GERARDI

3

Wide range of standard elements to clamp special applications

STD - StandardFLEX

Elementi Modulari / *Modular Elements*

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VALIGETTA DI CAMPIONATURA STD / StdFLEX
SAMPLE KIT CASE STD / StdFLEX

Art. 981

Morsa / Vise **Art. 1**

Cod.	0.98.10000
PRICE LIST €	~~2.094~~
SPECIAL PRICE €	1.100

Art. 1 - All'Interno - Inside:

Art. 985

Morsa / Vise **Art. 1A**

Cod.	0.98.50000
PRICE LIST €	~~2.123~~
SPECIAL PRICE €	1.100

Art. 1 - All'Interno - Inside:

SIMBOLOGIA DATI TECNICI
TECHNICAL DATA ICONS

GANASCE JAWS	Fissa Fixed	Mobile Movable	Intermedia Interme-diate	Fissa con piastra singola Fixed with single plate	Fissa con piastra doppia Fixed with double plate
PIASTRE GANASCE JAW PLATES		Discen-dente Pull down	Piane Straight	Cambio ra-pido manuale Quick manu-al change StandardFLEX	GRIP integrale Integral GRIP

POSSIBILITÀ POSSIBILITY	Serraggio di 1 particolare Clamping only 1 piece	Serraggio di 2 particolari Clamping 2 pieces	Montaggio sul fianco o in serie Side moun-ting or gang operation	Predisposi-zione Zero Point Zero Point ready	Cubi-morsa Vise tower
PAGINE PAGES			Accessori & Ricambi Accessories & Spare Parts	Istruzioni corretto utilizzo Instruction for a proper use	Diagrammi forze di serraggio Clamping force diagrams

OPZIONI LAVORAZIONI EXTRA
OPTIONS FOR EXTRA MACHINING

Nei codici, **STD** si riferisce agli articoli dei gruppi 1, 2 e 3.
In codes, **STD** refers to articles in groups 1, 2 and 3.

Lavorazione extra Extra machining	Cod.	PRICE LIST €
AGGIUNTA di un foro calibrato ADDITION of a calibrated hole	MAN-010-STD	113
AGGIUNTA di una chiavetta calibrata ADDITION of a calibrated key-way	MAN-020-STD	113
PREDISPOZIZIONE SEMPLICE SIMPLE SET UP	MAN-030-STD	113
PREDISPOSIZIONE & MONTAGGIO COMPLETO COMPLETE SET UP & MOUNTING	MAN-040-STD	225
MONTAGGIO PARZIALE PARTIAL ASSEMBLY	MAN-050-STD	113

Lavorazione extra Extra machining	Cod.	PRICE LIST €
MONTAGGIO SEMPLICE SIMPLE ASSEMBLY	MAN-060-STD	-
MONTAGGIO ed ALLINEAMENTO (Standard) (Standard) ASSEMBLY and ALIGNMENT	MAN-070-STD	113
MONTAGGIO VERTICALE COMPLETE VERTICAL ASSEMBLY	MAN-080-STD	169
ALLINEAMENTO e CONTROLLO tramite DEA ALIGNMENT and CONTROL by DEA \ CMM	MAN-090-STD	449
TABULATO controllo DEA PRINTOUT DEA control	MAN-100-STD	225

Vedi pagina 3.16 per esempi applicativi - See page 3.16 for application examples

Elementi modulari / Modular Elements

STD / StdFLEX

Precisione / Accuracy
±0,02mm

HRC

Durezza / Hardened
HRC 58±2

Elementi indipendenti per una versatilità estrema!

Independent elements for an extreme versatility!

USURA INESISTENTE / NO WEAR

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

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

MODULARITÀ / MODULARITY

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

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

DESIGN COMPATTO / SPACE SAVING DESIGN

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

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

SERRAGGI RAPIDI / QUICK CLAMPING

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

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

Doppia posizione
Double position

Le ganasce fisse hanno la possibilità, grazie alla doppia chiavetta, di essere posizionate sia con piastrine all'interno della base, sia con piastrine che fuoriescono dalla base in modo da poter serrare anche particolari posizionati sul piano della tavola della macchina.

Fixed jaw has the possibility by the double key nuts, to be positioned both with jaw plates inside the vise base and with jaw plates externally from the vise base in order to be able to clamp even workpieces positioned on the machine table directly.

Ganascia monoblocco
Solid Guided Jaws

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

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

Sovraganascia
Stack type jaw

Quattro fori filettati supplementari sopra le ganasce danno la possibilità di installare ganasce sovrapponibili per applicazioni speciali.

4 extra tapped holes over the jaws for special Gerardi stack type jaw application

Gli elementi modulari GERARDI sono la parte mobile e la parte fissa della morsa Standard sezionate e rese completamente indipendenti per permettere di ottimizzare i bloccaggi di pezzi particolarmente grandi, che richiedano le lavorazioni più gravose, sfruttando anche il piano della tavola della macchina come punto di appoggio. Gli elementi modulari sono sicuramente l'esempio più lampante dell'estrema versatilità del sistema modulare Gerardi. La disponibilità di una vastissima gamma di composizioni modulari permette di realizzare con soluzioni standard anche gli allestimenti che credevate speciali.

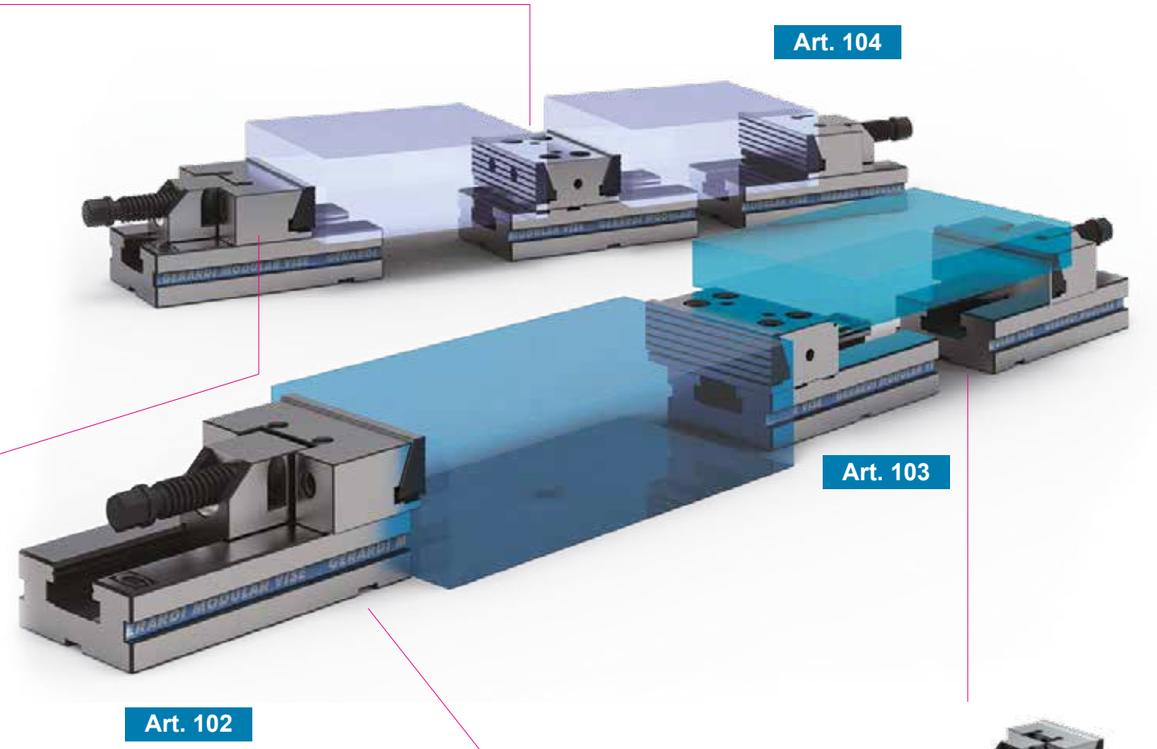
GERARDI modular elements are simply standard vises sections, the movable section and the fixed one, which in this way result completely independent for an extreme versatility and to allow you perfect clamping even of big workpieces which need the heaviest machining using the machine table as surface. Modular elements are the best example of the extreme versatility of the Gerardi modular system.The avalaibility of the broadest assortment program allows to build with standard solutions even the fixtures you thought special. They are a solution for a lot of applications and, with the many reference points available, a perfect complement or alternative to single or double vises.

