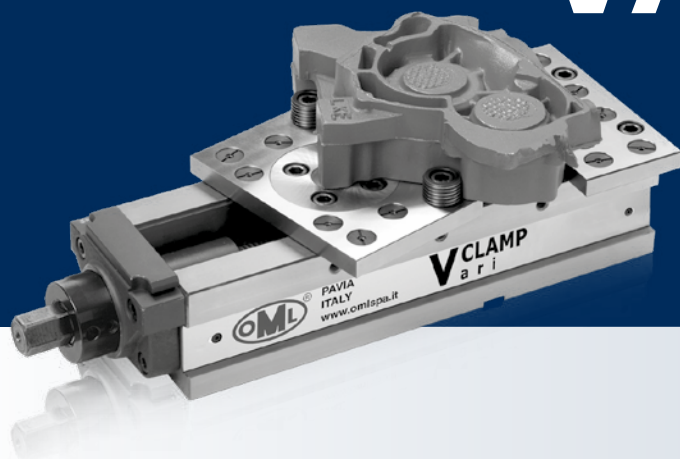
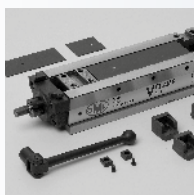


VARI CLAMP

9.1



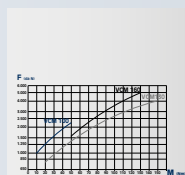
Clamping vise



Vari CLAMP

Clamping vise without mechanical/ mechanical clamping force multiplier

Page 9.1.4



Vari CLAMP

Clamping force diagrams

Page 9.1.17



Vari CLAMP

Accessories

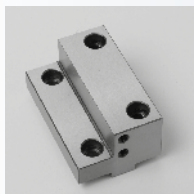
Page 9.1.6



Vari CLAMP

Working examples

Page 9.1.18



Vari CLAMP

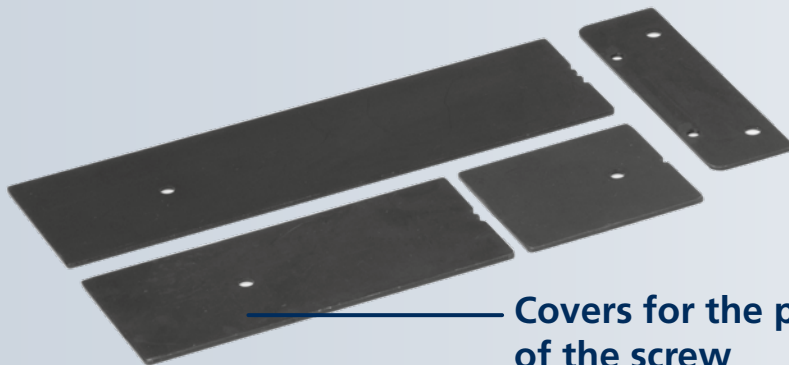
spare parts

Page 9.1.10

Movable jaw "grip"



Floating jaw "grip"



Covers for the protection of the screw



Movable square block jaw



VARI CLAMP

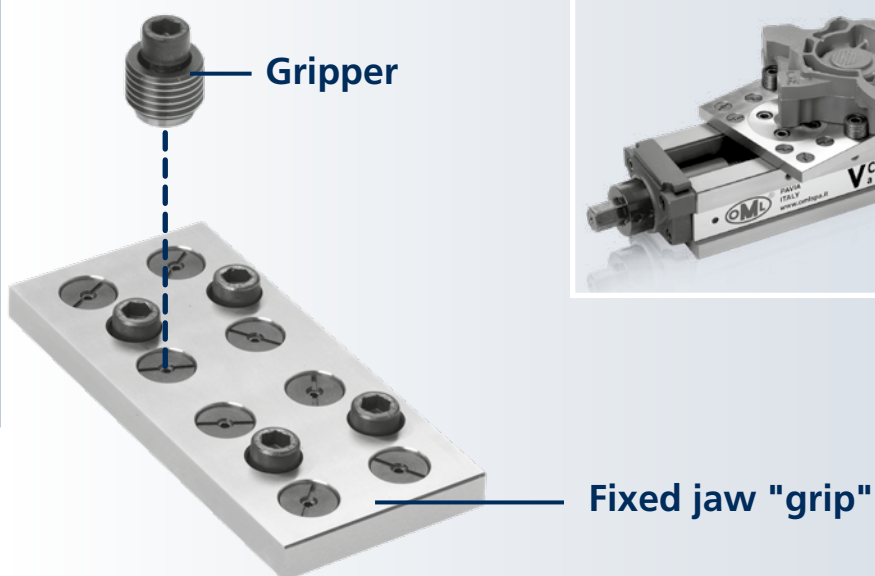
All the features of the vise V-Power are further increased in the version Vari-Clamp.

1. Super-low design both of stationary jaw and movable jaw is suitable for clamping thinner workpieces to increase heavy duty cutting capacity and precision of processing.

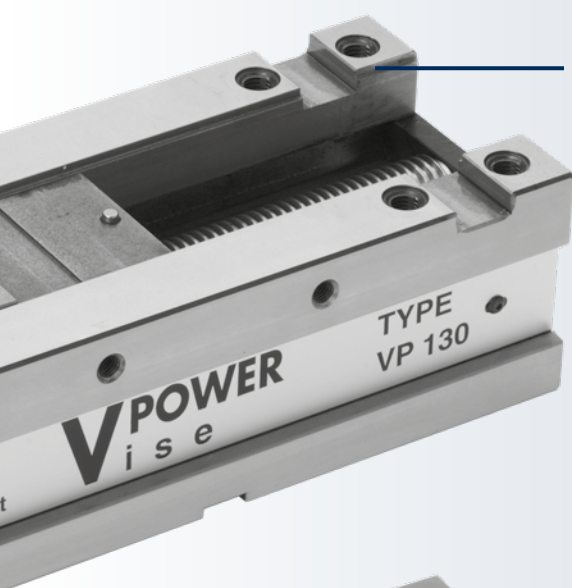
2. Movable jaw is designed by balance mechanism, and there are many kinds of gripper onto the jaw in order to suit the requirement for various workpieces and difficult clamping shapes.

3. Balance jaw is designed by balance mechanism, its function is able to clamp easily slanting or not smooth surface for rough material, casting material and slanting rough surface after processed by sawing machine.

