

*To clamp workpieces  
of unusual dimension!*

**XL - XLFLEX**

**Morse e Cubi / Vises & Vise Towers**

**DOGA®** | USINAGE

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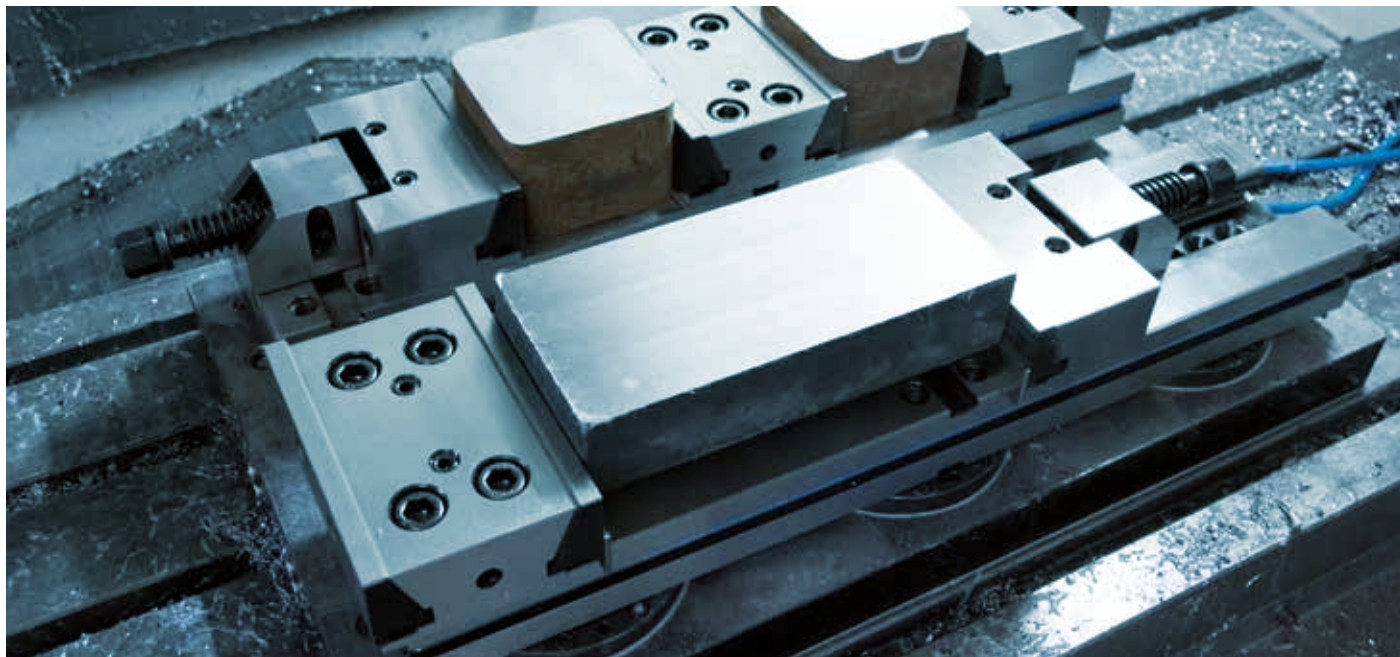
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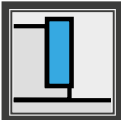





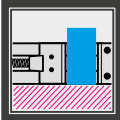
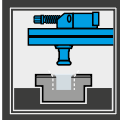
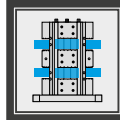


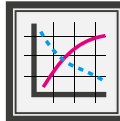
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## SIMBOLOGIA DATI TECNICI TECHNICAL DATA ICONS

<p><b>GANASCE</b> JAWS</p>	 Fissa Fixed	 Mobile Movable	 Intermedia Intermediate	 Fissa con piastra doppia liscia Fixed with double straight plate	 Fissa con piastra singola Fixed with single plate	 Fissa con piastra doppia Fixed with double plate
<p><b>PIASTRE</b> GANASCE JAW PLATES</p>		 Discendente Pull down	 Piana Straight	 Cambio rapido manuale Quick manual change  <b>XL FLEX</b>	 GRIP integrale Integral GRIP	 Inserti GRIP Inserti GRIP
<p><b>POSSIBILITÀ</b> POSSIBILITY</p>		 Serraggio di 1 particolare Clamping only 1 piece	 Serraggio di 2 particolari Clamping 2 pieces	 Montaggio sul fianco o in serie Side mounting or gang operation	 Predisposizione Zero Point Zero Point ready	 Cubi-morsa Vise tower
<p><b>PAGINE</b> PAGES</p>				 Accessori & Ricambi Accessories & Spare Parts	 Istruzioni corretto utilizzo Instruction for a proper use	 Diagrammi forze di serraggio Clamping force diagrams

**Morse / Vises**

# XL EXTRA LONG BASES

Come le morse Standard, ma con la base **mooolto** più lunga!  
 As the Standard vises but with a **loooonger** base


 Precisione / Accuracy  
**±0,02mm**

 Durezza / Hardened  
**HRC 58±2**

## 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 particulars 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 ganasce) 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 intercambiabili e indipendenti: 1 - Idraulici / 2 - Pneumatici / 3 - Idraulici manuali / 4 - Idraulici elettrici. L'operazione è in termini di secondi.

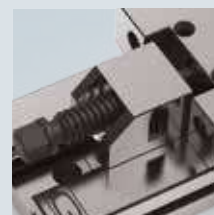
Thanks to the clamping device sliding in the vise base slide (compact rack type) till the proximity of the workpiece. The clamping is completed with the main screw. Besides the manual mechanic system, 4 further interchangeable and independent clamping systems are available: 1- Hydraulic / 2- Pneumatic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



### Ganasce fisse doppie Double fixed jaws

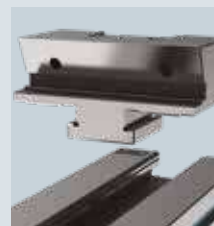
Ganasce fisse doppie posizionabili sia al centro (per serraggi doppi), sia all'estremità della base (per serraggi singoli di particolari di grosse dimensioni). La morsa XL doppia permette la lavorazione di un numero maggiore di pezzi sfruttando al massimo la lunghezza della tavola della macchina utensile.

Double fixed jaw position both in the center of the vise base (for double clamping) and at the end (for single big workpieces Clamping). Double XL vise allows to machine more workpieces using the total length of the machine tool, this means to increase productivity of the workicle and of the machine



### Serraggi indipendenti Independent clamping

Due Gruppi di serraggio indipendenti  
Two independent clamping devices



### Ganascia monoblocco Solid guided jaw

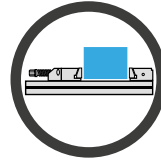
Entrambe le ganasce sono costruite in corpo unico (non esistono slitte o tasselli di fissaggio) per garantire una maggiore rigidità e nessuna flessione. Entrambe le piastre ganasce sono costruite con un **angolo di spinta verso il basso**. Ciò assicura, nel momento della chiusura, una trazione del pezzo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

Quando lo spazio sulla tavola della macchina è limitato le morse XL sono la risposta per avere due morse in una trasformandosi rapidamente da morsa a doppio serraggio a morsa singola aumentando l'apertura di serraggio. La morsa XL doppia permette la lavorazione di un numero maggiore di pezzi sfruttando al massimo la lunghezza della tavola della macchina utensile, ciò significa aumentare la produttività delle fasi attive del ciclo e di macchina stessa in quanto abbiamo

La versione XL singola permette il serraggio di pezzi di dimensioni insolite e di piastre (con le appropriate ganasce). La notevole gamma di dimensioni e lunghezze delle basi garantisce il soddisfacimento delle più svariate necessità nonché una rigidità notevole dell'attrezzatura. A richiesta tutte le morse sono fornibili con tasselli di riferimento di varie grandezze o con fori calibrati.

Space on the machine table is sometimes limited: XL vises enable to have 2 vises in 1 because they can quickly change from double vise to single vise with very large opening. Double XL vise allows to machine more workpieces using the total length of the machine tool, this means to increase productivity of the workcycle and of the machine. Single XL vise allows to clamp pieces of unusual dimensions and plates (with the right jaws). The very wide range of widths and lengths of bases guarantees the satisfaction of the widest variety of works and a big rigidity of the fixture too. In conclusion all this allows to reduce to a minimum dead times/interruptions and consequently faster payback period of machines and fixtures. On request all vises can be supplied with key-nuts of different sizes or with ground holes.