SCAN IT TO SEE
THE WEB PAGE

5 YEARS WARRANTY

Ampia gamma di moduli standard per ottenere allestimenti speciali

Wide range of standard elements to clamp special applications



Base versatile
Base versatility

Slittone base (per Art.103 e 104) o elemento di prolunga (per Art.102) sempre previsti con chiavette di posizionamento longitudinali e trasversali per allineamento agli assi della macchina.

Vise bases (for Art. 102 and 104) or base extensions (for Art. 102) are always built with longitudinal and cross keyways in order to be aligned with the machine axis..

Staffe d'ancoraggio / Vise holding clamps

NEW 2026

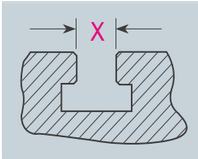
Standard / StandardFLEX

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

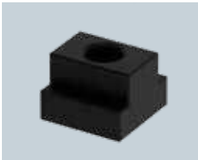
Pair of vise holding clamps Art.296 complete of screw and "T" nuts

Esempio d'ordine per morsa tipo 3 su macchina con cave a T da 18mm: Art.296 T.3 X=18mm
Oppure con codice: 2.29.6300 X=18mm

Order example for Type 3 vise on machine with 18mm T-slots: Art.296 T.3 X=18mm
Also with code: 2.29.6300 X=18mm



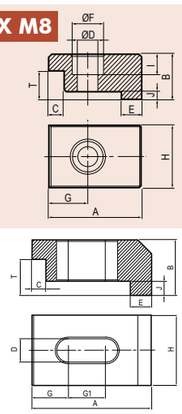
Cava a T
T Slot
Specificare sempre la cava della vostra macchina
Always specify the machine T-slot dimension



Art.287 (Pag.4.34)
Dadi a T - T Nuts
Per fissaggio morse alle cave a T della macchina
For vise clamping on the machine T-slots

Art.296
(Art.298 + Art.287)
Consigliate 2 coppie di staffe Art.296 per ogni elemento modulare
Suggested 2 pairs of holding clamps Art.296 for each modular element

Tipo (grandezza) morsa / Vise type (size)		1				1 - 2								3 - 4							5 - 6					
Art. 296 Coppia di staffe / Holding clamps pair	Cava a T slot X	12	14	16	18	12*	14	16	16	18	20	18*	20	22	16	18	20	22	18*	20	22	16	18	20	22	18*	20	22
	T-nuts Ref. N°	8	9	10	11	12	13	14	20	21	22	32	33	34	20	21	22	23	32	33	34	20	21	22	23	32	33	34
	Filetto vite / Screw thread	M8				M10			M12 *			M16			M12 *				M16			M12				M16 *		
1 X M8	A	50				50			50			50			76				76			86				86		
	B	24				24			24			24			30				30			40				40		
	C	6				6			6			6			6				6			10				10		
	Ø D	8,5				11			13			17			13				17			13				17		
	E	10				10			10			10			13				13			15				15		
	Ø F	14				-			-			-			-				-			-				-		
	G	14				16			17,5			19			17				16			26				26		
	G1	17				15			13			9			22				15			27				27		
	H	34				34			34			34			42				42			50				50		
	I	8				10			10			10			-				-			-				-		
	J	4				4			4			4			10				10			10				10		
	T ± 0,1	15				15			15			15			20				20			26				26		
	Cod.	2.29.61000 / M8				2.29.61000 / M10			2.29.61000 / M12			2.29.61000 / M16			2.29.63000 / M12				2.29.63000 / M16			2.29.65000 / M12				2.29.65000 / M16		
	€	46				46			46			46			58				58			90				90		



*Scelta consigliata - Suggested choice

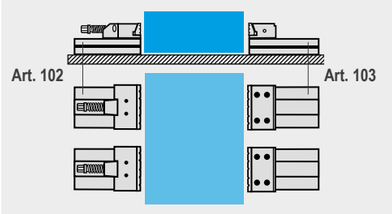
***Scelta NON consigliata - NO Suggested choice**

Soluzioni personalizzate / Customized solutions

Modular elements

Soluzioni personalizzate a tutti i vostri problemi di serraggio

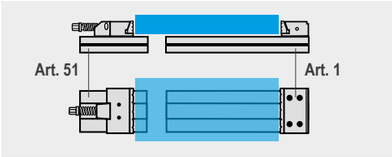
Customized solutions for all your clamping problems



Esempio #1
Example #1

Particolari di grosse dimensioni posizionati direttamente sulla tavola macchina

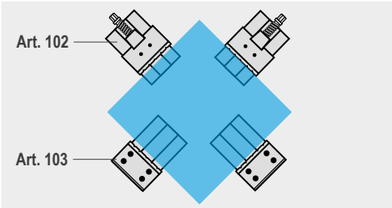
Huge workpieces clamped directly on the machine table



Esempio #2 Art.1+51
Example #2 Art.1 + 51

Art.258 + Art.127 inseriti in un elemento di prolunga Art.51

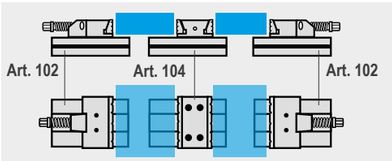
Art.258 + Art.127 to assemble them on a extension base Art.51



Esempio #3
Example #3

Particolari di medie dimensioni posizionati sugli elementi modulari

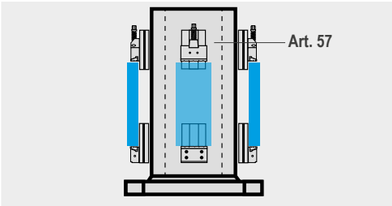
Medium size workpieces clamped directly on the vise sections



Esempio #4
Example #4

Elemento fisso doppio Art.104 + 2 elementi mobili Art.102

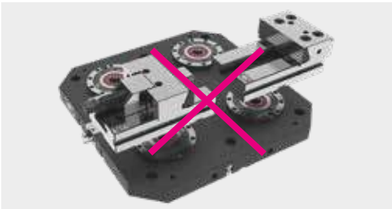
Double fixed vise section Art.104 + 2 movable vise section Art.102



Esempio #5
Example #5

Elementi modulari su cubo a croce Art. 57

Modular elements assembled on cross cube type Art.57



Utilizzo non conforme
Non compliant use

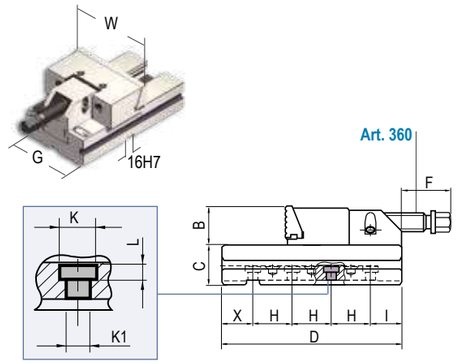
NON utilizzare gli elementi modulari in modo indipendente su due unità Zero Point senza collegarli tra di loro con una piastra d'interfaccia

NEVER mount modular elements independently on two Zero Point units without connecting them with an interface plate

3

Art. 102

Blocco tenditore completo di base.
Movable jaw section and base assy.



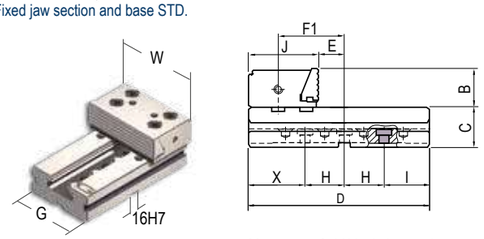
M = numero fori / M = holes number

Tipo (grandezza) morsa / Vise type (size)	kN	1 16 kN	2 25 kN	3 30 kN	4 30 kN	5 40 kN	6 40 kN
	W	100	125	150	175	200	300
	B	30	40	50	60	65	80
	C	35	40	50	58	70	78
	D	140	160	230	240	300	350
	F	55	83	82	62	92	70
	G	75	95	125	145	170	195
	H	40	40	50	50	100	100
	I	29	39	40	82,5	50	83
	K1 Ø	6,5	8,5	13	13	17	17
	K Ø	10,5	13,5	19	19	26	26
	L	4,5	5,5	8,5	8,5	17	17
	X	31	41	40	57,5	50	67
	kg	3,4	6,3	14,2	20,8	35	60
	M	3	3	4	3	5	5
	Cod.	2.10.21000	2.10.22000	2.10.23000	2.10.24000	2.10.25000	2.10.26000
	€	388	481	605	708	1.055	1.629

Disponibile anche versione **Art.112** con piastre piane - Also available **Art.112** version with straight plate jaws

Art. 103

Blocco fisso con ganascia fissa STD.
Fixed jaw section and base STD.



