

9.11.A2000

SIZE 2



Order Code

9.11.B2000

SIZE 3



Order Code

9.10.A3000

SIZE 3



Order Code

9.10.B3000

SIZE 3



Order Code

9.11.A3000

SIZE 3



Order Code

9.11.B3000



CLAMP KIT WITH SERRATED STEP BLOCKS

- Made from high quality steel
- Set contains: 6 t-nuts, 16 studs, 6 support nuts, 4 nuts with washer, 2 extension nuts, 4 thick washers, 4 serrated clamps, 8 clamps with support hole and 1 t-slot scraper

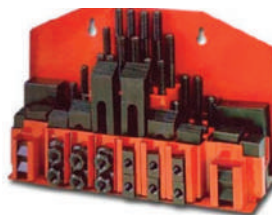


Bolt and T-Nut Size	kg	Order Code
M10x12	7.2	2010-1012
M12x14	9.2	2010-1214
M14x16	12.2	2010-1416
M16x18	15.6	2010-1618
M18x20	18.0	2010-1820



52PC BASIC STEEL CLAMPING KIT

- Made from high quality steel
- Set contains: 6 t-nuts, 24 studs, 4 coupling nuts, 6 flange nuts, 6 step clamps and 6 serrated step blocks



Bolt and T-Nut Size	Weight	Order Code
M8x10	8	CK-08
M10x12	9.5	CK-10
M12x14	12.8	CK-12A
M14x16	15.9	CK-14
M16x18	12.7	CK-16
M20x22	18	CK-18



PARALLEL SET GROUND & HARDENED 28PC SET

- Includes 2pcs: 14, 16, 18, 20, 22, 24, 26, 28, 30, 32, 35, 40, 45 & 50mm high
- Tolerance +/-0.01mm
- 150mm wide



Order Code

2230-028



PARALLEL SET GROUND & HARDENED 16PC SET

- Includes 2pcs: 20, 23, 28, 36, 42, 48, 58 & 65mm high
- Tolerance +/-0.01mm
- 20, 23 & 28 are 100mm wide, all others are 150mm wide



Order Code

2250-016



PARALLEL SET GROUND & HARDENED

- For parallel support of workpieces in machine vices, on machine tools or on marking-off plates
- In pairs, tolerance IT 5, nominal width to DIN ISO 2768-1, tolerance class m

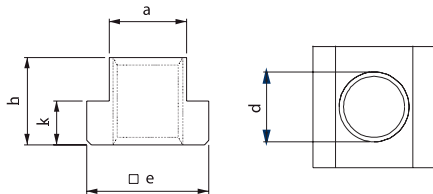
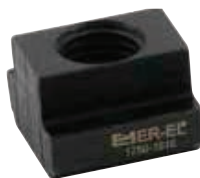


Composition of set (Width x Height)	Min. Set Height mm	Max. Set Height mm	Width mm	Pair Tolerance	Order Code
2x5, 2x10, 2x15, 2x20, 3x6, 3x11, 3x16, 3x21, 4x7, 4x12, 4x17, 4x22, 5x8, 5x23, 6x9, 6x14, 6x19, 6x24	2	24	100	IT 5	26254010
8x11, 8x16, 8x21, 8x26, 8x31, 8x36, 10x13, 10x18, 10x23, 10x28, 10x33, 10x38, 12x15, 12x20, 12x25, 12x30, 12x35, 12x40, 14x17, 14x22, 14x27, 14x32, 14x37, 14x42	8	42	125	IT 5	26254020
8x11, 8x16, 8x21, 8x26, 8x31, 8x36, 10x13, 10x18, 10x23, 10x28, 10x33, 10x38, 12x15, 12x20, 12x25, 12x30, 12x35, 12x40, 14x17, 14x22, 14x27, 14x32, 14x37, 14x42	8	42	150	IT 5	26254030