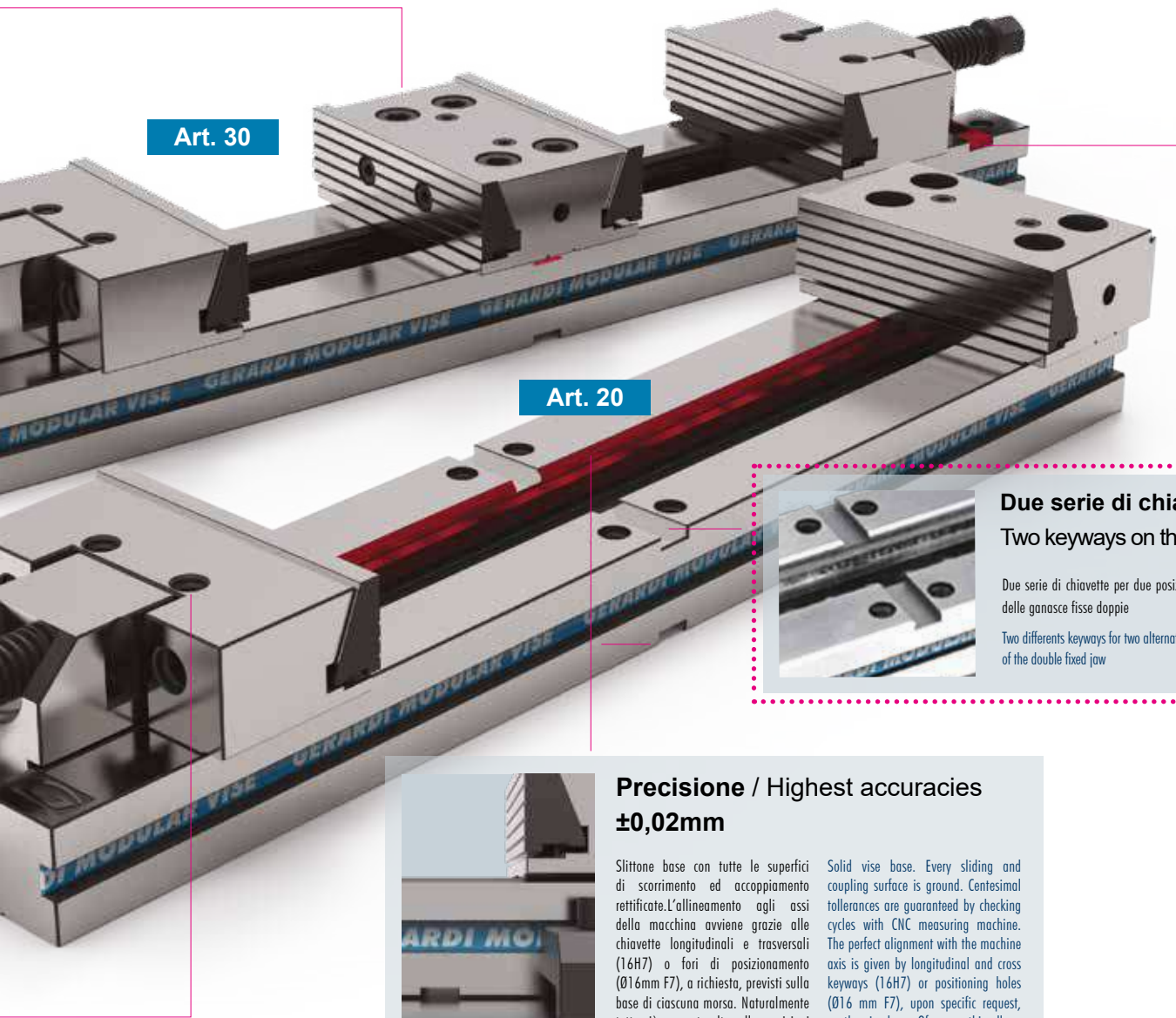
SCAN IT TO WATCH THE



VIDEO PRESENTATION



*Ideali per particolari di grandi dimensioni!*  
*To clamp workpieces of unusual dimension!*



Art. 30

Art. 20

**Due serie di chiavette**  
Two keyways on the top side

Due serie di chiavette per due posizioni alternative delle ganasce fisse doppie

Two different keyways for two alternative positions of the double fixed jaw



**Precisione / Highest accuracies**  
**±0,02mm**

Slittone base con tutte le superfici di scorrimento ed accoppiamento rettificato. L'allineamento agli assi della macchina avviene grazie alle chiavette longitudinali e trasversali (16H7) o fori di posizionamento (Ø16mm F7), a richiesta, previsti sulla base di ciascuna morsa. Naturalmente tutto ciò consente oltre alle precisioni dichiarate tempi di installazione ristrettissimi.

Solid vise base. Every sliding and coupling surface is ground. Centesimal tolerances are guaranteed by checking cycles with CNC measuring machine. The perfect alignment with the machine axis is given by longitudinal and cross keyways (16H7) or positioning holes (Ø16 mm F7), upon specific request, on the vise base. Of course this allows minimum of set up times and gang operations.

# Staffe d'ancoraggio / Vise holding clamps

**NEW**  
**2024**

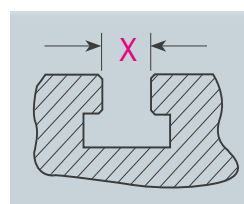
## XL extra long bases

**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**

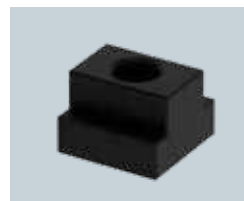
 Order example for Type 3 vise on machine with 18mm T-slots: Art.296 T.3 X=18mm

Also with code: 2.29.6300 X=18mm


**Cava a T**
**T Slot**

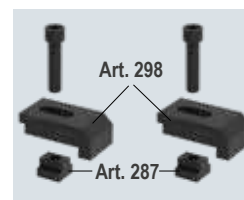
Specificare sempre la cava della vostra macchina

Always specify the machine T-slot dimension


**Art.287 (Pag.4.34)**
**Dadi a T - T Nuts**

Per fissaggio morsa alle cave a T della macchina

For vise clamping on the machine T-slots


**Art.296**

(Art.298 + Art.287)

Consigliate 3 coppie di staffe Art.296 per ogni morsa

Suggested 3 pairs of holding clamps Art.296 for each vise

Tipo (grandezza) morsa Vise type (size)	1				1 - 2				3 - 4				5 - 6																																																																																																								
	12	14	16	18	12*	14	16	18	20	18*	20	22	16	18	20	22	18*	20	22	16	18	20	22																																																																																														
<b>Art. 296</b> Coppia di staffe Holding clamps pair	Cava a T slot X																																																																																																																				
	T-nuts Ref. N°																																																																																																																				
	Filetto vite Screw thread																																																																																																																				
	M8				M10				M12 *				M16				M12 *				M16				M12				M16 *																																																																																								
<b>1 X M8</b>	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 / M12	2.29.65000 / M12	2.29.65000 / M16

\*Scelta consigliata - Suggested choice

\*Scelta NON consigliata - NO Suggested choice

## Soluzioni personalizzate / Customized solutions

# XL extra long bases

2

### Soluzioni personalizzate a tutti i vostri problemi di serraggio

Customized solutions for all your clamping problems



#### Morse XL

XL Vises

#### Morse XL montate orizzontalmente per lavorazioni su centro verticale

XL modular vises horizontally assembled for vertical machining centre



#### Morse XL

XL Vises

#### Morse XL montate verticalmente su cubo portapezzi per lavorazioni su centro orizzontale

XL Vises vertically assembled on a tombstone for horizontal machining centre.



#### Morse XL

XL Vises

#### Morse XL doppie montate su spalla in orizzontale

XL double vises horizontally assembled on a 2 sides tombstone



#### Versione singola

Single version

#### La versione XL singola permette il serraggio anche di pezzi di dimensioni insolite

Single XL vise allows to clamp also pieces of unusual dimensions



#### Morse modulari

Modular Vises

#### Tutte le morse ed accessori sono componibili fra loro e con tali accessori è possibile trasformare o riconfigurare la morsa per ottenere differenti soluzioni di serraggio

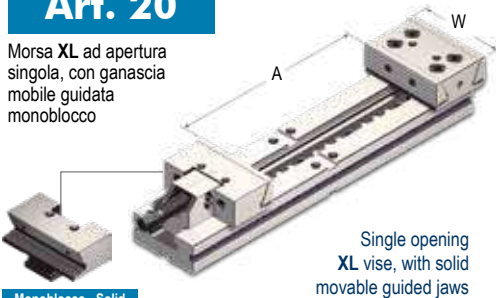
All vises and accessories are modular and components of all our vises will interchange with perfect alignment to upgrade your vise and provide different workholding solutions

**2**

Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4	
		16 kN	25 kN	30 kN	30 kN	30 kN	30 kN	30 kN	30 kN
Apertura massima / Maximum spread	A	290	320	360	460	400	500	600	700
	W	100	125	150			175		
	B	30	40	50			60		
	C	35	40	50			58		
	D	460	520	580	680	666	766	866	966
	G	75	95	125			145		
	kg	10	17	32	35	47	52	56	61
	Cod.	3.21.00000	3.22.10000	3.23.20000	3.23.30000	3.24.20000	3.24.30000	3.24.40000	3.24.50000

**Art. 20**

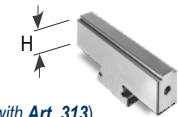
Morsa XL ad apertura singola, con ganascia mobile guidata monoblocco


**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !**
**Art. 313**

 Coppia di Parallele magnetiche  
 Pair of magnetic parallel plates


Cod.	4.31.3100C	4.31.3200C	4.31.3300C	4.31.3400C
H	23	33	43	53

**Art. 212**

 Ganascia mobile intermedia  
 (da usare con Art. 313)  
 Intermediate movable jaw (to be used with Art. 313)


Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000
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**Art. 217**

 Ganascia mobile prismatica  
 Prismatic movable jaw


Cod.	2.21.71000	2.21.72000	2.21.73000	2.21.74000
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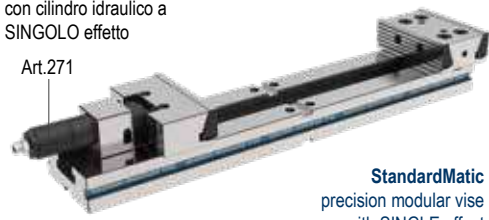
**Art. 242G**

 Piastra ganascia con inserti GRIP completa di parallela magnetica  
 Jaw plate with GRIP inserts with magnetic parallel

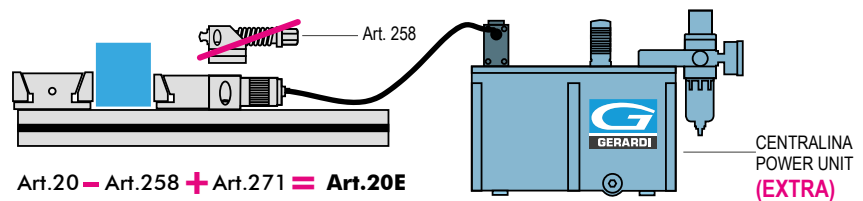

Cod.	1.24.2G100	1.24.2G200	1.24.2G300	1.24.2G400
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**Art. 20E**
**NEW 2024**

Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto

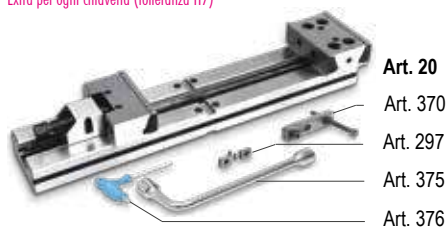

**StandardMatic**  
 precision modular vise with SINGLE effect hydraulic cylinder

Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41			
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**MORSE StandardMatic**


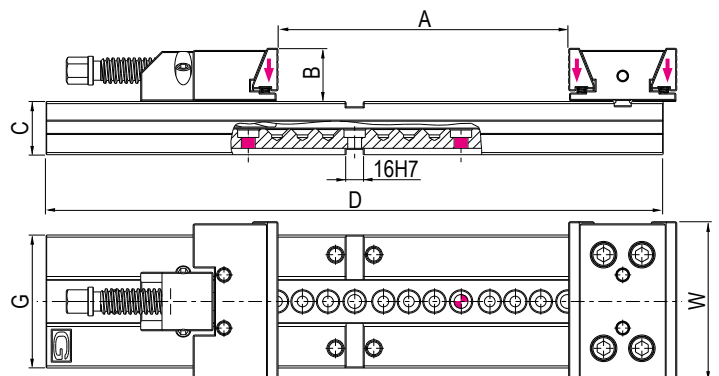
Dotazione standard:

- 1 arresto laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
 Extra per ogni chiavevta (tolleranza H7)



Standard equipment:

- 1 workstop Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
 Extra charge for each calibrated key nut (F7 tolerance)