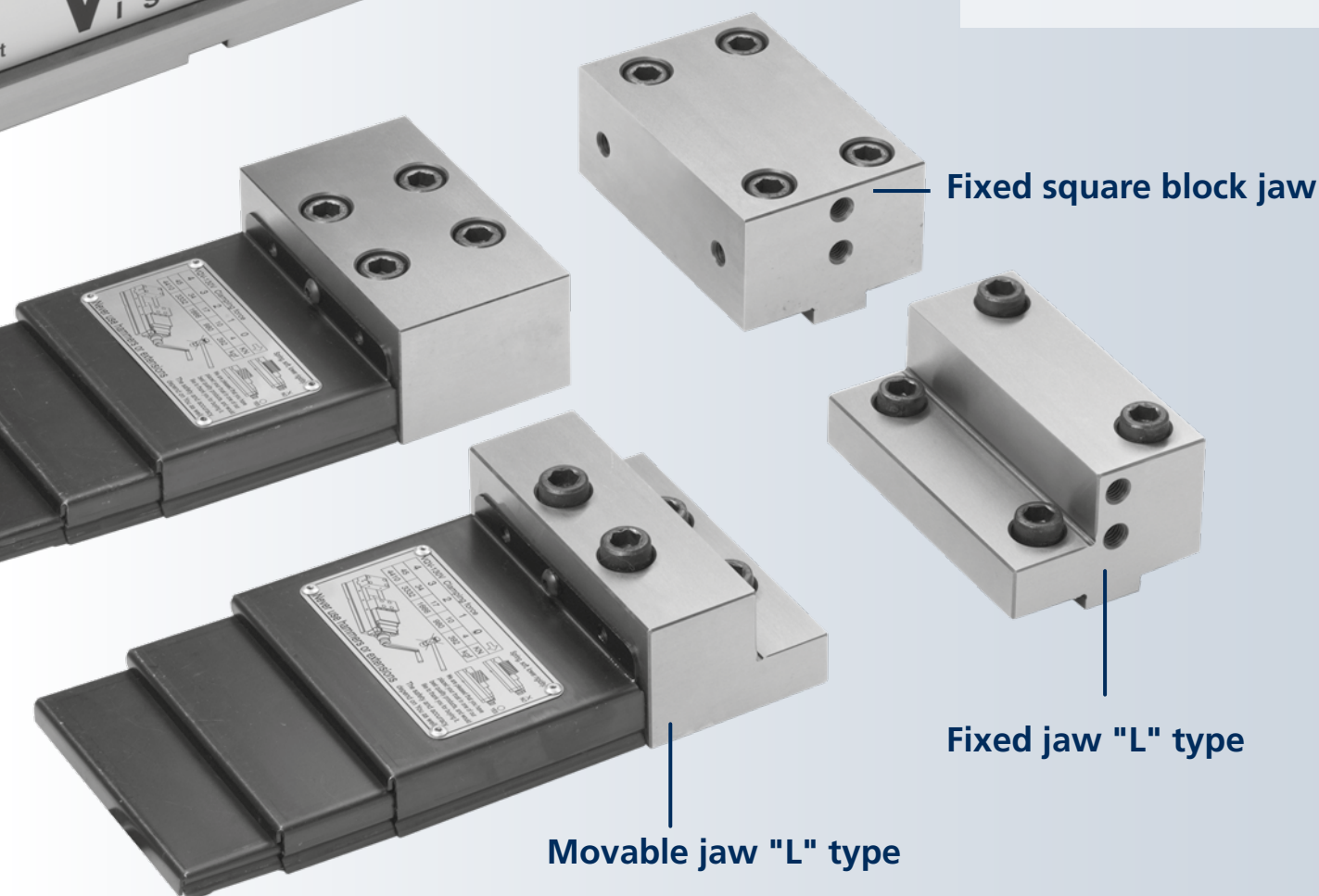
4. Vari-Clamp allows clamping of irregular, round, elliptic, rectangular, irregular-curved, step workpieces and slanting workpieces of difficult clamping using the balance mechanism of movable jaws and the different shapes of gripper to perform well-done the clamping.



Fixed jaw "grip"



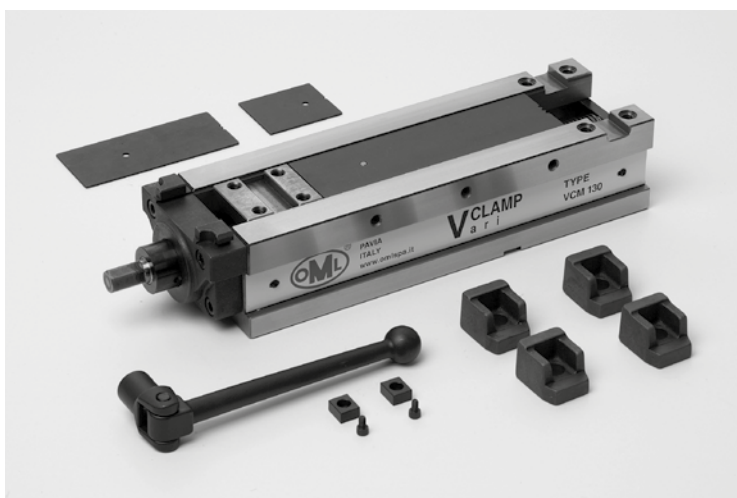
Body



Fixed square block jaw

Fixed jaw "L" type

Movable jaw "L" type



Mechanical set base VCM

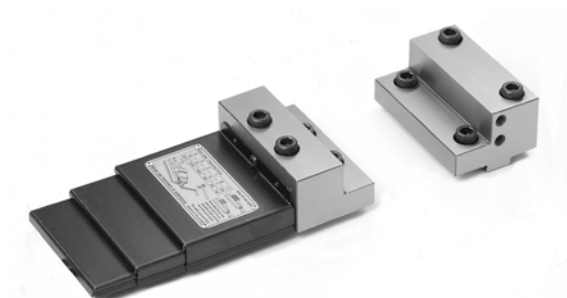
Set base Vise Power complete with:

- wrench
- cover for the protection of the screw
- 2 positioning keys with screw
- 4 clamps