STANDARD T-NUT

- Hardened (Grade 10)
- DIN 508

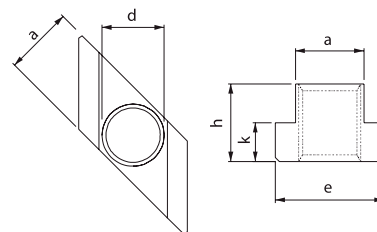


Thread d	T-Nut Size	a	e	h	k	Order Code
M5	6	5.7	10	8	4	1750-0506
M6	8	7.7	13	10	6	1750-0608
M8	10	9.7	15	12	6	1750-0810
M8	12	11.7	18	14	7	1750-0812
M10	12	11.7	18	14	7	1750-1012
M8	14	13.7	22	16	8	1750-0814
M10	14	13.7	22	16	8	1750-1014
M12	14	13.7	22	16	8	1750-1214
M8	16	15.7	25	18	9	1750-0816
M10	16	15.7	25	18	9	1750-1016
M12	16	15.7	25	18	9	1750-1216
M14	16	15.7	25	18	9	1750-1416
M8	18	17.7	28	20	10	1750-0818
M10	18	17.7	28	20	10	1750-1018
M12	18	17.7	28	20	10	1750-1218
M14	18	17.7	28	20	10	1750-1418
M16	18	17.7	28	20	10	1750-1618
M16	20	19.7	32	24	12	1750-1620
M18	20	19.7	32	24	12	1750-1820
M16	22	21.7	35	28	14	1750-1622
M18	22	21.7	35	28	14	1750-1822
M20	22	21.7	35	28	14	1750-2022
M16	24	23.7	40	32	16	1750-1624
M20	24	23.7	40	32	16	1750-2024
M22	24	23.7	40	32	16	1750-2224
M16	28	27.7	44	36	18	1750-1628
M20	28	27.7	44	36	18	1750-2028
M22	28	27.7	44	36	18	1750-2228
M24	28	27.7	44	36	18	1750-2428
M24	36	35.6	54	44	22	1750-2436
M30	36	35.6	54	44	22	1750-3036
M36	42	41.6	65	52	26	1750-3642
M42	48	47.6	75	60	30	1750-4248



RHOMBOID T-NUT

- Hardened (Grade 10)
- T-nut can be located from above the T-slot

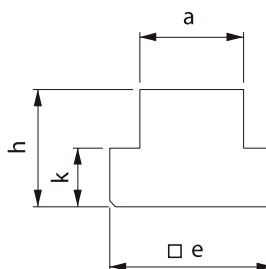
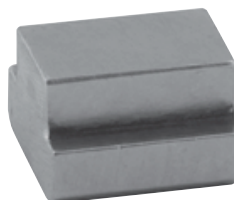


Thread d	T-Nut Size	a	e	a	e	Order Code
M8	10	9.7	15	12	6	1770-0810
M10	12	11.7	18	14	7	1770-1012
M10	14	13.7	22	16	8	1770-1014
M12	14	13.7	22	16	8	1770-1214
M14	16	15.7	25	18	9	1770-1416
M10	18	17.7	28	20	10	1770-1018
M16	18	17.7	28	20	10	1770-1618
M16	20	19.7	32	24	12	1770-1620
M18	20	19.7	32	24	12	1770-1820
M16	22	21.7	35	28	14	1770-1622
M20	22	21.7	35	28	14	1770-2022
M16	28	27.7	44	36	18	1770-1628
M20	28	27.7	44	36	18	1770-2028
M24	28	27.7	44	36	18	1770-2428



T-NUT WITHOUT HOLE

- Machinable

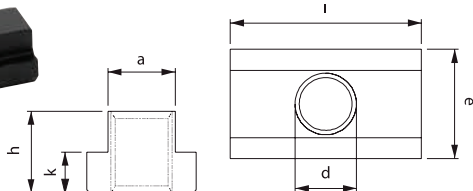


T-Nut Size	a	e	h	k	Order Code
6	5.7	10	8	4	1730-06
8	7.7	13	10	6	1730-08
10	9.7	15	12	6	1730-10
12	11.7	18	14	7	1730-12
14	13.7	22	16	8	1730-14
16	15.7	25	18	9	1730-16
18	17.7	28	20	10	1730-18
20	19.7	32	24	12	1730-20
22	21.7	35	28	14	1730-22
24	23.7	40	32	16	1730-24
28	27.7	44	36	18	1730-28
36	35.6	54	44	22	1730-36
42	41.6	65	52	26	1730-42



LONG T-NUT

- Hardened (Grade 10)



Thread d	T-Nut Size	a	e	l	h	k	Order Code
M8	10	7.7	13	26	10	6	1710-0608
M10	12	9.7	15	30	12	6	1710-0810
M10	14	11.7	18	36	14	7	1710-1012
M12	14	13.7	22	44	16	8	1710-1214
M14	16	15.7	25	50	18	9	1710-1416
M16	18	17.7	28	56	20	10	1710-1618
M18	20	19.7	32	64	24	12	1710-1820
M20	22	21.7	35	70	28	14	1710-2022
M22	24	23.7	40	80	32	16	1710-2224
M24	28	27.7	44	88	36	18	1710-2428
M30	36	35.6	54	108	44	22	1710-3036