 Vedi gruppo 4 per gamma completa accessori  
 See group 4 for complete range of accessories



	5 40 kN					6 40 kN						
A	500	600	700	800	900	500	600	700	800	900	1000	1100
W	200					300						
B	65					80						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	64	69	74	79	84	95	105	115	125	135	145	155
Cod.	3.25.20000	3.25.30000	3.25.40000	3.25.50000	3.25.60000	3.26.20000	3.26.30000	3.26.40000	3.26.50000	3.26.60000	3.26.70000	3.26.80000

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

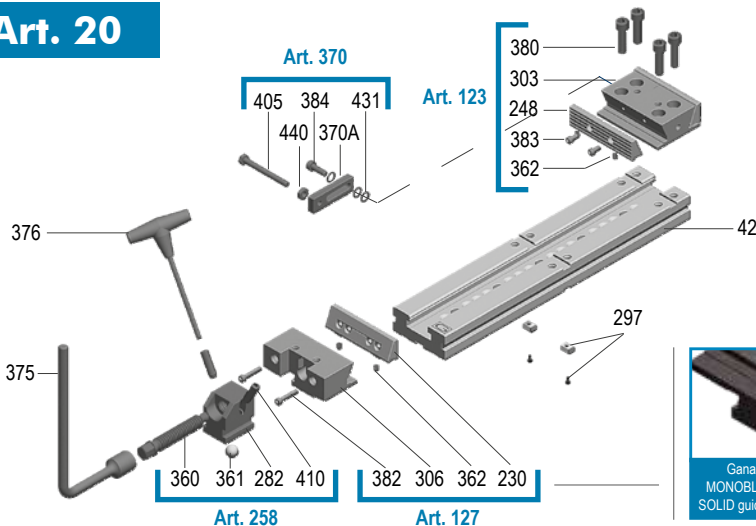
4.31.3500C	<b>Art. 313</b>		4.31.3600C
53			68
1.21.25000	<b>Art. 212</b>		1.21.26000
2.21.75000	<b>Art. 217</b>		2.21.76000
1.24.2G500	<b>Art. 242G</b>		1.24.2G600
Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41		

**StandardMatic VISES**



**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 20**



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<b>282</b>	4.36	<b>382</b>	4.28
<b>297</b>	4.34	<b>383</b>	4.28
<b>303</b>	4.29	<b>384</b>	4.28
<b>306</b>	4.29	<b>405</b>	4.35
<b>360</b>	4.36	<b>410</b>	4.36
<b>361</b>	4.36	<b>431</b>	4.28
<b>362</b>	4.28	<b>440</b>	4.28
<b>370A</b>	4.35	-	-

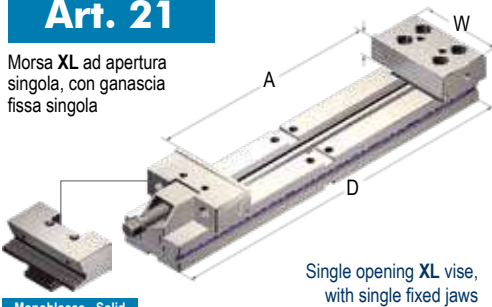


**2**

Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4	
		16 kN	25 kN	30 kN	30 kN	30 kN	30 kN	30 kN	30 kN
Apertura massima / Maximum spread	A	290	320	360	460	400	500	600	700
	W	100	125	150			175		
	B	30	40	50			60		
	C	35	40	50			58		
	D	460	520	580	680	666	766	866	966
	G	75	95	125			145		
	kg	10	17	32	35	47	52	56	61
	Cod.	2.21.12900	2.21.23200	2.21.33600	2.21.34600	2.21.44000	2.21.45000	2.21.46000	2.21.47000

**Art. 21**

Morsa XL ad apertura singola, con ganaschia fissa singola



Single opening XL vise, with single fixed jaws

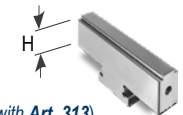
Monoblocco - Solid

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !**
**Art. 313**

 Coppia di Parallele magnetiche  
 Pair of magnetic parallel plates


Cod.	4.31.3100C	4.31.3200C	4.31.3300C	4.31.3400C
H	23	33	43	53

**Art. 212**

 Ganaschia mobile intermedia  
 (da usare con Art. 313)  
 Intermediate movable jaw (to be used with Art. 313)


Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000
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**Art. 217**

 Ganaschia mobile prismatica  
 Prismatic movable jaw


Cod.	2.21.71000	2.21.72000	2.21.73000	2.21.74000
------	------------	------------	------------	------------

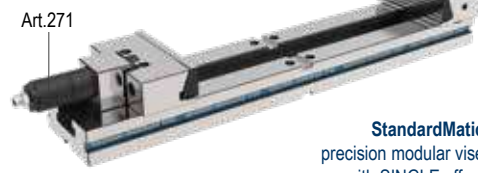
**Art. 242G**

 Piastra ganaschia con inserti GRIP completa di parallela magnetica  
 Jaw plate with GRIP inserts with magnetic parallel


Cod.	1.24.2G100	1.24.2G200	1.24.2G300	1.24.2G400
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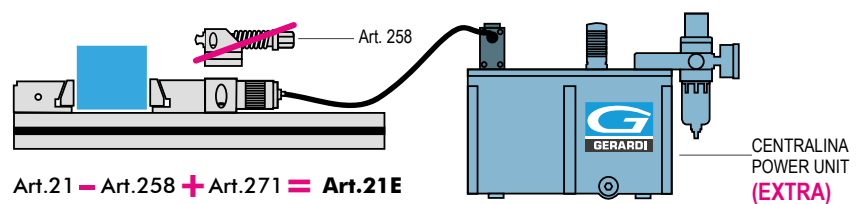
**Art. 21E**
**NEW 2024**

Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto



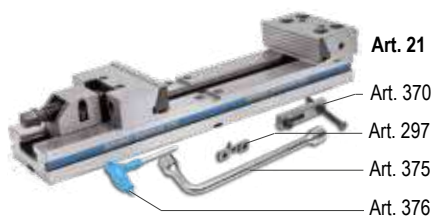
StandardMatic precision modular vise with SINGLE effect hydraulic cylinder

Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41			
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**MORSE StandardMatic**


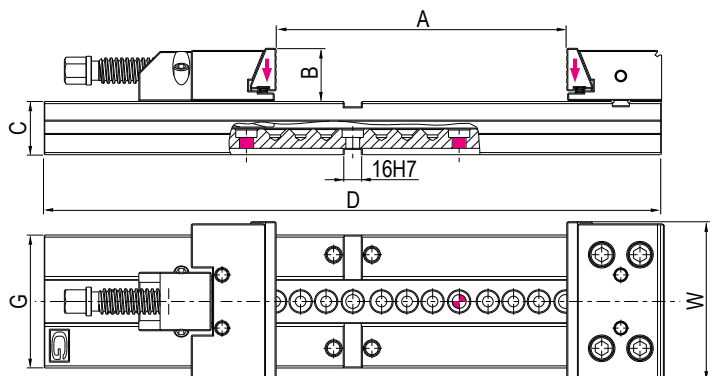
Dotazione standard:

- 1 arresto laterale Art. 370
- 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
- 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376

 Extra per ogni foro calibrato (tolleranza F7)  
 Extra per ogni chiave (tolleranza H7)


Standard equipment:

- 1 workshop Art. 370
- 1 pair of positioning key-nuts for 16 mm slot Art. 297
- 1 box wrench Art. 375 ■ 1 T-wrench Art. 376

 Extra charge for each calibrated hole (F7 tolerance)  
 Extra charge for each calibrated key nut (F7 tolerance)

 Vedi gruppo 4 per gamma completa accessori  
 See group 4 for complete range of accessories



	5 40 kN					6 40 kN						
A	500	600	700	800	900	500	600	700	800	900	1000	1100
W	200					300						
B	65					80						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	64	69	74	79	84	95	105	115	125	135	145	155
Cod.	2.21.55000	2.21.56000	2.21.57000	2.21.58000	2.21.59000	2.21.65000	2.21.66000	2.21.67000	2.21.68000	2.21.69000	2.21.61000	2.21.61100

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3500C

**Art. 313**

53



4.31.3600C

68

1.21.25000

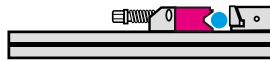
**Art. 212**



1.21.26000

2.21.75000

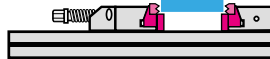
**Art. 217**



2.21.76000

1.24.2G500

**Art. 242G**



1.24.2G600

Cod.

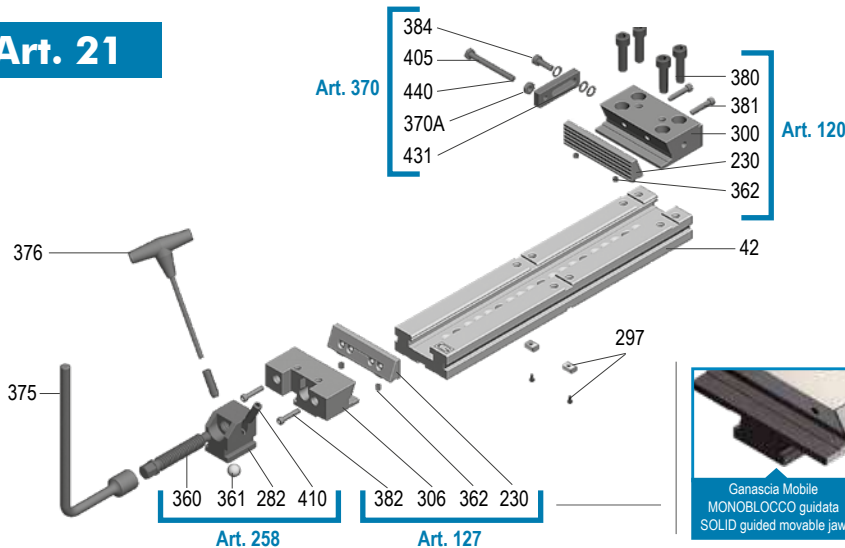
Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**



**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 21**

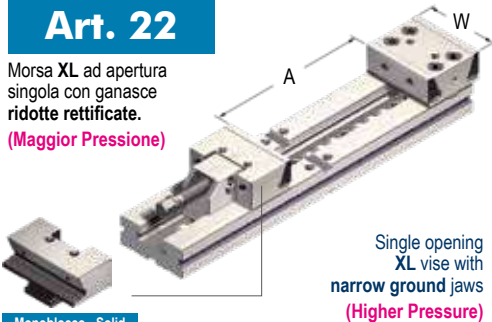


Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>375</b>	4.35
<b>230</b>	4.9	<b>376</b>	4.35
<b>248</b>	4.9	<b>380</b>	4.28
<b>282</b>	4.36	<b>382</b>	4.28
<b>297</b>	4.34	<b>383</b>	4.28
<b>300</b>	4.29	<b>384</b>	4.28
<b>306</b>	4.29	<b>405</b>	4.35
<b>360</b>	4.36	<b>410</b>	4.36
<b>361</b>	4.36	<b>431</b>	4.28
<b>362</b>	4.28	<b>440</b>	4.28
<b>370A</b>	4.35	-	-