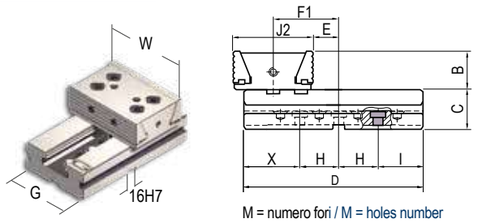
M = numero fori / M = holes number

J	77,9	77,9	89,4	96,9	113,4	120,4
E	33,6	33,6	33,6	33,6	33,6	33,6
F1	76	76	84,5	89	100	107
X	31	31	72,5	79	45	52
H	40	40	50	50	100	100
I	29	49	57,5	61	55	98
kg	3,3	5,8	12,6	17,8	29,8	50,5
M	3	3	3	4	5	5
Cod.	2.10.31000	2.10.32000	2.10.33000	2.10.34000	2.10.35000	2.10.36000
€	336	421	547	605	993	1.545

Disponibile anche versione **Art.113** con piastre piane - Also available **Art.113** version with straight plate jaws

Art. 104

Blocco fisso con ganascia doppia STD.
Fixed double jaw section and base STD.

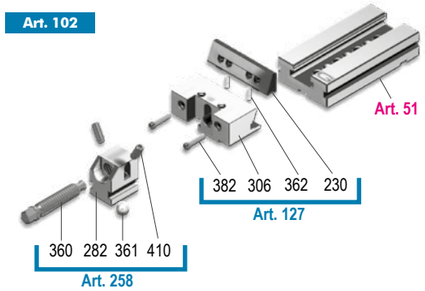


M = numero fori / M = holes number

J2	84,8	84,8	101,8	110,8	132,8	146,8
E	33,6	33,6	33,6	33,6	33,6	33,6
kg	3,4	6	13,3	18,8	30	52,5
M	3	3	3	4	5	5
Cod.	2.10.41000	2.10.42000	2.10.43000	2.10.44000	2.10.45000	2.10.46000
€	379	488	642	720	1.162	1.775

Disponibile anche versione **Art.114** con piastre piane - Also available **Art.114** version with straight plate jaws

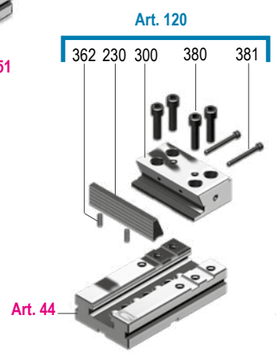
Art. 102



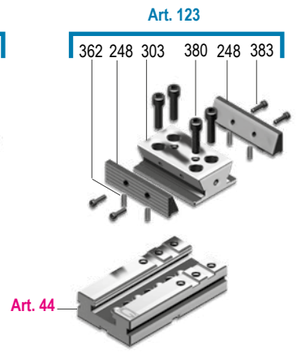
Dotazione standard:
- 1 coppia di tasselli di posizionamento Art. 297

Standard equipment:
- 1 pair of positioning key-nuts Art. 297

Art. 103



Art. 104



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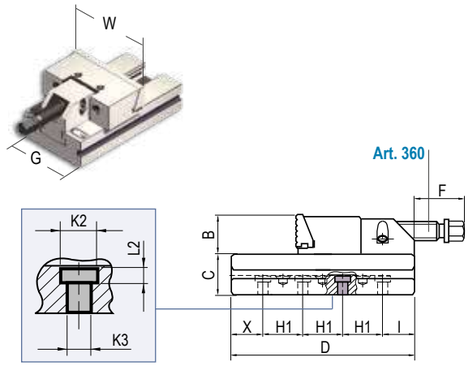
258	4.36
282	4.36

3

Art. 102A a reticolo / grid *

Blocco tenditore completo di base per posizionamento con viti calibrate
Movable jaw section and base assy for positioning through shoulder screws



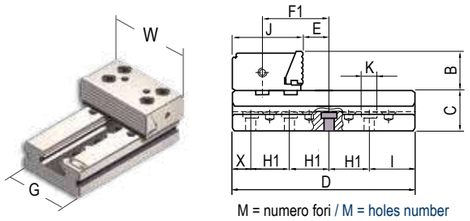
Foro calibrato / Calibrated hole

M = numero fori / M = holes number

Tipo (grandezza) morsa / Vise type (size)	kN	1 16 kN	2 25 kN	3 30 kN	4 30 kN	5 40 kN	6 40 kN
	W	100	125	150	175	200	300
	B	30	40	50	60	65	80
	C	35	40	50	58	70	78
	D	140	160	230	240	300	350
	F	55	83	82	62	92	70
	G	75	95	125	145	170	195
	H1	50	50	50	50	100	100
	I	54	39	40	57,5	69	83
	K2 Ø	25	25	25	25	25	25
	K3 Ø	16 F7	16 F7	16 F7	16 F7	16 F7	16 F7
	L2	8	8	10	10	10	10
	X	36	21	40	32,5	31	67
	kg	3,4	6,3	14,2	20,8	35	60
	M	2	3	4	4	3	3
	Cod.	2.10.2A100	2.10.2A200	2.10.2A300	2.10.2A400	2.10.2A500	2.10.2A600
	€	515	676	862	967	1.247	1.824

Art. 103A a reticolo / grid *

Blocco fisso con ganascia fissa per posizionamento con viti calibrate
Fixed jaw section and base for positioning through shoulder screws

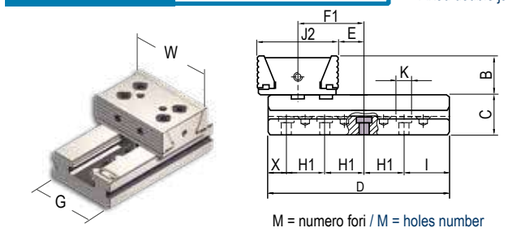


M = numero fori / M = holes number

J	77,9	77,9	89,4	96,9	113,4	120,4
E	33,6	33,6	33,6	33,6	33,6	33,6
F1	76	76	84,5	89	100	107
X	61	21	72,5	29	45	52
H1	50	50	50	50	100	100
I	29	49	57,5	61	55	98
kg	3,3	5,8	12,6	17,8	29,8	50,5
M	2	2	3	4	3	3
Cod.	2.10.3A100	2.10.3A200	2.10.3A300	2.10.3A400	2.10.3A500	2.10.3A600
€	465	612	741	862	1.189	1.741

Art. 104A a reticolo / grid *

Blocco fisso con ganascia doppia per posizionamento con viti calibrate
Fixed double jaw section and base for positioning through shoulder screws



M = numero fori / M = holes number

J2	84,8	84,8	101,8	110,8	132,8	146,8
E	33,6	33,6	33,6	33,6	33,6	33,6
kg	3,4	6	13,3	18,8	30	52,5
M	2	2	3	4	3	3
Cod.	2.10.4A100	2.10.4A200	2.10.4A300	2.10.4A400	2.10.4A500	2.10.4A600
€	508	692	837	976	1.356	1.967

Art.	Pag.
300	4.29
303	4.29
306	4.29
360	4.36
361	4.36
362	4.28
380	4.28
381	4.28
383	4.28
410	4.36

Art. 102A

Senza alcuna dotazione
Without accessory equipment

A richiesta: vite calibrata Art. 83 o 83B
On request: shoulder screw Art. 83 or 83B

Art. 103A

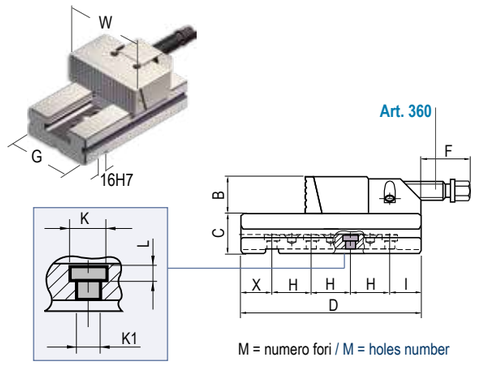
Art. 104A

* Passo del reticolo = 50 mm - Vite calibrata Ø 16F7 Grid Pitch = 50 mm - Shoulder screw Ø 16F7