ZERO SETTER

- Magnetic base



Height mm	Accuracy	Test Force	Order Code
50	±10µm	9N (at 50mm)	2397-502A



100MM ZERO SETTER

- Magnetic base with on/off switch
- 100mm height
- Graduation: 0.01mm



Accuracy mm/inch	Order Code
±0.010	2394-100A



50MM ELECTRONIC ZERO SETTER

- The base is electrically conducted to the cutting tools through the table and chuck, the LED lights up when the cutting tool touches the anvil
- Magnetic base
- 2 batteries LR44 or SR44
- Base Ø39mm



Height mm	Accuracy mm	Order Code
50	0.01	6553-50



ZERO SETTER

- Includes setting rod
- Base Ø63mm
- Dial face Ø40



Height mm	Accuracy	Test Force	Order Code
50	0.01	10N	6556-50



ZERO SETTER

- Base Ø65mm
- Dial face Ø40mm



Height mm	Accuracy	Test Force	Order Code
50	±10µm	9N (at 50mm)	6554-50



IP65 DIGITAL ZERO SETTER

- Resolution: 0.001mm/0.00005"
- Magnetic base
- Automatic backlight at zero



Height mm	Accuracy	Test Force	Order Code
50	±10µm	9N (at 50mm)	6557-50

**2D EDGE FINDER**

- Hardened shank and contact point
- Suitable for machine speed 400-600rpm



Shank mm	Contact point mm	Accuracy	Order Code
10	6	8µm	6567-1

**2D ELECTRONIC EDGE FINDER**

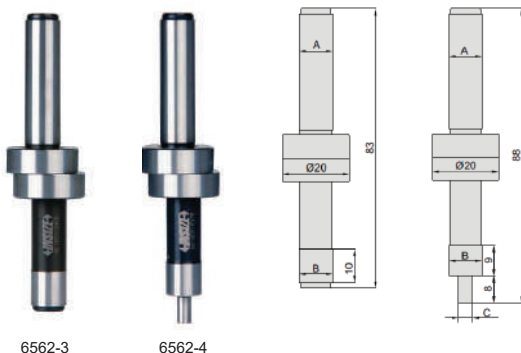
- Not suitable for rotary use
- Hardened shank and contact ball
- More accurate than Wigglers / Wobbler
- Edge finder automatically resets when you back away from the setting edge
- Contact ball 10mm



Shank mm	Beeper	Order Code
20	Without	6566-2
	With	6566-3

**2D EDGE FINDER**

- Hardened shank and contact point
- Suitable for machine speed 400-600rpm



Shank (A) mm	Contact Point (B) mm	(C) mm	Accuracy	Order Code
Ø10	Ø10	-	5µm	6562-3
		Ø4		6562-4

**3D ELECTRONIC EDGE FINDER**

- Shank is electrically conducted to the metal workpiece through the chuck and table, the LED lights up, when the ball touches the workpiece
- Not suitable for rotary use
- Hardened contact ball



Shank mm	Contact Ball mm	Accuracy	Battery	Order Code
Ø16	SØ10	10µm	A23S, 12Vx1pc	6571-1
Ø20			A23S, 12Vx1pc	6571-2

**IP67 NEW GENERATION DIAL 3D SENSOR**

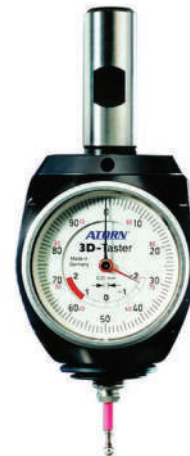
- Compact IP67-rated 3D sensor for precise spindle alignment and workpiece set-up
- Improved, easy-grip design with no restriction to the working area
- High accuracy of 0.01 mm for reliable measuring and positioning
- Marked overrun safety distance helps protect the sensor during use
- Ideal for setting zero points, aligning edges, centring bores and shafts
- Also suitable for measuring lengths, depths, straightness and surface levelness



Reading mm	Shank Diameter Ø	Accuracy mm	Order Code
0.01	12	±0.01	80.360.00NG

**IP67 UNIVERSAL DIAL 3D SENSOR**

- IP67 protection
- For milling and EDM machines
- Smallest unit of measure: 0.01mm
- Supplied with 4mm insulated probe
- Clamped into a tool holder & inserted into milling spindle
- Find exact positioning of the spindle axis on the edges of the workpiece
- Approach in any direction (X, Y, Z axis)
- No calculating on the probe's ball diameter is necessary - just zero it out!
- Replaceable probes give maximum flexibility



Reading mm	Shank Diameter Ø	Accuracy mm	Order Code
0.01	12	±0.01	80.360.00NG



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