**2**

Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4	
		16 kN	25 kN	30 kN	30 kN	30 kN	30 kN	30 kN	30 kN
Apertura massima / Maximum spread	A	290	320	360	460	400	500	600	700
	W	75	95	125			145		
	B	30	40	50			60		
	C	35	40	50			58		
	D	460	520	580	680	666	766	866	966
	G	75	95	125			145		
	kg	9.4	15.8	29.8	32.8	44.8	49.8	54.8	59.8
	Cod.	3.21.00220	3.22.10220	3.23.20220	3.23.30220	3.24.20220	3.24.30220	3.24.40220	3.24.50220



Monoblocco - Solid

**Art. 313R**

 Coppia di Parallele magnetiche  
 Pair of magnetic parallel plates


Cod.	4.31.3R10C	4.31.3R20C	4.31.3R30C	4.31.3R40C
H	23	33	43	53

**Art. 213**

 Ganascia mobile intermedia  
 (da usare con Art. 313R)  
 Intermediate movable jaw (to be used with Art. 313R)


Cod.	1.21.31000	1.21.32000	1.21.33000	1.21.34000
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**Art. 218**

 Ganascia mobile prismatica  
 Prismatic movable jaw


Cod.	2.21.81000	2.21.82000	2.21.83000	2.21.84000
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**Art. 243G**

 Piastra ganascia ridotta con inserti GRIP  
 completa di parallela magnetica  
 Narrow width jaw plate with GRIP inserts with magnetic parallel

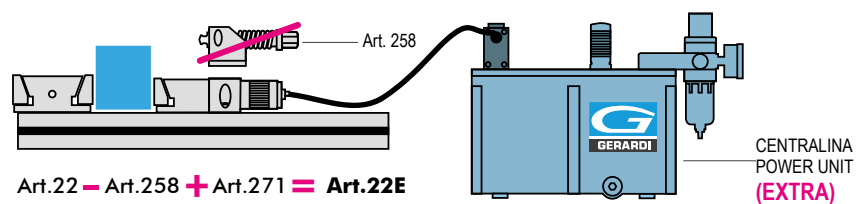

Cod.	1.24.3G100	1.24.3G200	1.24.3G300	1.24.3G400
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**Art. 22E**
**NEW 2024**

 Morsa modulare StandardMatic  
 con cilindro idraulico a  
 SINGOLO effetto

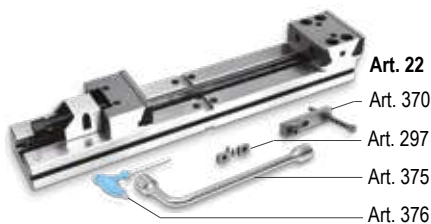
**StandardMatic**  
 precision modular vise  
 with SINGLE effect  
 hydraulic cylinder

Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41			
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**MORSE StandardMatic**


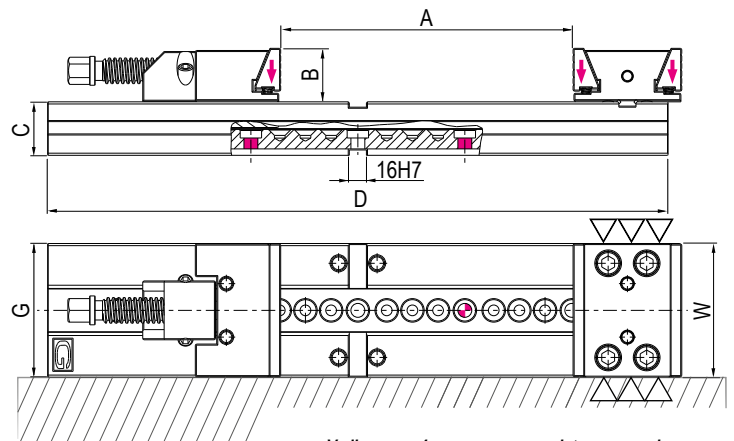
Dotazione standard:

- 1 arresto laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
 Extra per ogni chiave (tolleranza H7)



Standard equipment:

- 1 workstop Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
 Extra charge for each calibrated key nut (F7 tolerance)


 Vedi gruppo 4 per gamma completa accessori  
 See group 4 for complete range of accessories

	5 40 kN					6 40 kN						
	A	500	600	700	800	900	500	600	700	800	900	1000
W	170					195						
B	65					80						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	3.25.20220	3.25.30220	3.25.40220	3.25.50220	3.25.60220	3.26.20220	3.26.30220	3.26.40220	3.26.50220	3.26.60220	3.26.70220	3.26.80220

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

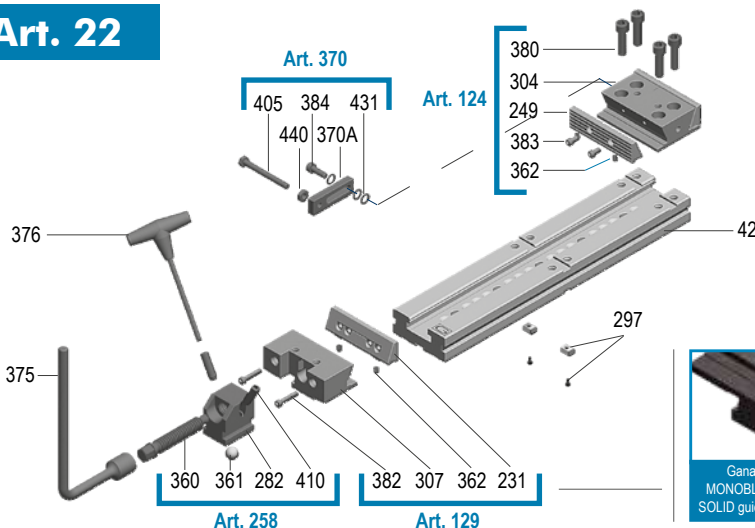
Art.	Accessories	Art.	Accessories
Art. 313R	4.31.3R50C 53	Art. 313R	4.31.3R60C 68
Art. 213	1.21.35000	Art. 213	1.21.36000
Art. 218	2.21.85000	Art. 218	2.21.86000
Art. 243G	1.24.3G500	Art. 243G	1.24.3G600
Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41		

**StandardMatic VISES**



**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 22**

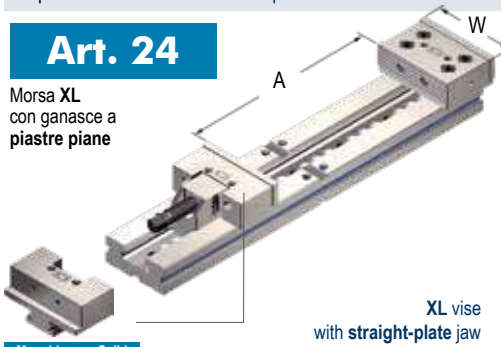


Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>375</b>	4.35
<b>231</b>	4.9	<b>376</b>	4.35
<b>249</b>	4.9	<b>380</b>	4.28
<b>282</b>	4.36	<b>382</b>	4.28
<b>297</b>	4.34	<b>383</b>	4.28
<b>304</b>	4.29	<b>384</b>	4.28
<b>307</b>	4.29	<b>405</b>	4.35
<b>360</b>	4.36	<b>410</b>	4.36
<b>361</b>	4.36	<b>431</b>	4.28
<b>362</b>	4.28	<b>440</b>	4.28
<b>370A</b>	4.35	-	-



**2**

Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4	
		16 kN	25 kN	30 kN	30 kN	30 kN	30 kN	30 kN	30 kN
Apertura massima / Maximum spread	A	290	320	360	460	400	500	600	700
	W	100	125	150			175		
	B	30	40	50			60		
	C	35	40	50			58		
	D	460	520	580	680	666	766	866	966
	G	75	95	125			145		
	kg	9.4	15.8	29.8	32.8	44.8	49.8	54.8	59.8
	Cod.	2.24.12900	2.24.23200	2.24.33600	2.24.34600	2.24.44000	2.24.45000	2.24.46000	2.24.47000



Monoblocco - Solid

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !**

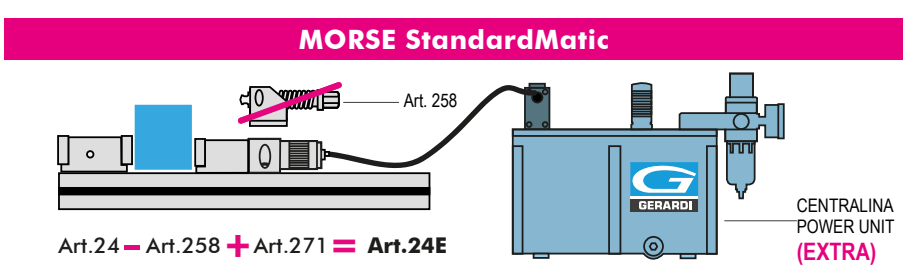
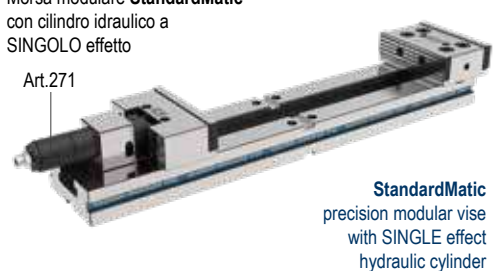
Art. 313	Cod.	4.31.3100C	4.31.3200C	4.31.3300C	4.31.3400C
Coppia di Parallele magnetiche / Pair of magnetic parallel plates	H	23	33	43	53

Art. 212	Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000
Ganascia mobile intermedia (da usare con Art. 313) / Intermediate movable jaw (to be used with Art. 313)	H				

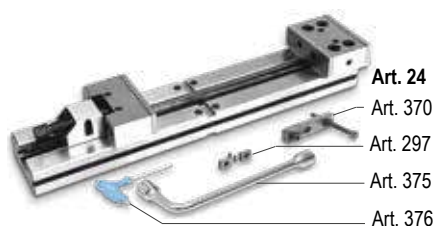
Art. 246	Cod.	1.65.16200	1.65.26200	1.65.36200	1.65.46200
Piastra piana in acciaio lavorabile / Machinable steel straight jaw plate					

