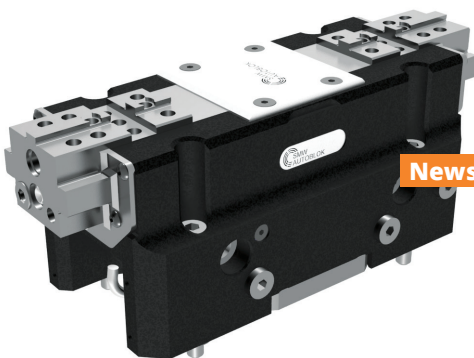
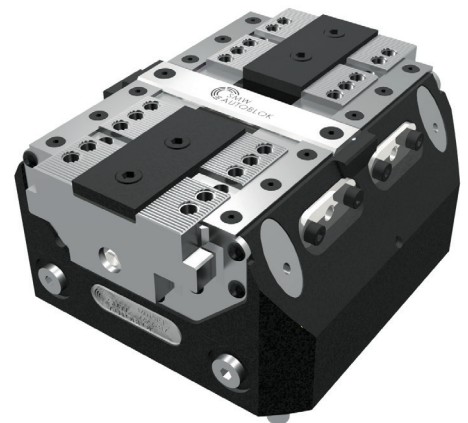
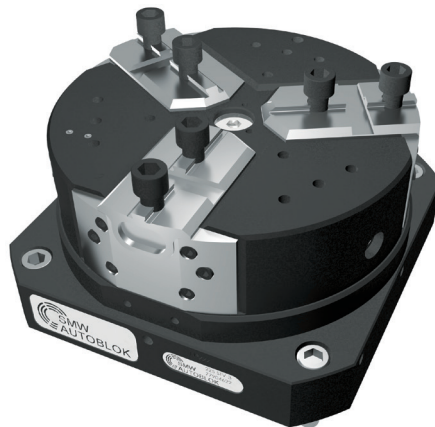
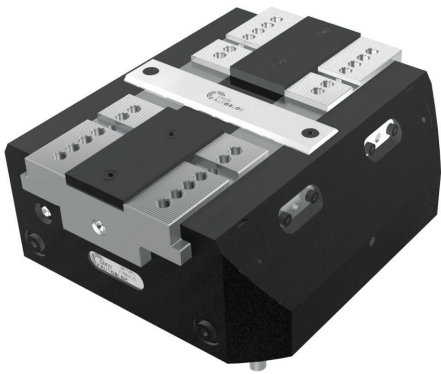


# TWIN VISES CATALOG

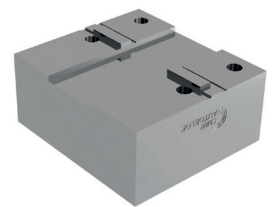


News 2020

## TWIN VISES TOP JAWS



News 2020



10706424 - rev. 2020

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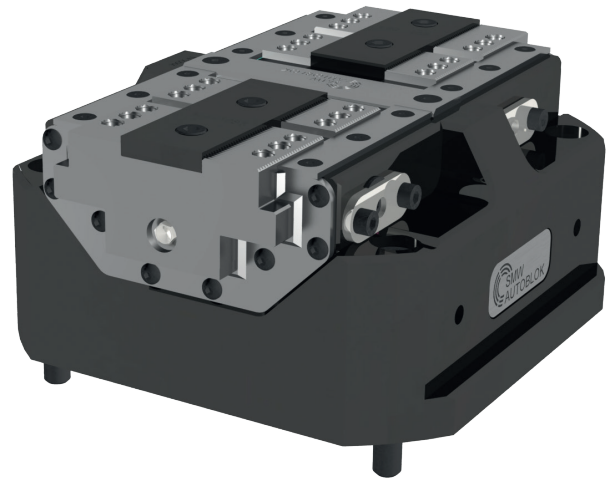
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**PT**

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**PROTECTED TWIN VISES**

**100-125-160-200-250**

# PTP-N PTP-L PTP-F

## Protected Pneumatic Twin Vise

- Pneumatic version
- Pneumatic open/close control (stroke control) master jaws valve

- PTP-N: Normal stroke
- PTP-L: Long stroke
- PTP-F: One fixed jaw

### Application/customer benefits

- Compact design
- Master jaws guide protected against swarf and chips
- Highest repeatability
- Highest rigidity
- Linear pressure adjustment

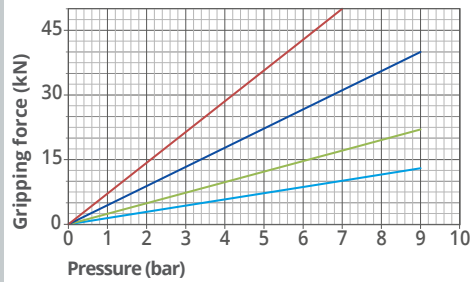
### Standard equipment

Self-centering vise without top jaws  
All bolts and centering bushings included

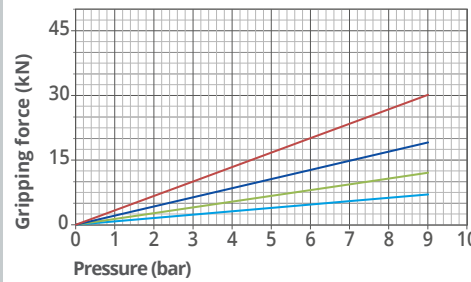
### Technical features

- Housing and functional parts hardened for high precision and long life
- Ready for air purge
- Ready for central grease lubrication
- Master jaws with both Tongue & Groove and fine serration 1,5mmx60°
- OD and ID clamping
- Pneumatic open/close control (stroke control) master jaws valve (optional see page 30)
- Air sensing
- Lubrication with SMW-Autoblok K67 grease
- Stroke control via proximity switches (optional see page 29) on all types and sizes except 100 PTP-F
- For 100 PTP-F only one stroke control via proximity switch for full closed vise

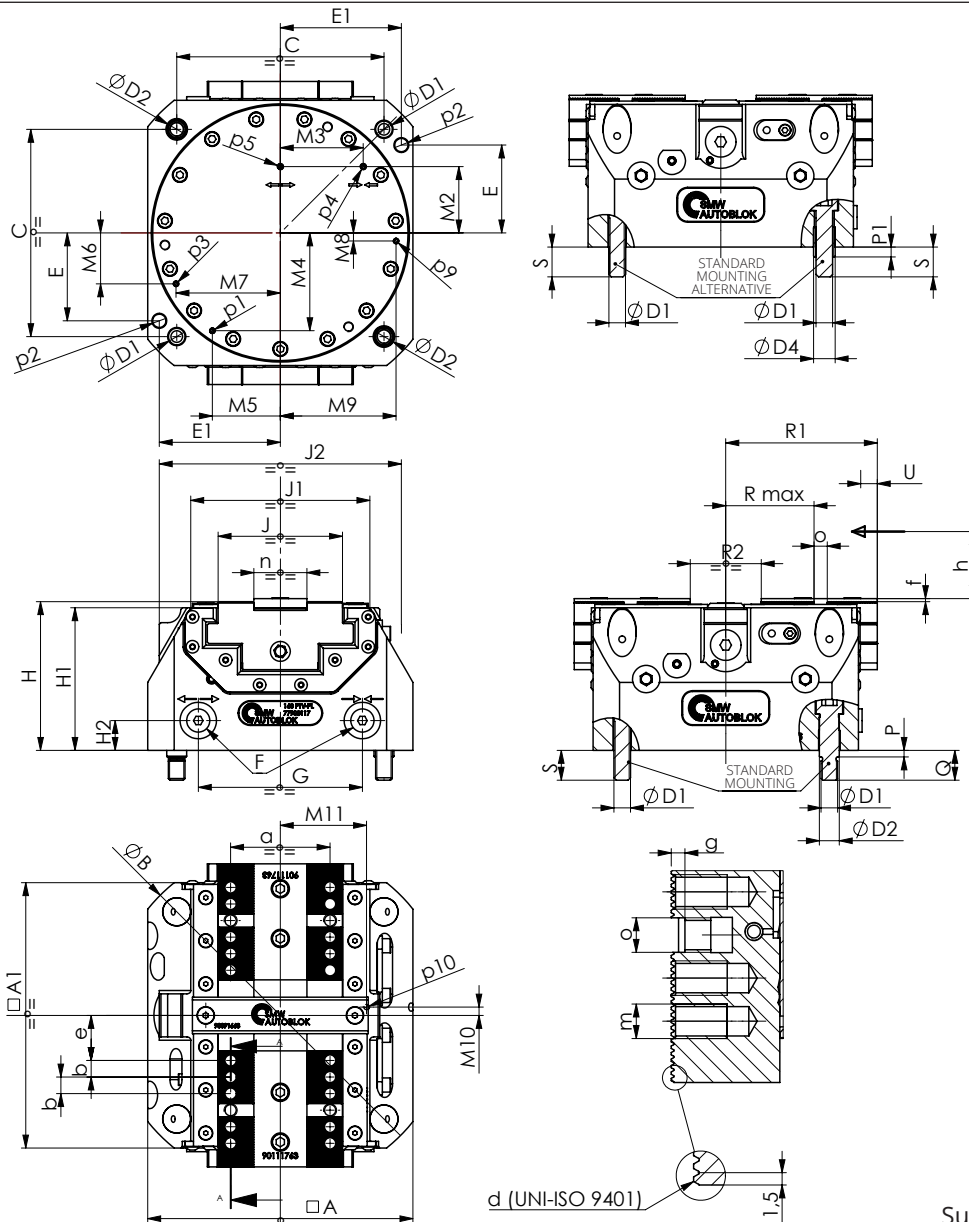
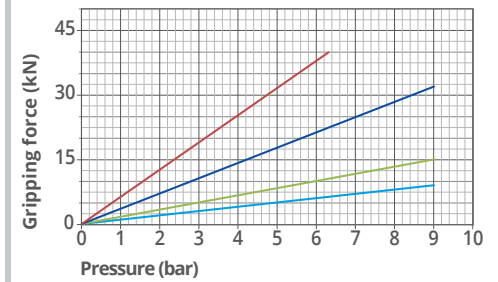
PTP-N 100 125 160 200



PTP-L 100 125 160 200



PTP-F 100 125 160 200



Subject to technical changes



# TECHNICAL DATA

TYPE	ID No.	STROKE TYPE	MAX CLAMPING FORCE	STROKE/JAW	PISTON AREA	MAX OPERATING PRESSURE	REPEATABILITY	WEIGHT
100 PTP-N	77905211	NORMAL	13 kN	2,6 mm	45 cm <sup>2</sup>	9 bar	0.01 mm	5,5 Kg
100 PTP-L	77905311	LONG	7 kN	6 mm				
100 PTP-F	77905411	FIXED JAW	9 kN	6 mm				
125 PTP-N	77905212	NORMAL	22 kN	2,6 mm	78 cm <sup>2</sup>	9 bar	0.01 mm	7 Kg
125 PTP-L	77905312	LONG	12 kN	6 mm				
125 PTP-F	77905412	FIXED JAW	15 kN	6 mm				
160 PTP-N	77905217	NORMAL	40 kN	3 mm	128 cm <sup>2</sup>	9 bar	0.01 mm	13 Kg
160 PTP-L	77905317	LONG	19 kN	8,4 mm				
160 PTP-F	77905417	FIXED JAW	32 kN	8,4 mm				
200 PTP-N	77905221	NORMAL	50 kN	4,2 mm	194 cm <sup>2</sup>	7 bar	0.02 mm	23 Kg
200 PTP-L	77905321	LONG	30 kN	10,2 mm		9 bar		
200 PTP-F	77905421	FIXED JAW	38 kN	10,2 mm		6 bar		

PTP		100	125	160	200
A		100	125	160	200
A1		110	125	160	200
B(Ø)		136	162	205	255
C		80	100	125	160
D1(Ø)		M8	M8	M10	M12
D2 (Øf7)		10	10	12	14
D4 (Øjs7)		11	11	13	16
E		32	/	53	73
E1		45	/	73	92
F		M5	M5	G1/8"	G1/8"
G		59	59	99	127
H		75,5	80,5	89,7	97
H1		72	77	86	93
H2		15	17	18	18
J		47	47	75	94
J1		82	100	108	144
J2		100	121	146	166
M2		32	32	40	50
M3		29,5	29,5	50	65
M4		34,2	40,5	59	72,8
M5		27,7	38,5	41	52,9
M6		14,2	10,6	30,7	39,5
M7		41,1	54,5	62,9	80,9
M8		8,3	4,8	4,9	9,4
M9		42,7	55,3	69,8	89,5
M10		5	5	5	8
M11		34	34	52	60
P		4	4	4	5
P1		4	4	6	6
Q		15	15	18	20
R max	MIN/MAX (LONG STROKE)	25.6/31.6	25.6/31.6	44.8/53.2	54.5/64.7
R max	MIN/MAX (NORMAL STROKE)	25.4/28	25.4/28	45/48	54.5/58.7
R max	MIN/MAX (FIXED JAW)	25.6/31.6	25.6/31.6	44.8/53.2	54.5/64.7
R1	MIN/MAX (LONG STROKE)	57.5/63.5	64.5/70.5	82.5/90.9	102.5/112.7
R1	MIN/MAX (NORMAL STROKE)	57.4/60	64.4/67	82.5/85.5	102.8/107
R1	MIN/MAX (FIXED JAW)	57.5/63.5	64.5/70.5	82.5/90.9	102.5/112.7
R2	MIN/MAX (LONG STROKE)	20/32	20/32	26/42.8	30/50.4
R2	MIN/MAX (NORMAL STROKE)	19.8/25	19.8/25	26/32	30.6/39
R2	MIN/MAX (FIXED JAW)	20/26	20/26	26/34.4	30/40.2
S		15	15	18	20
U	LONG STROKE	6	6	8.4	10.2
U	NORMAL STROKE	2.6	2.6	3	4.2
U	FIXED JAW	6	6	8.4	10.2
a		35	35	60	80
b		7	7	10	10
d	SERRATION	1,5x60°	1,5x60°	1,5x60°	1,5x60°
e	MIN/MAX (LONG STROKE) (FIXED JAW)	14.6/20.6	14.6/20.6	18.8/27.2	28.5/38.7
e	MIN/MAX (NORMAL STROKE)	14.4/17	14.4/17	19/22	28.5/32.7
f		1.8	1.8	1.8	2
g		2.7	2.7	3.2	4
h		16	16	25	35
m		M6x10	M6x10	M8x12	M8x12
n (g6)		20	20	32	40
o (H7)		6	6	8	8
p1	LUBRICATION FITTING	M4	M4	M4	M4
p2 (øH7)		/	/	8x14	8x14
p3	PNEUMATIC OPEN/CLOSE- STROKE CONTROL M.JAWS OR AIR PURGE	M4	M4	M4	M4
p4	WISE CLOSE	M4	M4	M4	M4
p5	WISE OPEN	M4	M4	M4	M4
p9	AIR SENSING CONNECTION	M4	M4	M4	M4
p10	AIR SENSING OUTLET (UNDER FRONT PLATE)	M4	M4	M4	M4

# PTH-N PTH-L PTH-F

## Protected Hydraulic Twin Vise

- Hydraulic version
- Pneumatic open/close control (stroke control) master jaws valve

- PTH-N: Normal stroke
- PTH-L: Long stroke
- PTH-F: One fixed jaw

### Application/customer benefits

- Compact design
- Master jaws guide protected against swarf and chips
- Highest repeatability
- Highest rigidity
- Linear pressure adjustment

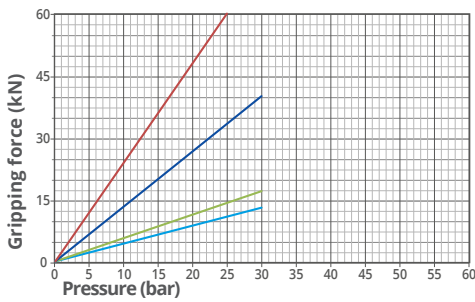
### Standard equipment

Self-centering vise without top jaws  
All bolts and centering bushings included

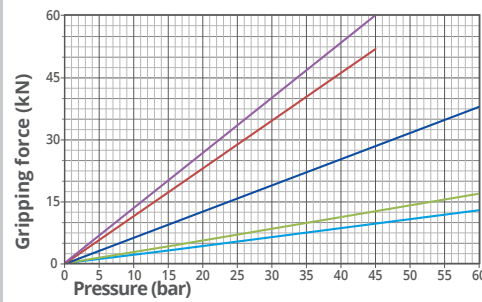
### Technical features

- Housing and functional parts hardened for high precision and long life
- Ready for air purge
- Ready for central grease lubrication
- Master jaws with both Tongue & Groove and fine serration 1,5mmx60°
- OD and ID clamping
- Pneumatic open/close control (stroke control) master jaws valve (optional see page 30)
- Air sensing
- Lubrication with SMW-Autoblok K67 grease
- Stroke control via proximity switches (optional see page 29) on all types and sizes except 100 PTH-F (optional, pag.29)
- for 100 PTH-F: only one stroke control via proximity switch for full closed vise

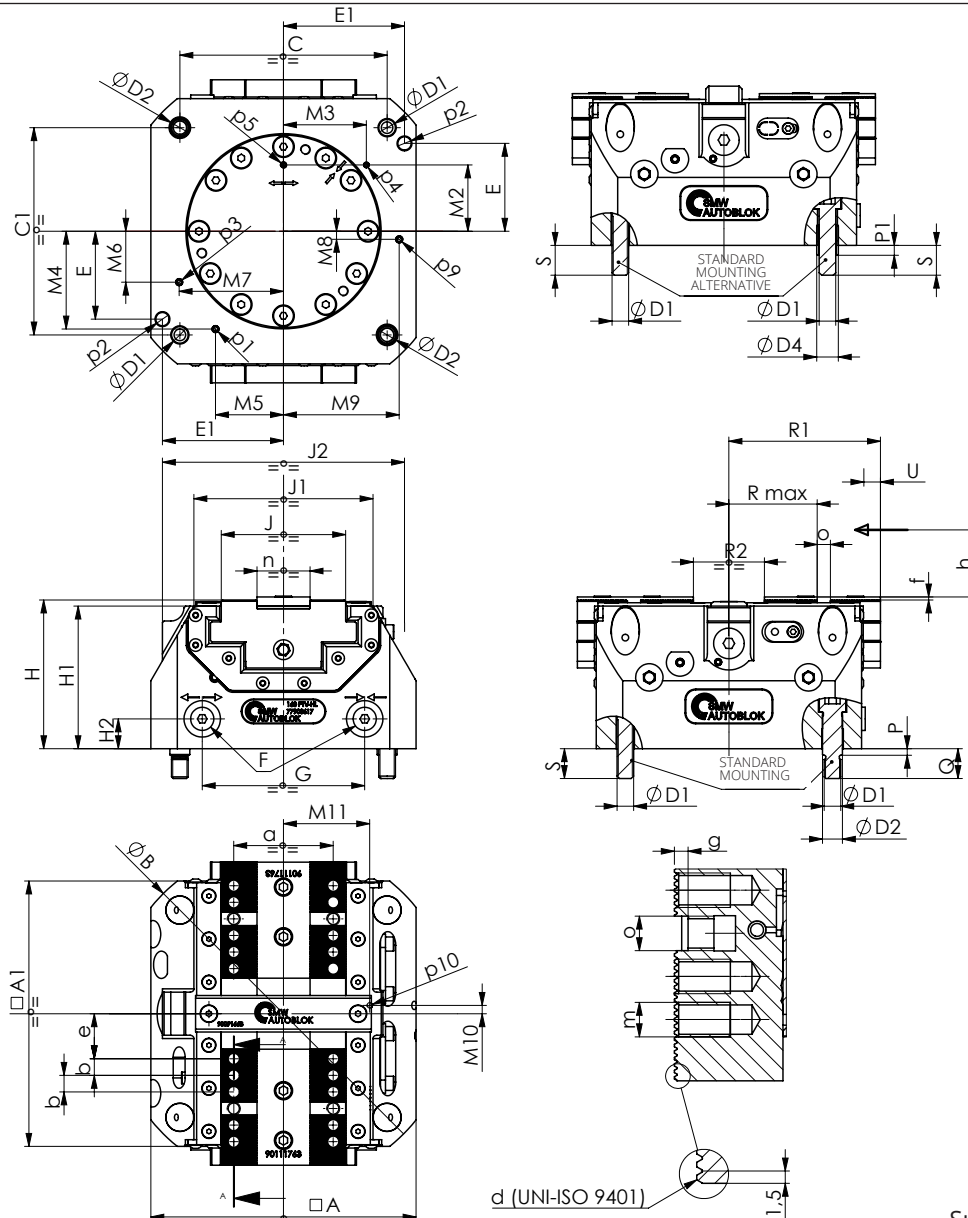
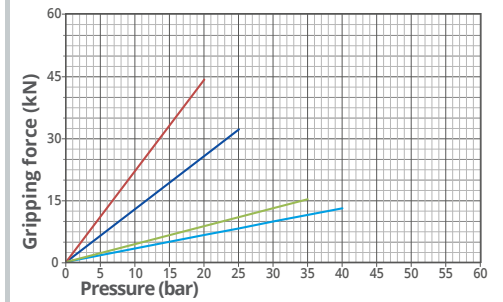
PTH-N 100 125 160 200



PTH-L 100 125 160 200 250



PTH-F 100 125 160 200



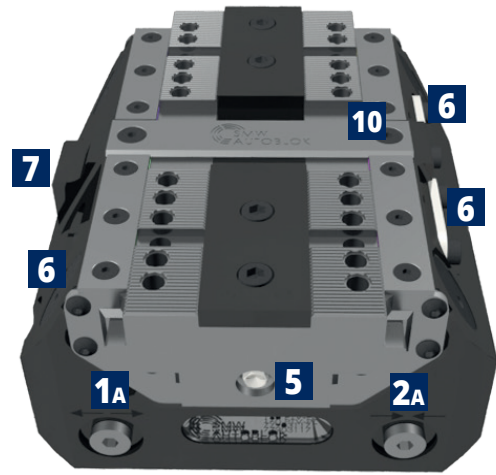
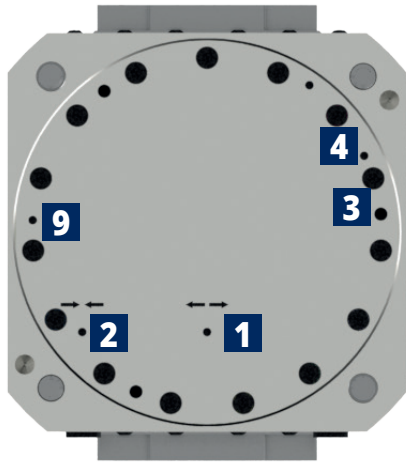
Subject to technical changes

# TECHNICAL DATA

TYPE	ID. No.	STROKE TYPE	STROKE/ JAW	MAX CLAMPING FORCE	PISTON AREA	MAX. OPERATING PRESSURE	REPEATABILITY	WEIGHT
100 PTH-N	77905711	NORMAL	2,6 mm	13 kN	15 cm <sup>2</sup>	30 bar	0.01 mm	6 Kg
100 PTH-L	77905811	LONG	6 mm			60 bar	0.01 mm	
100 PTH-F	77905911	FIXED JAW	6 mm			40 bar	0,01 mm	
125 PTH-N	77905712	NORMAL	2,6 mm	17 kN	20 cm <sup>2</sup>	30 bar	0.01 mm	8 Kg
125 PTH-L	77905812	LONG	6 mm			60 bar	0.01 mm	
125 PTH-F	77905912	FIXED JAW	6 mm			35 bar	0,01 mm	
160 PTH-N	77905717	NORMAL	3 mm	40 kN	45 cm <sup>2</sup>	30 bar	0,01 mm	15 Kg
160 PTH-L	77905817	LONG	8,4 mm	38 kN		60 bar	0.01 mm	
160 PTH-F	77905917	FIXED JAW	8,4 mm	32 kN		25 bar	0,01 mm	
200 PTH-N	77905721	NORMAL	4,2mm	60 kN	68 cm <sup>2</sup>	25 bar	0.02 mm	25 Kg
200 PTH-L	77905821	LONG	10,2 mm	52 kN		45 bar	0.02 mm	
200 PTH-F	77905921	FIXED JAW	10,2 mm	44 kN		20 bar	0,02 mm	
250 PTH-L	77905826	LONG	15 mm	60 kN	113 cm <sup>2</sup>	45 bar	0.02 mm	35 Kg