Id.No.	for type
77 58 90 60	VCM 100
77 58 91 60	VCM 130
77 58 92 60	VCM 160

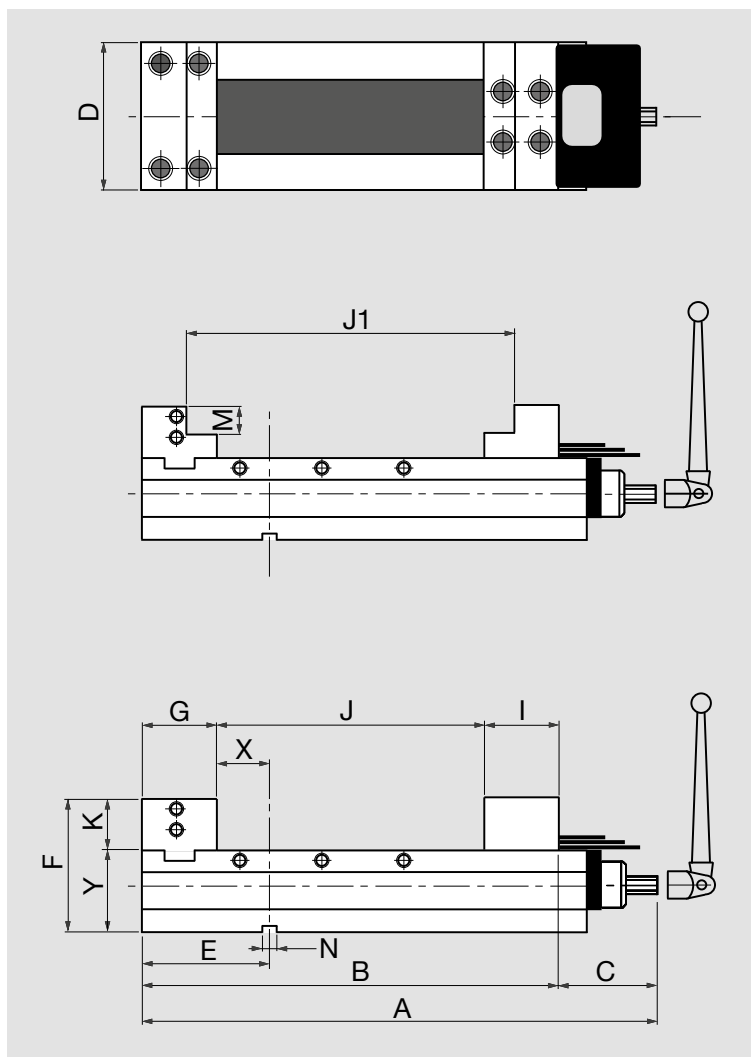
"L" jaw kit

Id.No.	for type
58 90 71 10	100
58 91 71 10	130
58 92 71 10	160



Square block jaw kit

Id.No.	for type
58 90 72 10	100
58 91 72 10	130
58 92 72 10	160

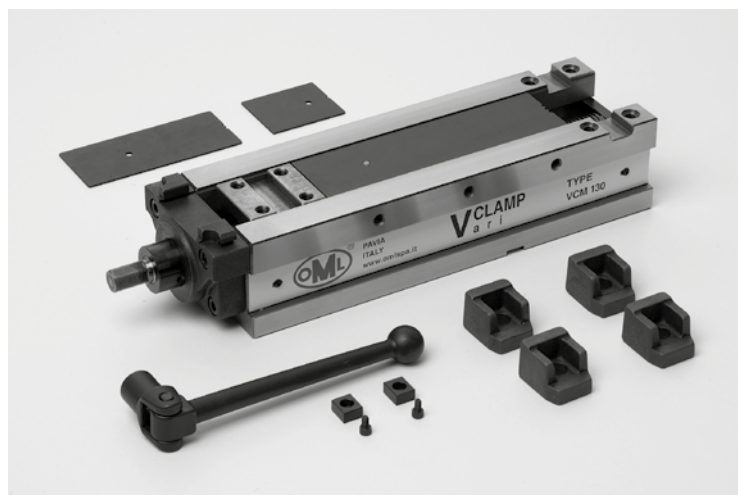


type	A mm	B mm	C mm	D mm	E mm	F mm	G mm	J mm	J1 mm	I mm	K mm	M mm	N mm	X mm	Y mm	max clamping force KN (kgf)	weight kg
VCM 100	398	300		101	124	130	78	155	213	64	45	25		45	85	20 (2.000)	22
VCM 130	508	410	98	131	149	147	83	250	315	74	52	30	18	65	95	40 (4.000)	40
VCM 160	573	475		161	152	160	86	300	370	86	55	30		65	105	50 (5.000)	62

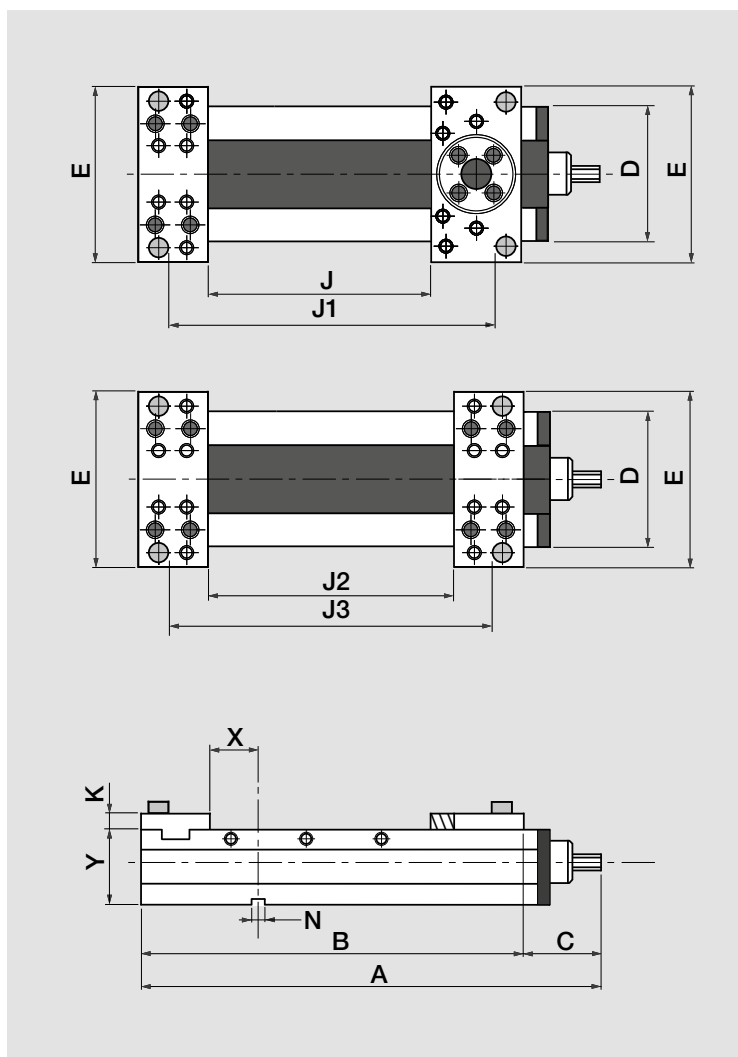
Mechanical set base VCM

Set base Vise Power complete with:

- wrench
- cover for the protection of the screw
- 2 positioning keys with screw
- 4 clamps



Id.No.	for type
77 58 90 60	VCM 100
77 58 91 60	VCM 130
77 58 92 60	VCM 160



Gripper jaw kit

Id.No.	for type
58 90 73 10	100
58 91 73 10	130
58 92 73 10	160



Floating gripper jaw kit

Id.No.	for type
58 90 73 20	100
58 91 73 20	130
58 92 73 20	160



type	A mm	B mm	C mm	D mm	E mm	J mm	J1 mm	J2 mm	J3 mm	K mm	N mm	X mm	Y mm	max clamping force KN (kgf)	weight kg
VCM 100	398	300		101	160	100	220	150	220	17		51	85	20 (2.000)	18,5
VCM 130	508	410	98	131	190	180	320	210	320	17	18	60	95	40 (4.000)	33,5
VCM 160	573	475		161	220	220	380	280	380	22		64	105	50 (5.000)	51,5

Set of 4 grippers h11 smooth

Id.No. 58 90 61 14



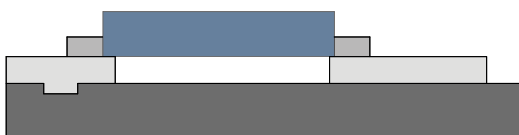
Set of 4 grippers h11 serrated

Id.No. 58 90 61 24



Set of 4 grippers h19 smooth

Id.No. 58 90 62 14



Set of 4 grippers h19 serrated

Id.No. 58 90 62 24



Set of 4 grippers h24 smooth

Id.No. 58 90 63 14



Set of 4 grippers h24 serrated



Id.No. 58 90 63 24



Set of 4 grippers h11 smooth-serrated



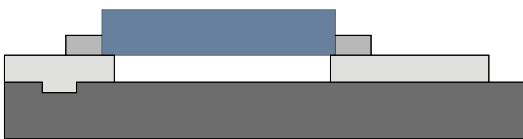
Id.No. 58 90 64 14



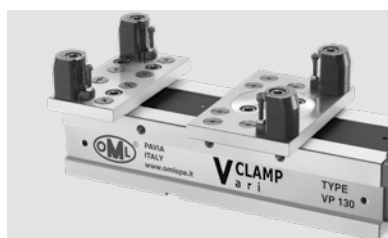
Set of 4 soft grippers h25 smooth



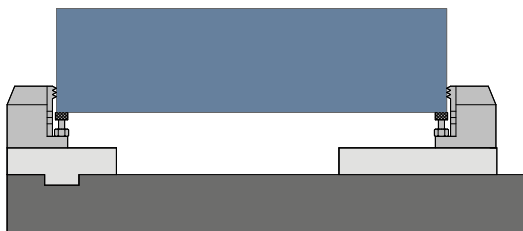
Id.No. 58 90 65 14



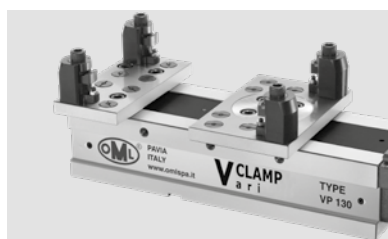
Set of 4 grippers h50 serrated with adjustable screw