Art. 246G	Cod.	1.24.6G100	1.24.6G200	1.24.6G300	1.24.6G400
Piastra ganascia con inserti GRIP completa di parallela magnetica / Jaw plate with GRIP inserts with magnetic parallel					

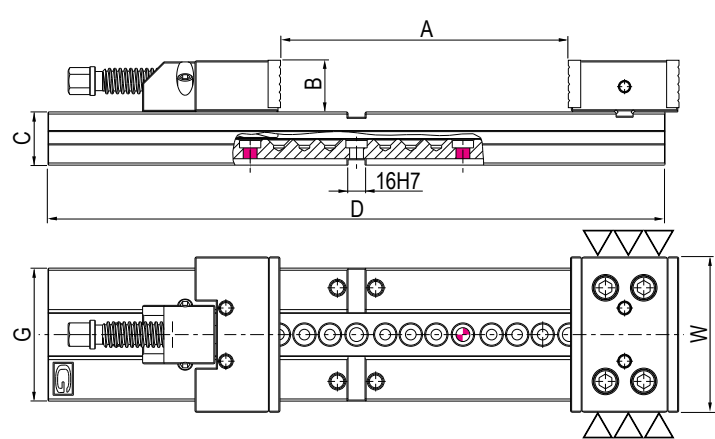
Art. 24E	Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41			
Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto					



- Dotazione standard:
- 1 arresto laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
 Extra per ogni chiave (tolleranza H7)



- Standard equipment:
- 1 workstop Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
 Extra charge for each calibrated key nut (F7 tolerance)


 Vedi gruppo 4 per gamma completa accessori  
 See group 4 for complete range of accessories

	5 40 kN					6 40 kN						
	A	500	600	700	800	900	500	600	700	800	900	1000
W	200					300						
B	65					80						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	2.24.55000	2.24.56000	2.24.57000	2.24.58000	2.24.59000	2.24.65000	2.24.66000	2.24.67000	2.24.68000	2.24.69000	2.24.61000	2.24.61100

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

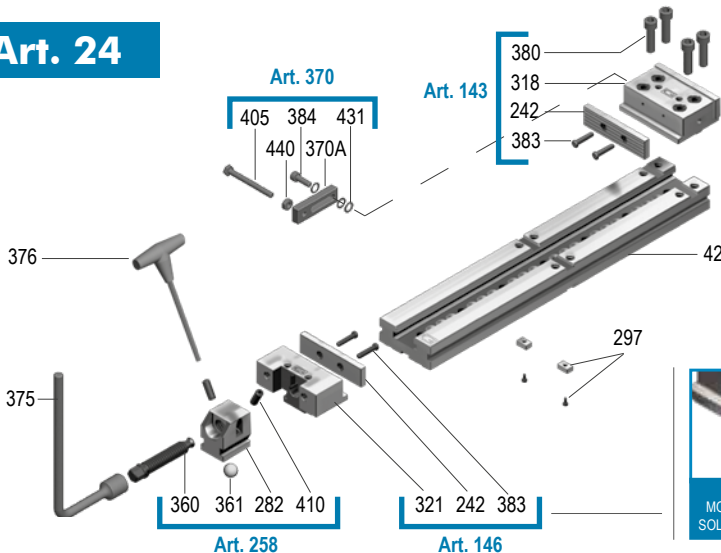
4.31.3500C		4.31.3600C	
<b>Art. 313</b>	53		68
1.21.25000		1.21.26000	
<b>Art. 212</b>			
1.65.56200		1.65.66200	
<b>Art. 246</b>			
1.24.6G500		1.24.6G600	
<b>Art. 246G</b>			
Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41		

**StandardMatic VISES**

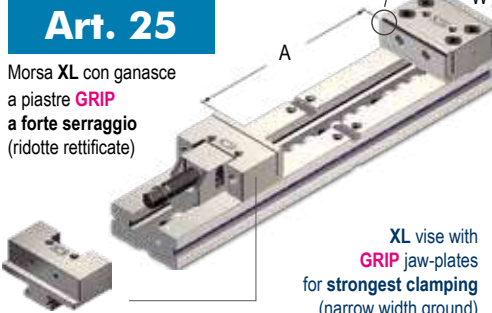


**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 24**



Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>380</b>	4.28
<b>242</b>	4.11	<b>383</b>	4.28
<b>282</b>	4.36	<b>384</b>	4.28
<b>297</b>	4.34	<b>405</b>	4.35
<b>318</b>	4.30	<b>410</b>	4.36
<b>321</b>	4.30	<b>431</b>	4.28
<b>360</b>	4.36	<b>440</b>	4.28
<b>361</b>	4.36	-	-
<b>370A</b>	4.35	-	-
<b>375</b>	4.35	-	-
<b>376</b>	4.35	-	-

**Tipo (grandezza) morsa**  
 Vise type (size)

**Art. 25**

 Morsa XL con ganasce a piastre **GRIP** a forte serraggio (ridotte rettificata)

 XL vise with **GRIP** jaw-plates for strongest clamping (narrow width ground)

Monoblocco - Solid

	1	2	3	4
	16 kN	25 kN	30 kN	30 kN
A	290	320	360	460
W	75	95	125	145
B	30	40	50	60
C	35	40	50	58
D	460	520	580	680
G	75	95	125	145
kg	9.4	15.8	29.8	32.8
Cod.	2.25.12900	2.25.23200	2.25.33600	2.25.34600
	2.25.44000	2.25.45000	2.25.46000	2.25.47000

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !**
**Art. 313R**

 Coppia di Parallele magnetiche  
 Pair of magnetic parallel plates


Cod. 4.31.3R10C 4.31.3R20C 4.31.3R30C 4.31.3R40C

H 23 33 43 53

**Art. 218**

 Ganasce mobile prismatica  
 Prismatic movable jaw


Cod. 2.21.81000 2.21.82000 2.21.83000 2.21.84000

**Art. 247**

 Piastra piana in acciaio lavorabile  
 Machinable steel straight jaw plate

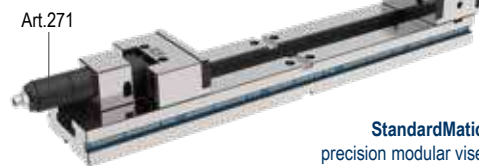

Cod. 1.65.17200 1.65.27200 1.65.37200 1.65.47200

**Art. 247G**

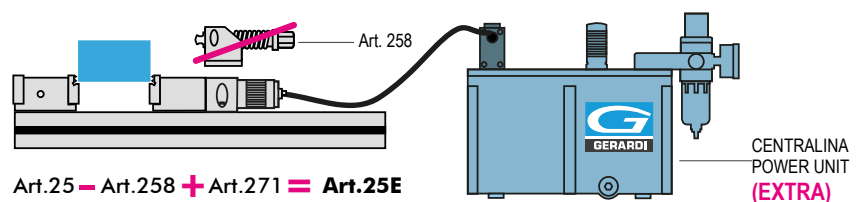
 Piastra ganasce ridotta con inserti GRIP completa di parallela magnetica  
 Narrow width jaw plate with GRIP inserts with magnetic parallel


Cod. 1.24.7G100 1.24.7G200 1.24.7G300 1.24.7G400

**Art. 25E**
**NEW 2024**

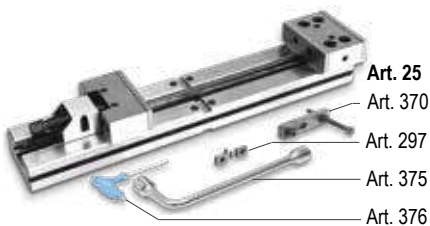
 Morsa modulare **StandardMatic** con cilindro idraulico a SINGOLO effetto

**StandardMatic**  
 precision modular vise with SINGLE effect hydraulic cylinder

Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**MORSE StandardMatic**


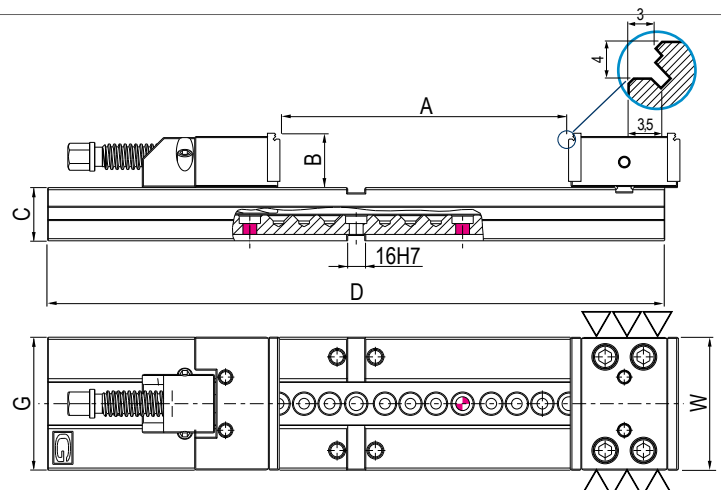
Dotazione standard:

- 1 arresto laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
 Extra per ogni chiave (tolleranza H7)



Standard equipment:

- 1 workstop Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
 Extra charge for each calibrated key nut (F7 tolerance)


 Vedi gruppo 4 per gamma completa accessori  
 See group 4 for complete range of accessories





	5 40 kN					6 40 kN						
	A	500	600	700	800	900	500	600	700	800	900	1000
W	170					195						
B	65					80						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	2.25.55000	2.25.56000	2.25.57000	2.25.58000	2.25.59000	2.25.65000	2.25.66000	2.25.67000	2.25.68000	2.25.69000	2.25.61000	2.25.61100

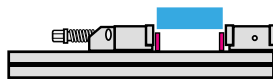
**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3R50C

4.31.3R60C

**Art. 313R**

53

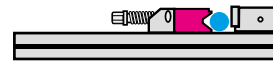


68

2.21.85000

2.21.86000

**Art. 218**



1.65.57200

1.65.67200

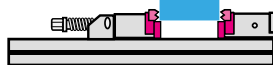
**Art. 247**



1.24.7G500

1.24.7G600

**Art. 247G**



Cod.