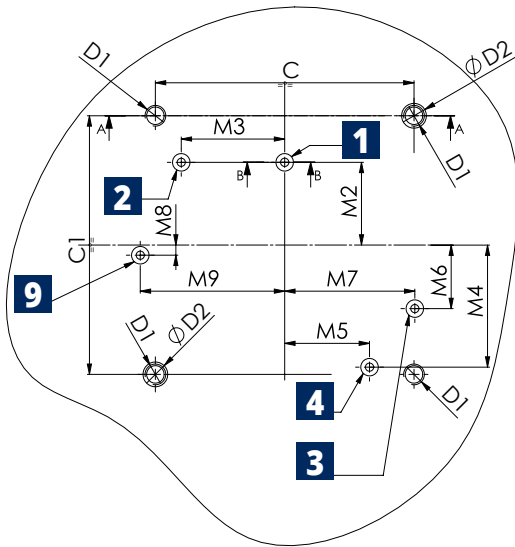
PTH		100	125	160	200	250
A		100	125	160	200	210
A1		110	125	160	200	238
B(Ø)		136	162	205	255	300
C		80	100	125	160	180
C1		80	100	125	160	200
D1(Ø)		M8	M8	M10	M12	M12
D2 (Øf7)		10	10	12	14	14
D4 (Øjs7)		11	11	13	16	16
E		32	/	53	73	80
E1		45	/	73	92	90
F		G1/8"	G1/8"	G1/8"	G1/8"	G1/8"
G		56	57	98	128	90
H		75,5	80,5	89,7	97	105
H1		72	77	86	93	100
H2		15	17	18	18	20
J		47	47	75	94	125
J1		82	100	108	144	180
J2		100	121	146	166	-
M2		32	32	40	50	80
M3		29,5	29,5	50	65	45
M4		34,2	40,5	59	72,8	89,8
M5		27,7	38,5	41	52,9	65,2
M6		14,2	10,6	30,7	39,5	0
M7		41,1	54,5	62,9	80,9	92
M8		8,3	4,8	4,9	9,4	6,7
M9		42,7	55,3	69,8	89,5	76,7
M10		5	5	5	8	9
M11		34	34	52	60	78
P		4	4	4	5	5
P1		4	4	6	6	6
Q		15	15	18	20	20
R max	MIN/MAX (LONG STROKE)	25.6/31.6	25.6/31.6	44.8/53.2	54.5/64.7	51,5/66,5
R max	MIN/MAX (NORMAL STROKE)	25,4/28	25,4/28	45/48	54,5/58,7	-
R max	MIN/MAX (FIXED JAW)	25.6/31.6	25.6/31.6	44.8/53.2	54.5/64.7	-
R1	MIN/MAX (LONG STROKE)	57.5/63.5	64,5/70,5	82.5/90.9	102.5/112.7	119,5/134,5
R1	MIN/MAX (NORMAL STROKE)	57,4/60	64,4/67	82,5/85,5	102,8/107	-
R1	MIN/MAX (FIXED JAW)	57,5/63,5	64,5/70,5	82,5/90,9	102,5/112,7	-
R2	MIN/MAX (LONG STROKE)	20/32	20/32	26/42,8	30/50,4	39/69
R2	MIN/MAX (NORMAL STROKE)	19,8/25	19,8/25	26/32	30,6/39	-
R2	MIN/MAX (FIXED JAW)	20/26	20/26	26/34,4	30/40,2	-
S		15	15	18	20	20
U	LONG STROKE	6	6	8,4	10,2	15
U	NORMAL STROKE	2,6	2,6	3	4,2	-
U	FIXED JAW	6	6	8,4	10,2	-
a		35	35	60	80	90
b		7	7	10	10	12
d	SERRATION	1,5x60°	1,5x60°	1,5x60°	1,5x60°	1,5x60°
e	MIN/MAX (LONG STROKE)	14.6/20.6	14.6/20.6	18.8/27.2	28.5/38.7	32,5/47,5
e	MIN/MAX (NORMAL STROKE)	14,4/17	14,4/17	19/22	28,5/32,7	-
e	MIN/MAX (FIXED JAW)	14.6/20.6	14.6/20.6	18.8/27.2	28.5/38.7	-
f		1.8	1.8	1.8	2	2,5
g		2.7	2.7	3.2	4	4
h		16	16	25	35	40
m		M6x10	M6x10	M8x12	M8x12	M10x15
n (g6)		20	20	32	40	50
o (H7)		6	6	8	8	10
p1	LUBRICATION FITTING	M4	M4	M5	M5	M5
p2 (ØH7)		/	/	8x14	8x14	10x20
p3	PNEUMATIC OPEN/CLOSE- STROKE CONTROL M.JAWS OR AIR PURGE	M4	M4	M5	M5	M5
p4	WISE CLOSE	M4	M4	M4	M4	M5
p5	WISE OPEN	M4	M4	M4	M4	M5
p9	AIR SENSING CONNECTION	M4	M4	M5	M5	M5
p10	AIR SENSING OUTLET (UNDER FRONT PLATE)	M4	M4	M4	M4	M5

# MOUNTING INSTRUCTIONS



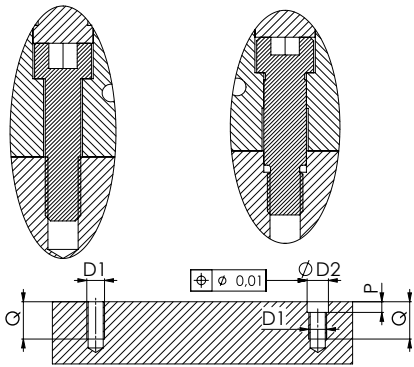
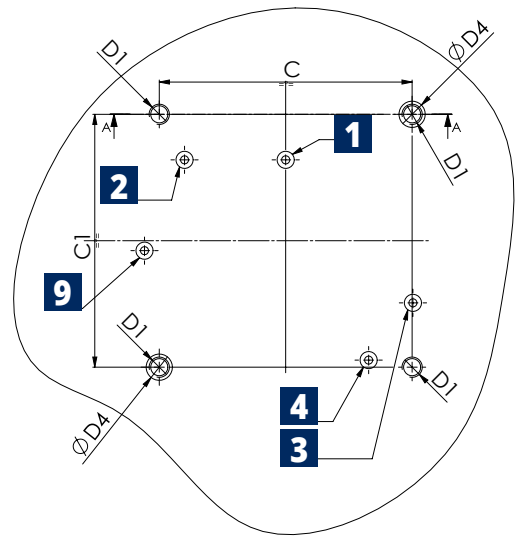
## SOLUTION 1 STANDARD

± 0,03 mm to clamping center

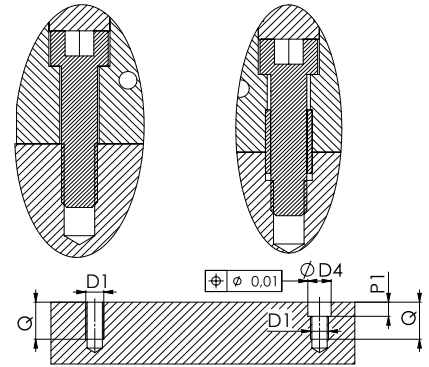


## SOLUTION 2 STANDARD

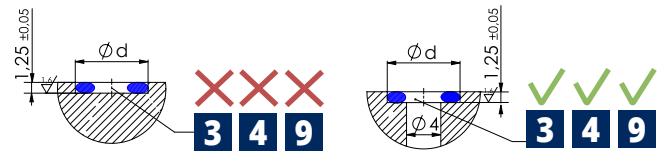
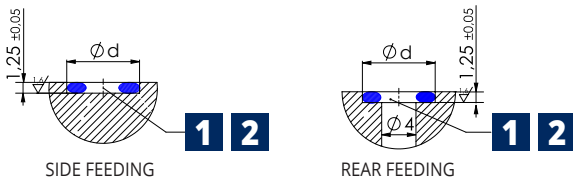
± 0,025 mm to clamping center



**ALL BOLTS AND CENTERING BUSHINGS INCLUDED**



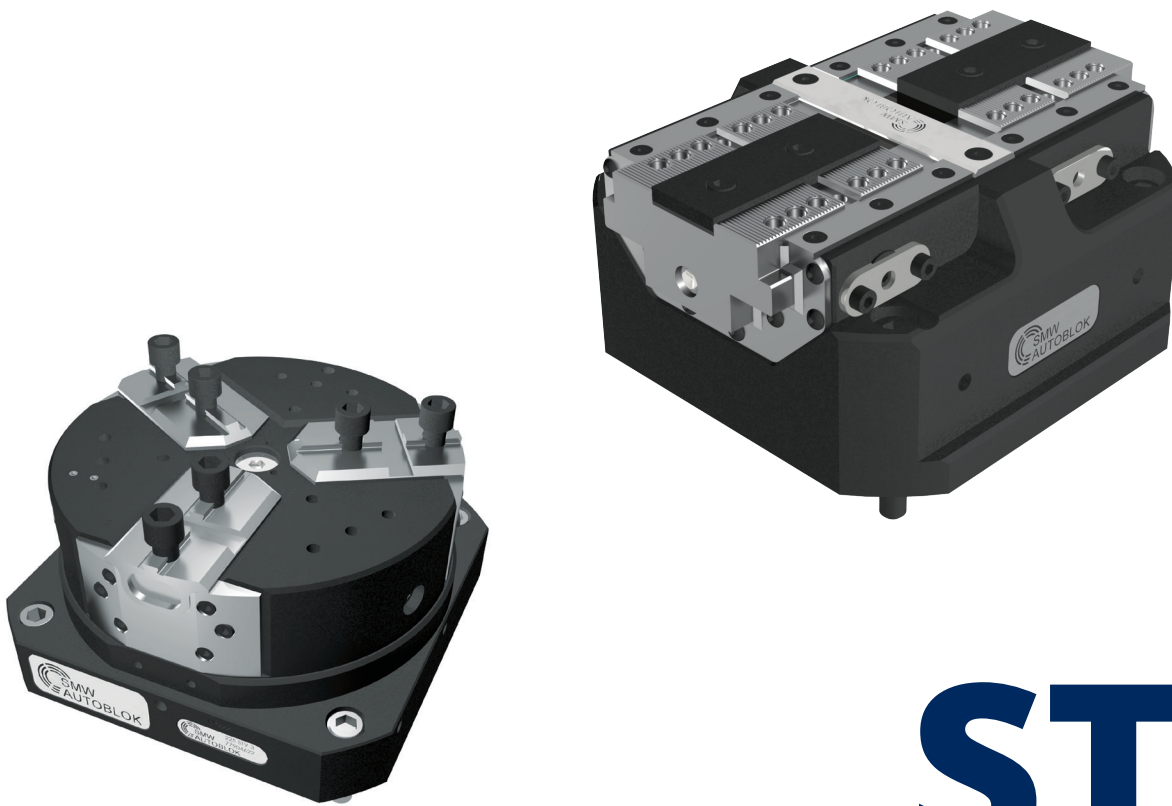
## FEEDING SEATS:



- 1** Open-Rear feeding
- 2** Closed-Rear feeding
- 3** Pneumatic open/close-stroke control or air purge connection\*
- 4** Central lubrication
- 5** Lubrication fitting
- 6** Proximity switch seats
- 7** Pneumatic open/close-stroke control-m.j.valve (optional see page 30)
- 9** Air sensing connection (only bottom)
- 10** Air sensing outlet (under front plate)

\*The air purge can be used only without the valve.

PT	C	C1	D1	D2H7	D4H7	M2	M3	M4	M5	M6	M7	M8	M9	P	P1	Q	Ød	OR
100	80	80	M8	10	11	32	29,5	34,2	27,7	14,2	41,1	7	43	6	6	18	8	OR2018
125	100	100	M8	10	11	32	29,5	40,5	38,5	9,6	54,6	4,8	55,3	6	6	18	8	OR2018
160	125	125	M10	12	13	40	50	59	41	30,7	62,9	4,9	69,8	6	7	21	8	OR2018
200	160	160	M12	14	16	50	65	72,8	52,9	39,5	80,9	9,4	89,5	7	7	24	8,8	OR2021
250	180	200	M12	14	16	80	45	89,8	65,2	0	92	6,7	76,7	7	7	24	8.8	OR2021



# STV

SPRING AND AIR  
OPERATED TWIN VISES

125-180-225

# STV-2N STV-2L

Spring and air operated Twin Vise

- Protected and springs clamping
- Pneumatic open/close control (stroke control) master jaws valve

- STV-2N: Normal stroke
- STV-2L: Long stroke
- 2 jaws

## Application/customer benefits

- Compact design
- Linear pressure adjustment
- Highest repeatability
- Highest rigidity

## Standard equipment

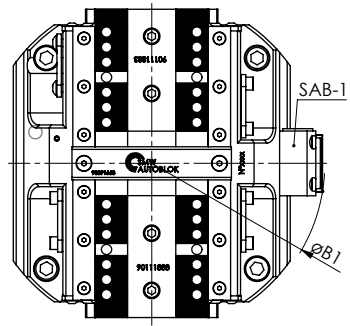
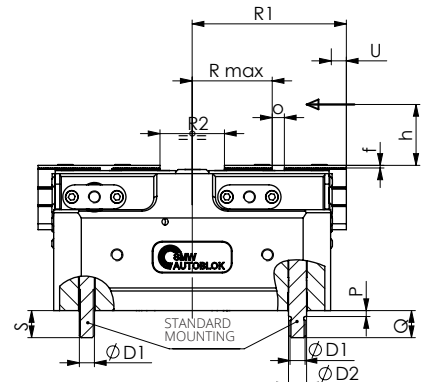
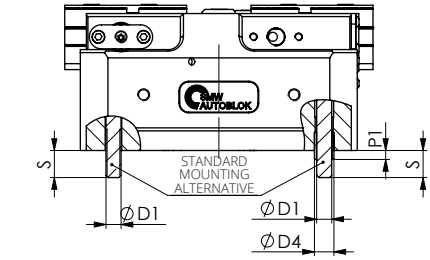
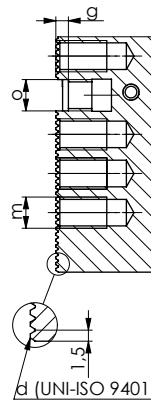
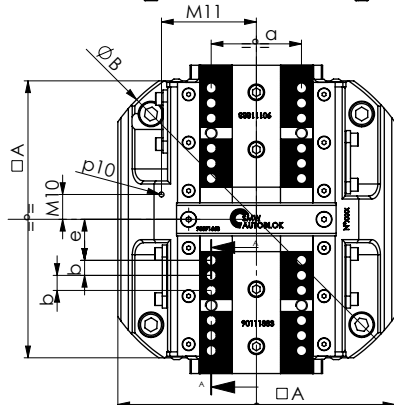
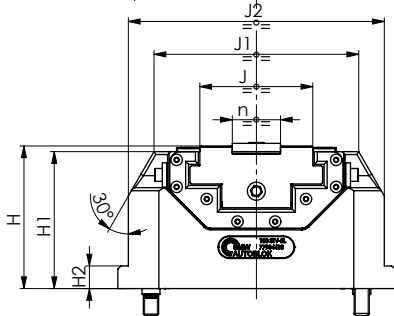
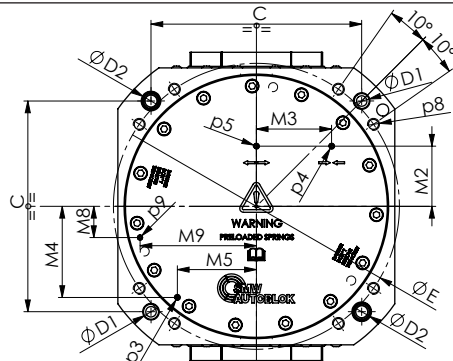
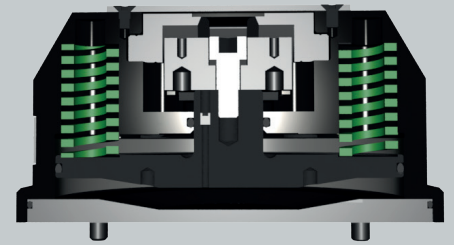
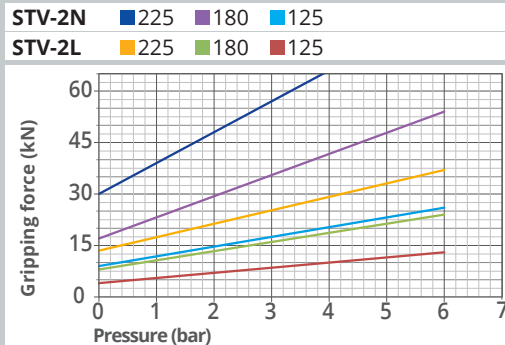
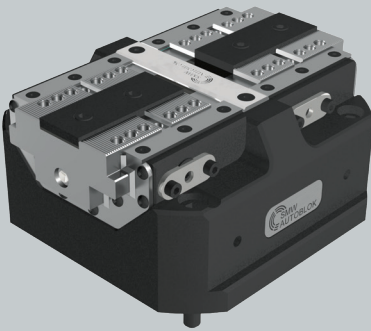
Self-centering vise without top jaws  
All bolts and centering bushings included

## Technical features

- Spring to clamp, pneumatic open
- Increase of the clamping force via Turbo function
- Housing and functional parts hardened for high precision and long life
- Ready for air purge
- Master jaws with both Tongue & Groove and fine serration 1,5mmx60°
- OD clamping only
- Safety valve SAB-1 to maintain air pressure during pallet transportation/storage and machining without feed (optional see page 30)
- Pneumatic open/close control (stroke control) master jaws valve (optional see page 30)
- Lubrication with SMW-Autoblok K67 grease
- Stroke control via proximity switches (optional see page 29)
- Air sensing

### ROTATION USE

The vise can be used up to maximum 500 rpm only if operated with springs + Turbo system (at minimum 3 bar) and with top jaws weight not higher than the standard ones.



Subject to technical changes



# TECHNICAL DATA

TYPE	ID. No.	TYPE STROKE	MAX. CLAMPING FORCE MIDDLE STROKE		STROKE/ JAW	PISTON AREA	RE-OPENING PRESSURE	MAX. OPERATING PRESSURE	REPEATABILITY	WEIGHT
			ONLY SPRINGS	SPRINGS+TURBO						
125 STV-2N	77904312	NORMAL	9 kN	26 kN	2.6 mm	78 cm <sup>2</sup>	5 bar	6 bar	0.01 mm	7 Kg
125 STV-2L	77904412	LONG	4 kN	13 kN	6 mm					
180 STV-2N	77904318	NORMAL	17 kN	54 kN	3 mm	170 cm <sup>2</sup>	5 bar	6 bar	0.01 mm	17,5 Kg
180 STV-2L	77904418	LONG	8 kN	24 kN	8,4 mm					
225 STV-2N	77904322	NORMAL	30 kN	66 kN	4,2 mm	250 cm <sup>2</sup>	6 bar	4 bar	0.02 mm	28 Kg
225 STV-2L	77904422	LONG	13,5 kN	37 kN	10,2 mm			6 bar		

TYPE WITH SAB-1	Id. No.	TYPE STROKE	COMPOSITION	MAX. OPERATING PRESSURE	
125 STV-2N + SAB-1	77904812	NORMAL	77904312 + 27581810	3.5/6 bar	
125 STV-2L + SAB-1	77904912	LONG	77904412 + 27581810		
180 STV-2N + SAB-1	77904818	NORMAL	77904318 + 27581810	3.5/6 bar	
180 STV-2L + SAB-1	77904918	LONG	77904418 + 27581810		
225 STV-2N + SAB-1	77904822	NORMAL	77904322 + 27581810	3.5 bar	4 bar
225 STV-2L + SAB-1	77904922	LONG	77904422 + 27581810	3.5 bar	6 bar

STV-2		125	180	225
A		125	184	225
B (Ø)		162	225	284
B1 (Ø)	SAB-1 VALVE OVERALL DIMENSION	186	230	276
C		100	140	180
D1(Ø)		M8	M10	M12
D2 (Øf7)		10	12	14
D4 (Øjs7)		11	13	16
E (ø)		136	190	240
H		80,5	94,7	102
H1		77	91	98
H2			15	15
J		47	75	94
J1		100	136	172
J2		125	170	216
M2		32	40	50
M3		29,5	50	65
M4		40,5	60,5	79
M5		38,5	52,5	63
M8		10,6	20,7	15
M9		54,5	77,3	99,9
M10		10,5	16,5	15
M11		46	63	81
P		4	4	5
P1		4	6	6
Q		15	18	20
R max	MIN/MAX (LONG STROKE)	25.6/31.6	44.8/53.2	54.5/64.7
R max	MIN/MAX (NORMAL STROKE)	25,4/28	45/48	54.5/58.7
R1	MIN/MAX (LONG STROKE)	64,5/70,5	94/102.4	114,5/124.7
R1	MIN/MAX (NORMAL STROKE)	64,4/67	94,5/97,5	114.8/119
R2	MIN/MAX (LONG STROKE)	20/32	26/42.8	30/50.4
R2	MIN/MAX (NORMAL STROKE)	19.8/25	26/32	30.6/39
S		15	18	20
U	LONG STROKE	6	8.4	10.2
U	NORMAL STROKE	2.6	3	4.2
a		35	60	80
b		7	10	10
d	SERRATION	1,5x60°	1,5x60°	1,5x60°
e	MIN/MAX (LONG STROKE)	14.6/20.6	18.8/27.2	28.5/38.7
e	MIN/MAX (NORMAL STROKE)	14.4/17	19/22	28.5/32.7
f		1.8	1.8	2
g		2.7	3.2	4
h		16	25	35
m		M6x10	M8x12	M8x12
n (g6)		20	32	40
o (H7)		6	8	8
p3	PNEUMATIC OPEN/CLOSE STROKE CONTROL OR AIR PURGE	M4	M4	M4
p4	WISE CLOSE	M4	M4	M4
p5	WISE OPEN	M4	M4	M4
p8		M6x12	M8x16	M10x18
p9		M4	M4	M4
p10		M4	M4	M4

# STV-3N STV-3L

## Spring and air operated Twin Vise

- Protected and springs clamping
- Pneumatic open/close control (stroke control) master jaws valve

- STV-3N: Normal stroke
- STV-3L: Long stroke
- 3 jaws

### Application/customer benefits

- Compact design
- Master jaws guide protected against swarf and chips
- Highest repeatability
- Highest rigidity