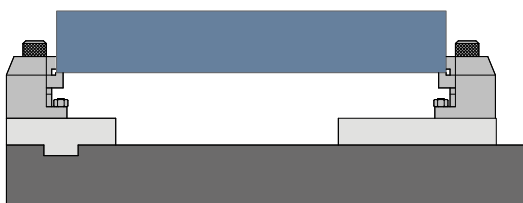
Id.No. 58 90 67 24



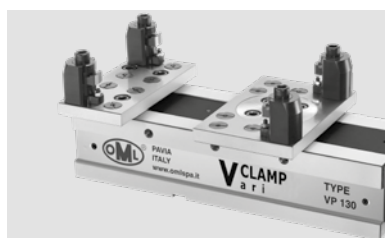
Set of 4 grippers h50 smooth with step



Id.No. 58 90 68 14



Set of 4 grippers h50 serrated with step



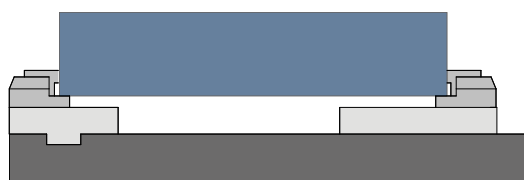
Id.No. 58 90 68 24



Set of 4 grippers h25 smooth with adjustable screw



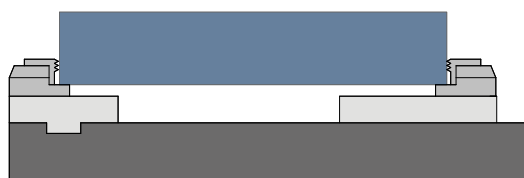
Id.No. 58 90 66 14



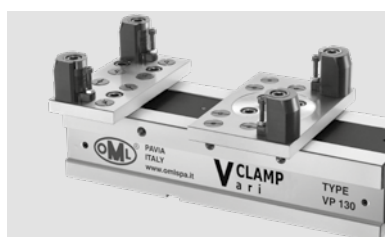
Set of 4 grippers h25 serrated with adjustable screw