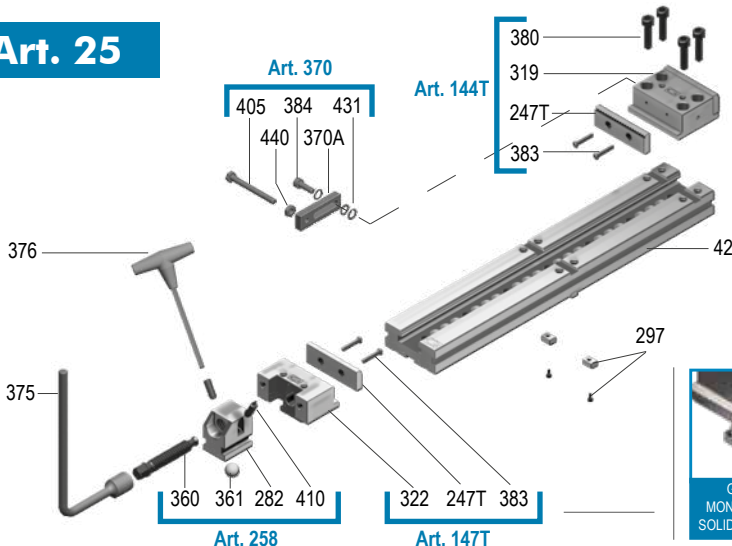
Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**



**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

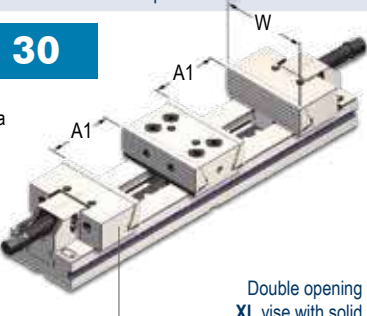
**Art. 25**



Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>380</b>	4.28
<b>247T</b>	4.11	<b>383</b>	4.28
<b>282</b>	4.36	<b>384</b>	4.28
<b>297</b>	4.34	<b>405</b>	4.35
<b>319</b>	4.30	<b>410</b>	4.36
<b>322</b>	4.30	<b>431</b>	4.28
<b>360</b>	4.36	<b>440</b>	4.28
<b>361</b>	4.36	-	-
<b>370A</b>	4.35	-	-
<b>375</b>	4.35	-	-
<b>376</b>	4.35	-	-



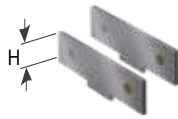
Ganascia Mobile MONOBLOCCO guidata SOLID guided movable jaw

Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4	
		16 kN	25 kN	30 kN	30 kN	30 kN	30 kN	30 kN	
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 160	2 x 120	2 x 170	2 x 220	2 x 270
<b>Art. 30</b> Morsa XL a doppia apertura con ganascia mobile guidata monoblocco 	W	100	125	150				175	
	B	30	40	50				60	
C	35	40	50					58	
D	460	520	580	680	666	766	866	966	
G	75	95	125					145	
kg	14.5	21	39	43	59	64	69	74	
Cod.	3.31.00600	3.32.10600	3.33.20600	3.33.30600	3.34.20600	3.34.30600	3.34.40600	3.34.50600	

Monoblocco - Solid

Double opening XL vise with solid movable guided jaws

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !**
**Art. 313**

 Coppia di Parallele magnetiche  
 Pair of magnetic parallel plates


Cod. 4.31.3100C 4.31.3200C 4.31.3300C 4.31.3400C

H 23 33 43 53

**Art. 212**

 Ganascia mobile intermedia  
 (da usare con Art. 313)  
 Intermediate movable jaw (to be used with Art. 313)


Cod. 1.21.21000 1.21.22000 1.21.23000 1.21.24000

**Art. 217**

 Ganascia mobile prismatica  
 Prismatic movable jaw


Cod. 2.21.71000 2.21.72000 2.21.73000 2.21.74000

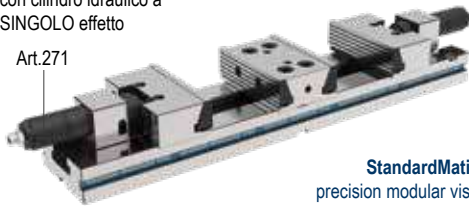
**Art. 242G**

 Piastra ganascia con inserti GRIP  
 completa di parallela magnetica  
 Jaw plate with GRIP inserts with magnetic parallel

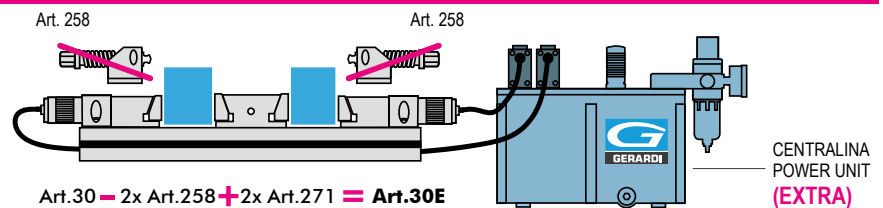

Cod. 1.24.2G100 1.24.2G200 1.24.2G300 1.24.2G400

**Art. 30E**

NEW 2024

 Morsa modulare StandardMatic  
 con cilindro idraulico a  
 SINGOLO effetto

 StandardMatic  
 precision modular vise  
 with SINGLE effect  
 hydraulic cylinder

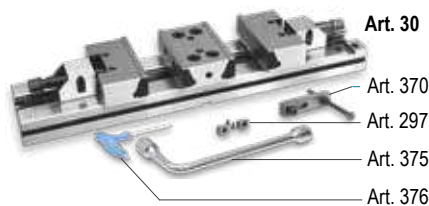
Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**MORSE StandardMatic**


Art.30 - 2x Art.258 + 2x Art.271 = Art.30E

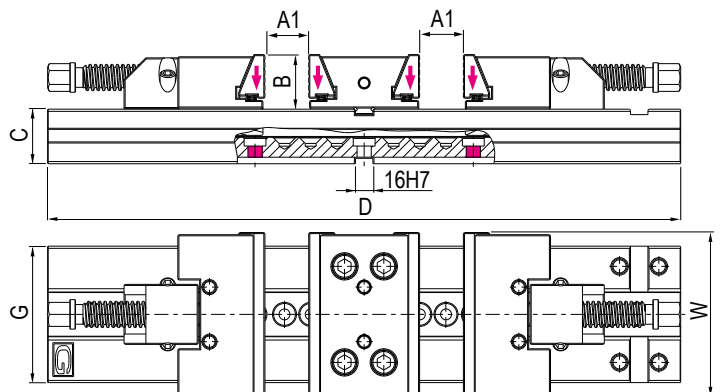
Dotazione standard:

- 2 arresti laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
 Extra per ogni chiave (tolleranza H7)



Standard equipment:

- 2 workstops Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
 Extra charge for each calibrated key nut (F7 tolerance)


 Vedi gruppo 4 per gamma completa accessori  
 See group 4 for complete range of accessories

	5 40 kN					6 40 kN						
	2 x 150	2 x 200	2 x 250	2 x 300	2 x 350	2 x 160	2 x 210	2 x 260	2 x 310	2 x 360	2 x 410	2 x 460
A1												
W	200					300						
B	65					80						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	96	102	108	114	120	155	163	171	179	187	195	213
Cod.	3.35.20600	3.35.30600	3.35.40600	3.35.50600	3.35.60600	3.36.20600	3.36.30600	3.36.40600	3.36.50600	3.36.60600	3.36.70600	3.36.80600

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3500C



4.31.3600C

1.21.25000

**Art. 212**

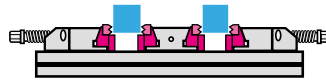

1.21.26000

2.21.75000

**Art. 217**


2.21.76000

1.24.2G500

**Art. 242G**


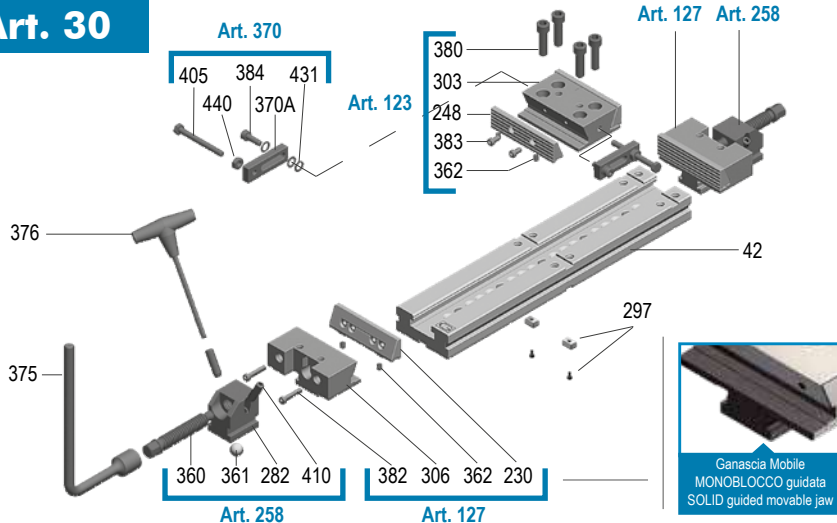
1.24.2G600

Cod.

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**

**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
 Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 30**


Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>375</b>	4.35
<b>230</b>	4.9	<b>376</b>	4.35
<b>248</b>	4.9	<b>380</b>	4.28
<b>282</b>	4.36	<b>382</b>	4.28
<b>297</b>	4.34	<b>383</b>	4.28
<b>303</b>	4.29	<b>384</b>	4.28
<b>306</b>	4.29	<b>405</b>	4.35
<b>360</b>	4.36	<b>410</b>	4.36
<b>361</b>	4.36	<b>431</b>	4.28
<b>362</b>	4.28	<b>440</b>	4.28
<b>370A</b>	4.35	-	-

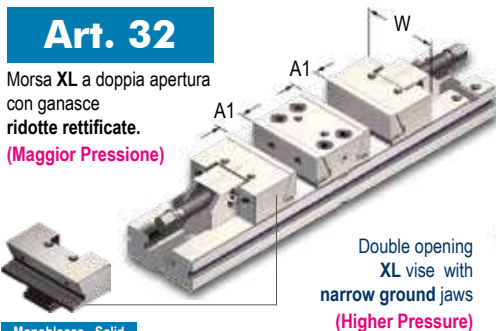


2

**Tipo (grandezza) morsa / Vise type (size)**

	kN	1 16 kN	2 25 kN	3 30 kN		4 30 kN			
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 160	2 x 120	2 x 170	2 x 220	2 x 270
	W	75	95	125		145			
	B	30	40	50		60			
	C	35	40	50		58			
	D	460	520	580	680	666	766	866	966
	G	75	95	125		145			
	kg	13.5	19.5	36	40	56	61	66	71
	Cod.	3.31.00720	3.32.10720	3.33.20720	3.33.30720	3.34.20720	3.34.30720	3.34.40720	3.34.50720

**Art. 32**

 Morsa XL a doppia apertura  
 con ganasce  
 ridotte rettificate.  
 (Maggior Pressione)

 Double opening  
 XL vise with  
 narrow ground jaws  
 (Higher Pressure)

Monoblocco - Solid

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !**
**Art. 313R**

 Coppia di Parallele magnetiche  
 Pair of magnetic parallel plates


Cod.	4.31.3R10C	4.31.3R20C	4.31.3R30C	4.31.3R40C
H	23	33	43	53

**Art. 213**

 Ganasca mobile intermedia  
 (da usare con Art. 313R)  
 Intermediate movable jaw (to be used with Art. 313R)