### Standard equipment

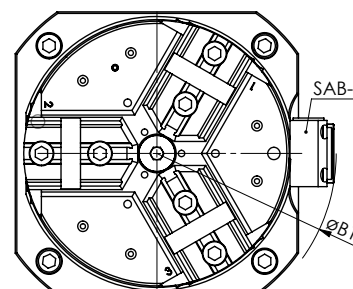
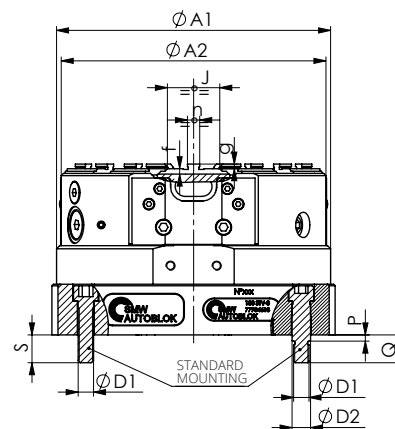
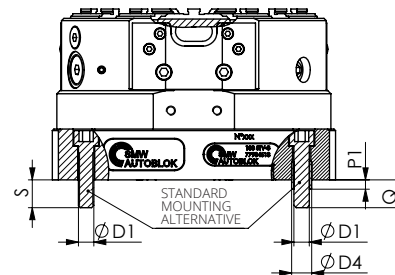
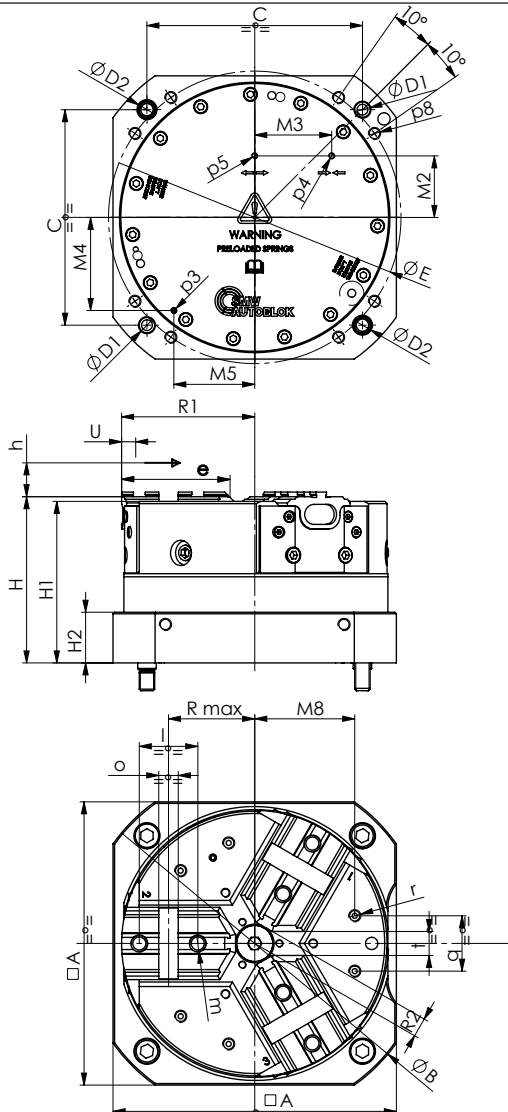
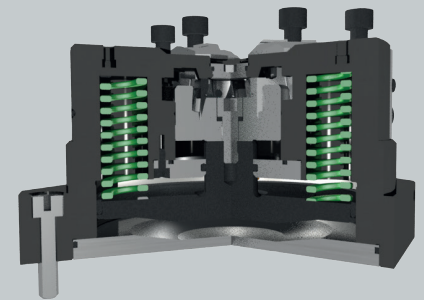
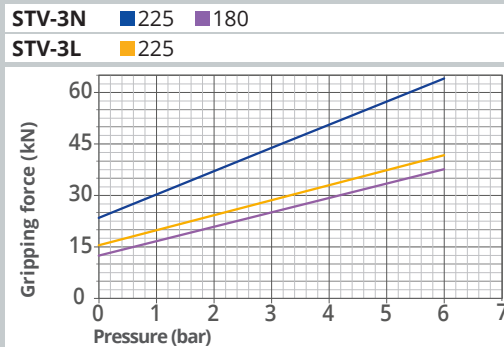
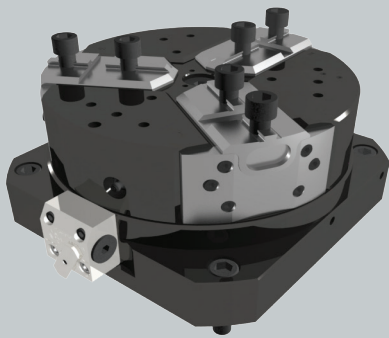
Self-centering vise without top jaws  
All bolts and centering bushings included

### Technical features

- Spring clamped, air open
- Increase of the clamping force via Turbo function
- Housing and functional parts hardened for high precision and long life
- Ready for air purge
- 3 jaw interfaces: Tongue & Groove
- OD clamping only
- Safety valve SAB-1 to maintain air pressure during pallet transportation/storage and machining without feed (optional see page 30)
- Pneumatic open/close control (stroke control) master jaws valve (optional see page 30)
- Lubrication with SMW-Autoblok K67 grease

#### ROTATION USE

The vise can be used up to max 1000 rpm (standard stroke version) and max 800 rpm (long stroke version) only if operated with springs + Turbo system (at minimum 3 bar) and with top jaws weight not higher than the standard ones.



Subject to technical changes

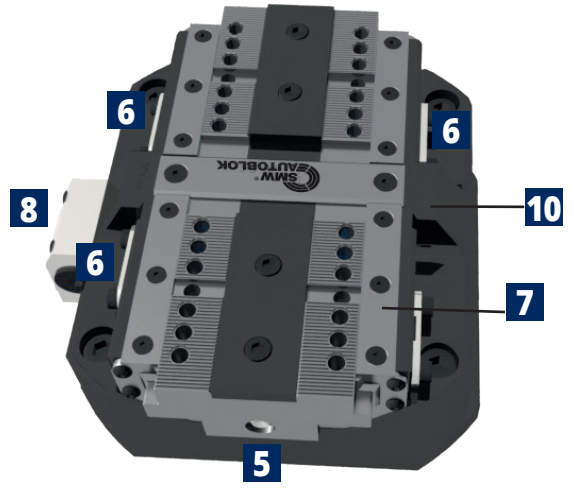
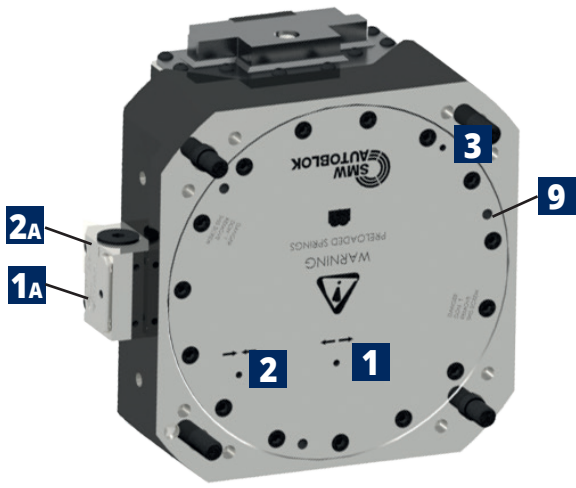
# TECHNICAL DATA

TYPE	ID. No.	STROKE TYPE	MAX. CLAMPING FORCE MIDDLE STROKE		STROKE/JAW	PISTON AREA	RE-OPENING PRESSURE	MAX. OPERATING PRESSURE	WEIGHT
			ONLY SPRINGS	SPRINGS+TURBO					
180 STV-3N	77904618	NORMAL	13 kN	38 kN	3.8 mm	170 cm <sup>2</sup>	5 bar	6 bar	18 Kg
225 STV-3N	77904622	NORMAL	24 kN	64 kN	4.2 mm	250 cm <sup>2</sup>	6 bar	6 bar	29.5 Kg
225 STV-3L	77904722	LONG	16 kN	42 kN	8 mm	250 cm <sup>2</sup>	6 bar	6 bar	29.5 Kg

TYPE WITH SAB-1	Id. No.	TYPE STROKE	COMPOSITION	MAX. OPERATING PRESSURE
180 STV-3N + SAB-1	77905018	NORMAL	77904618 + 27581810	3.5/6 bar
225 STV-3N + SAB-1	77905022	NORMAL	77904622 + 27581810	
225 STV-3L + SAB-1	77905122	LONG	77904722 + 27581810	

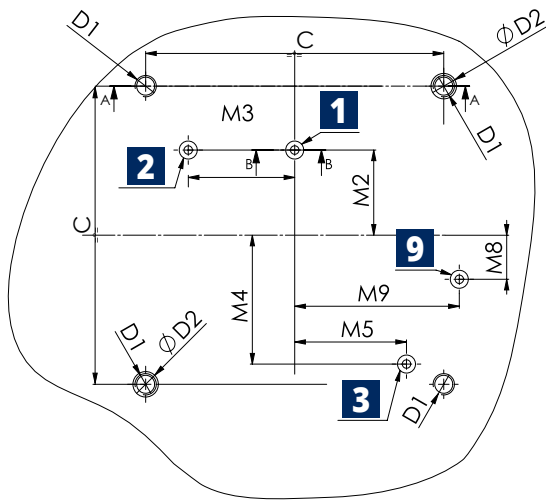
STV-3		180	225
A		184	225
A1		178	222
A2		172	216
B (∅)		225	284
B1 (∅)	SAB-1 VALVE OVERALL DIMENSION	233	276
C		140	180
D1(∅)		M10	M12
D2 (∅f7)		12	14
D4 (∅js7)		13	16
E (∅)		190	240
H		108	115
H1		105	112
H2		33	38
J		34	46
M2		40	50
M3		50	65
M4		60,5	79
M5		52,5	63
M8		65	80
P		4	5
P1		6	6
Q		18	20
R max	MIN/MAX (NORMAL STROKE)	52.2/56	67,8/72
R1	MIN/MAX (NORMAL STROKE)	82,7/86,5	103.8/108
R2	MIN/MAX (NORMAL STROKE)	8,7/12,5	12.8/17
R max	MIN/MAX (LONG STROKE)	/	68/76
R1	MIN/MAX (LONG STROKE)	/	104.5/112.5
R2	MIN/MAX (LONG STROKE)	/	9/17
S		18	20
U	NORMAL STROKE	3,8	4.2
U	LONG STROKE	/	8
e		70	87
f		3,5	3,5
g		3	3
h		25	35
l		38	44,4
m		M10x12	M12x14
n (h8)		7,94	7,94
o (H7)		12,68	12,68
p3	PNEUMATIC OPEN/CLOSE STROKE CONTROL OR AIR PURGE	M4	M4
p4	WISE CLOSE	M4	M4
p5	WISE OPEN	M4	M4
p8		M8x16	M10x18
q		36	45
r		M8x10	M8x10
t	MIN/MAX (NORMAL STROKE)	9/15,6	13.5/20,9
t	MIN/MAX (LONG STROKE)	/	6.8/20.9

# MOUNTING INSTRUCTIONS



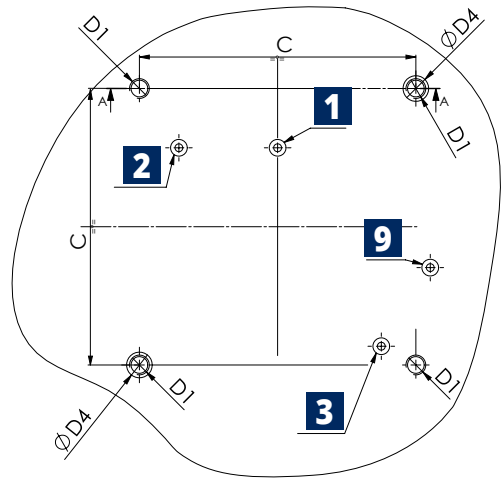
## SOLUTION 1 STANDARD

± 0,03 mm to clamping center

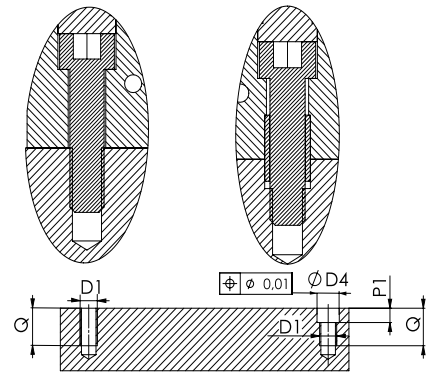
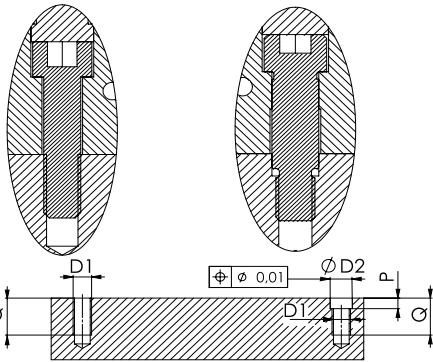


## SOLUTION 2 STANDARD

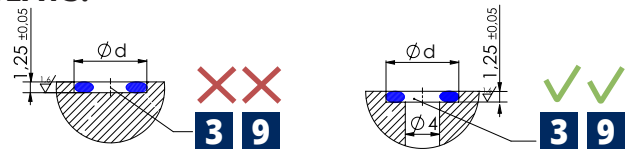
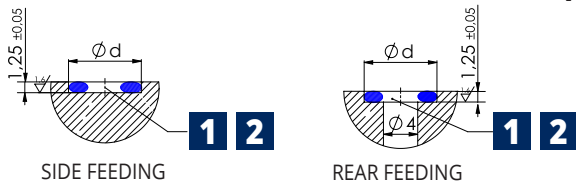
± 0,025 mm to clamping center



**ALL BOLTS AND CENTERING BUSHINGS INCLUDED**



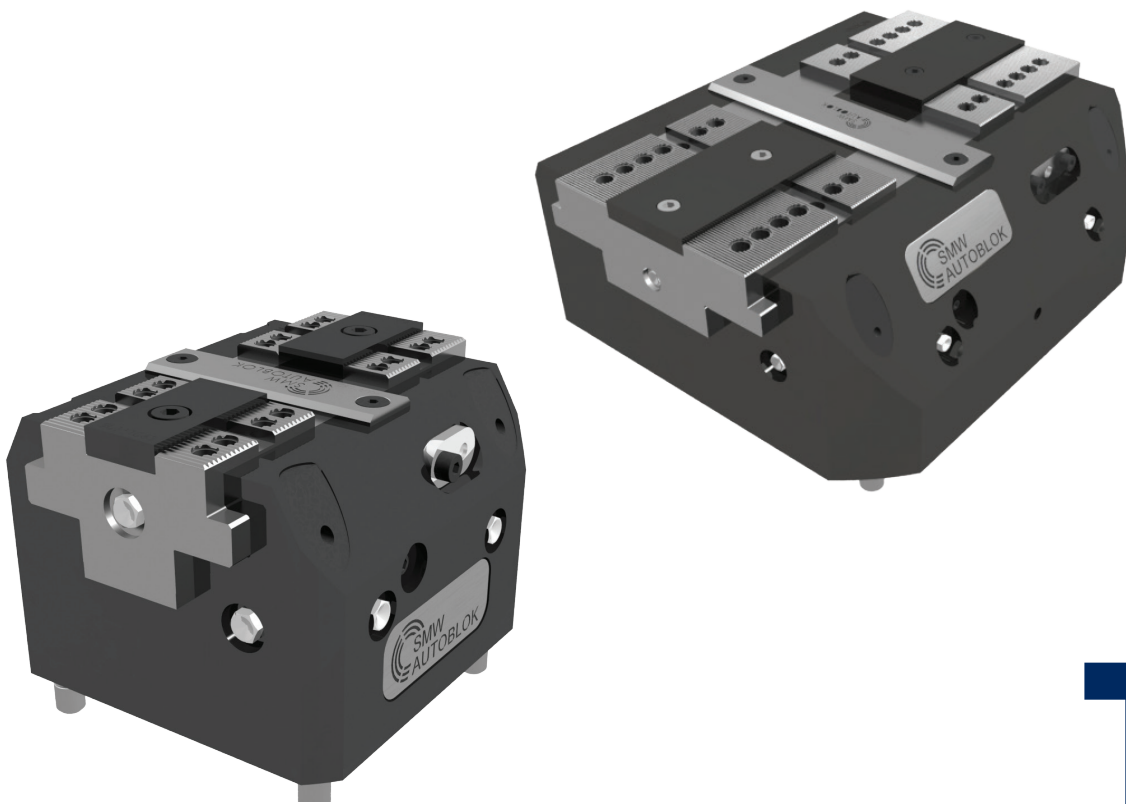
## FEEDING SEATS:



- 1** Open-Rear feeding
- 1A** Open-Side feeding
- 10** Air sensing outlet\*\* (under front plate)
- 2** Closed-Rear feeding
- 2A** Closed-Side Feeding
- 3** Pneum.open dose stroke control or Air purge\*
- 5** Lubrication fitting
- 6** Proximity switches seats
- 7** Pneumatic open close stroke control valve (optional page 30)
- 8** Safety valve SAB-1 (optional see page 30)
- 9** Air sensing connection\*\* (only bottom)

\* The air purge can be used only without the valve.  
 \*\*9 and 10 Points available only on 2 jaws version.

STV	C	D1	D2H7	D4H7	M2	M3	M4	M5	M8	M9	P	P1	Q	Ød	OR
125	100	M8	10	11	32	29,5	40,5	38,5	10,6	54,5	6	6	18	8	OR2018
180	140	M10	12	13	40	50	60,5	52,5	20,7	77,3	6	7	21	8,8	OR2021
225	180	M12	14	16	50	65	79	63	15	99,9	7	7	24	8,8	OR2021



**TV**

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**STANDARD TWIN VISES**

**100-160-200-250-315**

# TVP-N TVP-L TVP-F

## Pneumatic Twin Vise

- TVP-N: Normal stroke
- TVP-L: Long stroke
- TVP-F: One fixed jaw

### Application/customer benefits

- Compact design
- Linear pressure adjustment
- Highest repeatability
- Highest rigidity

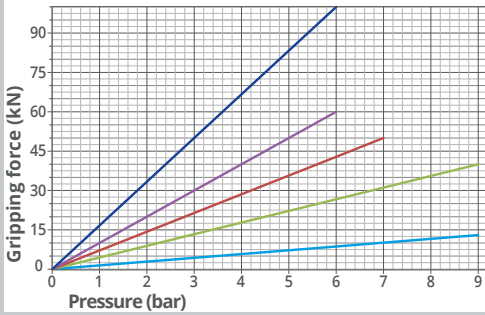
### Standard equipment

Self-centering vise without top jaws  
All bolts and centering bushings included

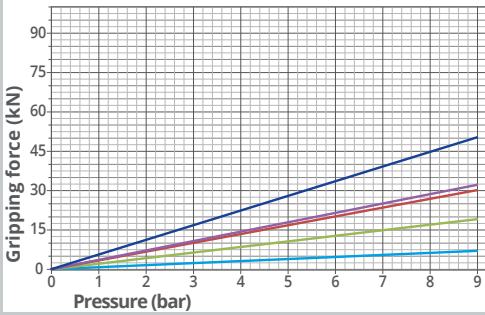
### Technical features

- H7 quality pilot bore (see p2 below)
- Housing and functional parts hardened for high precision and long life
- Ready for air purge
- Ready for central grease lubrication
- Master jaws with both Tongue & Groove and fine serration 1,5mmx60°
- OD and ID clamping
- Lubrication with SMW-Autoblok K67 grease
- Stroke control via proximity switches (optional see page 29)

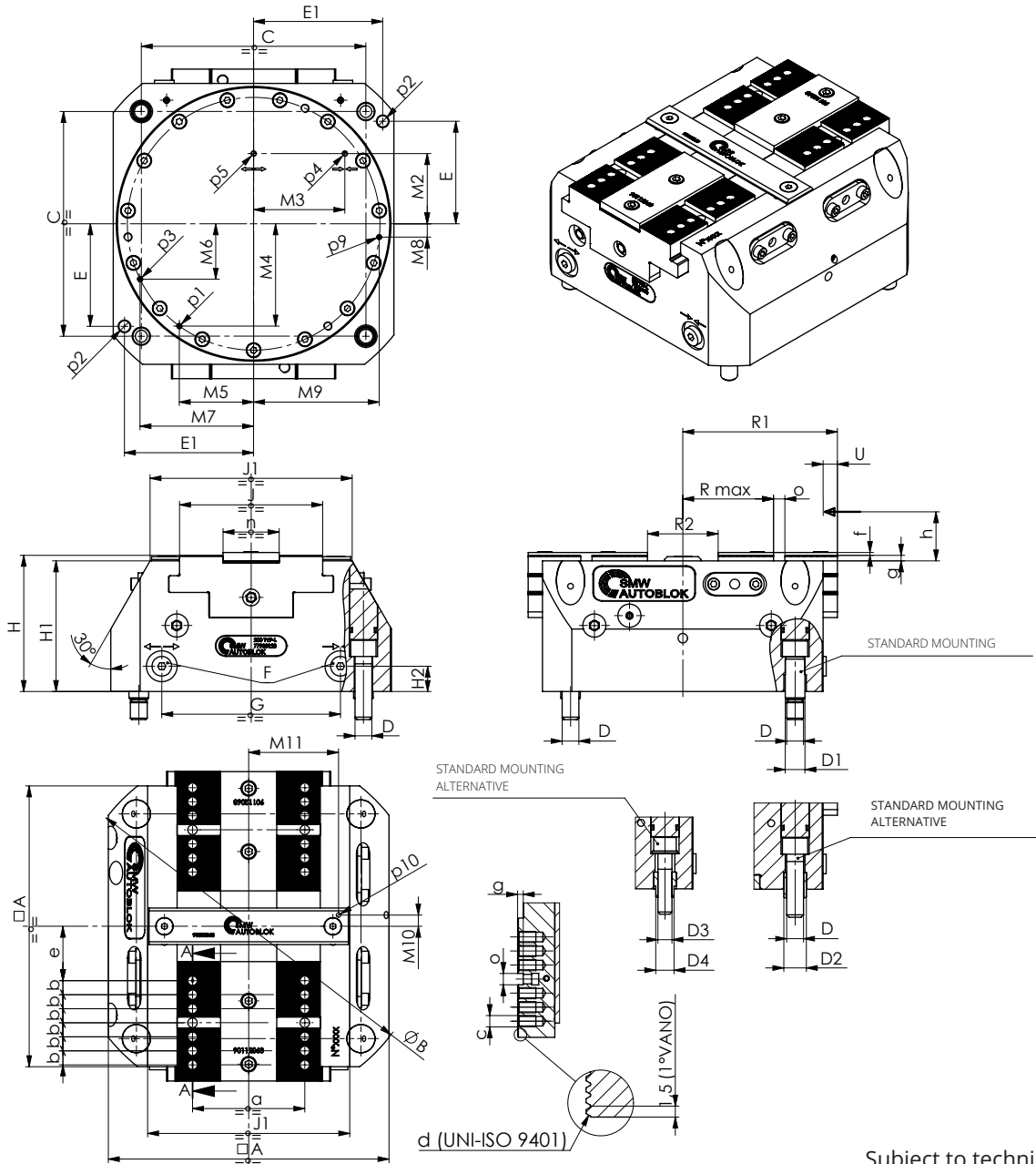
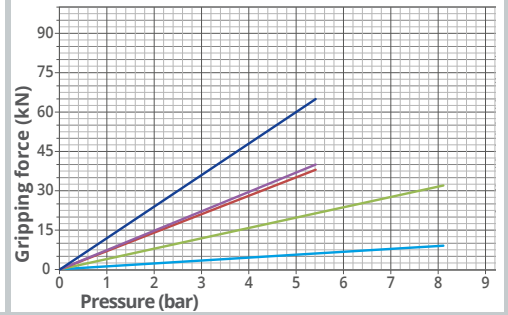
TVP-N 100 160 200 250 315



TVP-L 100 160 200 250 315



TVP-F 100 160 200 250 315



Subject to technical changes



# TECHNICAL DATA

TYPE	ID. No.	STROKE TYPE	MAX. CLAMPING FORCE	STROKE/JAW	MAX OPERATING PRESSURE	REPEATABILITY	WEIGHT
100 TVP-N	77903010	NORMAL	13 kN	2.6 mm	9 bar	0.01 mm	4.3 kg
100 TVP-L	77903110	LONG	7 kN	6 mm	9 bar	0.01 mm	4.3 kg
100 TVP-F	77903210	FIXED JAW	9 kN	6 mm	9 bar	0.01 mm	4.3 kg
160 TVP-N	77903016	NORMAL	40 kN	3 mm	9 bar	0.01 mm	13 kg
160 TVP-L	77903116	LONG	19 kN	8.4 mm	9 bar	0.01 mm	13 kg
160 TVP-F	77903216	FIXED JAW	32 kN	8.4 mm	9 bar	0.01 mm	13 kg
200 TVP-N	77903020	NORMAL	50 kN	4.2 mm	7 bar	0.02 mm	23 kg
200 TVP-L	77903120	LONG	30 kN	10.2 mm	9 bar	0.02 mm	23 kg
200 TVP-F	77903220	FIXED JAW	38 kN	10.2 mm	6 bar	0.02 mm	23 kg
250 TVP-N	77903025	NORMAL	60 kN	5.3 mm	6 bar	0.02 mm	39 kg
250 TVP-L	77903125	LONG	32 kN	15 mm	9 bar	0.02 mm	39 kg
250 TVP-F	77903225	FIXED JAW	40 kN	15 mm	6 bar	0.02 mm	39 kg
315 TVP-N	77903031	NORMAL	100 kN	6.4 mm	6 bar	0.03 mm	84 kg
315 TVP-L	77903131	LONG	50 kN	18 mm	9 bar	0.03 mm	84 kg
315 TVP-F	77903231	FIXED JAW	65 kN	18 mm	6 bar	0.03 mm	84 kg