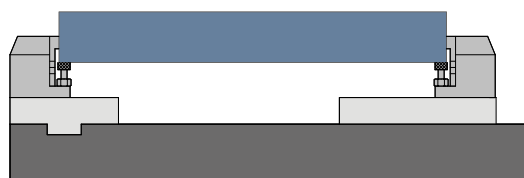
Id.No. 58 90 66 24



Set of 4 grippers h50 smooth with adjustable screw



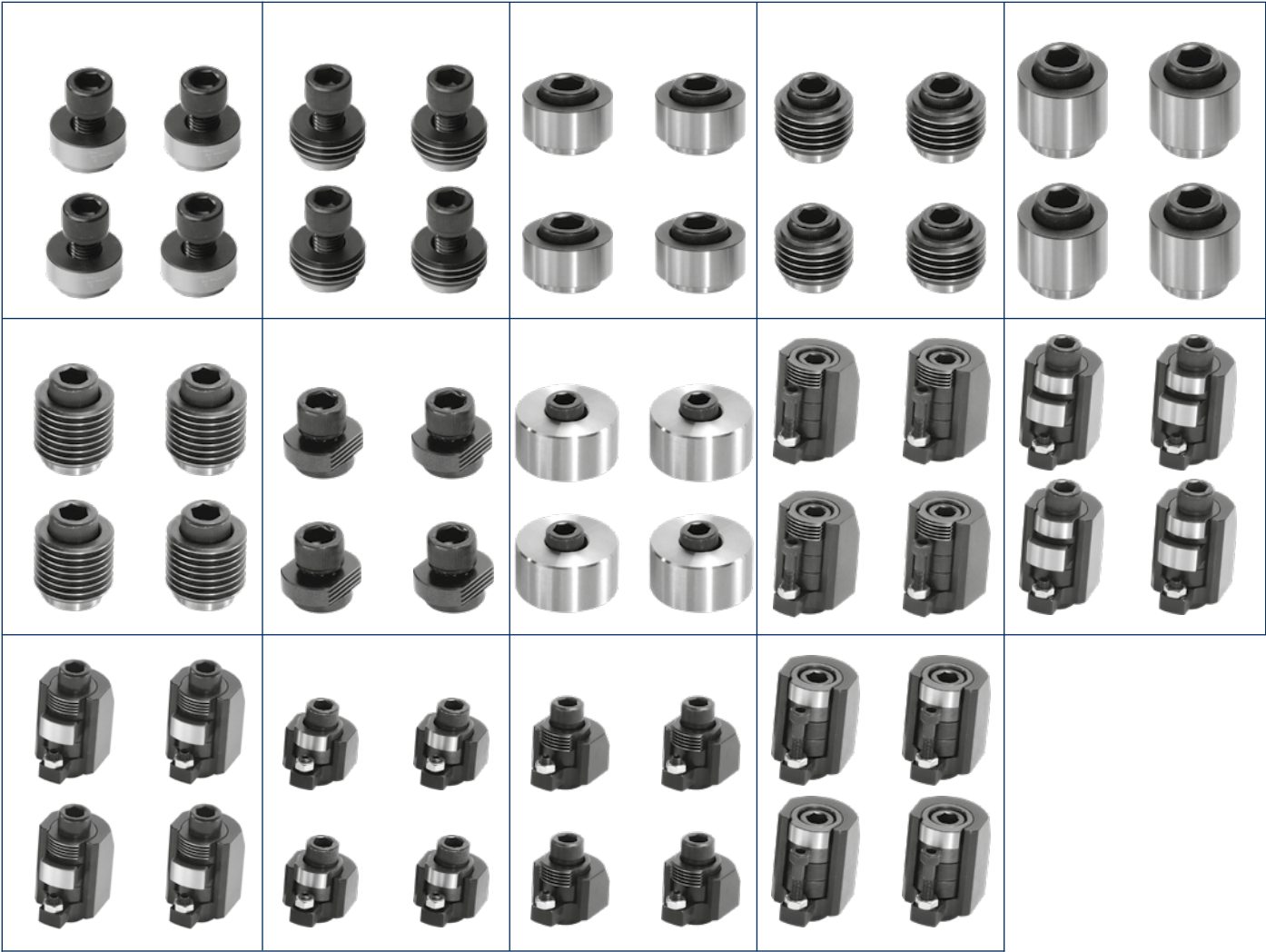
Id.No. 58 90 67 14



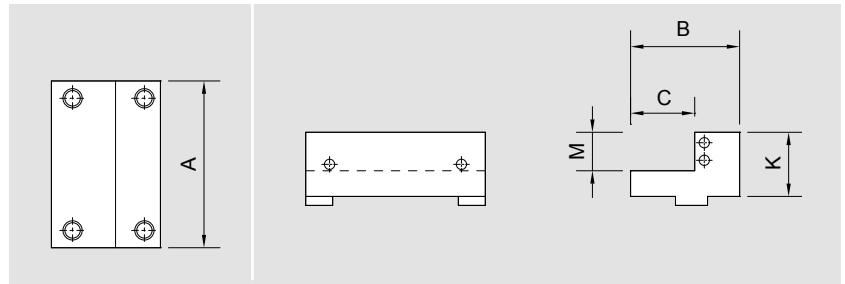
Kit of 14 sets of 4 grippers

9.1

Id.No. 58 90 60 09 for type VCP 100 - VCP 130 -VCP 160

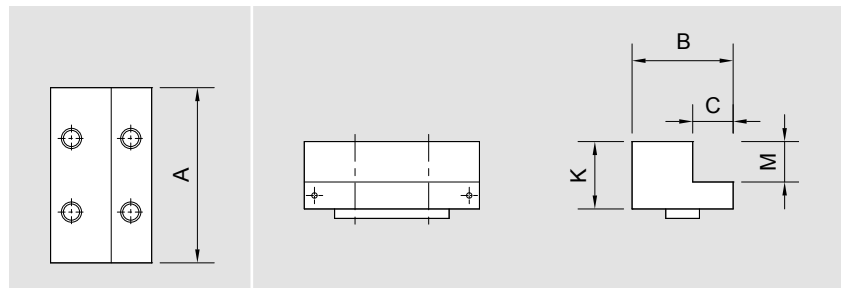


Fixed jaw "L" type



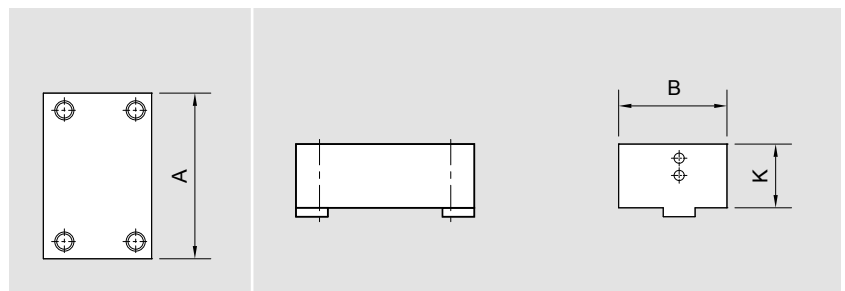
Id.No.	type	A mm	B mm	C mm	K mm	M mm	weight kg
58 90 02 10	100	100	78	32,5	45	25	2
58 91 02 10	130	130	83	35	52	30	3
58 92 02 10	160	160	86	35	95	30	4,2

Moveable jaw "L" type (with expanding chip cover)



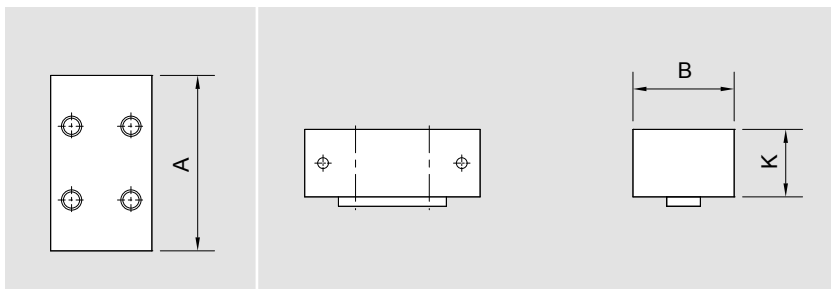
Id.No.	type	A mm	B mm	C mm	K mm	M mm	weight kg
58 90 03 10	100	100	64	26	45	25	1,5
58 91 03 10	130	130	74	30	52	30	2,8
58 92 03 10	160	160	86	35	55	30	4,2

Fixed square block jaw



Id.No.	type	A mm	B mm	K mm	weight kg
58 90 02 20	100	100	78	45	3
58 91 02 20	130	130	83	52	4
58 92 02 20	160	160	86	55	6

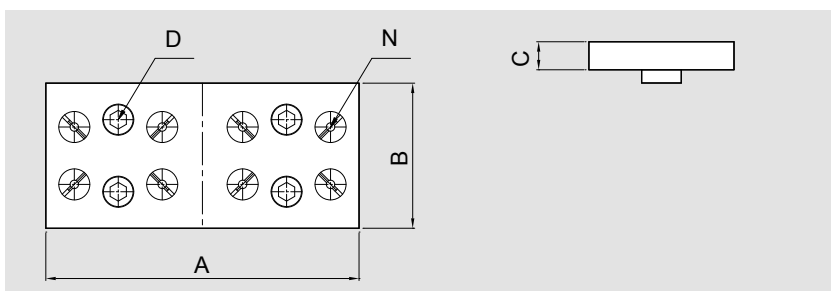
Moveable square block jaw (with expanding chip cover)



Id.No.	type	A mm	B mm	K mm	weight kg
58 90 03 20	100	100	64	45	2,5
58 91 03 20	130	130	74	52	4,5
58 92 03 20	160	160	86	55	6



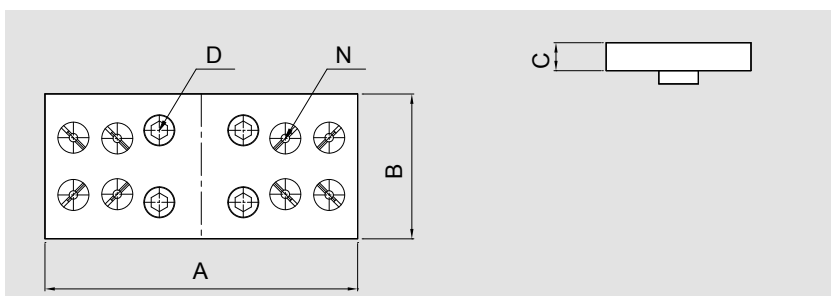
Fixed square block jaw gripper



Id.No.	type	A mm	B mm	C mm	D mm	N	weight kg
58 90 02 30	100	160	73	22	M10x25L	6	1,3
58 91 02 30	130	190	88	22	M12x30L	8	2,2
58 92 02 30	160	220	88	22	M14x30L	8	3,0



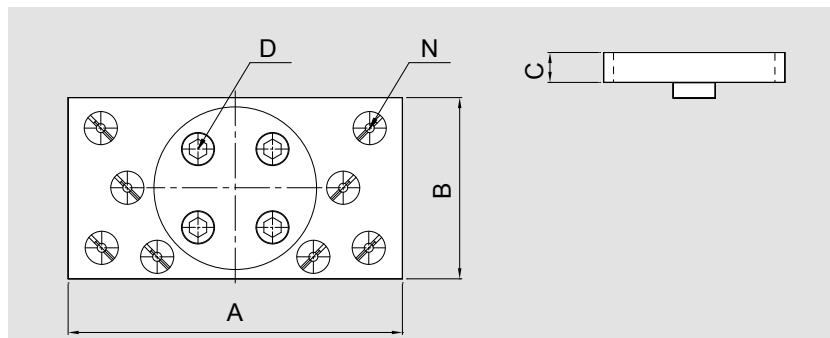
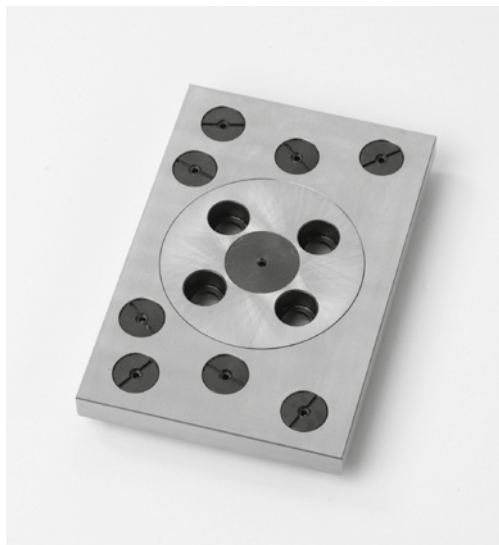
Moveable jaw gripper