Cod.	1.21.31000	1.21.32000	1.21.33000	1.21.34000

**Art. 218**

 Ganasca mobile prismatica  
 Prismatic movable jaw

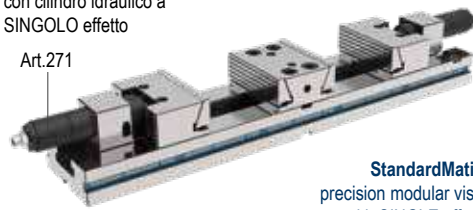

Cod.	2.21.81000	2.21.82000	2.21.83000	2.21.84000

**Art. 243G**

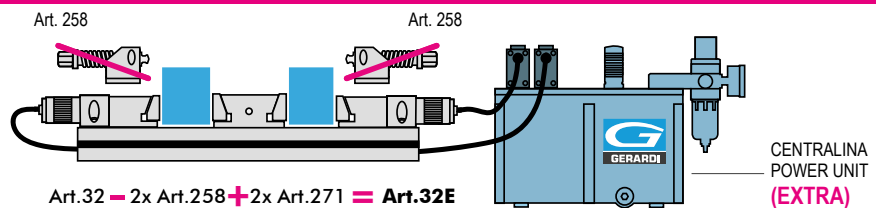
 Piastra ganasca ridotta con inserti GRIP  
 completa di parallela magnetica  
 Narrow width jaw plate with GRIP inserts with magnetic parallel


Cod.	1.24.3G100	1.24.3G200	1.24.3G300	1.24.3G400

**Art. 32E**
**NEW  
2024**

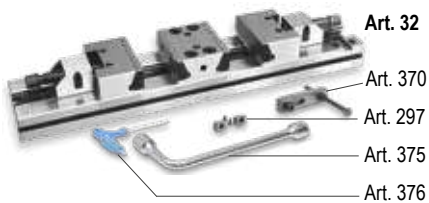
 Morsa modulare StandardMatic  
 con cilindro idraulico a  
 SINGOLO effetto

 StandardMatic  
 precision modular vise  
 with SINGLE effect  
 hydraulic cylinder

Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41			

**MORSE StandardMatic**


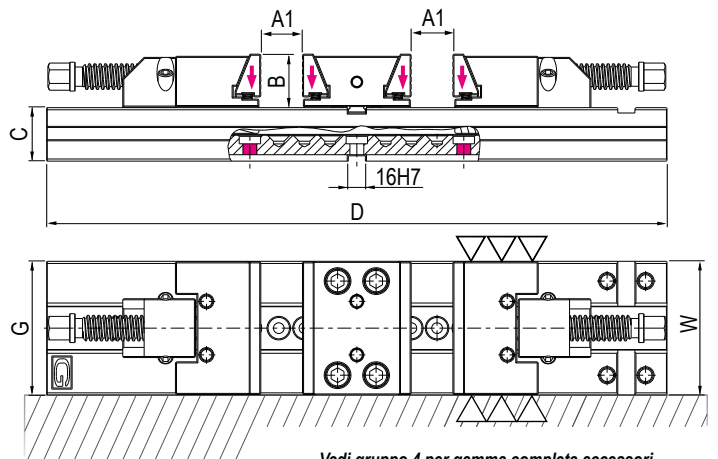
Dotazione standard:

- 2 arresti laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
 Extra per ogni chiave (tolleranza H7)






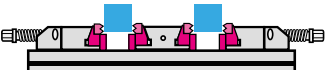
Standard equipment:

- 2 workstops Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
 Extra charge for each calibrated key nut (F7 tolerance)


 Vedi gruppo 4 per gamma completa accessori  
 See group 4 for complete range of accessories

	5 40 kN					6 40 kN						
	2 x 150	2 x 200	2 x 250	2 x 300	2 x 350	2 x 160	2 x 210	2 x 260	2 x 310	2 x 360	2 x 410	2 x 460
A1												
W			170						195			
B			65						80			
C			70						78			
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G			170						195			
kg	93	99	105	108	117	144	152	160	168	176	184	202
Cod.	3.35.20720	3.35.30720	3.35.40720	3.35.50720	3.35.60720	3.36.20720	3.36.30720	3.36.40720	3.36.50720	3.36.60720	3.36.70720	3.36.80720

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

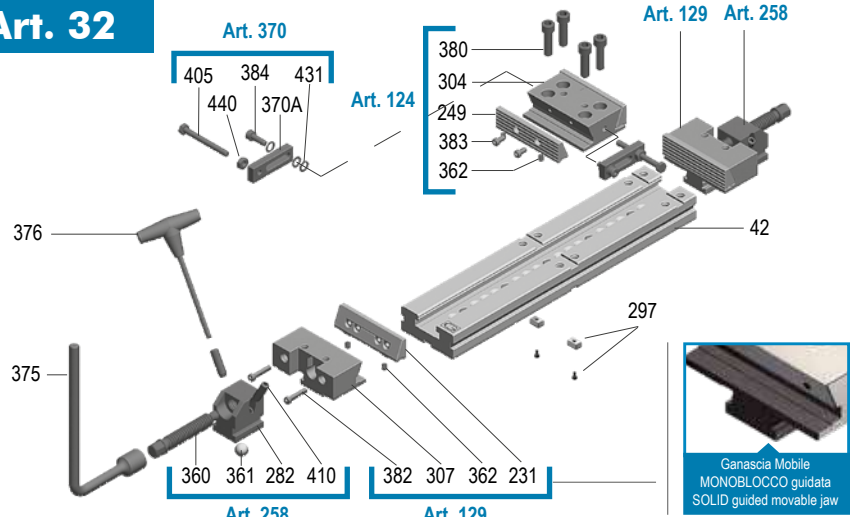
<p>Art. 313R</p> <p>53</p>	<p>4.31.3R50C</p> 	<p>Art. 313R</p> <p>68</p>	<p>4.31.3R60C</p>
<p>Art. 213</p>	<p>1.21.35000</p> 	<p>Art. 213</p>	<p>1.21.36000</p>
<p>Art. 218</p>	<p>2.21.85000</p> 	<p>Art. 218</p>	<p>2.21.86000</p>
<p>Art. 243G</p>	<p>1.24.3G500</p> 	<p>Art. 243G</p>	<p>1.24.3G600</p>
<p>Cod. <span style="float: right;">Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41</span></p>			

**StandardMatic VISES**

**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)



**Art. 32**



Art.	Pag.	Art.	Pag.
42	2.32	375	4.35
231	4.9	376	4.35
249	4.9	380	4.28
282	4.36	382	4.28
297	4.34	383	4.28
304	4.29	384	4.28
307	4.29	405	4.35
360	4.36	410	4.36
361	4.36	431	4.28
362	4.28	440	4.28
370A	4.35	-	-

2

Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4	
		16 kN	25 kN	30 kN	30 kN	30 kN	30 kN	30 kN	
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 160	2 x 120	2 x 170	2 x 220	2 x 270
<b>Art. 34</b> Morsa XL a doppia apertura con ganasce a piastre piane  Double opening XL vise with straight-plate jaws Monoblocco - Solid	W	100	125	150				175	
	B	30	40	50				60	
	C	35	40	50				58	
	D	460	520	580	680	666	766	866	966
	G	75	95	125				145	
	kg	9.4	15.8	29.8	32.8	44.8	49.8	54.8	59.8
	Cod.	2.34.19000	2.34.21000	2.34.31100	2.34.31600	2.34.41200	2.34.41700	2.34.42200	2.34.42700

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !**

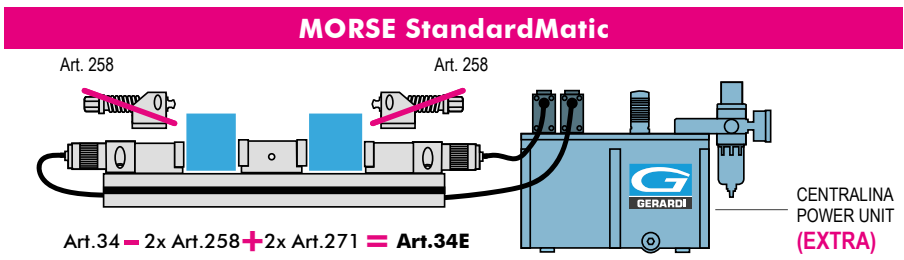
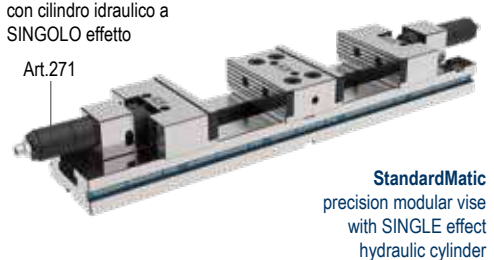
Art. 313 Coppia di Parallele magnetiche Pair of magnetic parallel plates	H	Cod.		4.31.3100C		4.31.3200C		4.31.3300C		4.31.3400C	
		23	33	43	53						

Art. 212 Ganascia mobile intermedia (da usare con Art. 313) Intermediate movable jaw (to be used with Art. 313)	H	Cod.		1.21.21000		1.21.22000		1.21.23000		1.21.24000	

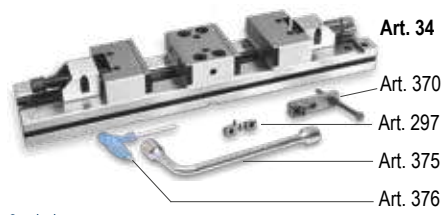
Art. 246 Piastra piana in acciaio lavorabile Machinable steel straight jaw plate	Cod.	1.65.16200		1.65.26200		1.65.36200		1.65.46200	

Art. 246G Piastra ganascia con inserti GRIP completa di parallela magnetica Jaw plate with GRIP inserts with magnetic parallel	Cod.	1.24.6G100		1.24.6G200		1.24.6G300		1.24.6G400	

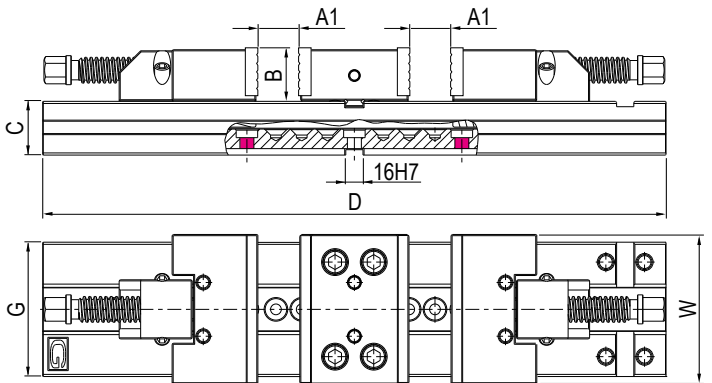
Art. 34E Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto NEW 2024	Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41							