TVP-N	TVP-L	TVP-F	100	160	200	250	315
A			100	160	200	250	315
B(∅)			132	205	255	314	394
C			80	125	160	200	250
D(∅)			M8x15	M10x18	M12x20	M12x20	M16x23
D1 (∅f7)			10x4	12x4	14x5	14x5	18x6
D2 (∅js7)			11x4	13x6	16x6	16x6	21x6
D3			-	-	M10x18	-	-
D4 (∅js7)			-	-	13x6	-	-
E			32	53	73	77	105
E1			45	73	92	115	140
F			M5	G1/8"	G1/8"	G1/8"	G1/8"
G			59.3	99	127.3	157	200.8
H			75.5	89.7	97	105	139
H1			72	86	93	100	133
H2			15	18	18	20	25
J			47	75	102	125	160
J1			72	108	144	180	230
M2			32	40	50	64	80
M3			29.5	50	65	75	90
M4			34.2	59	72.8	89.8	117.7
M5			27.7	41	52.9	65.2	79.4
M6			14.2	30.7	39.5	48.7	57.8
M7			41.1	62.9	80.9	99.8	129.7
M8			8.3	4.9	9.4	11.6	12.4
M9			42.7	69.8	89.5	110.4	141.5
M10			5	5	8	11	12
M11			34	52	64	78	102
p1	LUBRICATION		M4	M4	M4	M5	M5
p2 ØH7			6x14	8x14	8x14	10x20	12x20
p3	AIR PURGE		M4	M4	M4	M5	M5
p4	WISE CLOSE		M4	M4	M4	M5	M5
p5	WISE OPEN		M4	M4	M4	M5	M5
p9	AIR SENSING CONNECTION		M4	M4	M4	M5	M5
p10	AIR SENSING OUTLET		M4	M4	M4	M6	M6
R2	MIN/MAX (LONG STROKE)		20/32	26/42.8	30/50.4	39/69	50/86
R1	MIN/MAX (LONG STROKE)		50/56	82.5/90.9	100/110.2	119.5/134.5	151.5/169.5
Rmax	MIN/MAX (LONG STROKE)		25.6/31.6	44.8/53.2	54.5/64.7	51.5/66.5	81.5/99.5
R2	MIN/MAX (NORMAL STROKE)		19.8/25	26/32	30.6/39	34.4/45	49.2/62
R1	MIN/MAX (NORMAL STROKE)		47.4/50	82.5/85.5	95.8/100	119.7/125	151.1/157.5
Rmax	MIN/MAX (NORMAL STROKE)		25.4/28	45/48	54.5/58.7	55.7/61	87.1/93.5
R2	MIN/MAX (FIXED JAW)		20/26	26/34.4	30/40.2	39/54	56/74
R1	MIN/MAX (FIXED JAW)		50/56	82.5/90.9	100/110.2	119.5/134.5	151.5/169.5
Rmax	MIN/MAX (FIXED JAW)		25.6/31.6	44.8/53.2	54.5/64.7	51.5/66.5	81.5/99.5
U	LONG STROKE		6	8.4	10.2	15	18
U	NORMAL STROKE		2.6	3	4.2	5.3	6.4
U	FIXED JAW STROKE		6	8.4	10.2	15	18
a			35	60	80	90	120
b			7	10	10	12	15
c			M6x10	M8x12	M8x12	M10x15	M12x17
d	SERRATION		1,5x60°	1,5x60°	1,5x60°	1,5x60°	1,5x60°
e	MIN/MAX (NORMAL STROKE)		14.4/17	19/22	28.5/32.7	24.7/30	33.1/39.5
e	MIN/MAX (LONG STROKE)		14.6/20.6	18.8/27.2	28.5/38.7	32.5/47.5	42.5/60.5
e	MIN/MAX (FIXED JAW)		14.6/20.6	18.8/27.2	28.5/38.7	32.5/47.5	42.5/60.5
f			1.8	1.8	2	2.5	2.5
g			2.7	3.2	4	4	4
h			16	25	35	40	40
o (H7)			6	8	8	10	12
n (g6)			20	32	40	50	60

# TVH-N TVH-L TVH-F

## Hydraulic Twin Vise

- TVH-N: Normal stroke
- TVH-L: Long stroke
- TVH-F: One fixed jaw

### Application/customer benefits

- Compact design
- Linear pressure adjustment
- Highest repeatability
- Highest rigidity

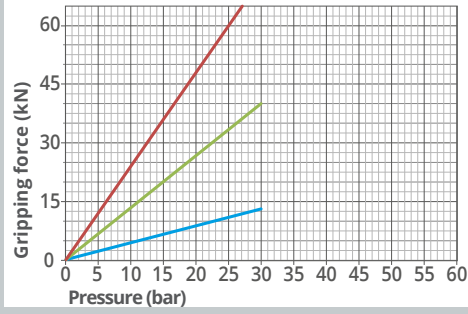
### Standard equipment

Self-centering vise without top jaws  
All bolts and centering bushings included

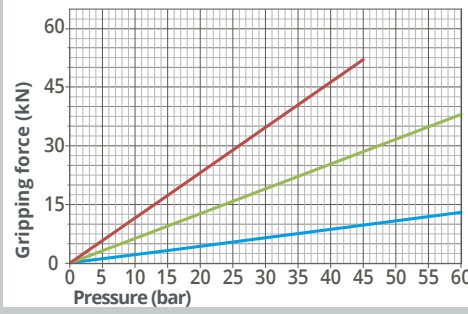
### Technical features

- H7 quality pilot bore (see p2 below)
- Housing and functional parts hardened for high precision and long life
- Ready for air purge
- Ready for central grease lubrication
- Master jaws with both Tongue & Groove and fine serration 1,5mmx60°
- OD and ID clamping
- Lubrication with SMW-Autoblok K67 grease
- Stroke control via proximity switches (optional see page 29)

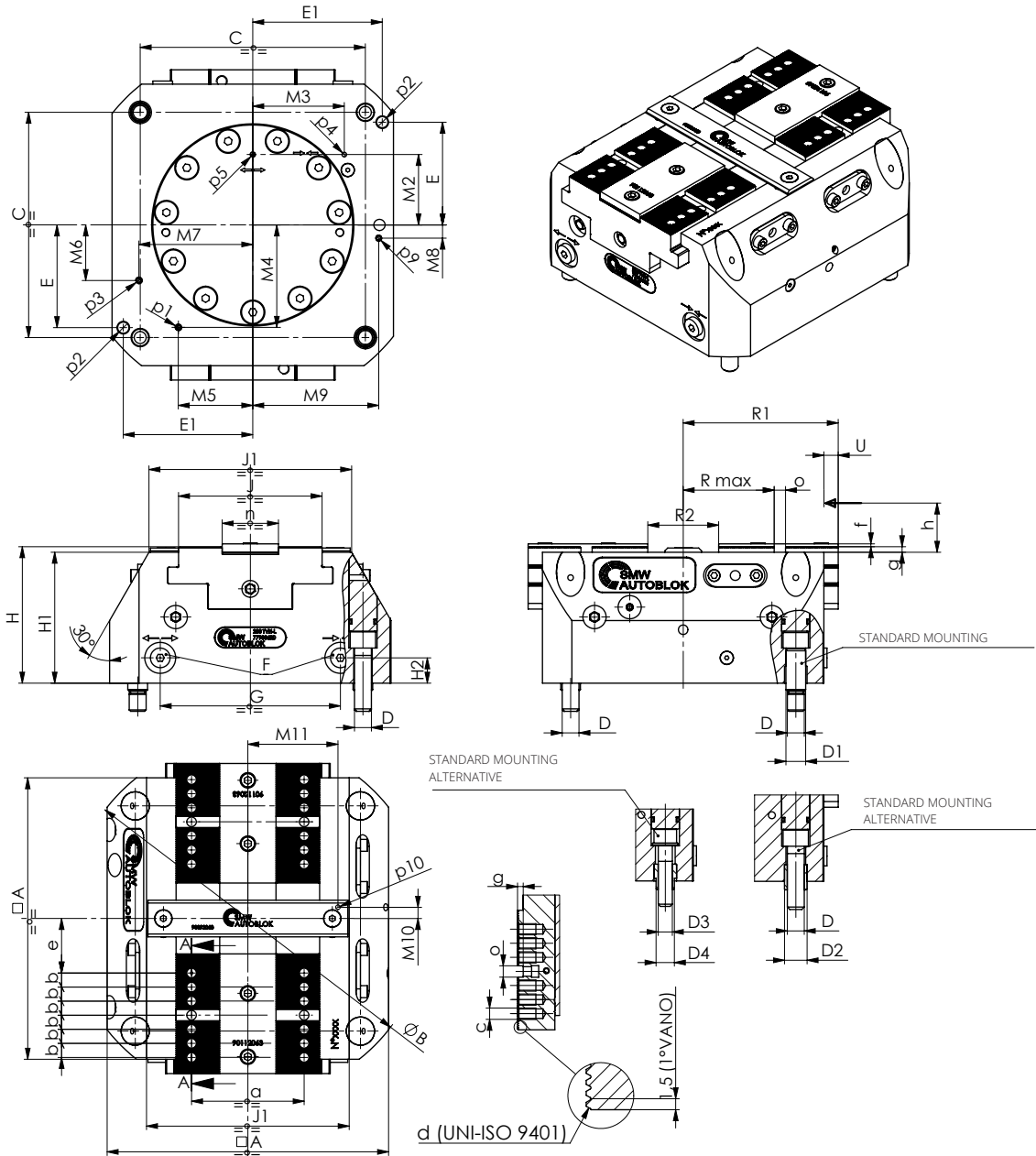
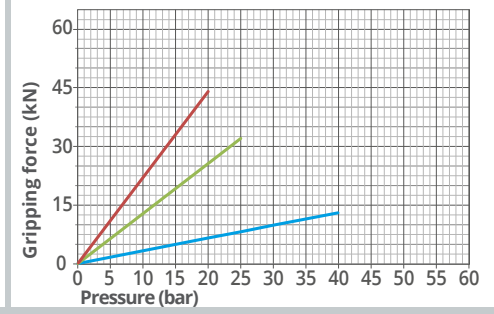
TVH-N 100 160 200



TVH-L 100 160 200



TVH-F 100 160 200



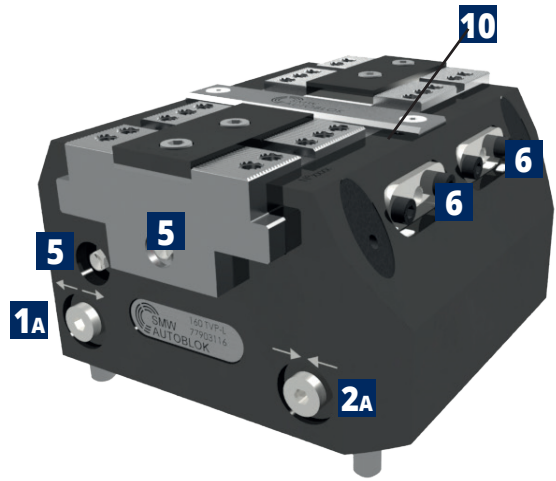
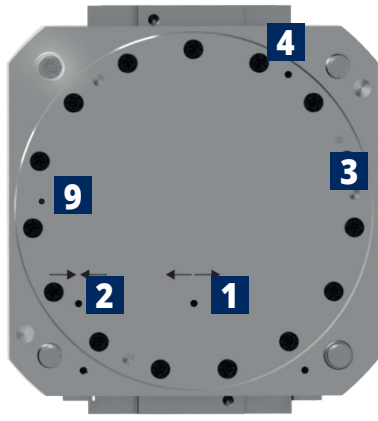
Subject to technical changes

# TECHNICAL DATA

TYPE	ID. No.	STROKE TYPE	MAX. CLAMPING FORCE	STROKE/JAW	MAX OPERATING PRESSURE	REPEATABILITY	WEIGHT
100 TVH-N	77903510	NORMAL	13 kN	2.6 mm	30 bar	0.01 mm	4.5 kg
100 TVH-L	77903610	LONG	13 kN	6 mm	60 bar	0.01 mm	4.5 kg
100 TVH-F	77903710	FIXED JAW	13 kN	6 mm	40 bar	0.01 mm	4.5 kg
160 TVH-N	77903516	NORMAL	40 kN	3 mm	30 bar	0.01 mm	14 kg
160 TVH-L	77903616	LONG	38 kN	8.4 mm	60 bar	0.01 mm	14 kg
160 TVH-F	77903716	FIXED JAW	32 kN	8.4 mm	25 bar	0.01 mm	14 kg
200 TVH-N	77903520	NORMAL	60 kN	4.2 mm	25 bar	0.02 mm	25 kg
200 TVH-L	77903620	LONG	52 kN	10.2 mm	45 bar	0.02 mm	25 kg
200 TVH-F	77903720	FIXED JAW	44 kN	10.2 mm	20 bar	0.02 mm	25 kg

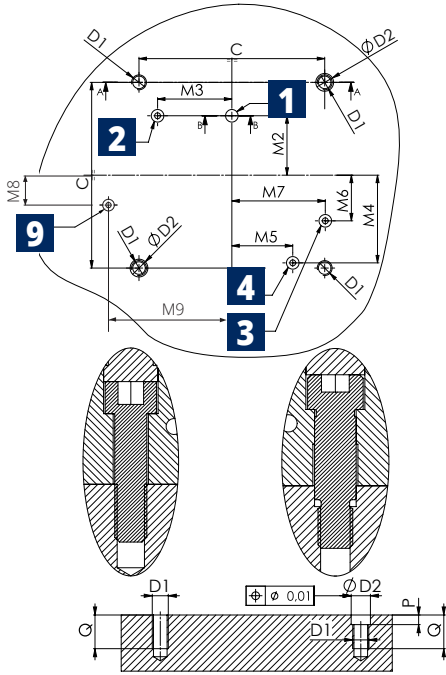
TVH-N	TVH-L	100	160	200
A		100	160	200
B(Ø)		132	205	255
C		80	125	160
D(Ø)		M8x15	M10x18	M12x20
D1 (Øf7)		10x4	12x4	14x5
D2 (Øjs7)		11x4	13x6	16x6
D3		-	-	M10x18
D4 (Øjs7)		-	-	13x6
E		32	53	73
E1		45	73	92
F		G1/8"	G1/8"	G1/8"
G		55	98	128
H		75.5	89.7	97
H1		72	86	93
H2		15	18	18
J		47	75	102
J1		72	108	144
M2		32	40	50
M3		29.5	50	65
M4		34.2	59	72,8
M5		27.7	41	52,9
M6		14.2	30.7	39,5
M7		41.1	62.9	80,9
M8		8.3	4.9	9.4
M9		42.7	69.8	89.5
M10		5	5	8
M11		34	52	64
p1	LUBRICATION	M4	M5	M5
p2 ØH7		6x14	8x14	8x14
p3	AIR PURGE	M4	M5	M5
p4	WISE CLOSE	M4	M4	M4
p5	WISE OPEN	M4	M4	M4
p9	AIR SENSING CONNECTION	M4	M5	M5
p10	AIR SENSING OUTLET	M4	M4	M4
R2	MIN/MAX (LONG STROKE)	20/32	26/42.8	30/50.4
R1	MIN/MAX (LONG STROKE)	50/56	82.5/90.9	100/110.2
Rmax	MIN/MAX (LONG STROKE)	25.6/31.6	44.8/53.2	54.5/64.7
R2	MIN/MAX (NORMAL STROKE)	19.8/25	26/32	30.6/39
R1	MIN/MAX (NORMAL STROKE)	47.4/50	82.5/85.5	95.8/100
Rmax	MIN/MAX (NORMAL STROKE)	25.4/28	45/48	54.5/58.7
R2	MIN/MAX (FIXED JAW)	20/26	26/34.4	30/40.2
R1	MIN/MAX (FIXED JAW)	50/56	82.5/90.9	100/110.2
Rmax	MIN/MAX (FIXED JAW)	25.6/31.6	44.8/53.2	54.5/64.7
U	LONG STROKE	6	8.4	10.2
U	NORMAL STROKE	2.6	3	4.2
U	FIXED JAW STROKE	6	8.4	10.2
a		35	60	80
b		7	10	10
c		M6x10	M8x12	M8x12
d	SERRATION	1,5x60°	1,5x60°	1,5x60°
e	MIN/MAX (NORMAL STROKE)	14.4/17	19/22	28.5/32.7
e	MIN/MAX (LONG STROKE)	14.6/20.6	18.8/27.2	28.5/38.7
e	MIN/MAX (FIXED JAW)	14.6/20.6	18.8/27.2	28.5/38.7
f		1.8	1.8	2
g		2.7	3.2	4
h		16	25	35
o (H7)		6	8	8
n (g6)		20	32	40

# MOUNTING INSTRUCTIONS



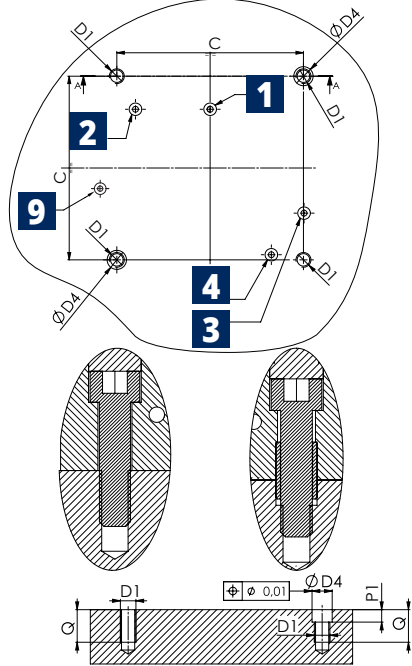
## SOLUTION 1 STANDARD

± 0,03 mm to clamping center



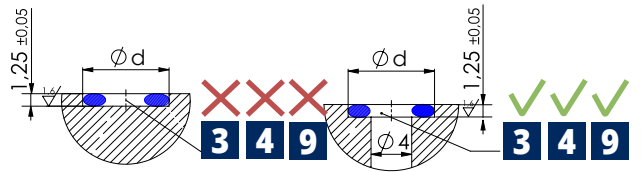
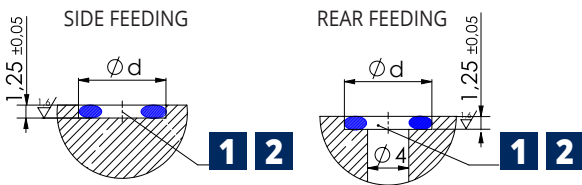
## SOLUTION 2 STANDARD

± 0,025 mm to clamping center



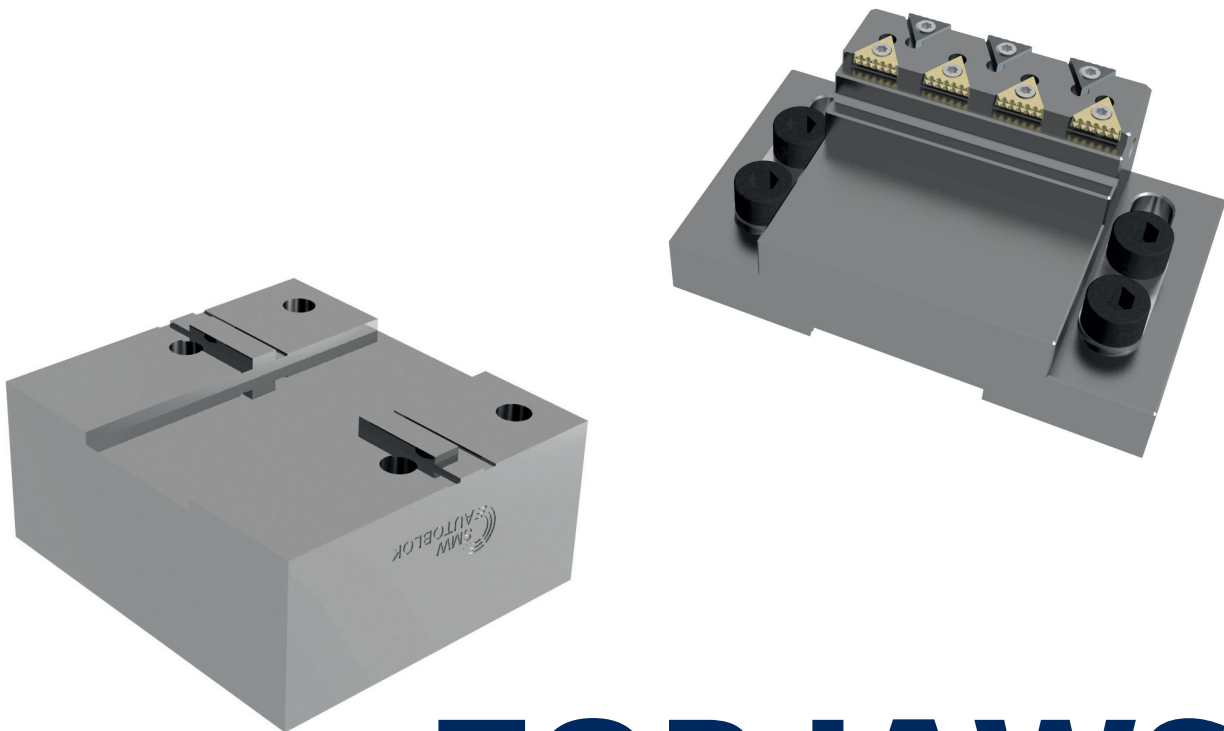
**ALL BOLTS AND CENTERING BUSHINGS INCLUDED**

## FEEDING SEATS: OBLIGATED EXECUTION



- 1** Open-Rear feeding
- 2** Closed-Rear feeding
- 3** Air purge
- 5** Lubrication fitting
- 9** Air sensing connection
- 1A** Open-Side feeding
- 2A** Closed-Side feeding
- 4** Central lubrication
- 6** Proximity switches seats
- 10** Air sensing outlet

TV	C	D1	D2H7	D4H7	M	M1	M2	M3	M4	M5	M6	M7	M8	M9	P	P1	Q	V	Z	Ød	OR
100	80	M8	10	11	45	29	32	29,5	34,2	27,7	14,2	41,1	8,3	42,7	6	6	18	37,3	96,5	8	OR2018
160	125	M10	12	13	69	48	40	50	59	41	30,7	62,9	4,9	69,8	6	7	21	50	155	8	OR2018
200	160	M12	14	16	88	62	50	65	72,8	52,9	39,5	80,9	9,4	89,5	7	7	24	62	195	8,8	OR2021
250	200	M12	14	16	113	77	64	75	89,8	65,2	48,6	99,8	11,6	110,4	7	7	24	80	239	8,8	OR2021
315	250	M15	18	21	-	-	80	90	115,7	84	62,7	128,5	12,4	141,5	8	7	27	-	-	8,8	OR2021