3

Art. 102i

* Blocco tenditore con ganascia a **cambio rapido**. *(Sistema a pettine)*
* Movable jaw section with **quick change** jaw plate. *(Comb system)*



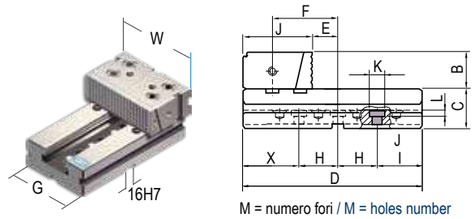
M = numero fori / M = holes number

Tipo (grandezza) morsa / Vise type (size)	kN	1 16 kN	2 25 kN	3 30 kN	4 30 kN	5 40 kN	6 40 kN
	W	96	121	146	171	196	296
	B	28	38	48	58	63	78
	C	35	40	50	58	70	78
	D	140	160	230	240	300	350
	F	55	83	82	62	92	70
	G	75	95	125	145	170	195
	H	40	40	50	50	100	100
	I	29	39	40	82,5	69	83
	K1 Ø	6,5	8,5	13	13	17	17
	K Ø	10,5	13,5	19	19	26	26
	L	4,5	5,5	8,5	8,5	17	17
	X	31	41	40	57,5	31	67
	kg	3,4	6,3	14,2	20,8	35	60
	M	3	3	4	3	5	5
	Cod.	3.10.2i100	3.10.2i200	3.10.2i300	3.10.2i400	3.10.2i500	3.10.2i600
	€	431	533	673	787	1.170	1.808

* Serraggi disassati laterlamente non possibili * Offset lateral clamping not possible

Art. 103i

* Blocco fisso con ganascia a **cambio rapido**. *(Sistema a pettine)*
* Fixed jaw section with **quick change** jaw plate. *(Comb system)*



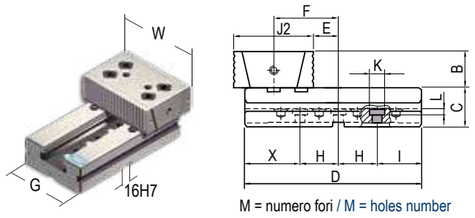
M = numero fori / M = holes number

J	77,9	77,9	89,4	96,9	113,4	120,4
E	33,6	33,6	33,6	33,6	33,6	33,6
F	76	76	84,5	89	100	107
X	31	31	72,5	29	45	52
H	40	40	50	50	100	100
I	29	49	57,5	61	55	98
kg	3,3	5,8	12,6	17,8	29,8	50,5
M	3	3	3	4	5	5
Cod.	3.10.3i100	3.10.3i200	3.10.3i300	3.10.3i400	3.10.3i500	3.10.3i600
€	375	465	606	673	1.103	1.716

* Serraggi disassati laterlamente non possibili * Offset lateral clamping not possible

Art. 104i

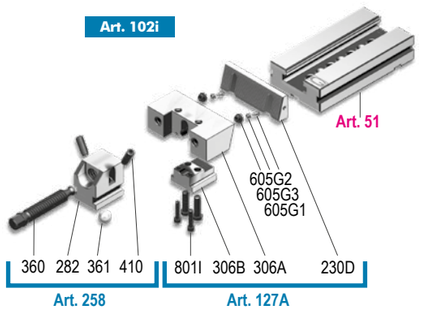
* Blocco fisso con ganascia doppia a **cambio rapido**. *(Sistema a pettine)*
* Fixed double-jaw section with **quick change** jaw plate. *(Comb system)*



M = numero fori / M = holes number

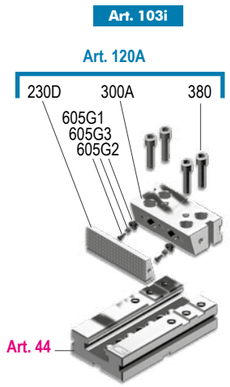
J2	84,8	84,8	101,8	110,8	132,8	146,8
E	33,6	33,6	33,6	33,6	33,6	33,6
kg	3,4	6	13,3	18,8	30	52,5
M	3	3	3	4	5	5
Cod.	3.10.4i100	3.10.4i200	3.10.4i300	3.10.4i400	3.10.4i500	3.10.4i600
€	423	555	713	798	1.290	1.971

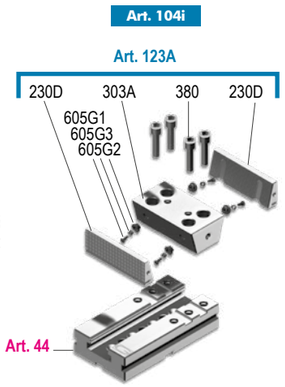
* Serraggi disassati laterlamente non possibili * Offset lateral clamping not possible



Dotazione standard:
- 1 coppia di tasselli di posizionamento Art. 297 + 2 tappi Art. 291

Standard equipment:
- 1 pair of positioning key-nuts Art. 297 + 2 insert Art. 291



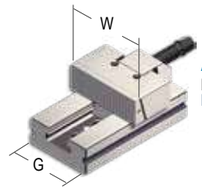


Art.	Pag.
44	3.12
44A	3.12
51	3.12
51A	3.12
120A	4.20
123A	4.20
127A	4.20
230D	4.21
258	4.36
282	4.36
300A	4.30

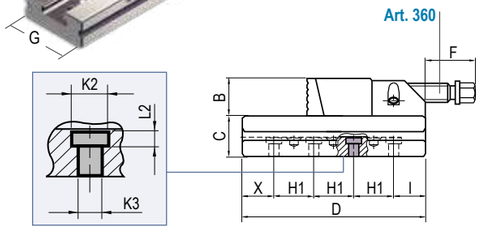
3

Art. 102Ai a reticolo / grid *

* Blocco tenditore con ganascia a **cambio rapido**. *(Sistema a pettine)*
* Movable jaw section with **quick change** jaw plate. *(Comb system)*



Art. 102Ai - 103Ai - 104Ai
Basi per posizionamento con viti calibrate
Base assy for positioning through shoulder screws



Foro calibrato / Calibrated hole

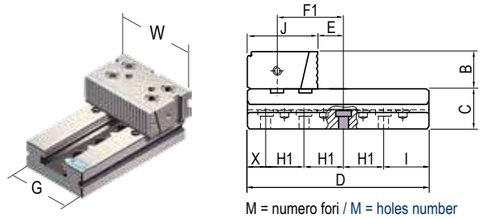
M = numero fori / M = holes number

Tipo (grandezza) morsa / Vise type (size)	kN	1 16 kN	2 25 kN	3 30 kN	4 30 kN	5 40 kN	6 40 kN
	W	96	121	146	171	196	296
	B	28	38	48	58	63	78
	C	35	40	50	58	70	78
	D	140	160	230	240	300	350
	F	55	83	82	62	92	70
	G	75	95	125	145	170	195
	H1	50	50	50	50	100	100
	I	54	39	40	57,5	69	83
	K3 Ø	16 F7	16 F7	16 F7	16 F7	16 F7	16 F7
	K2 Ø	25	25	25	25	25	25
	L2	8	8	10	10	10	10
	X	36	21	40	32,5	31	67
	kg	3,4	6,3	14,2	20,8	35	60
	M	2	3	4	4	3	3
	Cod.	3.10.2Ai10	3.10.2Ai20	3.10.2Ai30	3.10.2Ai40	3.10.2Ai50	3.10.2Ai60
	€	573	747	960	1.074	1.386	2.024

* Serraggi disassati laterlamente non possibili * Offset lateral clamping not possible

Art. 103Ai a reticolo / grid *

* Blocco fisso con ganascia a **cambio rapido**. *(Sistema a pettine)*
* Fixed jaw section with **quick change** jaw plate *(Comb system)*



