

Standard Modular Vises



Gerardi Precision Modular Vises

**Accuracy within
0.02 mm/0.0008"**

Manufactured under rigid quality control. Only the most suitable materials are used, and the accuracy of even the smallest components is assured.

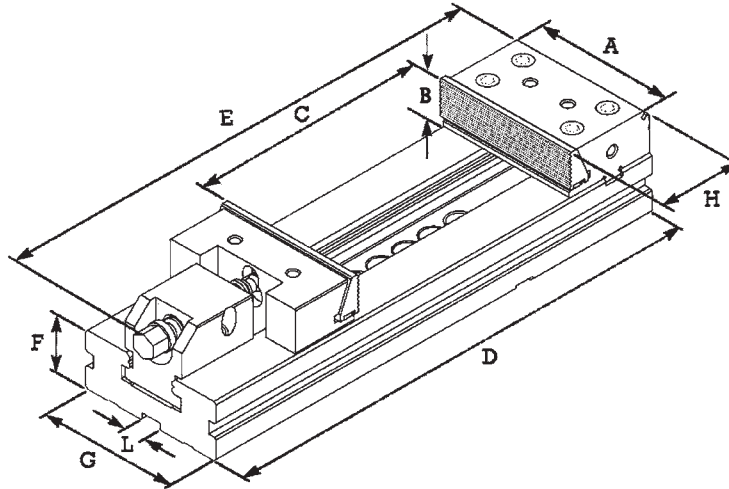
As a result of the high standard construction GERARDI vises can maintain their accuracy under the most severe operating conditions. Hardened and Ground steel construction throughout, they max your machine performance because they allow: bigger clamping power, bigger cutting performances, total exclusion of vibrations, lower tool wear and higher precision during machine work. The modular design and the concept of inter-changeability makes possible a wide variety of set up combination and solutions.

All GERARDI vises are modular and the components of all our vises will interchange with perfect alignment. The vises can be matched side to side with the highest precision and minimum of set up times thanks to many fixed reference points. All this is possible thanks to the high precision of the vise particularly as regards: the high of the base, alignment with longitudinal key-nuts with respect to the fixed jaw, the perpendicularity of the fixed jaw with respect to the vise base and the parallelism of the base top and bottom surfaces. Those features allows us to solve the most varied and complicated problems of clamping in a few seconds with the use of more vises.

The GERARDI precision modular vise is successful thanks not only to the high accuracy, but also because of the unlimited variety of combinations and versatility.

1. The floating movable jaw allows a fast and safety clamping for rough pieces not perfectly parallels. GERARDI precision modular vise in the standard version is supplied with the guided movable jaw running parallel along the whole vise body axis.
2. The fixed jaw can be turned around 180 degrees and its back 5x5 mm step matches with centesimal accuracy to the prismatic jaw step, in this way the maximum vice opening is increased.
3. Jaw plates manufactured with a pull-down angle, ensure, during the clamping operation, a downward run of the work piece against the vise vise (by dragging).
4. The compact rack blocking system, allows mechanic hydraulic and pneumatic clamping even automatic, with simply fitting the winched/ needed blocking device; this operation takes only a few seconds.
5. The swivel base with positioning pin for perfect alignment; using the sine bar principle permits setting of angles quickly and accurately with gage blocks. The vise could be positioned on the swivel base along its whole axis.
6. The vise base is made from a solid steel bar, hardened HRC60 and perfectly ground with centesimal tolerances.