# **TOP JAWS**

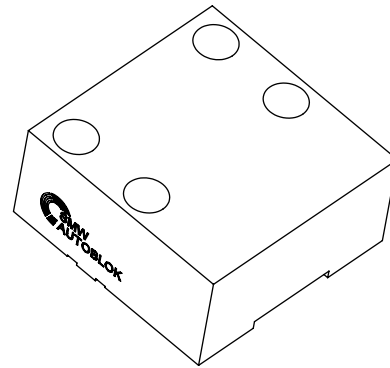
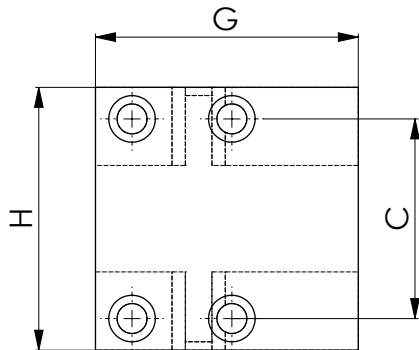
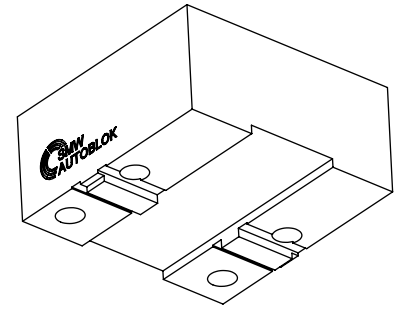
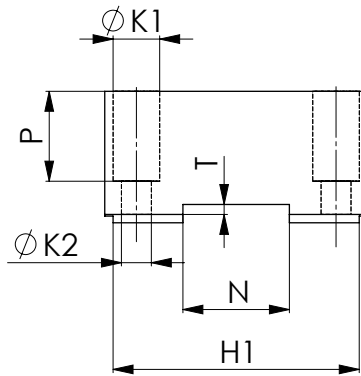
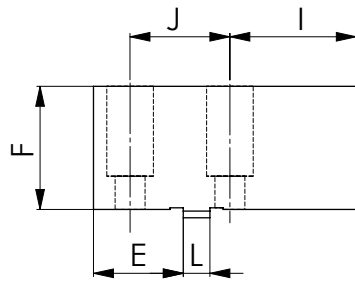
FOR TWIN VISES

**HARD AND SOFT TOP JAWS**

# SOFT TOP JAWS for Twin Vises

- Soft blank top jaws
- Tongue & Groove

Material: C40 UNI7847

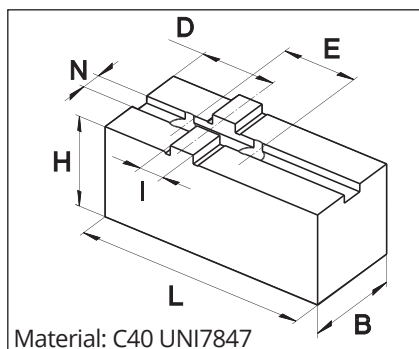


Subject to technical changes

## SOFT BLANK TOP JAWS, TONGUE & GROOVE

TYPE	ID No*	C	E	F	G	H	H1	I	J	K1	K2	L	N	P	T	CLAMPING RANGE	WEIGHT (Kg)
100 TV / PT	90711063	35	18	27.5	49	54.5	45	21	21	11	7	6h7	20h8	20	3	0-70	0,5
125 STV-2 / PT	90711283	35	33	27,5	64	54,5	45	21	35	11	7	6h7	20h8	20	3	0-100	0,65
100 TV / PT	90721063	35	18	47.5	49	54.5	45	21	21	11	7	6h7	20h8	40	3	0-70	0,85
125 STV-2 / PT	90721283	35	33	47,5	64	54,5	45	21	35	11	7	6h7	20h8	40	3	0-100	1,15
160 TV / PT	90711663	60	27	37	79	79	74	38	30	14	9	8h7	32h8	27	3	0-120	1,6
180 STV-2 / PT	90711883	60	41	37	93	79	74	38	40	14	9	8h7	32h8	27	3	0-140	1,9
160 TV / PT	90721663	60	27	76,5	79	79	74	38	30	14	9	8h7	32h8	66.5	3	0-120	3,3
180 STV-2 / PT	90721883	60	41	76,5	93	79	74	38	40	14	9	8h7	32h8	66.5	3	0-140	4
200 TV / PT	90712063	80	37	47	98.5	109	92	47.5	40	14	9	8h7	40h8	37	3,5	0-150	3,6
200 TV / PT	90722063	80	37	86,5	98.5	109	92	47.5	40	14	9	8h7	40h8	76.5	3,5	0-150	6,8
225 STV-2	90712283	80	52	47	113.5	109	92	47.5	50	14	9	8h7	40h8	37	3,5	0-170	4,2
225 STV-2	90722283	80	52	86,5	113.5	109	92	47.5	50	14	9	8h7	40h8	76.5	3,5	0-170	7,9
250 TV	90712563	90	59	47	120	124	/	44	48	18	11	10h7	50h8	31	3,5	0-180	5
250 TV	90722563	90	59	97,5	120	124	/	44	48	18	11	10h7	50h8	81.5	3,5	0-180	10,5
315 TV	90713163	120	54	57	150	160	/	75	60	20	13.5	12h7	60h8	42	3,5	0-240	10
315 TV	90723163	120	54	102.5	150	160	/	75	60	20	13.5	12h7	60h8	87.5	3,5	0-240	18

\*The Id.n. refers to one single piece.



Material: C40 UNI7847

## TONGUE & GROOVE SOFT BLANK TOP JAWS "C" FOR TWIN VISE STV-3

TYPE	ID No*	B	H	L	N	D	E	I	CLAMPING RANGE	WEIGHT (Kg)
180 STV-3	12041660	30	32	80	7.94	30	38.1	12.68	0-140	0,58
225 STV-3	12042060	35	37	100	7.94	35	44.4	12.68	0-170	0,92

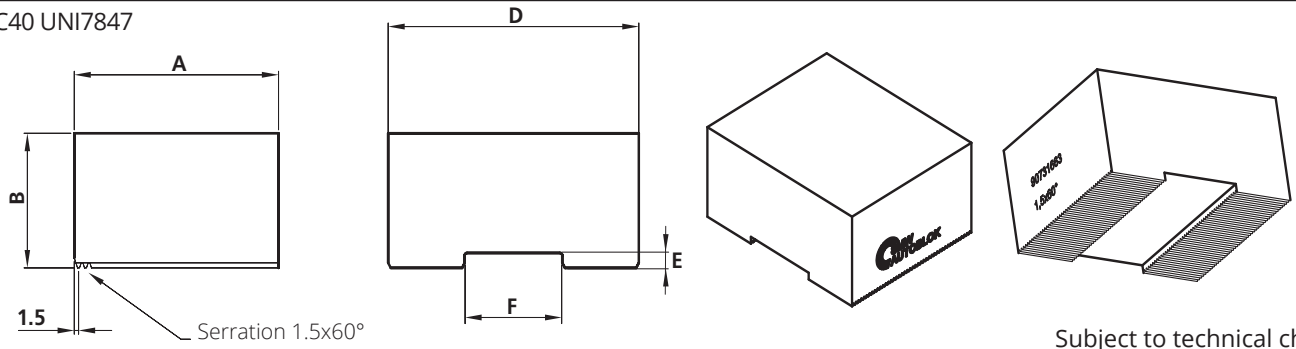
\*The Id.n. refers to one single piece.



- Soft blank top jaw
- Fine serration 1.5mmx60°

# SOFT TOP JAWS for Twin Vise

Material: C40 UNI7847



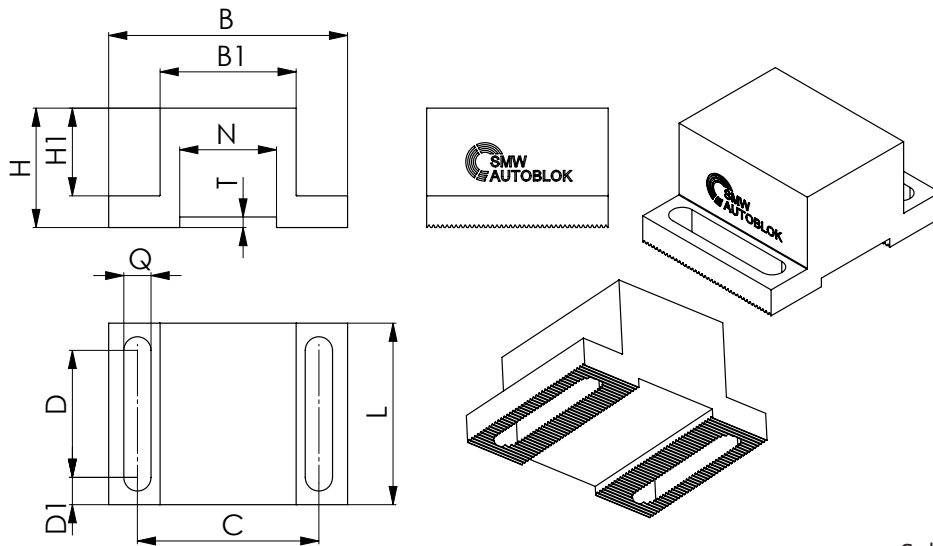
Subject to technical changes

## SOFT BLANK TOP JAWS, FINE SERRATION 1.5 mm x 60°

TYPE	ID No*	A	B	D	E	F	WEIGHT (Kg)
100-125 TV	90731063	42	29.5	54.5	3.5	20H8	0.5
100-125 TV	90741063	47	49.5	54.5	3.5	20H8	0.95
160-180 TV	90731663	66	39.5	79	3.5	32H8	1.5
160-180 TV	90741663	76	79	79	3.5	32H8	3.6
200-225 TV	90732063	87	49.5	109	4	40H8	3.5
200-225 TV	90742063	87	89	109	4	40H8	6.5
250 TV	90732563	108	49.5	124	4	50H8	5
250 TV	90742563	108	99	124	4	50H8	10.2
315 TV	90733163	160	49.5	160	4	60H8	9.6
315 TV	90743163	160	105	160	4	60H8	20.7

\*The Id.n. refers to one single piece.

Material: C40 UNI7847



Subject to technical changes

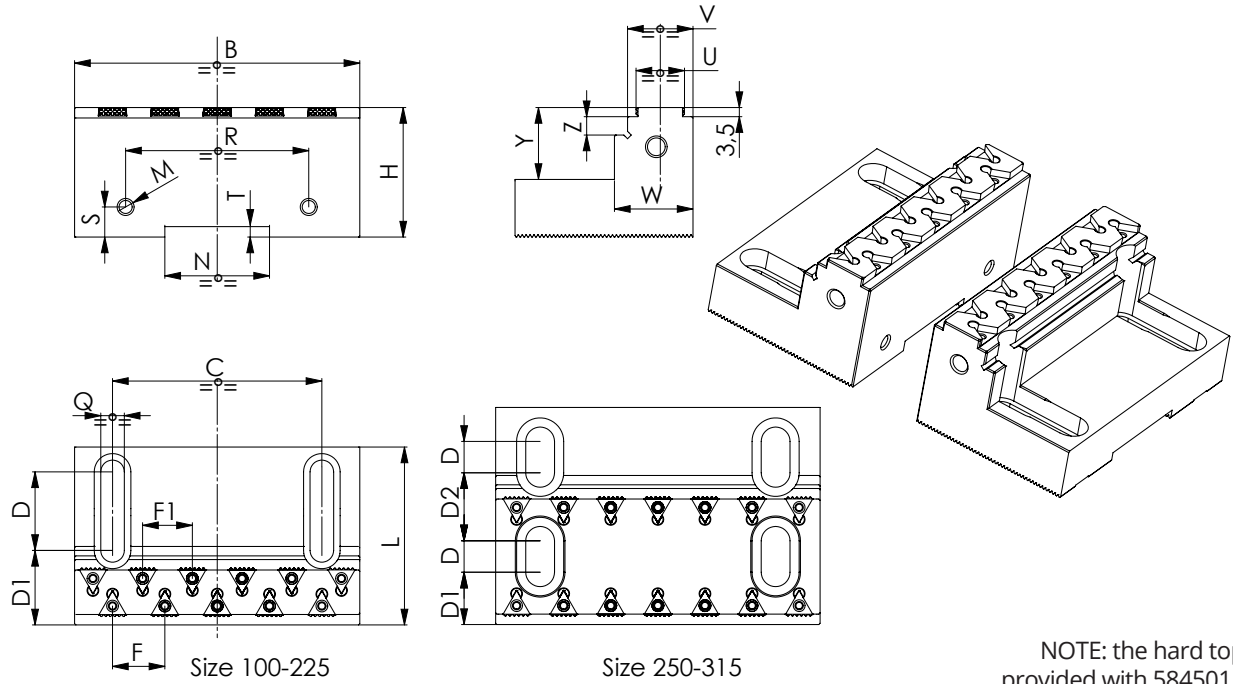
## SOFT BLANK TOP JAWS, FINE SERRATION 1.5 mm x 60°

TYPE	ID No*	B	B1	C	D	D1	H	H1	L	N	Q	T	WEIGHT (Kg)
100-125 TV	90751063	54.5	24	35	30	6	29.5	21.5	42	20H8	6.6	3.5	0.25
160-180 TV	90751663	79	45	60	42	9	39.5	29	60	32H8	9	3.5	0.9
200-225 TV	90752063	109	65	80	62	9	49.5	39	80	40H8	9	4	2
250 TV	90752563	124	72	90	62	14	49.5	33	90	50H8	11	4	2.7
315 TV	90753163	160	90	120	82	12	49.5	31.5	106	60H8	13.5	4	4.2

\*The Id.n. refers to one single piece.

# WIDE HARD TOP JAWS SinterGrip

- Hard top jaws with SinterGrip inserts
- Metric serrated 1.5 mm x 60°



NOTE: the hard top jaws are provided with 58450119 inserts mounted only on one side.

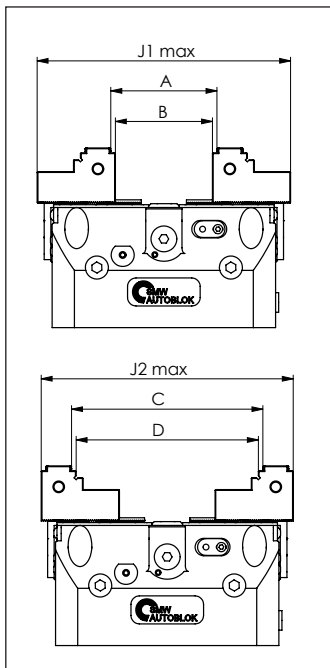
Subject to technical changes

## WIDE HARD TOP JAWS DIMENSIONS

TYPE	ID No set of 2 top jaws	B mm	C mm	D mm	D1 mm	D2 mm	F mm	F1 mm	H mm	L mm	M mm	N mm	Q mm	R mm	S mm	T mm	U mm	V mm	W mm	Y mm	Z mm	N° inserts provided	*N° seat inserts	Weight (Kg)
100-125 TV-STV-PT	58454115	72	35	21	9	/	12/23	12/23	26	39	M5	20H8	6,6	60	10	3,5	21,5	28	33	13	5	8	16	0,7
160-180 TV-STV-PT	58454125	104	60	30	14	/	15/28	15/28	34,5	57	M6	32H8	9	86	11,5	3,5	21,5	28	33	15,5	5	10	20	2
200-225 TV-STV-PT	58454135	109	80	30	29	/	20	19	34,5	68	M6	40H8	9	70	11,5	4	18,5	25	30	15,5	7	12	22	2,3
250 TV-PT	58454145	124	90	12	20	26	18	18	39,5	83	M8	50H8	11	80	15	4	45,5	52	57	17,5	7	14	28	4,3
315 TV	58454155	160	120	15	23,5	35	20	20	44,5	105	M8	60H8	13	80	15	4	55,5	62	67	17,5	7	16	32	8,3

\*The number of seats inserts indicated refers to set of 2 top jaws

## WIDE HARD TOP JAWS CLAMPING RANGES for long and normal stroke Twin Vise models



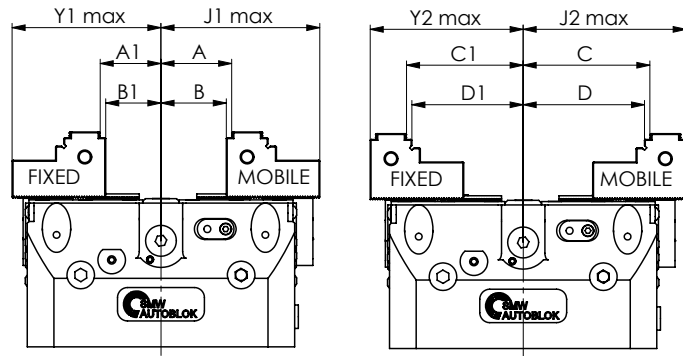
ID No set of 2 top jaws	TYPE	A mm	B mm	J1 max mm	C mm	D mm	J2 max mm	Gripping force max [kN]**
58454115	100 TV-N	10-32	4-25	106	32-70	25-63	122	13
	100 TV-L							
	100 PT-N	10-46	4-40	120	32-83	25-76	135	13
	100 PT-L							
	125 PT-N	10-60	4-53	134	32-98	25-91	150	22
	125 PT-L							
	125 STV-N	10-60	4-53	134	32-98	25-91	150	26
125 STV-L								
58454125	160 TV-N	10-70	4-63	180	66-138	59-131	190	40
	160 TV-L							
	160 PT-N	10-70	4-63	180	66-138	59-131	190	40
	160 PT-L							
	180 STV-N	10-85	4-78	195	66-160	59-153	213	54
	180 STV-L							
58454135	200 TV-N	10-93 (***)	4-86	225	96-175	89-168	220	60
	200 TV-L	10-96	4-89	228				
	200 PT-N	10-93 (***)	4-86	225	96-175	89-168	220	60
	200 PT-L	10-96	4-89	228				
	225 STV-N	10-96	4-89	228	96-202	89-196	250	66
	225 STV-L							
58454145	250 TV-N	10-88	4-82	250	88-192	82-186	292	60
	250 TV-L	10-106	4-100	270	88-202	82-196	302	
	250 PT-N	10-88	4-82	250	88-192	82-186	292	60
	250 PT-L	10-106	4-100	270	88-202	82-196	302	
58454155	315 TV-N	18-108	12-102	315	104-246	98-240	366	
	315 TV-L	18-132	12-126	338	120-255	114-248	375	100

\*\*the maximum gripping force values are indicative since they depend on the number of inserts used.

\*\*\*with 200 TV-PN and 200 PT-N models is not possible to clamp workpieces with dimensions between from 93 to 96 mm.

- Hard top jaws with SinterGrip inserts
- Metric serrated 1.5 mm x 60°

# WIDE HARD TOP JAWS SinterGrip



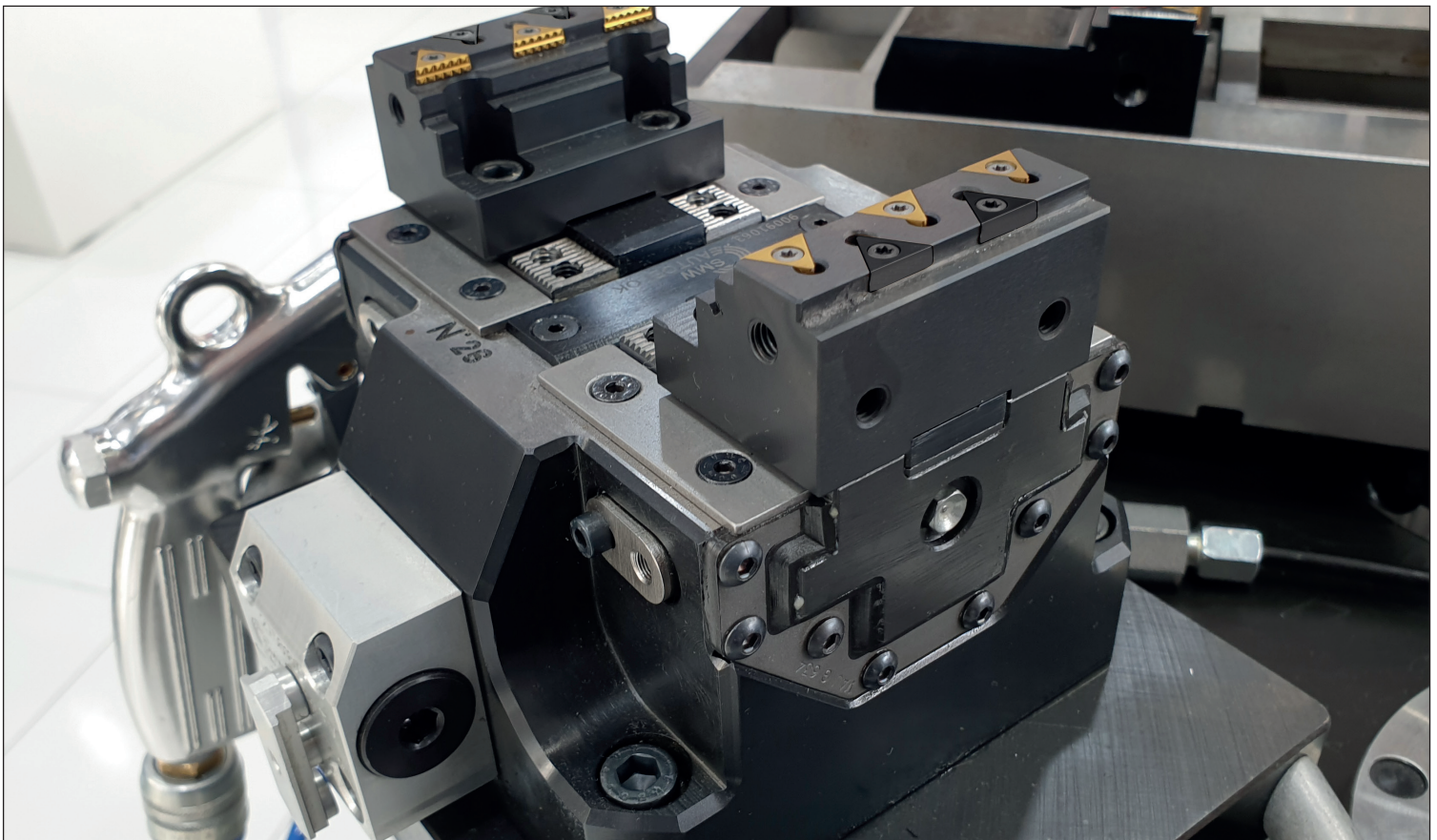
NOTE: the A1 - B1 - C1 - D1 dimensions for fixed jaws clamping range have tolerance  $\pm 0,75$  mm due to the serration pitch 1,5 mm

Subject to technical changes

## WIDE HARD TOP JAWS CLAMPING RANGES for one fixed jaw Twin Vise models

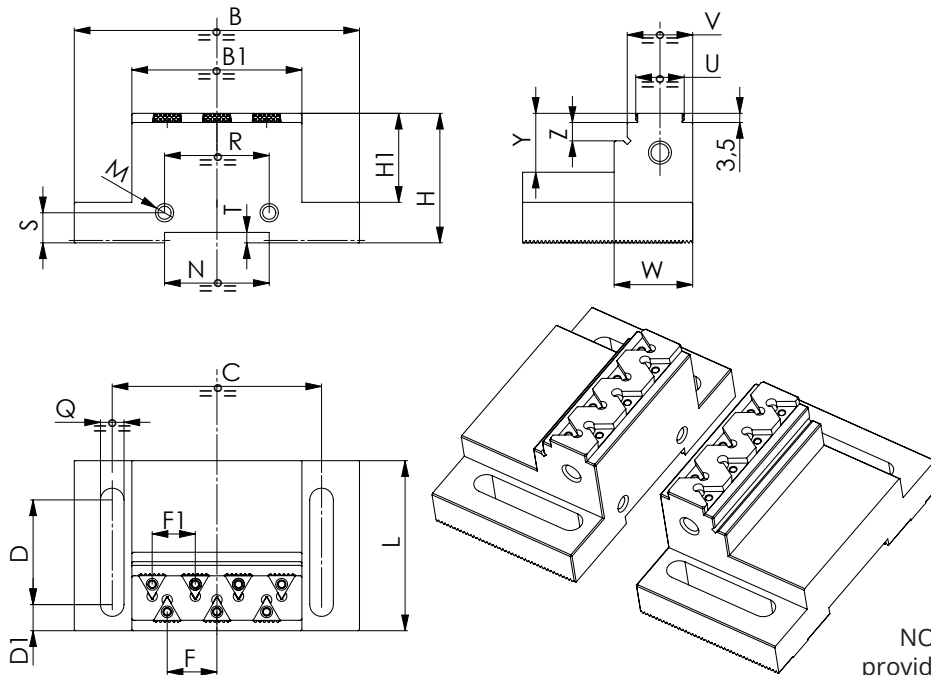
ID No set of 2 top jaws	TYPE	A mm	B mm	A1 mm	B1 mm	J1 max mm	Y1 max mm	C mm	D mm	C1 mm	D1 mm	J2 max mm	Y2 max mm	Gripping force max [kN]**
58454115	100 TV-F	5-16	2-13	5-16	2-13	53	52	16-35	13-32	16-35	13-32	61	60	13
	100 PT-F	5-23	2-20	5-23	2-20	60	59	16-41	13-38	16-41	13-38	67	66	13
	125 PT-F	5-30	2-27	5-30	2-27	67	66	16-49	13-46	16-49	13-46	75	74	15
58454125	160 TV-F	5-35	2-32	5-35	2-32	90	89	33-69	30-66	33-69	30-66	95	93	32
	160 PT-F	5-35	2-32	5-35	2-32	90	89	33-69	30-66	33-69	30-66	95	93	32
58454135	200 TV-F	5-48	2-45	5-48	2-45	114	113	48-87	45-84	48-87	45-84	110	109	44
	200 PT-F	5-48	2-45	5-48	2-45	114	113	48-87	45-84	48-87	45-84	110	109	44
58454145	250 TV-F	5-53	2-50	5-53	2-50	135	134	44-101	41-98	44-88	41-85	151	137	40
58454155	315 TV-F	9-66	6-63	9-66	6-63	169	168	60-127	57-124	60-112	57-109	187	171	65

\*\* the maximum gripping force values are indicative since they depend on the number of inserts used.