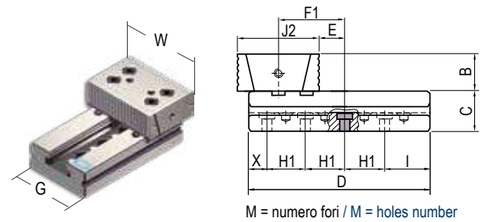
M = numero fori / M = holes number

J	77,9	77,9	89,4	96,9	113,4	120,4
E	33,6	33,6	33,6	33,6	33,6	33,6
F1	76	76	84,5	89	100	107
X	61	21	72,5	29	45	52
H1	50	50	50	50	100	100
I	29	49	57,5	61	55	98
kg	3,3	5,8	12,6	17,8	29,8	50,5
M	2	2	3	4	3	3
Cod.	3.10.3Ai10	3.10.3Ai20	3.10.3Ai30	3.10.3Ai40	3.10.3Ai50	3.10.3Ai60
€	516	681	823	960	1.319	1.933

* Serraggi disassati laterlamente non possibili * Offset lateral clamping not possible

Art. 104Ai a reticolo / grid *

* Blocco fisso con ganascia doppia a **cambio rapido**. *(Sistema a pettine)*
* Fixed double-jaw section with **quick change** jaw plate. *(Comb system)*

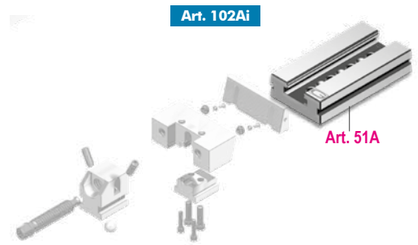


M = numero fori / M = holes number

J2	84,8	84,8	101,8	110,8	132,8	146,8
E	33,6	33,6	33,6	33,6	33,6	33,6
kg	3,4	6	13,3	18,8	30	52,5
M	2	2	3	4	3	3
Cod.	3.10.4Ai10	3.10.4Ai20	3.10.4Ai30	3.10.4Ai40	3.10.4Ai50	3.10.4Ai60
€	565	770	930	1.085	1.504	2.185

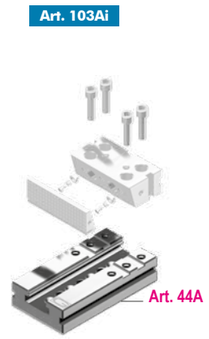
* Serraggi disassati laterlamente non possibili * Offset lateral clamping not possible

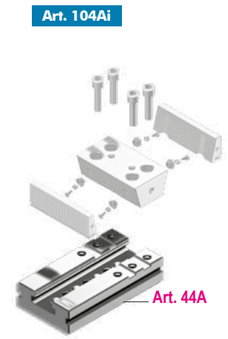
Art.	Pag.
303A	4.30
306A	4.30
306B	4.30
360	4.36
361	4.36
380	4.28
410	4.36
605G1	4.22
605G2	4.22
605G3	4.22
801I	5.61



Senza alcuna dotazione
Without accessory equipment

A richiesta: vite calibrata Art. 83 o 83B
On request: calibrated screw Art. 83 or 83B



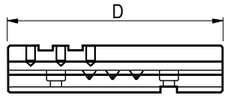


*** Passo del reticolo = 50 mm - Vite calibrata Ø 16F7** **Grid Pitch = 50 mm - Shoulder screw Ø 16F7**

ELEMENTI MODULARI BASE
BASIC MODULAR UNITS

Extra per ogni foro calibrato (tolleranza F7) - MAN-010-STD : euro 113,00
Extra charge for each calibrated hole (F7 tolerance) - MAN-010-STD : euro 113,00

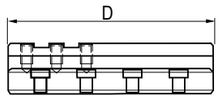
Art. 44



Slittone base per ganascia fissa
Split base for fixed jaw

Tipo (grandezza) / Type (size)	1	2	3	4	5	6
G	75	95	125	145	170	195
D	140	160	230	240	300	350
kg	1.8	3.3	6.9	8	14.5	21.8
Cod.	1.80.14140	1.80.24160	1.80.34230	1.80.44250	1.80.54300	1.80.64350
€	191	244	329	354	612	969

Art. 44A

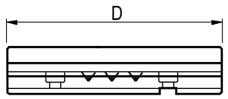


Slittone base a reticolo (Passo 50 mm, Ø 16 per blocco fisso)
Split grid (50 mm) pitch, Ø 16 base for fixed section

D	140	160	230	240	300	350
kg	1.7	3.2	6.8	7.9	14.4	21.7
Cod.	3.44.A1000	3.44.A2000	3.44.A3000	3.44.A4000	3.44.A5000	3.44.A6000
€	291	393	480	555	764	1.169

Art. 51

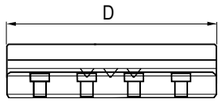
Elemento di prolunga base per ganascia mobile
Base extension for movable jaw



D	140	160	230	240	300	350
kg	2.1	3.4	8.2	11.5	20	30
Cod.	1.80.13140	1.80.23160	1.80.33230	1.80.43250	1.80.53300	1.80.63350
€	162	203	275	321	509	808

Art. 51A

Elemento di prolunga base a reticolo (Passo 50 mm, Ø 16)
Grid (50 mm) pitch, Ø 16 base extension

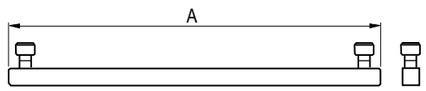


Cod.	3.51.A1000	3.51.A2000	3.51.A3000	3.51.A4000	3.51.A5000	3.51.A6000
€	264	354	478	521	659	962

ACCESSORI
ACCESSORIES

Art. 358

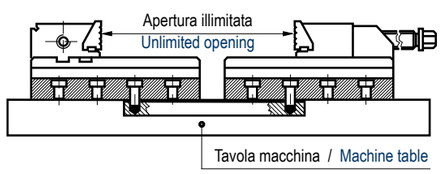
Barra di tensione / Tension bar

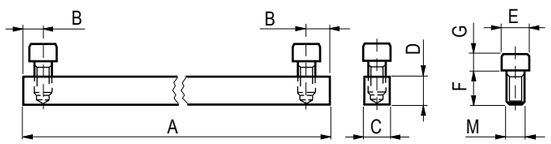


Accessori per Art. 51 e 102
A richiesta altre larghezze senza variazione di prezzo

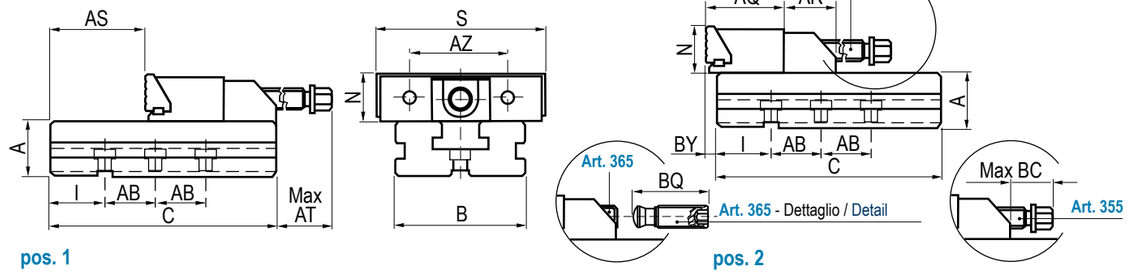
Accessories for Art. 51 and 102
Other widths available on request without price change

Tipo (grandezza) / Type (size)	1	2	3	4	5	6
A	320	320	400	400	500	500
B	11	11	18	18	20	20
C	10	10	15	15	20	20
D	20	20	25	25	25	25
M	M6	M8	M12	M12	M16	M16
E	9	12	18	18	24	24
F	15	15	20	20	30	30
G	6	8	12	12	16	16
kg	0.5	0.5	1.2	1.2	2	2
Cod.	3.35.81000	3.35.82000	3.35.83000	3.35.84000	3.35.85000	3.35.86000
€	29	29	32	32	37	37