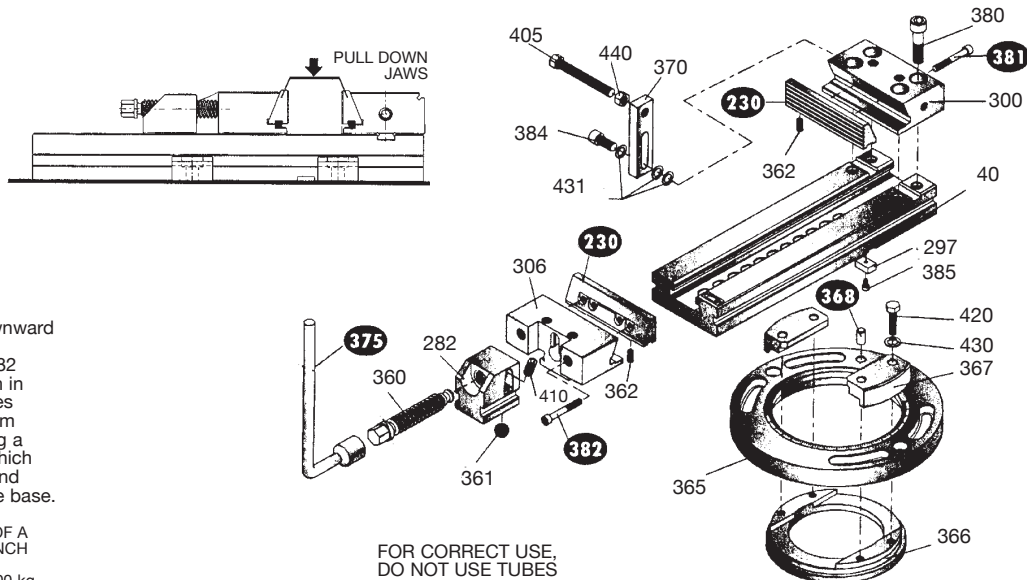
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All vises include as standard equipment:
Workstop, positioning key nuts, box wrench, movable jaws supplied as either floating or guided – no extra charge

Model number	Order number	A mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	L mm	KG
1	301-00000	100	30	100	270	320	35	75	77.9	16	6.8
2	302-10000	125	40	150	345	410	40	95	77.9	16	12.9
3	303-20000	150	50	200	420	500	50	125	89.4	16	25.5
3	303-30000	150	50	300	520	600	50	125	89.4	16	29
4	304-20000	175	60	200	455	530	58	145	96.9	16	37
4	304-30000	175	60	300	555	630	58	145	96.9	16	42
4	304-40000	175	60	400	655	730	58	145	96.9	16	47
4	304-50000	175	60	500	755	830	58	145	96.9	16	52
5	305-20000	200	65	200	495	580	70	170	113.4	16	64
5	305-30000	200	65	300	595	680	70	170	113.4	16	69
5	305-40000	200	65	400	695	780	70	170	113.4	16	74
5	305-50000	200	65	500	795	880	70	170	113.4	16	79
5	305-60000	200	65	600	895	980	70	170	113.4	16	84
6	306-20000	300	80	200	535	630	78	195	120.4	16	95
6	306-30000	300	80	300	635	730	78	195	120.4	16	105
6	306-40000	300	80	400	735	830	78	195	120.4	16	115
6	306-50000	300	80	500	835	930	78	195	120.4	16	125
6	306-60000	300	80	600	935	1030	78	195	120.4	16	135
6	306-70000	300	80	700	1035	1130	78	195	120.4	16	145
6	306-80000	300	80	800	1135	1230	78	195	120.4	16	155



INSTRUCTIONS
Before using the vises, wishing to use the downward jaw option, loosen the screws part 381 and 382 of one quarter of a turn in order to allow jaw plates part 230-236 to run from top to bottom obtaining a downward clamping which holds work piece flat and parallel against the vise base.

TO CLAMP A QUARTER OF A TURN OF THE BOX WRENCH part 375 IS ENOUGH TO EASILY REACH 3,000-4,000 kg BLOCKING FORCE

FOR CORRECT USE, DO NOT USE TUBES OR HAMMERS

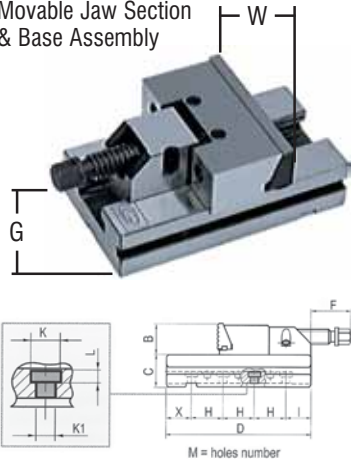
SOFT & HARD TOP JAWS, SEAM, SAMCHULLY & KITAGAWA POWER CHUCKS, COLLET CHUCKS, TOMBSTONES & VISES