# NARROW HARD TOP JAWS SinterGrip

- Hard top jaws with SinterGrip inserts
- Metric serration 1.5 mm x 60°



Subject to technical changes

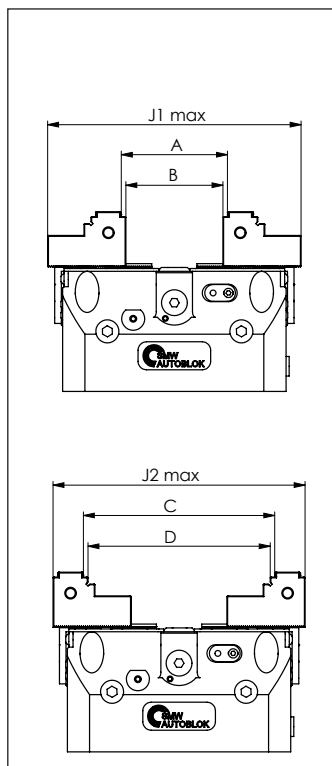
NOTE: the hard top jaws are provided with 58450119 inserts mounted only on one side.

## NARROW HARD TOP JAWS DIMENSIONS

TYPE	ID No set of 2 top jaws	B mm	B1 mm	C mm	D mm	D1 mm	F mm	F1 mm	H mm	H1 mm	L mm	M mm	N mm	Q mm	R mm	S mm	T mm	U mm	V mm	W mm	Y mm	Z mm	N° inserts provided	*N° seat	Weight (Kg)
100-125 TV-STV-PT	58454215	54,5	24	35	27	6	12	12	29,5	20	39	-	20H8	6,6	-	-	3,5	21,5	28	33	17,5	7	4	8	0,4
160-180 TV-STV-PT	58454225	79	45	60	38	9	20	15,5	39,5	26	56	M6	32H8	9	26	11,5	3,5	18,5	25	30	17,5	7	6	10	1,3
200-225 TV-STV-PT	58454235	109	65	80	40	10	19	16,5	44,5	27,5	65	M6	40H8	9	40	11,5	4	18,5	25	30	18,5	7	8	14	2,5
250 TV-PT	58454245	124	72	90	48	14	14	14	49,5	34	76	M6	50H8	11	40	11,5	4	21,5	28	33	20,5	7	10	20	3,5
315 TV	58454255	160	90	120	60	15	15	15	49,5	32	90	M6	60H8	13	60	15	4	27,5	34	39	19,5	7	12	24	5,5

\*The number of seats inserts indicated refers to set of 2 top jaws

## NARROW HARD TOP JAWS CLAMPING RANGES for long and normal stroke Twin Vise models



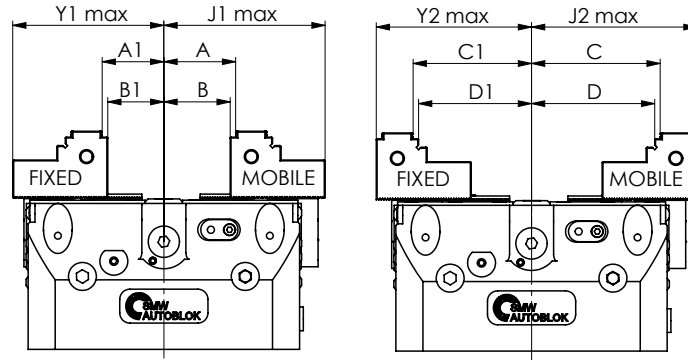
ID No set of 2 top jaws	TYPE	A mm	B mm	J1 max mm	C mm	D mm	J2 max mm	Gripping force max [kN]**
58454215	100 TV-N	10-32	4-25	106	32-75	25-68	127	13
	100 TV-L							
	100 PT-N	10-46	4-40	120	32-85	25-78	137	13
	100 PT-L							
	125 PT-N	10-60	4-53	134	32-100	25-93	152	22
	125 PT-L							
58454225	125 STV-N	10-60	4-53	134	32-100	25-93	152	26
	125 STV-L							
	160 TV-N	10-74	4-67	182	74-140	67-133	188	40
	160 TV-L							
	160 PT-N	10-74	4-67	182	74-140	67-133	188	40
58454235	160 PT-L							
	180 STV-N	10-88	4-82	196	74-160	67-153	208	54
	180 STV-L	10-98	4-92	206				
	200 TV-N	10-93	4-87	220	93-175	87-168	220	60
	200 TV-L							
58454245	200 PT-N	10-93	4-87	220	93-175	87-168	220	60
	200 PT-L							
	225 STV-N	10-110	4-104	237	93-202	87-196	250	66
	225 STV-L	10-120	4-114	247				
	250 TV-N	22-108	16-102	255	108-218	102-212	272	60
58454255	250 TV-L	22-122	16-116	270				
	250 PT-N	22-108	16-102	255	108-218	102-212	272	60
	250 PT-L	22-122	16-116	270				
	315 TV-N	30-138	23-132	315	138-275	132-268	340	100
	315 TV-L	30-162	23-156	338	160-275	154-268	340	

\*\*the maximum gripping force values are indicative since they depend on the number of inserts used.



- Hard top jaws with SinterGrip inserts
- Metric serration 1.5 mm x 60°

# NARROW HARD TOP JAWS SinterGrip



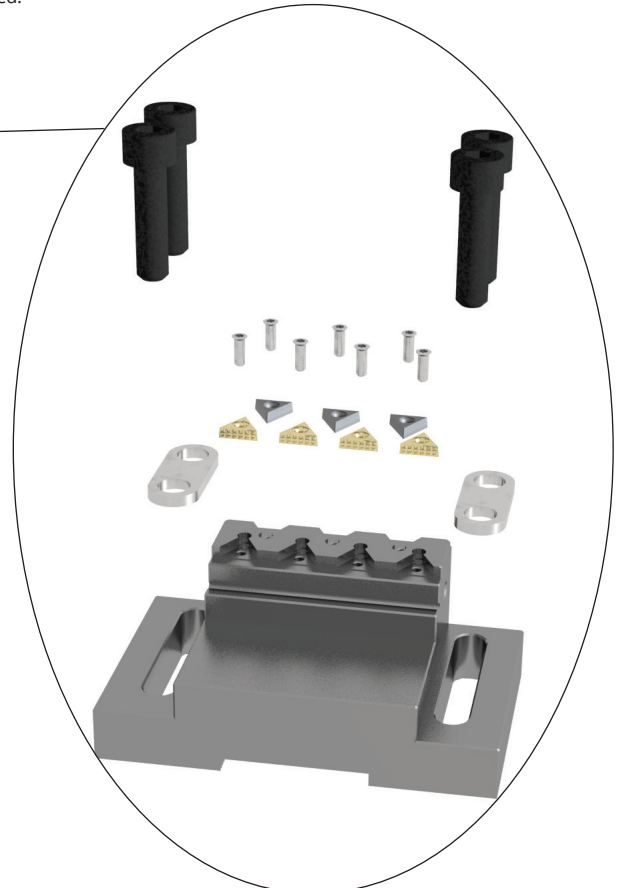
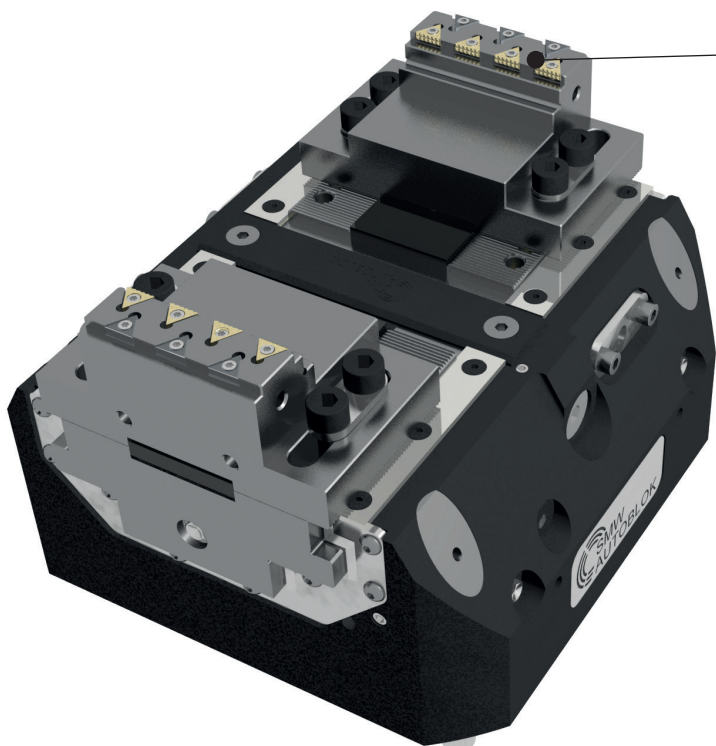
Subject to technical changes

NOTE: the A1 - B1 - C1 - D1 dimensions for fixed jaws clamping range have tolerance  $\pm 0,75$  mm due to the serration pitch 1,5 mm

## NARROW HARD TOP JAWS CLAMPING RANGES for a fixed jaw Twin Vise models

ID No set of 2 top jaws	TYPE	A mm	B mm	A1 mm	B1 mm	J1 max mm	Y1 max mm	C mm	D mm	C1 mm	D1 mm	J2 max mm	Y2 max mm	Gripping force max [kN]**
58454215	100 TV-F	5-16	2-13	5-16	2-13	53	52	16-38	13-34	16-38	13-34	64	63	13
	100 PT-F	5-23	2-20	5-23	2-20	60	59	16-43	13-40	16-43	13-40	69	68	13
	125 PT-F	5-30	2-27	5-30	2-27	67	66	16-50	13-47	16-50	13-47	76	75	15
58454225	160 TV-F	5-37	2-34	5-37	2-34	91	90	37-70	34-67	37-70	34-67	94	92	32
	160 PT-F	5-37	2-34	5-37	2-34	91	90	37-70	34-67	37-70	34-67	94	92	32
58454235	200 TV-F	5-47	2-44	5-47	2-44	110	109	47-87	44-84	47-87	44-84	110	109	44
	200 PT-F	5-47	2-44	5-47	2-44	110	109	47-87	44-84	47-87	44-84	110	109	44
58454245	250 TV-F	11-61	8-58	11-61	8-58	135	134	54-109	51-106	54-109	51-106	136	134	40
58454255	315 TV-F	15-81	12-78	15-81	12-78	169	168	80-137	77-134	80-137	77-134	170	168	65

\*\* the maximum gripping force values are indicative since they depend on the number of inserts used.



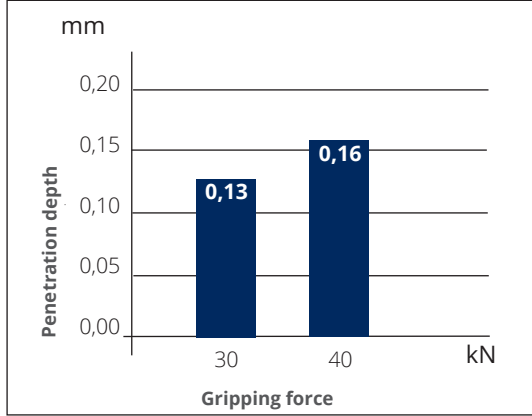
# SinterGrip inserts

- Patented
- 3,5 mm clamping surface
- Pull down effect during penetration

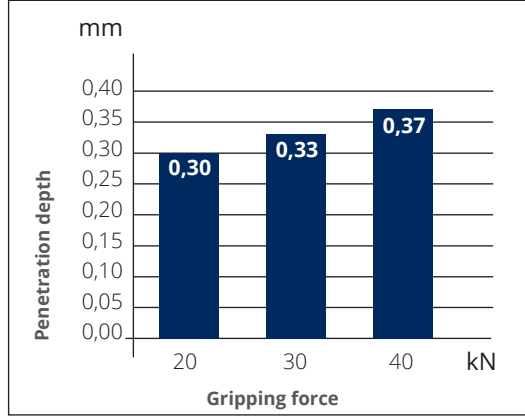
The patented SinterGrip insert was designed to clamp a workpiece as few millimeters as possible. SinterGrip inserts allows to clamp a component with only 3,5 mm of clamping surface with the advantage of being able to clamp the workpiece in only one operation and to be able to save on raw materials.

The insert with his special shape penetrates the material and it also gives a strong pull down effect. Each pair of inserts (one on each opposite top jaw) can be loaded with a maximum Gripping force of 8 kN.

## PENETRATION DEPTHS EXAMPLES



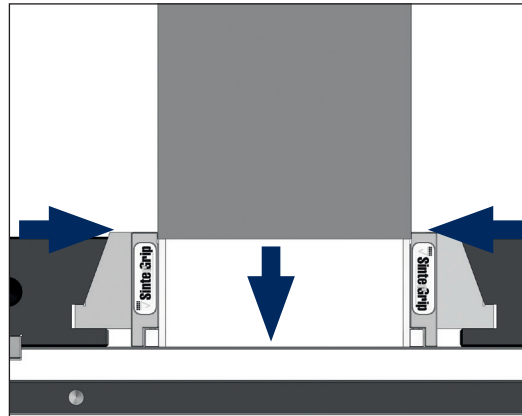
Steel with tensile strenght  $\approx 980 \text{ N/mm}^2$   
 n. 5 inserts for jaw  
 10 inserts total  
 clamping surface 3,5 mm



Aluminum  
 n. 5 inserts for jaw  
 10 inserts total  
 clamping surface 3,5 mm

IMPORTANT:  
 the penetration depths are obtained with new or good condition inserts.

## SINTERGRIP PULL-DOWN EFFECT



## SINTERGRIP INSERTS AND ACCESSORIES PART NUMBERS

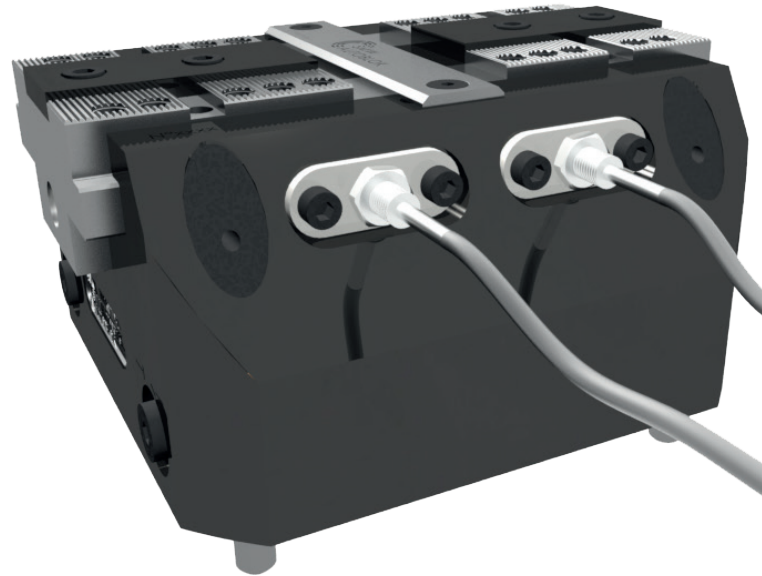
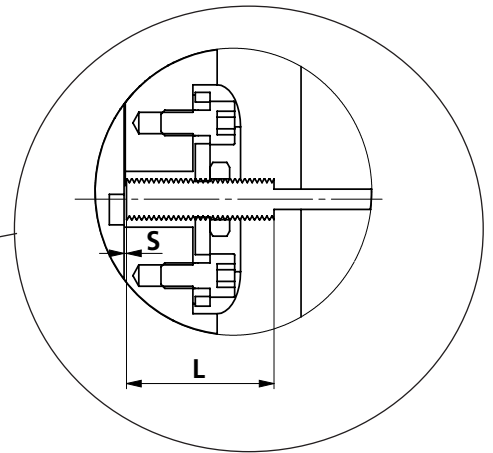
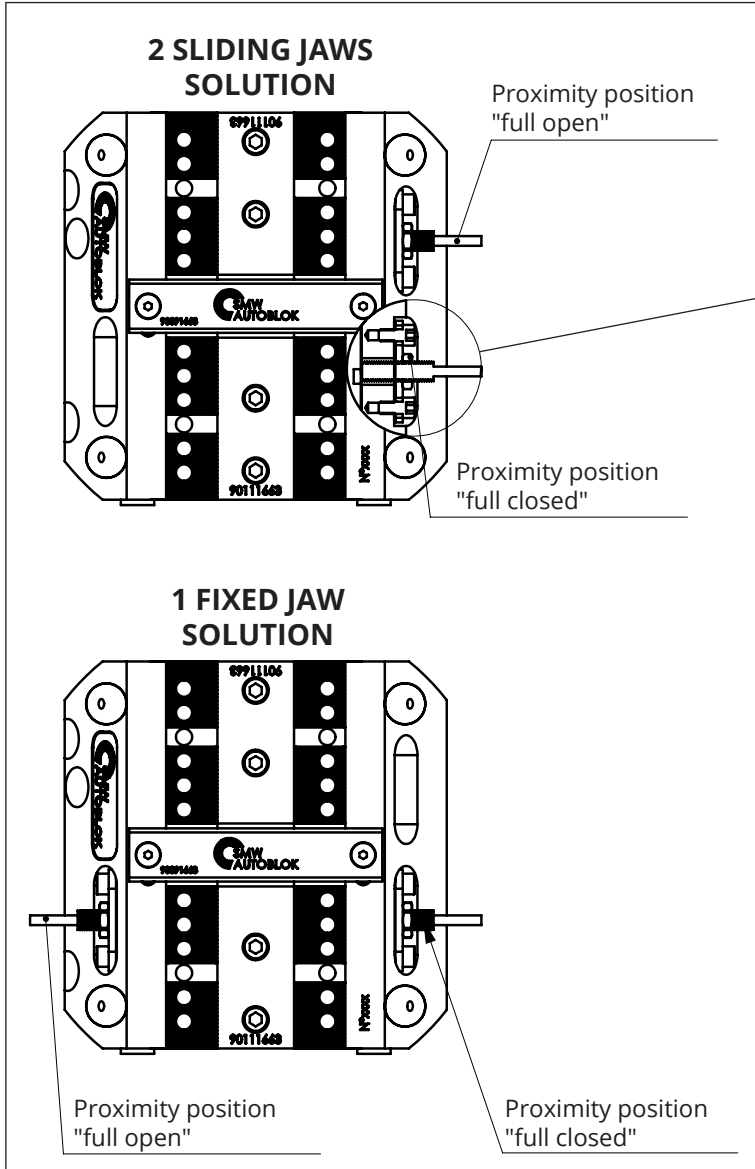


Part Nr.	DESCRIPTION	POS
58450119	set 10 steel inserts STD	<b>1</b>
58450139	set 10 aluminum inserts SINTERGRIP	<b>2</b>



Part Nr.	DESCRIPTION	POS
58450219	set of 10 screws TORX T9 for SINTERGRIP inserts	<b>3</b>
58450320	wrench TORX T9	<b>4</b>
58450519	set of 10 aluminum protection inserts	<b>5</b>



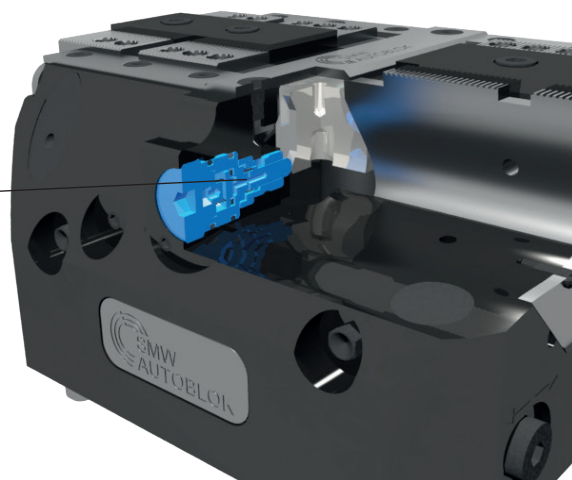
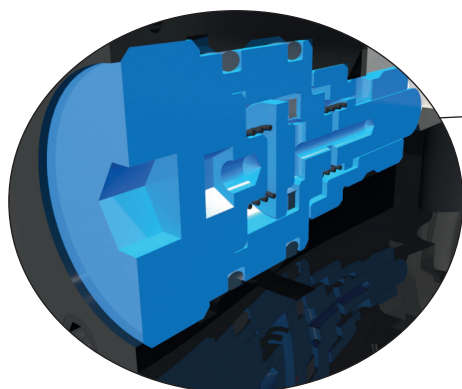


TWIN VISE TYPE	THREAD	BALLUFF SENSOR recommended by SMW-AUTOBLOK	OMRON SENSOR alternative	TELEMECANIQUE SENSOR alternative	S	L
100 TV	M5x0,5	BES516-3005-G-E4-C-PU02	E2EX1-B1	XS1N05PA310	0.5	20
160-200-250 TV	M8x1	BES516-324-G-E4-C-PU02	E2AS08KS02-WP-B12M	XS508B1PAL2	1	30
315 TV	M8x1	BESE08EF-PSC20B-BP02	E2AS08LS02-WP-BI2M	XS508BLPAL2	1	40
125 STV-2	M5x0,5	BES516-3005-G-E4-C-PU02	E2EX1-B1	XS1N05PA310	0.5	20
180-225 STV-2	M8x1	BES516-324-G-E4-C-PU02	E2AS08KS02-WP-B12M	XS508B1PAL2	1	30
100-125 PT	M5x0,5	BES516-3005-G-E4-C-PU02	E2EX1-B1	XS1N05PA310	0.5	20
160-200-250 PT	M8x1	BES516-324-G-E4-C-PU02	E2AS08KS02-WP-B12M	XS508B1PAL2	1	30

# Pneumatic valve (optional)

■ open/close (stroke control) master jaw

AVAILABLE ON STV-2 STV-3 PTP PTH PP



TWIN VISE MODEL	PP MODEL	SMW-AUTOBLOK PART NUMBER
125 STV-2	-	90902283
180 STV-2	-	90902283
225 STV-2	-	90902283
180 STV-3	250 PP	97901801
225 STV-3	-	97902204
100 PTP PTH	125 PP	90901163
125 PTP PTH	160-200 PP	90901763
160 PTP PTH	-	90901763
200 PTP PTH	-	90901763
250 PTH	-	90901763

The pneumatic open/close stroke control valve signals the locking jaws end-of-stroke positions, both in fully open and fully closed positions.