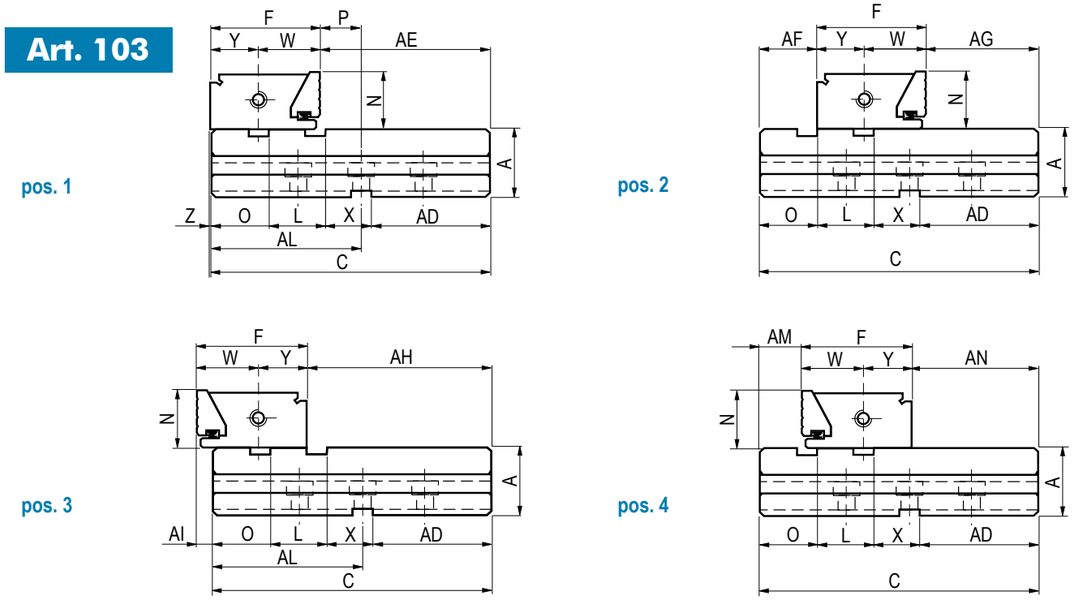




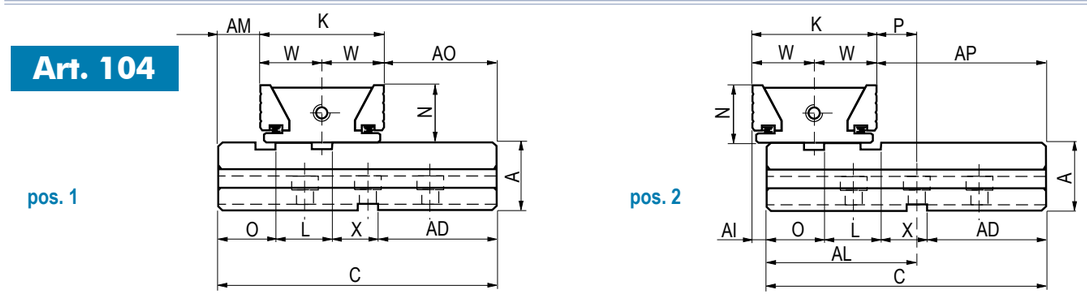
Art. 102

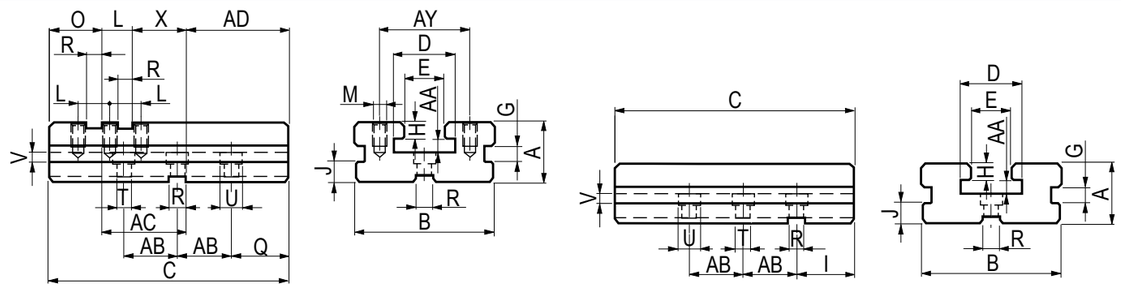


Art. 103



Art. 104

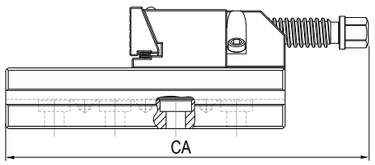




Art. 44 Art. 51

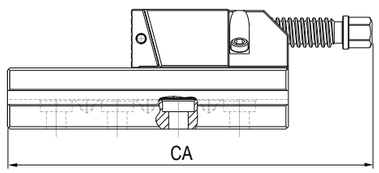
Art. 102A

pos. 1



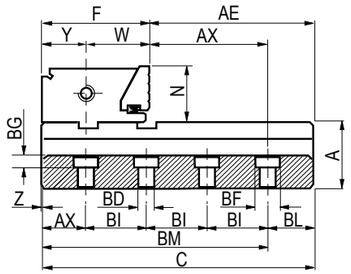
Art. 102Ai

pos. 2

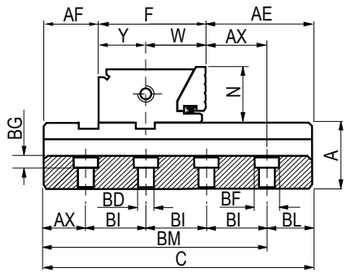


Art. 103A

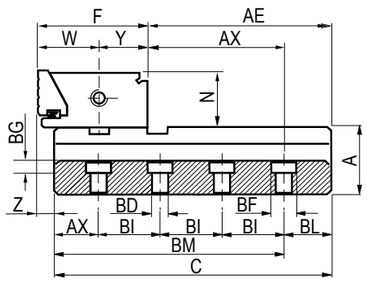
pos. 1



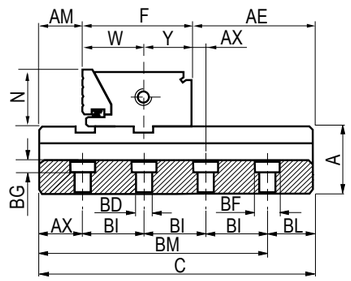
pos. 2



pos. 3

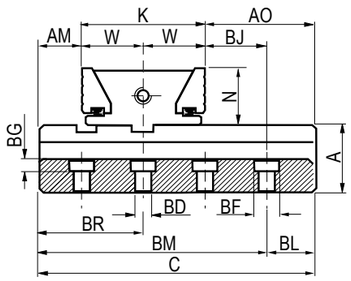


pos. 4

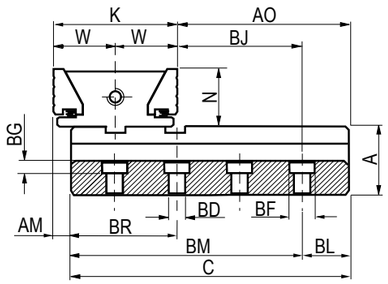


Art. 104A

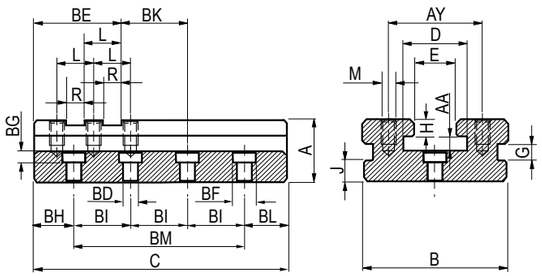
pos. 1



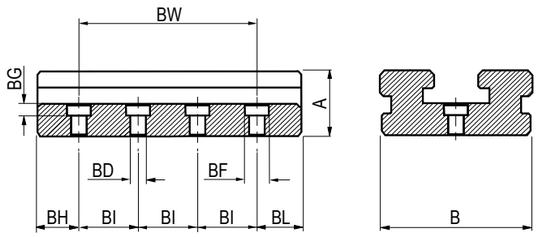
pos. 2



Art. 44A



Art. 51A



Tipo (grandezza) morsa / Vise (type) size

mm	1	2	3	4	5	6	Tolleranza Tolerance
A	35	40	50	58	70	78	- 0.02
B	75	95	125	145	170	195	- 0.02
C	140	160	230	240	300	350	
D	31	41	57	70	80	90	
E	21	28	41	51	61	71	+ 0.02
F	77.9	77.9	89.4	96.9	113.4	120.4	- 0.04
G	9.5	9.5	11.5	11.5	17.5	17.5	
H	10	10	13	15	20	20	- 0.02
I	31	41	40	57.5	31	67	
J	15	15	20	20	26	26	
K	84.8	84.8	101.8	101.8	132.8	146.8	- 0.04
L	32	32	36	36	44	44	- 0.02
M	M10	M12	M14	M16	M20	M20	
N	30	40	50	60	65	80	± 0.02
O	43	43	46	48	53	53	
P	33.6	33.6	33.6	33.6	33.6	33.6	± 0.02
Q	29	49	157.5	61	55	98	
R	16	16	16	16	16	16	H7
S	100	125	150	175	200	300	
T	6.5	8.5	13	13	17	17	
U	10.5	13.5	19	19	26	26	
V	4.5	5.5	8.5	8.5	17	17	
W	42.4	42.4	50.9	55.4	66.4	73.4	± 0.02
X	44	44	48.5	53	56	63	± 0.02
Y	35.5	35.5	35.5	41.5	47	47	± 0.02
Z	0.5	0.5	0.5	1.5	2	2	
AA	10	10	12	18	18	18	+ 0.04
AB	40	40	50	50	100	100	
AC	76	76	84.5	89	100	107	- 0.02
AD	21	41	99.5	103	147	190	
AE	62.6	82.6	141.6	144.6	188.6	231.6	
AF	31.5	31.5	35.5	35.5	42	42	
AG	30.6	50.6	105.1	108.6	144.6	187.6	
AH	69.5	89.5	153.5	158.5	208	258	
AI	7.4	7.4	12.9	15.4	21.4	28.4	
AJ	36	36	40.5	45	48	55	± 0.1
AK	80	80	120	120	160	240	± 0.01
	3 x Ø12	3 x Ø12	4 x Ø12	4 x Ø12	3 x Ø12	4 x Ø12	
AL	111	111	122.5	129	145	152	
AM	24.6	24.6	23.6	20.6	22.6	15.6	
AN	37.5	57.5	117.5	122.5	164.	214	
AO	30.6	50.6	105.1	108.6	144.6	187.6	
AP	62.6	82.6	141.6	144.6	188.6	231.6	
AQ	50	60	80	90	100	120	
AR	32	51	48	68	78	94	
AS	28	49	102	82	122	136	
AT	55	68	82	62	92	70	
AU	45	38	47	27	52	45	

Tipo (grandezza) morsa / Vise (type) size

mm	1	2	3	4	5	6	Tolleranza Tolerance
AV	29	49	107.5	111	155	198	
AW	111	111	122.5	129	145	152	
AX	33.6	33.6	33.6	33.6	33.6	33.6	± 0.02
AY	50	62	88	100	120	133	
AZ	62	80	90	116	138	184	
BA							
BB	20	32	50	50	76	90	
BC	45	38	47	32	52	55	
BD	16	16	16	16	16	16	F7
BE	75	75	82	84	97	97	
BF	20.5	25	25	25	25	25	
BG	8	8	10	10	10	10	
BH	36	21	40	32.5	31	67	
BI	50	50	50	50	50	50	± 0.01
BJ	33.6	33.6	33.6	33.6	33.6	33.6	± 0.02
BK	36	36	40.5	45	48	55	± 0.01
BL	29	39	40	57.5	69	83	
BM	111	121	190	182.5	231	267	
BN	320	320	400	400	500	500	
BO	11	11	18	18	20	20	
BP	24.6	24.6	23.1	20.6	22.6	15.6	
BQ	35	35	38	40	45	45	
BR	67	67	74	76	89	89	
BS	12	12	12	12	12	12	F7