Modular Vise Elements

SOFT & HARD TOP JAWS, SEOAM, SAMCHULLY & KITAGAWA POWER CHUCKS, COLLET CHUCKS, TOMBSTONES & VISES

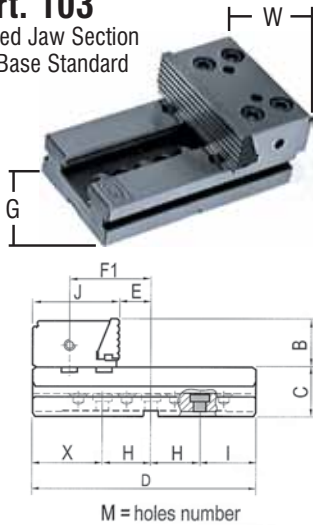
Art. 102

Movable Jaw Section & Base Assembly



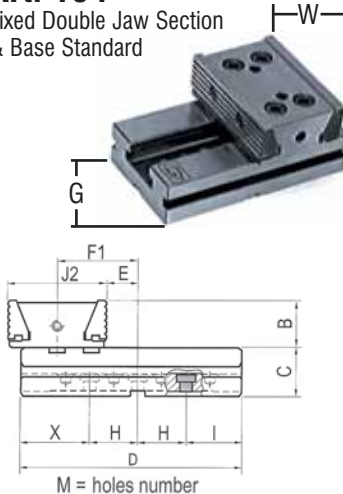
Art. 103

Fixed Jaw Section & Base Standard



Art. 104

Fixed Double Jaw Section & Base Standard



Art. 102

Vise Type Size	1	2	3	4	5	6
W	100mm	125mm	150mm	175mm	200mm	300mm
B	30mm	40mm	50mm	60mm	65mm	80mm
C	35mm	40mm	50mm	58mm	70mm	78mm
O	140mm	160mm	230mm	240mm	300mm	350mm
F	55mm	83mm	82mm	62mm	92mm	70mm
G	75mm	95mm	125mm	145mm	170mm	195mm
H	40mm	40mm	50mm	50mm	100mm	100mm
29	39mm	40mm	82.5mm	69mm	83mm	63mm
K1	6.5mm	8.5mm	13mm	13mm	17mm	17mm
K	10.5mm	13.5mm	19mm	19mm	26mm	26mm
L	4.5mm	5.5mm	8.5mm	8.5mm	17mm	17mm
X	31mm	41mm	40mm	57.5mm	31mm	67mm
kg	3.4	6.3	14.2	20.8	35	60
M	3	3	4	3	5	5
Order No.	210-21000	210-22000	210-23000	210-24000	210-25000	210-26000

Art. 103

Vise Type Size	1	2	3	4	5	6
J	77.9mm	77.9mm	89.4mm	96.9mm	113.4mm	120.4mm
E	33.6mm	33.6mm	33.6mm	33.6mm	33.6mm	33.6mm
F1	76mm	76mm	84.5mm	89mm	100mm	107mm
X	31mm	31mm	72.5mm	29mm	45mm	52mm
H	40mm	40mm	50mm	50mm	100mm	100mm
I	29mm	49mm	57.5mm	61mm	55mm	98mm
kg	3.3	5.8	12.6	17.8	29.8	50.5
M	3	3	3	4	5	5
Order No.	210-31000	210-32000	210-33000	210-34000	210-35000	210-36000

Art. 104

Vise Type Size	1	2	3	4	5	6
J2	84.8mm	84.8mm	101.8mm	110.8mm	132.8mm	146.8mm
E	33.6mm	33.6mm	33.6mm	33.6mm	33.6mm	33.6mm
kg	3.4	6	13.3	18.8	30	52.5
M	3	3	3	4	5	5
Order No.	210-31000	210-32000	210-33000	210-34000	210-35000	210-36000