Id.No.	type	A mm	B mm	C mm	D mm	N	weight kg
58 90 03 30	100	160	64	22	M10x25L	6	1,4
58 91 03 30	130	190	88	22	M12x30L	8	2,2
58 92 03 30	160	220	88	22	M14x30L	8	3,3



Floating jaw gripper

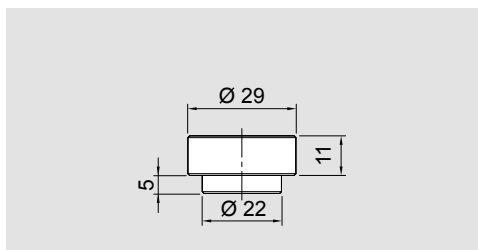


Id.No.	type	A mm	B mm	C mm	D mm	N	weight kg
58 90 03 40	VCP 100	160	88	22	M10x25L	6	2,2
58 91 03 40	VCP 130	190	103	22	M12x30L	8	3,2
58 92 03 40	VCP 160	220	128	22	M14x30L	8	5,7

Gripper h11 smooth

Id.No.

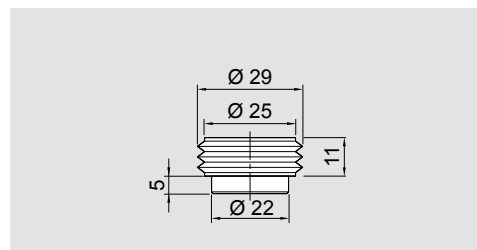
58 90 61 10



Gripper h11 serrated

Id.No.

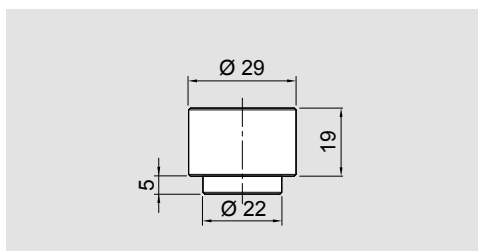
58 90 61 20



Gripper h19 smooth

Id.No.

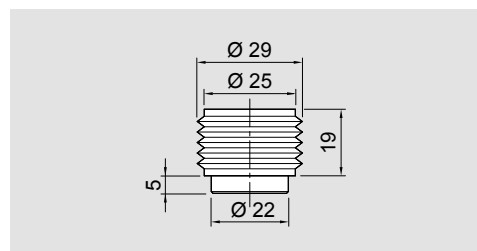
58 90 62 10



Gripper h19 serrated

Id.No.

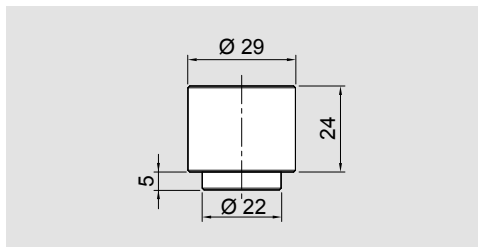
58 90 62 20



Gripper h24 smooth

Id.No.

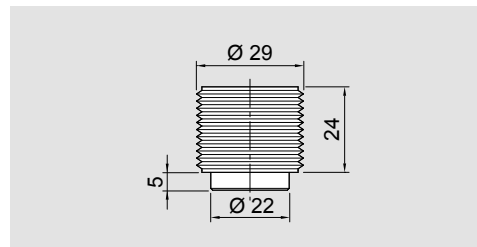
58 90 63 10



Gripper h24 serrated

Id.No.

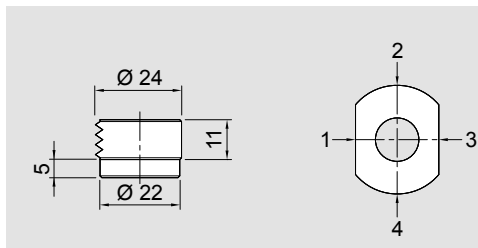
58 90 63 20



Gripper h11 smooth-serrated

Id.No.

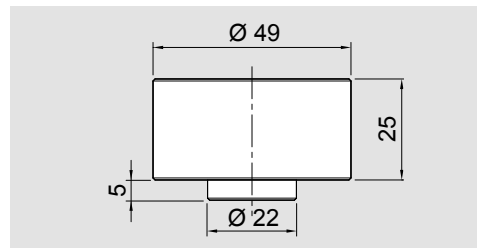
58 90 64 10



Soft gripper h25 smooth

Id.No.

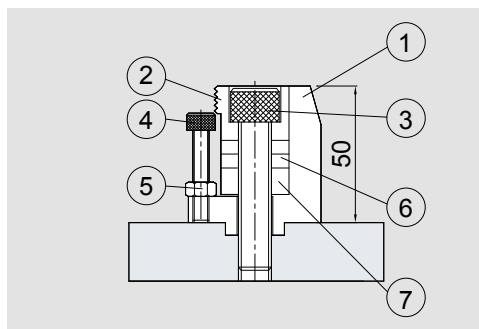
58 90 65 10



Gripper h50 serrated with adjustable screw

Id.No.

58 90 67 20

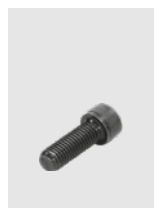


Pos.

Id.No.

Description

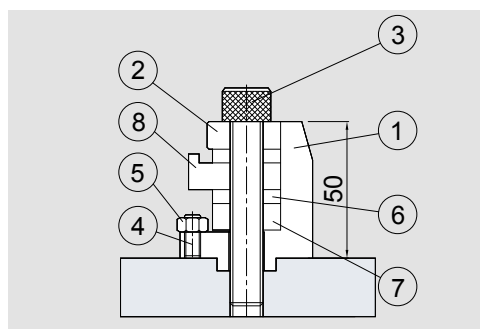
1	58 90 51 20	Body
2	58 90 52 20	Serrated gripper
3	71 11 31 09	Screw TCEI M12x60 12.9
4	71 11 30 47	Screw TCEI M6x30 12.9
5	71 15 02 06	Nut M6
6	58 90 54 10	Washer (5 mm)
7	58 90 54 20	Washer (10 mm)



Gripper h50 smooth with step

Id.No.

58 90 68 10

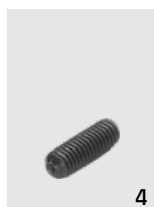


Pos.

Id.No.