The valve needs a pneumatic line with **filtered and lubricated air and a pressure of 0,5-1 bar.**

- when the locking jaws are in one of the end stroke position (fully open or closed), the valve is open causing a pressure drop in the pneumatic line or the beginning of an air flow.
- when the locking jaws are in the working stroke, the valve is closed and there is no pressure drop in the pneumatic line and there no air flow.

### Only the PTP and PTH vises

The vises can be supplied (when requested) with the **opposite functioning** of the valve: that is closed valve at the end of the strokes and open in the working/middle stroke.

# Safety valve SAB-1 (optional)



SAB-1 Valve  
Id.n. 27581810  
weight 0,150 kg

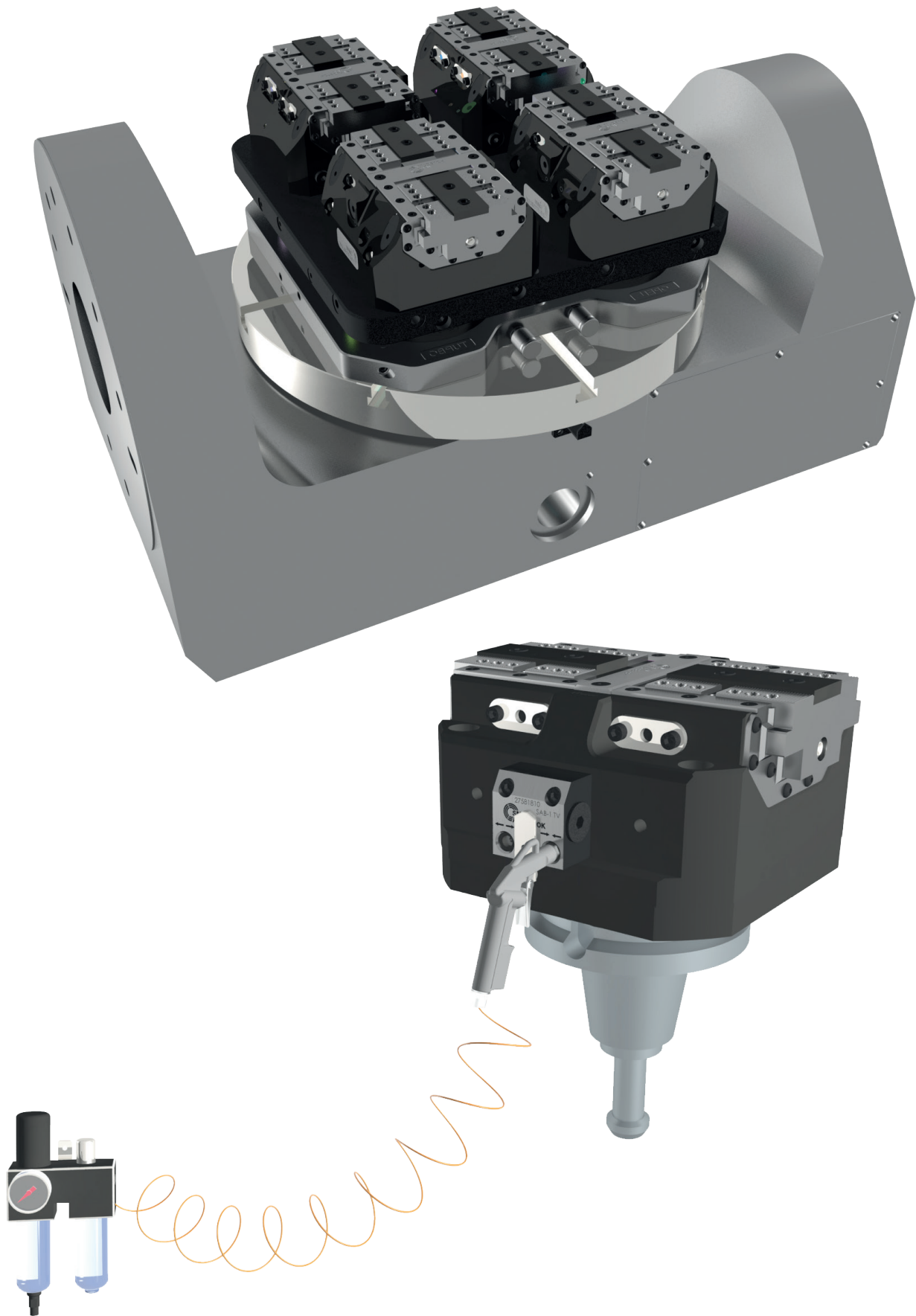
The Safety valve SAB-1 maintains air pressure in the cylinder pallet transportation / storage or machining without feed.

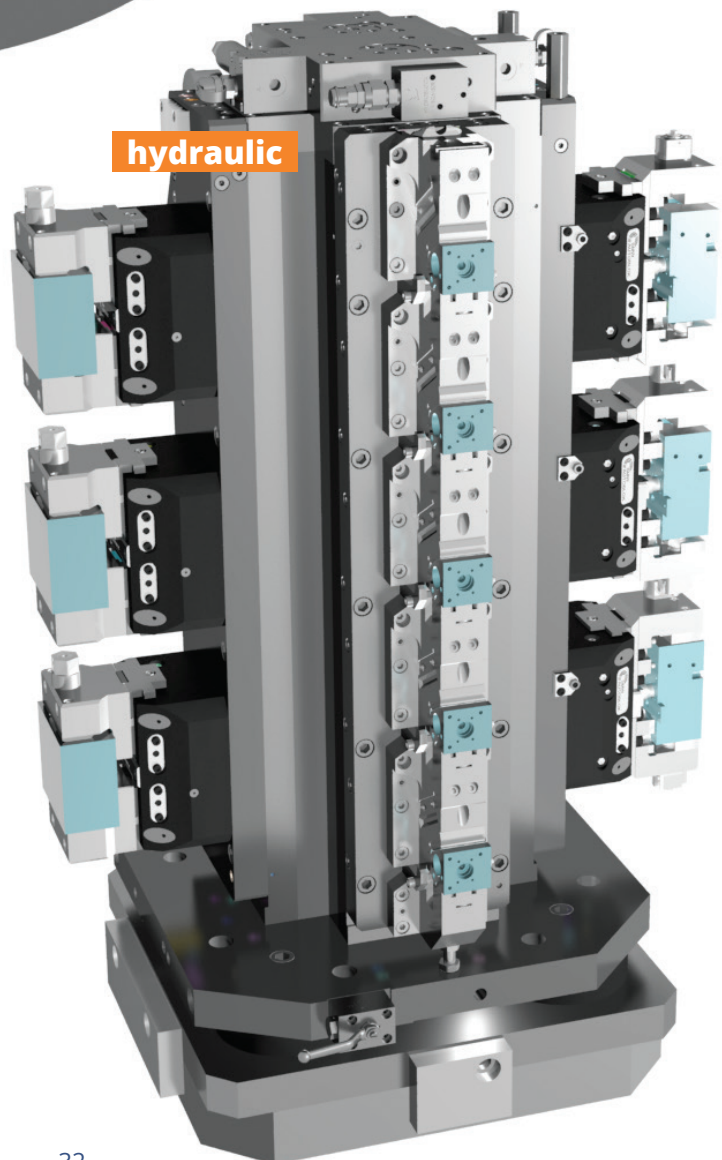
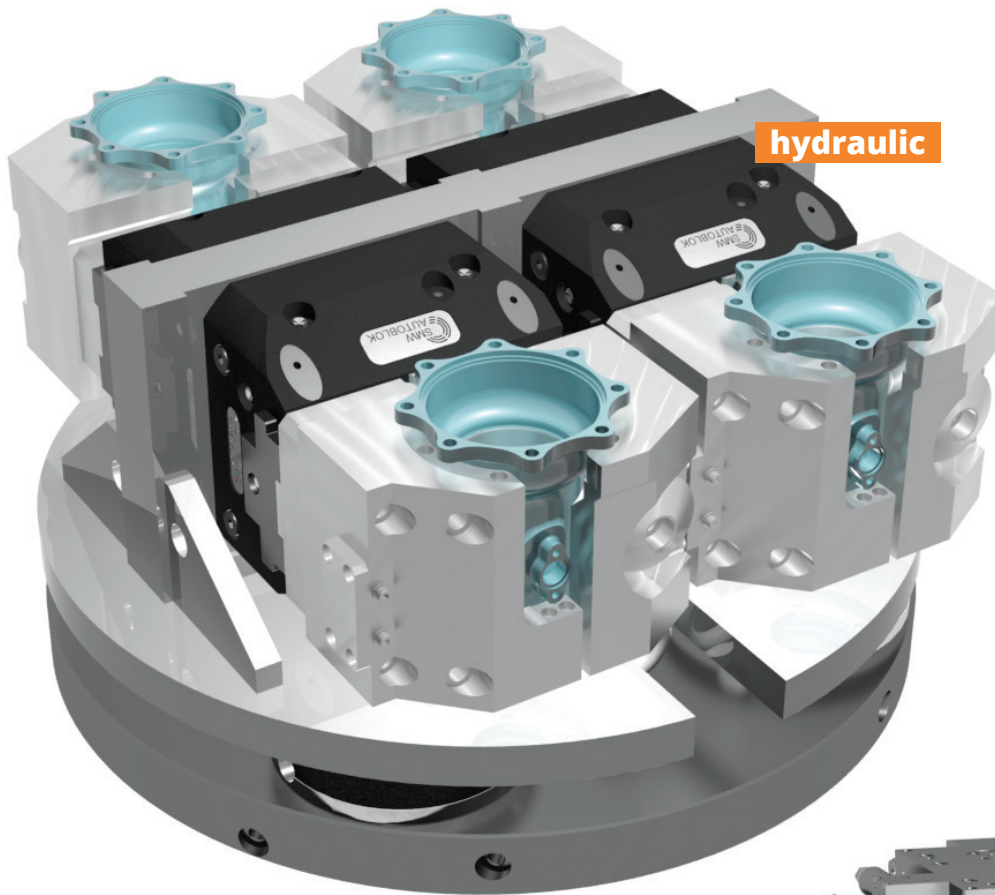
ONLY FOR STV-2 STV-3

# Pneumatic gun with steel nozzle

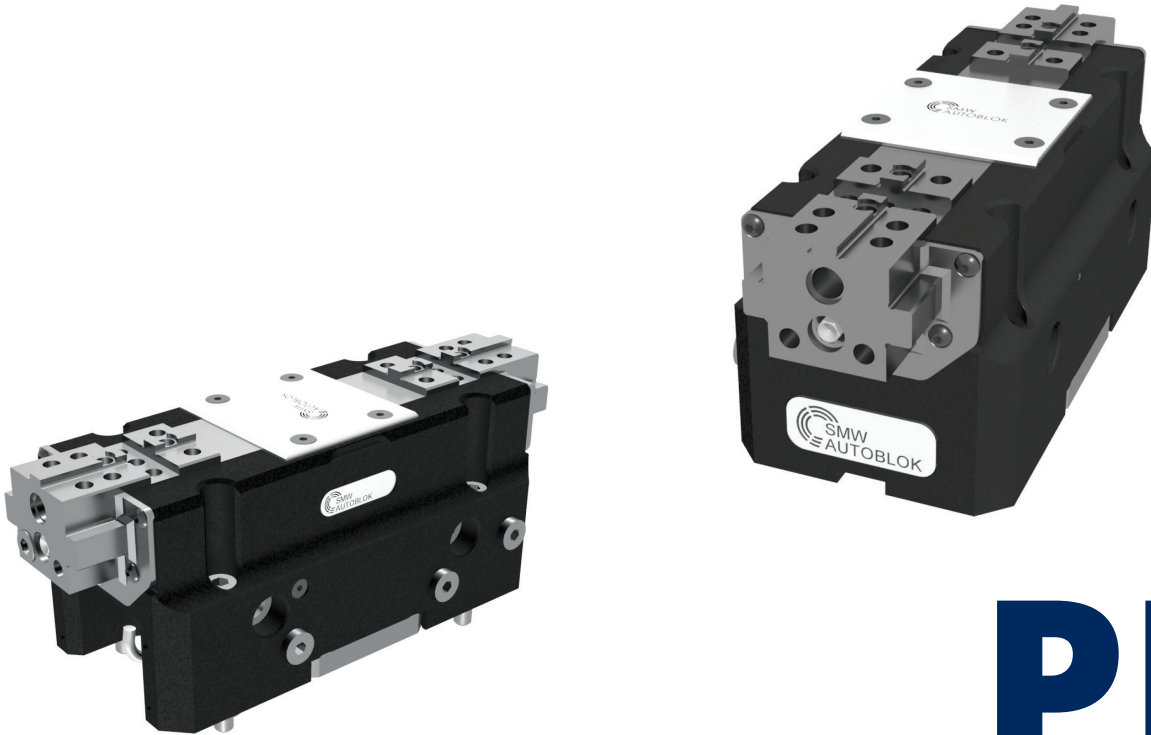


Id.n. 41702140









**PP**

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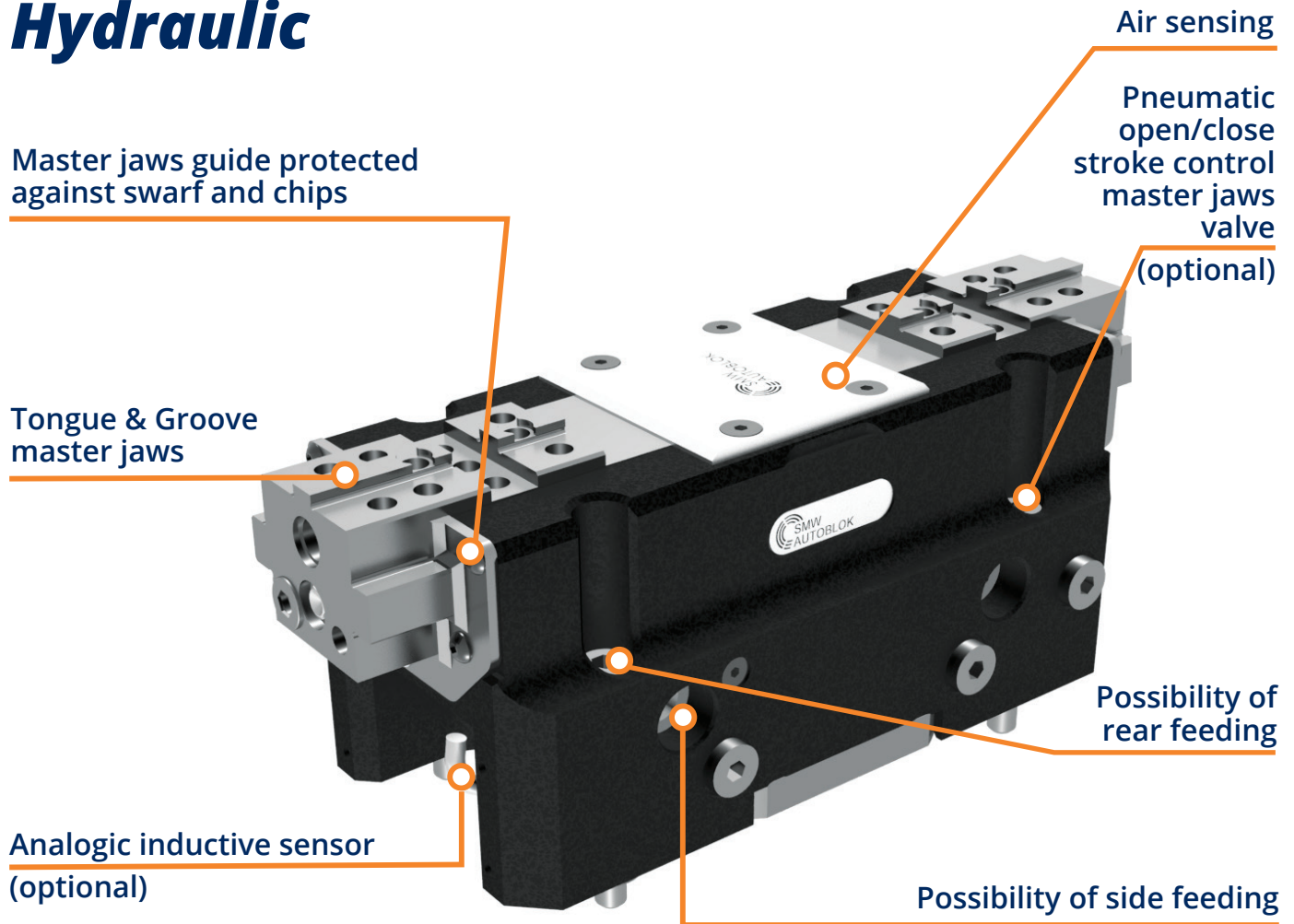
**PNEUMATIC  
AND HYDRAULIC  
PROTECTED VISES**

**125-160-200-250**

# PP-N PP-L

## Self centering protected vise

**Protected  
Pneumatic  
Hydraulic**



### Applications /Customer benefits

- Compact design
- Master jaws guide protected against swarf and chips
- Highest repeatability
- Highest rigidity
- Linear pressure adjustment

### Standard equipment

Self-centering vise without top jaws  
All bolts and centering bushings included

### Technical features

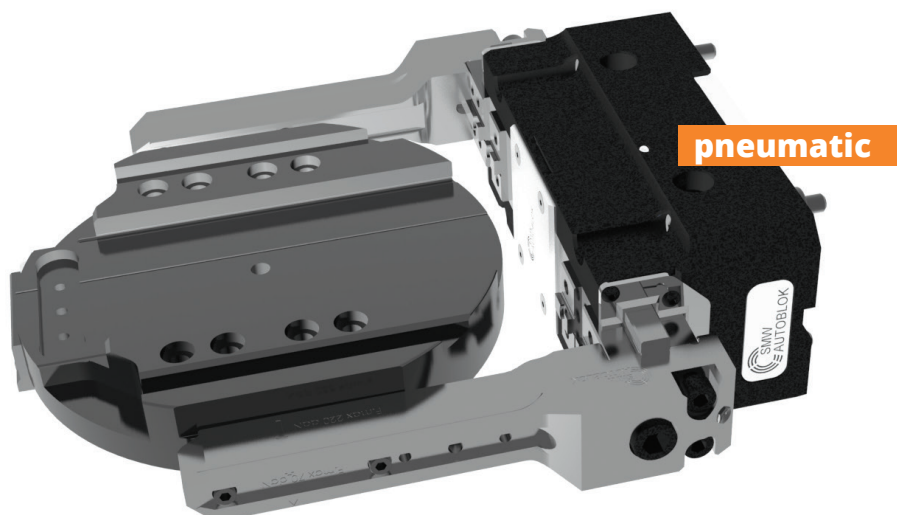
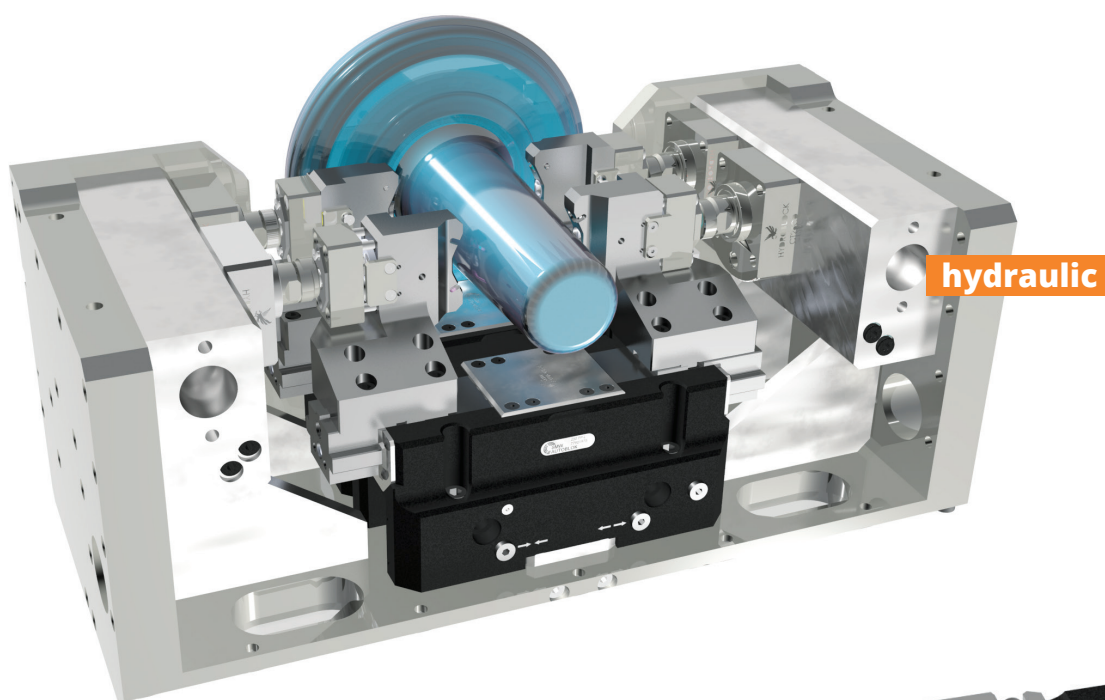
- Body and functional parts hardened for high precision and long life
- Prepared to air purge
- Tongue & Groove master jaws (in the long stroke master jaws is prepared for rear mounting top jaw)
- OD and ID clamping
- Pneumatic open/close -stroke control- master jaws valve optional (see page 30)
- Air sensing
- Lubricated with SMW-Autoblok K67 grease
- Stroke control system via analogic proximity switches (optional)

# NEW RANGE OF PRODUCTS SMW-AUTOBLOK

## Technical data PP-N PP-L vise

MODEL	ID No	STROKE TYPE	STROKE	PISTON AREA	MAX CLAMPING FORCE		MAX PRESSURE		WEIGHT
					PNEUMATIC	HYDRAULIC	PNEUMATIC	HYDRAULIC	
125 PP-N	77901862	NORMAL	5,5 mm	27 cm <sup>2</sup>	2,9 KN	14,6 KN	6 bar	30 bar	4,9 Kg
125 PP-L	77901962	LONG	13 mm	27 cm <sup>2</sup>	1,3 KN	6,5 KN	6 bar	30 bar	4,9 Kg
160 PP-N	77901866	NORMAL	5,5 mm	35 cm <sup>2</sup>	4 KN	19 KN	6 bar	30 bar	5,7 Kg
160 PP-L	77901966	LONG	13 mm	35 cm <sup>2</sup>	1,7 KN	8,4 KN	6 bar	30 bar	5,7 Kg
200 PP-N	77901870	NORMAL	7,2 mm	53 cm <sup>2</sup>	5,8 KN	28,5 KN	6 bar	30 bar	11 Kg
200 PP-L	77901970	LONG	16,7 mm	53 cm <sup>2</sup>	2,5 KN	12,7 KN	6 bar	30 bar	11 Kg
250 PP-N	77901875	NORMAL	10,1 mm	81 cm <sup>2</sup>	8,7 KN	43,7 KN	6 bar	30 bar	19,5 Kg
250 PP-L	77901975	LONG	29,8 mm	81 cm <sup>2</sup>	3,2 KN	15,8 KN	6 bar	30 bar	19,5 Kg