BT	20	20	20	20	20	20	
BU	8	8	8	8	8	8	
BV	31	31	42.5	49	65	72	
BW	100	100	150	150	200	200	± 0.01
	3 x Ø16	3 x Ø16	4 x Ø16	4x Ø16	3 x Ø16	3 x Ø16	
BX	10	10	15	15	20	20	
BY	10	10	15	20	25	30	
BZ	40	40	40	40	40	40	± 0.01
CA	195	228	312	302	392	420	
CB							
CC	20	20	25	25	25	25	
CD	M6	M8	M12	M12	M16	M16	
CE	9	12	18	18	24	24	
CF	15	15	20	20	30	30	
CG	4	5	12	12	16	16	

3

PREDISPOSIZIONE e MONTAGGIO ELEMENTI MODULARI su CUBI LAVORATI
CUBE SET UP and MODULAR ELEMENTS MOUNTING on MACHINED TOMBSTONES

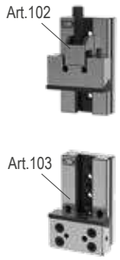
Art. 53C — **Cubo lavorato** / Machined cube

Dim. A=550 / B=750 / H=850

Cod. 8.53.C00220

€ 9.940

Art. 102+103 — **Tipo di morsa** / Vise type



Art.102 Type 5 € 1.055	Art.103 Type 5 € 993
Cod. 2.10.25000	Cod. 2.10.35000
Numero morse / Vises number x 4	Numero morse / Vises number x 4

Tot. **€ 8.192** +

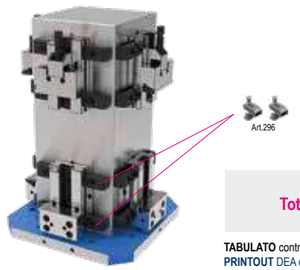
Predisposizione e montaggio completo
Complete set up & mounting

Cod. MAN-040-STD

Per modulo / each modular element € 225
Tot. **€ 1.800** +

Realizzazione di fori filettati o fori di fissaggio (da un minimo di 4 a un massimo di 6), fori calibrati o chiavette (da un minimo di 2 a un massimo di 3).
Creation of threaded holes or screw holes (minimum 4 and maximum 6), calibrated holes or key-ways (minimum 2 and maximum 3).

Cubo con morse
Cube with vises



Tot. **€ 19.932** =

TABULATO controllo DEA - MAN-100-STD : **€ 225 Extra**
PRINTOUT DEA control - MAN-100-STD : **€ 225 Extra**

MONTAGGIO e ALLINEAMENTO ELEMENTI MODULARI su CUBI a RETICOLO
ALIGNEMENT and MODULAR ELEMENTS MOUNTING on GRID TOMBSTONES

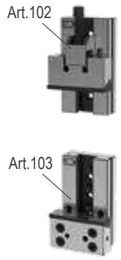
Art. 53F — **Cubo lavorato** / Machined cube

Dim. A=550 / B=750 / H=850

Cod. 8.53.F00220

€ 14.911

Art. 102+103 — **Tipo di morsa** / Vise type



Art.102 Type 5 € 1.055	Art.103 Type 5 993
Cod. 2.10.25000	Cod. 2.10.35000
Numero morse / Vises number x 4	Numero morse / Vises number x 4

Tot. **€ 8.192** +

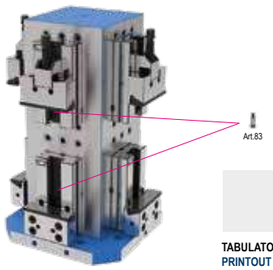
Montaggio ed allineamento (standard)
(Standard) Assembly and alignment

Cod. MAN-070-STD

Per modulo / each modular element € 113
Tot. **€ 904** +

Montaggio di una o più morse e/o attrezzature già predisposte tra loro comprensivo di controllo manuale. Il prezzo di listino comprende manodopera, viti, staffe e tasselli per singola morsa.
Assembly of one or more vises or equipments already interfaced between themselves complete of manual check. The list price includes working hours, screws, holding clamps and key-nuts for only one vise.

Cubo con morse
Cube with vises



Tot. **€ 24.007** =

TABULATO controllo DEA - MAN-100-STD : **€ 225 Extra**
PRINTOUT DEA control - MAN-100-STD : **€ 225 Extra**

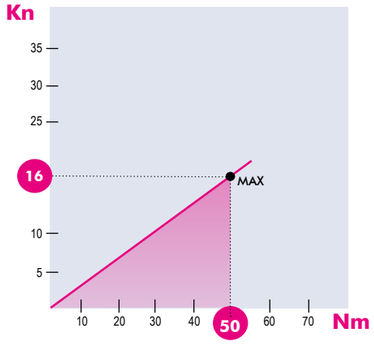
3

Diagrammi di serraggio / Clamping diagrams

Modular elements

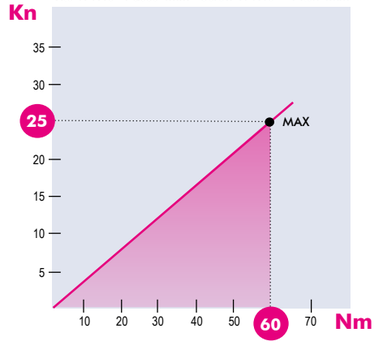
Diagrammi di serraggio meccanico con chiave dinamometrica
Mechanical clamping diagrams with torque wrench