Description

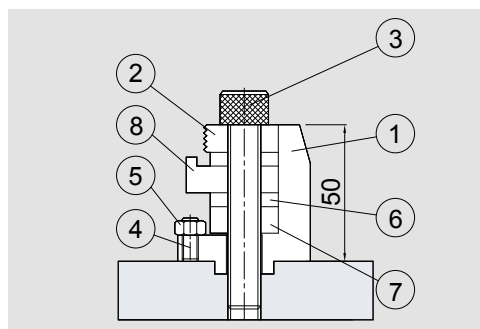
1	58 90 51 20	Body
2	58 90 53 10	Smooth gripper
3	71 11 31 10	Screw TCEI M12x70 12.9
4	71 11 21 24	Grub screw M6x16
5	71 15 02 06	Nut M6
6	58 90 54 10	Washer (5 mm)
7	58 90 54 20	Washer (10 mm)
8	58 90 55 10	Step washer



Gripper h50 serrated with step

Id.No.

58 90 68 20

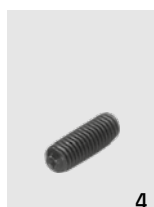


Pos.

Id.No.

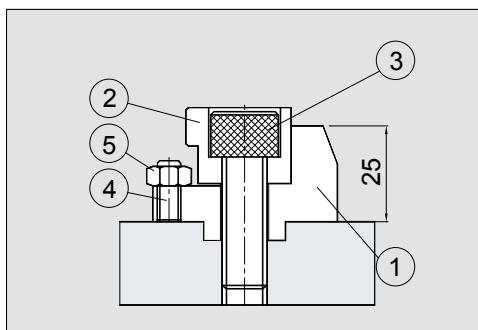
Description

1	58 90 51 20	Body
2	58 90 53 20	Serrated gripper
3	71 11 31 10	Screw TCEI M12x70 12.9
4	71 11 21 24	Grub screw M6x16
5	71 15 02 06	Nut M6
6	58 90 54 10	Washer (5 mm)
7	58 90 54 20	Washer (10 mm)
8	58 90 55 10	Step washer

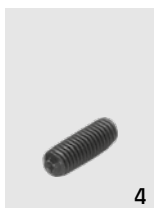


Gripper h25 smooth with adjustable screw

Id.No.
58 90 66 10

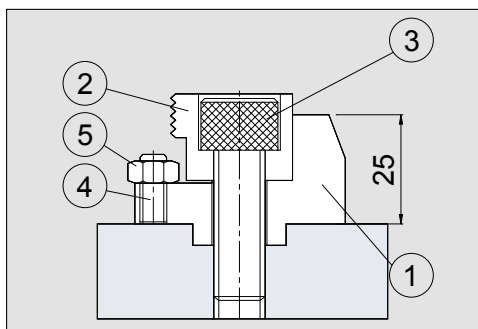


Pos.	Id.No.	Description
1	58 90 51 10	Body
2	58 90 52 10	Smooth gripper
3	71 11 31 05	Screw TCEI M12x35 12.9
4	71 11 21 24	Grub screw M6x16
5	71 15 02 06	Nut M6

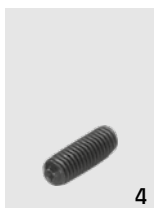


Gripper h25 serrated with adjustable screw

Id.No.
58 90 66 20

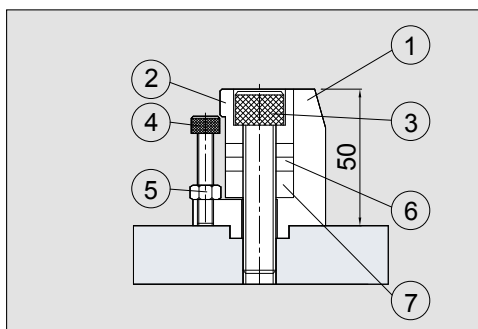


Pos.	Id.No.	Description
1	58 90 51 10	Body
2	58 90 52 20	Serrated gripper
3	71 11 31 05	Screw TCEI M12x35 12.9
4	71 11 21 24	Grub screw M6x16
5	71 15 02 06	Nut M6

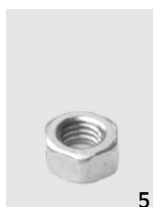
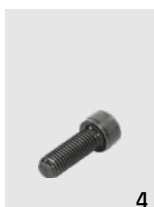


Gripper h50 smooth with adjustable screw

Id.No.
58 90 67 10



Pos.	Id.No.	Description
1	58 90 51 20	Body
2	58 90 52 10	Smooth gripper
3	71 11 31 09	Screw TCEI M12x60 12.9
4	71 11 30 47	Screw TCEI M6x16
5	71 15 02 06	Nut M6
6	58 90 54 10	Washer (5 mm)
7	58 90 54 20	Washer (10 mm)



Pair of positioning keys

Id.No.	mm	Id.No.	mm
58 90 13 92	18 x 12	58 90 13 95	18 x 18
58 90 13 93	18 x 14	58 90 13 96	18 x 20
58 90 13 94	18 x 16	58 90 13 97	18 x 22



Kit of 4 clamps

Id.No.	for type
58 90 27 09	VCP 100 - VP 100
	VCP 130 - VP 130
	VCP 160 - VP 160



Wrench VCM/VCA

Id.No.	for type
58 90 19 10	VCM 100 - VCA 100
	VCM 130 - VCA 130
	VCM 160 - VCA 160



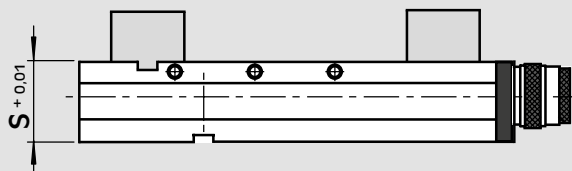
Torque wrench

Id.No.	for type
51 50 10 10	VCM 100 - VCA 100
	VCM 130 - VCA 130
	VCM 160 - VCA 160

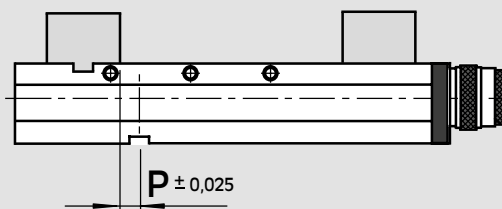


Manufacturing tolerances for all type of vises

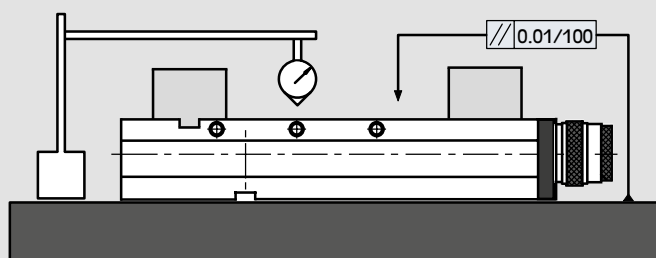
A



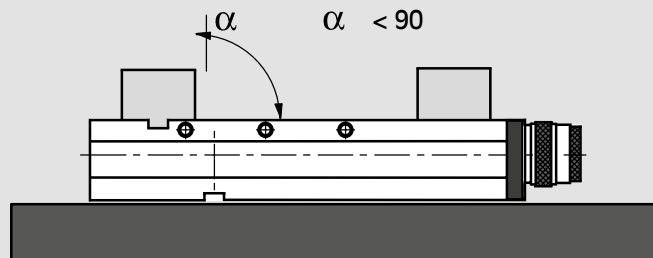
B



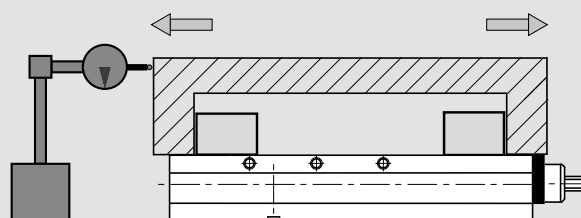
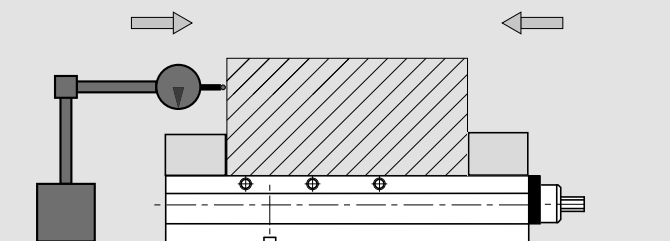
C