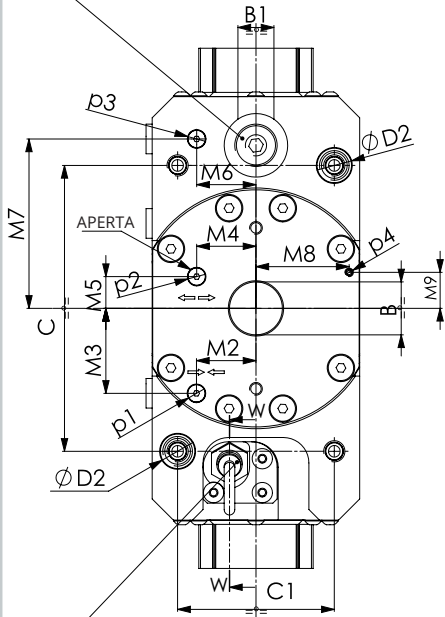
## Application examples vises PP





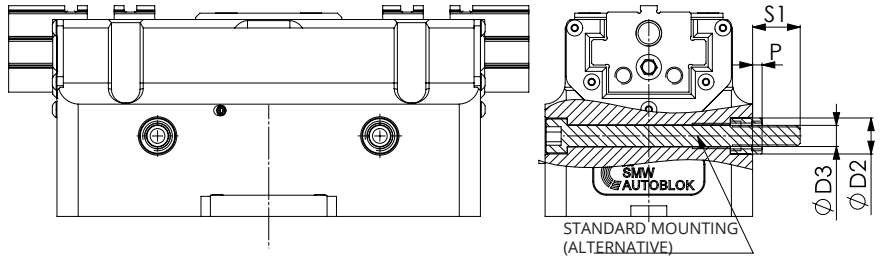
# NEW RANGE OF PRODUCTS SMW-AUTOBLOK

PNEUMATIC OPEN CLOSE STROKE CONTROL VALVE (OPTIONAL)  
check full closed and full opened positions

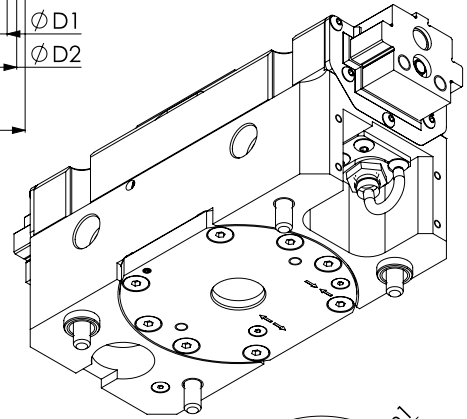
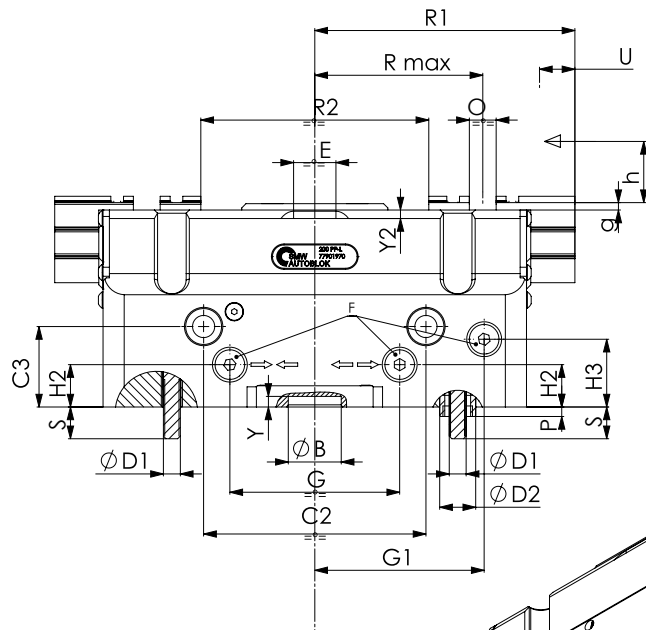
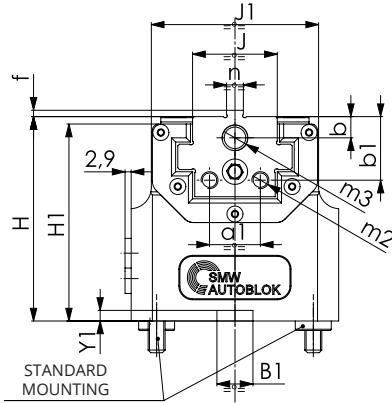
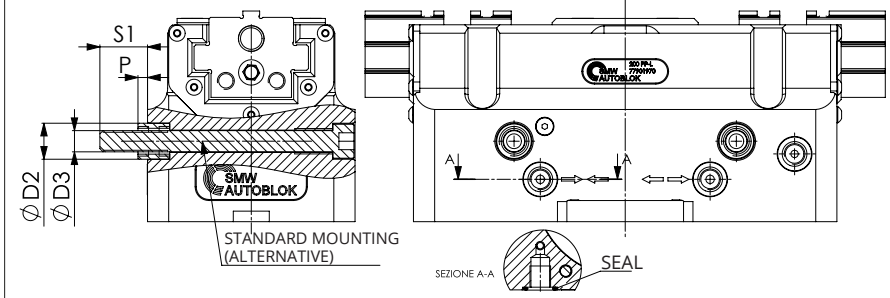


INDUCTIVE SENSOR M12x1 L=30  
(continuous stroke control)  
OPTIONAL

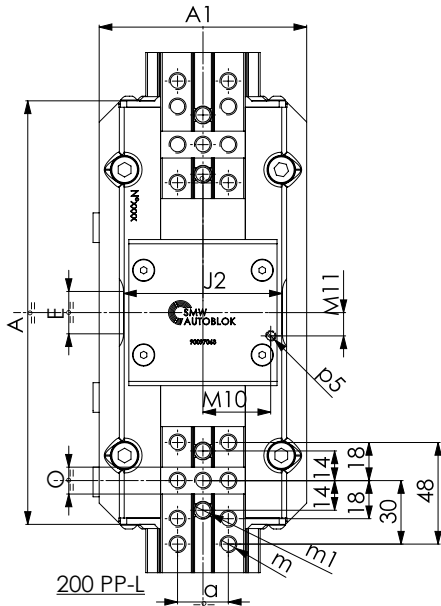
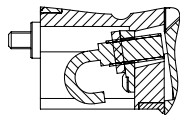
MOUNTING SIDE C



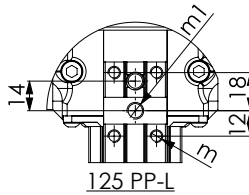
MOUNTING SIDE B



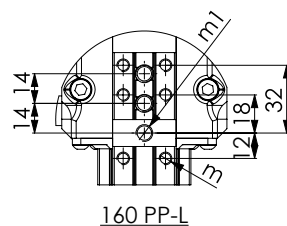
SEZIONE W-W



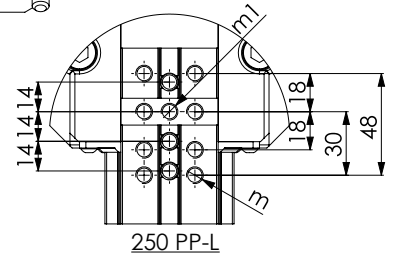
200 PP-L



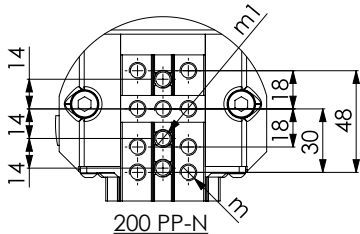
125 PP-L



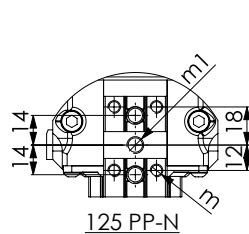
160 PP-L



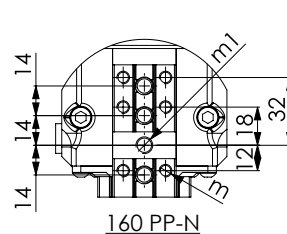
250 PP-L



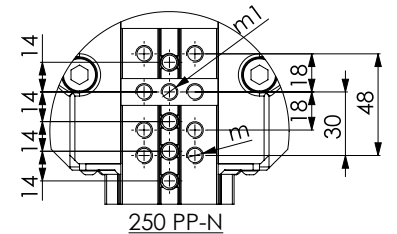
200 PP-N



125 PP-N



160 PP-N

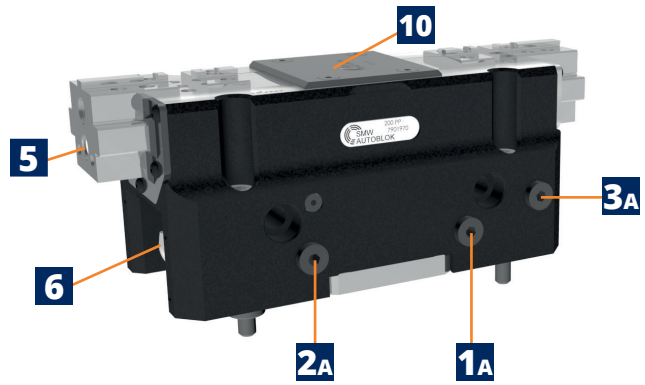
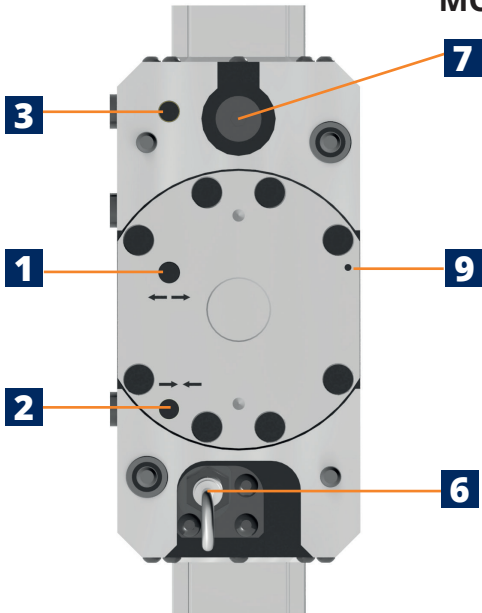


250 PP-N

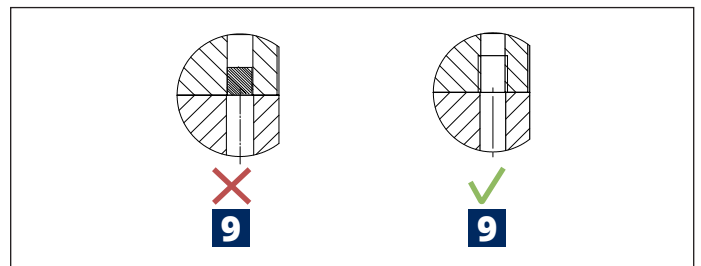
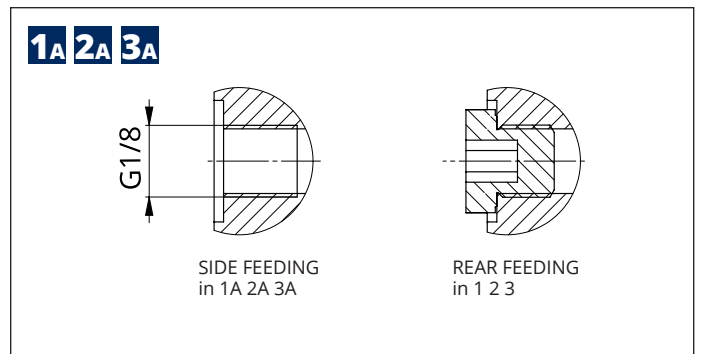
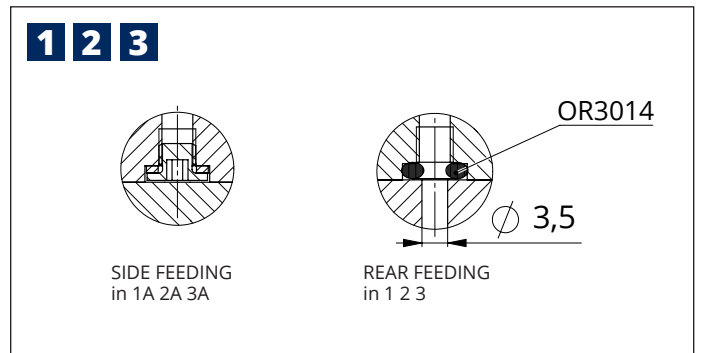
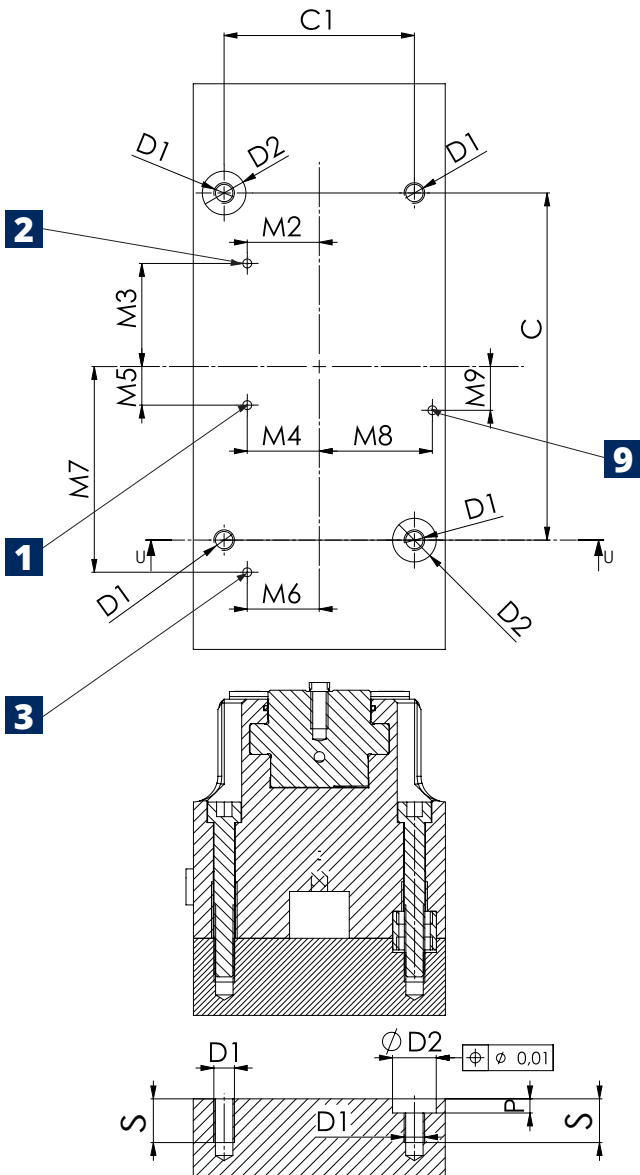
# NEW RANGE OF PRODUCTS SMW-AUTOBLOK

SMW-AUTOBLOK Type		125 PP	160 PP	200 PP	250 PP
A		130	160	200	250
A1		78	78	98	120
B (øH7)		25	25	25	25
B1 (H7)		-	14	17	20
C		84	110	135	160
C1		60	60	74	85
C2		-	86	105	128
C3		-	32	38	38
D1 (Ø)		M6	M6	M8	M10
D2 (Ø js7)		14	14	17	20
D3 (Ø)		-	M8	M10	M12
E		20	20	20	20
F		G1/8"	G1/8"	G1/8"	G1/8"
G		59	65,4	80,2	102
G1		53	65	80	95
H		79,5	79,5	96,5	114,5
H1		76	76	93	111
H2		18	18	20	20
H3		-	19,5	32	35
J		30	30	40	46
J1		69	69	79	94
J2 (h7)		60	60	75	90
M2		20,5	22,5	28	29,5
M3		29,5	32,5	40,1	51,1
M4		20,5	22,5	28	29,5
M5		10	12	15	18
M6		22,5	22,5	28	29,5
M7		53	65	80	95
M8		34	34,5	44	54
M9		10	13,5	17	18
M10		26	26	32	36
M11		7	7	11	11
P		4,5	4,5	4,5	4,5
R max	MIN/MAX (LONG STROKE)	47,5/60,5	62,5/75,5	62,5/79,2	78/107,8
R max	MIN/MAX (NORMAL STROKE)	47,5/53	62,5/68	62,5/69,7	78/88,1
R1	MIN/MAX (LONG STROKE)	72/85	87/100	106/122,7	131/160,8
R1	MIN/MAX (NORMAL STROKE)	72/77,5	87/92,5	106/113,2	131/141,1
R2	MIN/MAX (LONG STROKE)	49/75	49/75	74/107,4	96/155,6
R2	MIN/MAX (NORMAL STROKE)	49/60	49/60	74/88,4	96/116,2
S		16	16	15	17
S1		-	20,5	22,5	22,5
U	LONG STROKE	13	13	16,7	29,8
U	NORMAL STROKE	5,5	5,5	7,2	10,1
Y		4,5	4,5	5	5
Y1		-	5	5	5
Y2		4	4	4	4
a		20	20	24	24
a1	LONG STROKE	17	17	24	24
a1	NORMAL STROKE	\	\	\	\
b	LONG STROKE	8	8	10	10
b	NORMAL STROKE	\	\	\	\
b1	LONG STROKE	27	27	30	30
b1	NORMAL STROKE	\	\	\	\
f		3	3	3	3
g		3,5	3,5	3,5	3,5
h		16	25	35	40
m		M6-12	M6-12	M8-15	M8-15
m1		M8-15	M8-15	M8-15	M8-15
m2		M6-10	M6-10	M8-15	M8-15
m3		M10-15	M10-15	M12-18	M12-18
n (h6)		7,94	7,94	7,94	7,94
o (H7)		12,68	12,68	12,68	12,68
p1 (Ø)	CLOSE	8,8-M5	8,8-M5	8,8-M5	8,8-M5
p2 (Ø)	OPEN	8,8-M5	8,8-M5	8,8-M5	8,8-M5
p3 (Ø)	PNEUM OPEN CLOSE VALVE (OPTION.) OR AIR PURGE	8,8-M5	8,8-M5	8,8-M5	8,8-M5
p4	AIR SENSING CONNECTION	M4	M4	M4	M4
p5	AIR SENSING OUTLET (UNDER FRONT PLATE)	M4	M4	M5	M5
PNEUMATIC OPEN/CLOSE-STROKE CONTROL VALVE (OPTIONAL)		90901163	90901763	90901763	97901801
PROXIMITIES SET L (OPTIONAL)		90686263	90687063	90687063	90687563
PROXIMITIES SET N (OPTIONAL)		90686260	90687060	90687060	90687063

## MOUNTING INSTRUCTIONS

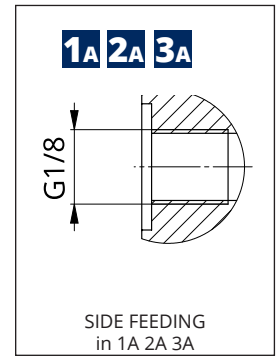
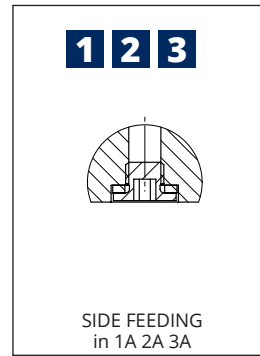
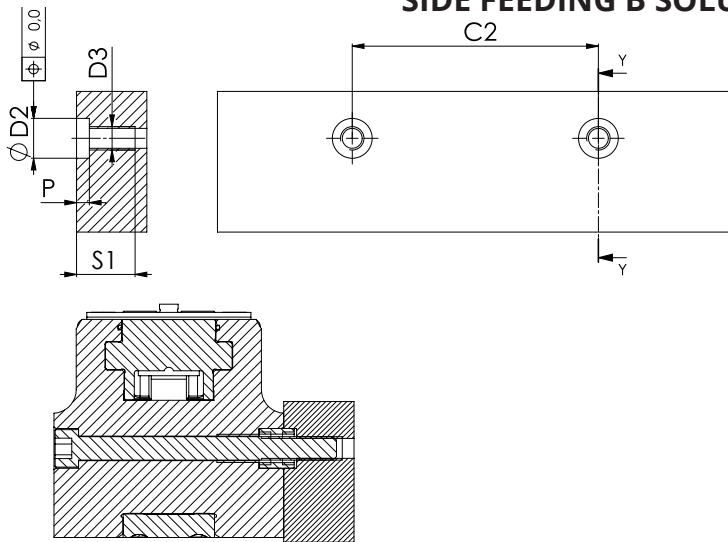


## REAR FEEDING SOLUTION



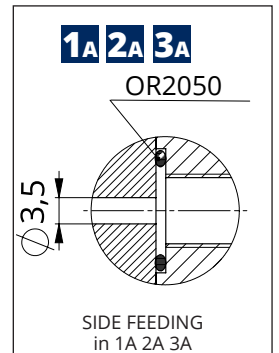
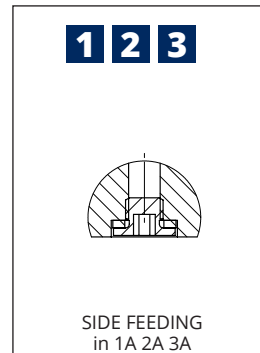
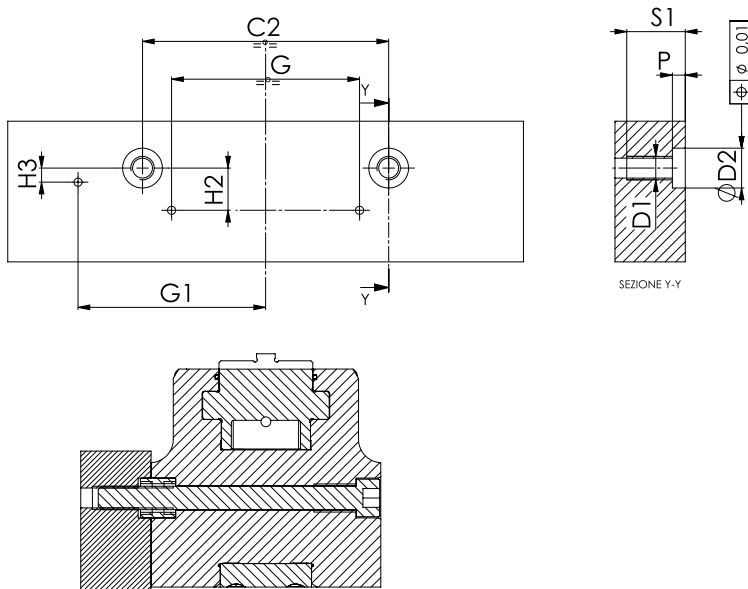
# NEW RANGE OF PRODUCTS SMW-AUTOBLOK

## SIDE FEEDING B SOLUTION



IMPORTANT NOTE: with the side feeding is not recommended the Air sensing system

## SIDE FEEDING C SOLUTION



IMPORTANT NOTE: with the side feeding is not recommended the Air sensing system

- 1** Open-rear Feeding
- 2** Closed Rear feeding
- 3** Pneumatic open/close stroke control valve (optional) or Air purge\* Rear feeding
- 5** Lubrication Fitting
- 7** Pneumatic jaw Open/close stroke control valve (optional)
- 10** Air sensing outlet (under front plate)
- 1a** Open-side Feeding
- 2a** Closed Side feeding
- 3a** Pneumatic open/close stroke control valve (optional) or Air purge\* Side feeding
- 6** Proximity Switches seat (optional)
- 9** Air sensing connection (on rear flange)

\*The air purge can be used only without the valve.

Type	C	C1	C2	D1	D2H7	D3	G	G1	H2	H3	M2	M3	M4	M5	M6	M7	M8	M9	P	S	S1
125 PP	84	60	-	M6	14	-	-	-	-	-	20,5	29,5	20,5	10	22,5	53	34	10	5,5	18	-
160 PP	110	60	86	M6	14	M8	65,4	65	14	12,5	22,5	32,5	22,5	12	22,5	65	34,5	13,5	5,5	18	23
200 PP	135	74	105	M8	17	M10	80,2	80	18	6	28	40,1	28	15	28	80	44	17	5,5	17	25
250 PP	160	85	128	M10	20	M12	102	95	18	3	29,5	51,1	29,5	18	29,5	95	54	18	5,5	19	25

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