Morse tipo Vises type **1**
Vite M12 - Passo 1,75mm - Screw M12 - Pitch 1,75mm



Art. 357

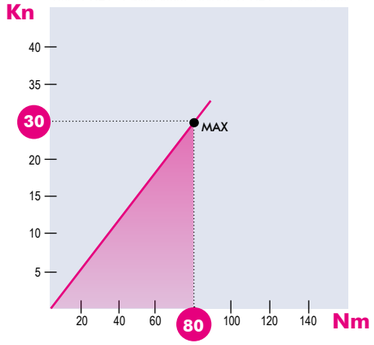
Morse tipo Vises type **2**
Vite TPN18 - Passo 4mm - Screw TPN18 - Pitch 4mm



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

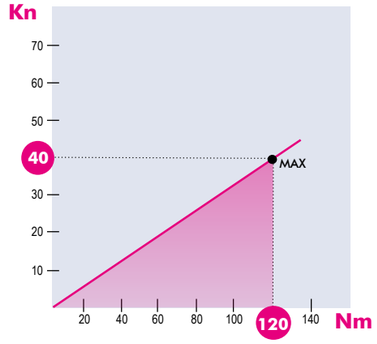
I diagrammi seguenti consentono di determinare le forze di serraggio ottenibili con le morse di varia grandezza (da 1 a 6), in funzione del momento applicato
The following diagrams give the clamping force that can be obtained with each vise type (size 1 to 6) depending on the torque

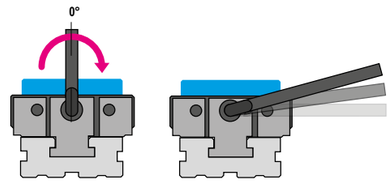
Morse tipo Vises type **3-4**
Vite TPN24 - Passo 5mm - Screw TPN24 - Pitch 5mm



Art. 357

Morse tipo Vises type **5-6**
Vite TPN30 - Passo 5mm - Screw TPN30 - Pitch 5mm





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

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

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

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

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

CONTROLLO ALLINEAMENTO TRA CAVA TRASVERSALE E GANASCIA FISSA
ALIGNEMENT BETWEEN THE CROSS KEYWAY AND THE FIXED JAW PLATE

Libretto Istruzioni / Instruction Book

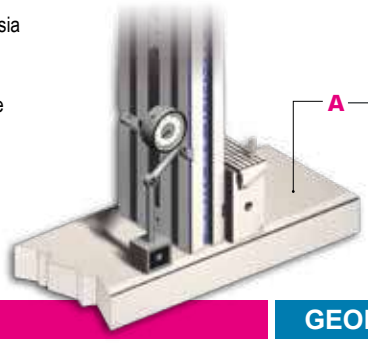
Scansiona il QR code e scarica le istruzioni complete

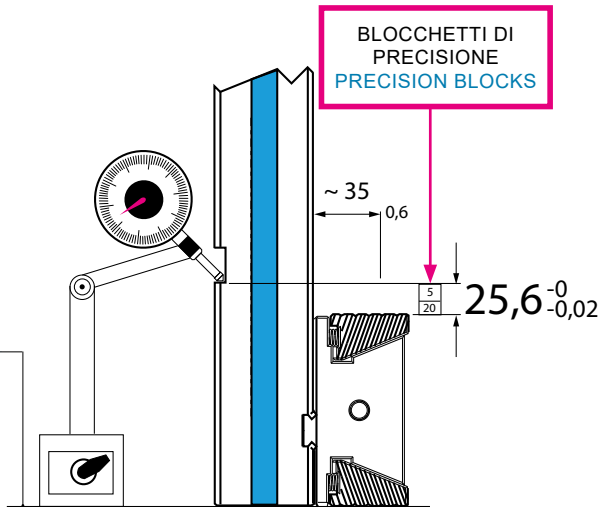
Scan the QR code to download the complete instructions

3

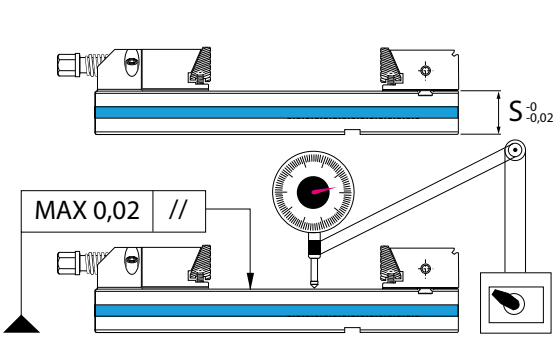
Posizionare la morsa verticalmente assicurandosi che sia perfettamente parallela al piano di appoggio A nei due sensi. Successivamente, con un comparatore centesimale, controllare il parallelismo del piano cava e della ganascia fissa.

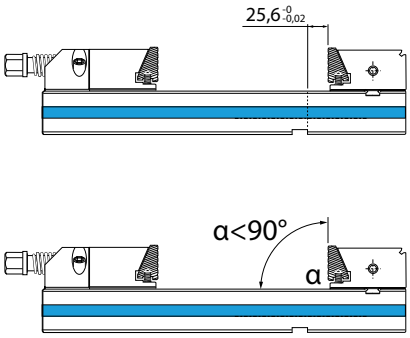
Set the vise vertically ensuring that it is perfectly at parallel to the table A in both sides.Then with an indicator check the parallelism of the keyway and its alignment with the fixed jaw plate.



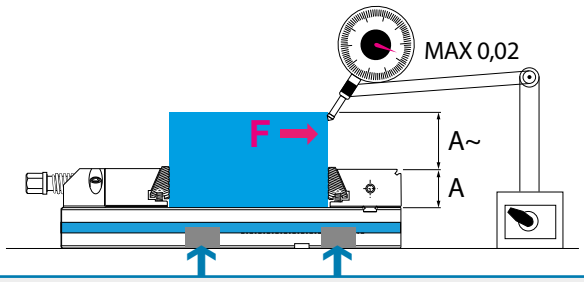


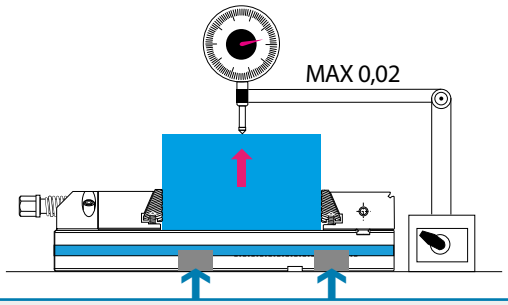
TOLLERANZE GEOMETRICHE / GEOMETRIC ACCURACIES





TOLLERANZE DINAMICHE / DYNAMIC ACCURACIES



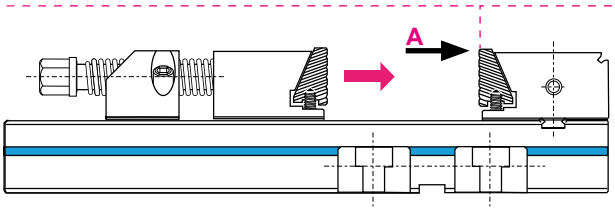


Morsa ancorata con 2 coppie di staffe Art.296 / Vise clamped with n. 2 pairs of Art.296

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

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

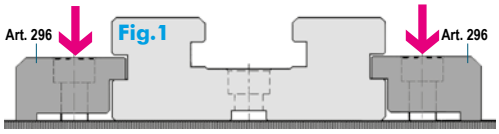
1 kgf . m = 9.806 Nm



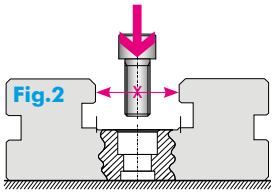
Kn	mm
60	0.1
50	0.07
40	0.05
30	0.03
20	0.02
10	0.01
5	0.004
2	0.002

Il sistema consigliato per l'ancoraggio della morsa sulla tavola macchina è tramite STAFFE Art.296. (Fig.1)
E' possibile ancorare la morsa tramite viti centrali, ma in questo caso la quota X potrebbe flettere e compromettere lo scorrimento della ganascia mobile. (Fig.2)
Nella tabella seguente sono riportati i valori di coppia massima applicabile mediante chiave dinamometrica

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



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



Type	1	2	3	4	5	6
Torque Nm	18	40	140	140	250	250
Viti - Screws	2	2	3	4	4	4