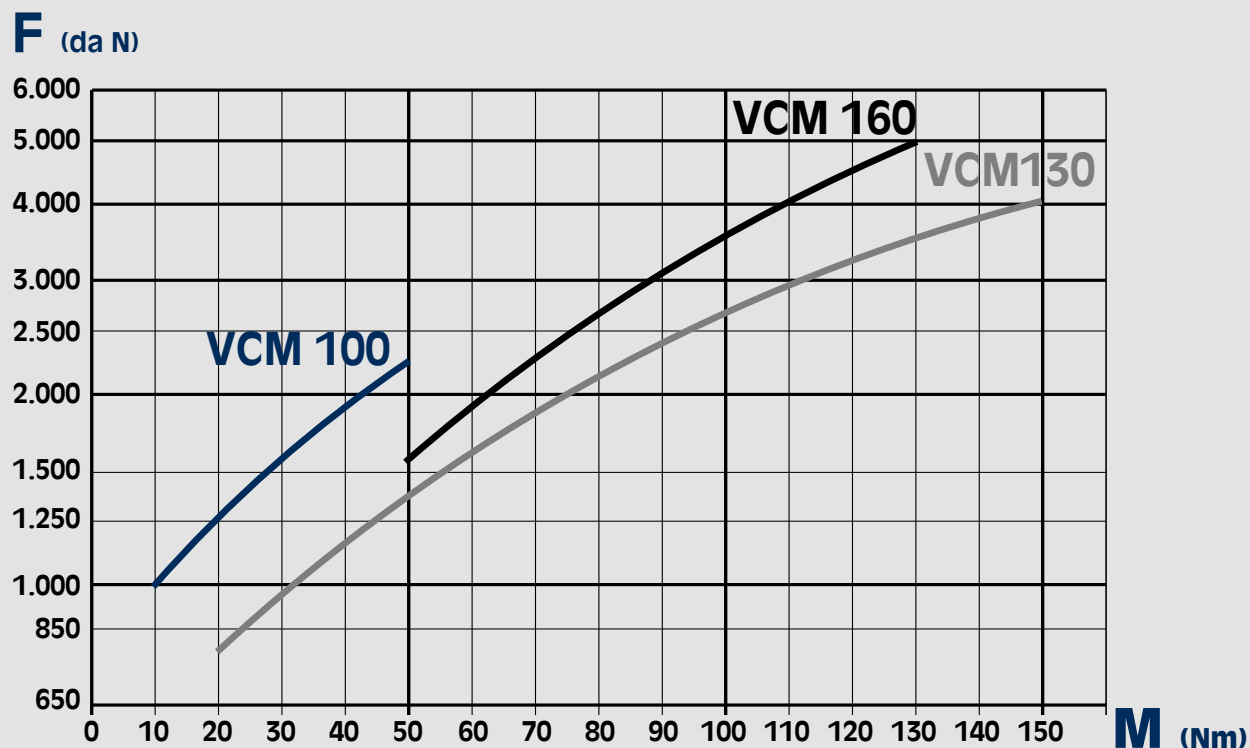
D

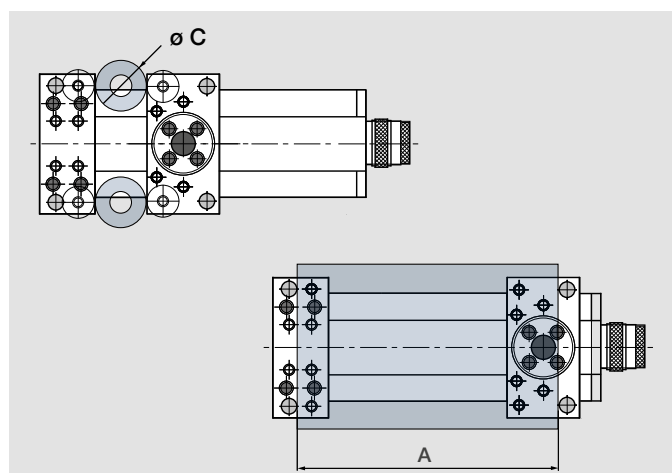
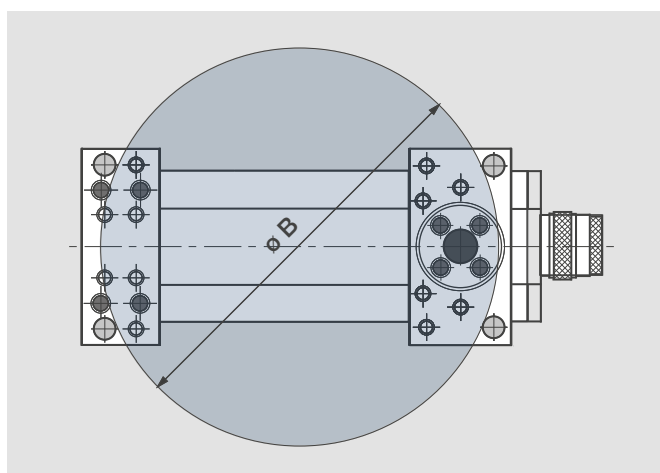


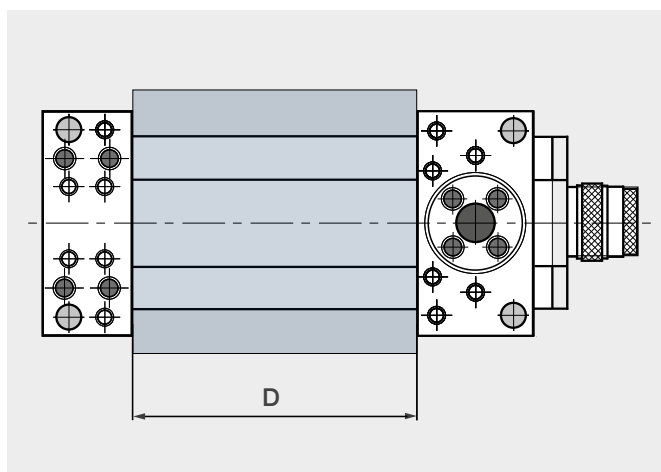
Repeatability accuracy for the clamping of model VCA $\pm 0,01$



Clamping force diagrams VCM without clamping force multiplier







type	A	Ø B	Ø C	D
VCP 100	0-220	80-250		0-150
VCP 130	0-320	90-350	0-90	0-210
VCP 160	0-380	90-420	0-90	0-240

NOTES