- Dotazione standard:
- 2 arresti laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
Extra per ogni chiave (tolleranza H7)



- Standard equipment:
- 2 workstops Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
Extra charge for each calibrated key nut (F7 tolerance)



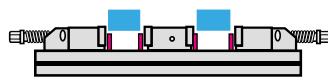
Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories

	5 40 kN					6 40 kN						
	2 x 150	2 x 200	2 x 250	2 x 300	2 x 350	2 x 160	2 x 210	2 x 260	2 x 310	2 x 360	2 x 410	2 x 460
A1	2 x 150	2 x 200	2 x 250	2 x 300	2 x 350	2 x 160	2 x 210	2 x 260	2 x 310	2 x 360	2 x 410	2 x 460
W	200					300						
B	65					80						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	2.34.51500	2.34.52000	2.34.52500	2.34.53000	2.34.53500	2.34.61600	2.34.62100	2.34.62600	2.34.63100	2.34.63600	2.34.64100	2.34.64600

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.31.3500C

53



4.31.3600C

68

1.21.25000

**Art. 212**

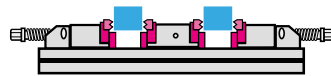

1.21.26000

1.65.56200

**Art. 246**


1.65.66200

1.24.6G500

**Art. 246G**


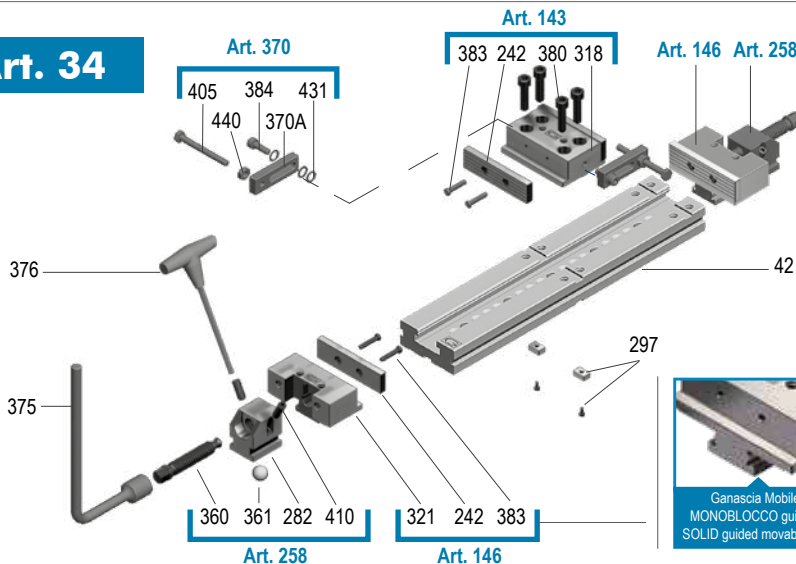
1.24.6G600

Cod.

Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**

**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
 Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 34**


Art.	Pag.
<b>42</b>	2.32
<b>242</b>	4.11
<b>282</b>	4.36
<b>297</b>	4.34
<b>318</b>	4.30
<b>321</b>	4.30
<b>360</b>	4.36
<b>361</b>	4.36
<b>370A</b>	4.35
<b>375</b>	4.35
<b>376</b>	4.35

Art.	Pag.
<b>380</b>	4.28
<b>383</b>	4.28
<b>384</b>	4.28
<b>405</b>	4.35
<b>410</b>	4.36
<b>431</b>	4.28
<b>440</b>	4.28
-	-
-	-
-	-
-	-



**Tipo (grandezza) morsa**  
 Vise type (size)

	1	2	3		4				
	16 kN	25 kN	30 kN		30 kN				
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 160	2 x 120	2 x 170	2 x 220	2 x 270
Art. 35	W	75	95	125		145			
	B	30	40	50		60			
	C	35	40	50		58			
	D	460	520	580	680	666	766	866	966
	G	75	95	125		145			
	kg	9.4	15.8	29.8	32.8	44.8	49.8	54.8	59.8
	Cod.	2.35.19000	2.35.21000	2.35.31100	2.35.31600	2.35.41200	2.35.41700	2.35.42200	2.35.42700

**Art. 35**

 Morsa XL a doppia apertura con piastre ganasce **GRIP** a forte serraggio (ridotte rettificate)

 Double opening XL vise with **GRIP** jaw-plates for strongest clamping (narrow with ground)

Monoblocco - Solid

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !**
**Art. 313R**

 Coppia di Parallele magnetiche  
 Pair of magnetic parallel plates


Cod.	4.31.3R10C	4.31.3R20C	4.31.3R30C	4.31.3R40C
H	23	33	43	53

**Art. 218**

 Ganaschia mobile prismatica  
 Prismatic movable jaw


Cod.	2.21.81000	2.21.82000	2.21.83000	2.21.84000

**Art. 247**

 Piastra piana in acciaio lavorabile  
 Machinable steel straight jaw plate

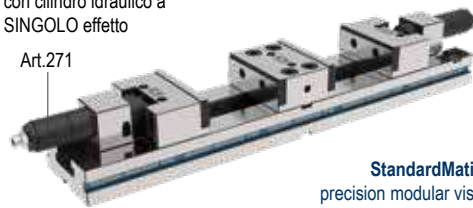

Cod.	1.65.17200	1.65.27200	1.65.37200	1.65.47200

**Art. 247G**

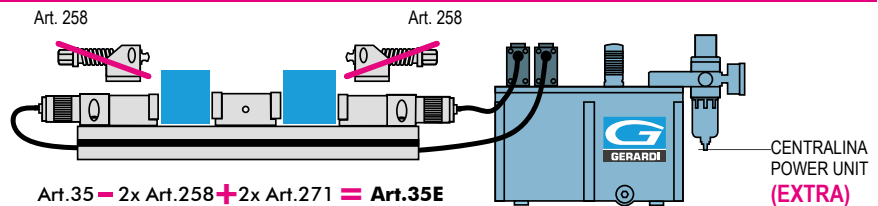
 Piastra ganaschia ridotta con inserti GRIP completa di parallela magnetica  
 Narrow width jaw plate with GRIP inserts with magnetic parallel


Cod.	1.24.7G100	1.24.7G200	1.24.7G300	1.24.7G400

**Art. 35E**
**NEW 2024**

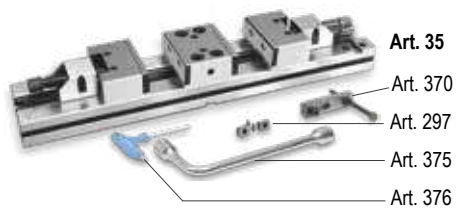
 Morsa modulare **StandardMatic** con cilindro idraulico a SINGOLO effetto


Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41			

**MORSE StandardMatic**


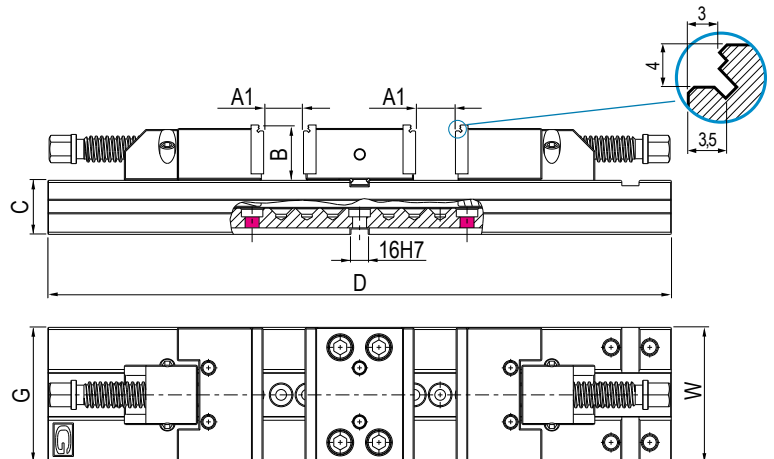
Dotazione standard:

- 2 arresti laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
 Extra per ogni chiave (tolleranza H7)



Standard equipment:

- 2 workstops Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
 Extra charge for each calibrated key nut (F7 tolerance)


 Vedi gruppo 4 per gamma completa accessori  
 See group 4 for complete range of accessories



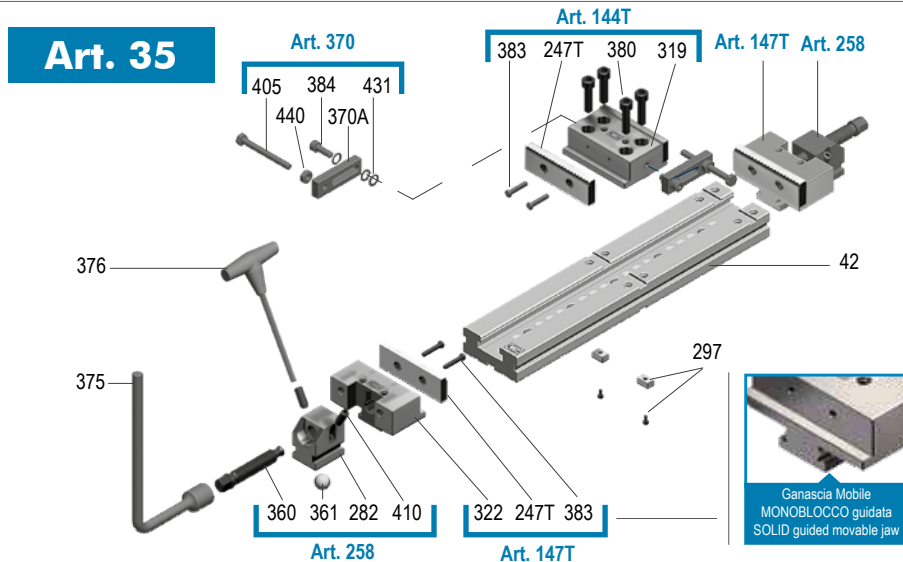
	5 40 kN					6 40 kN						
A1	2 x 150	2 x 200	2 x 250	2 x 300	2 x 350	2 x 160	2 x 210	2 x 260	2 x 310	2 x 360	2 x 410	2 x 460
W	170					195						
B	65					80						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	82.5	88.5	96.5	103.5	110.5	116	129	139	149	159	169	179
Cod.	2.35.51500	2.35.52000	2.35.52500	2.35.53000	2.35.53500	2.35.61600	2.35.62100	2.35.62600	2.35.63100	2.35.63600	2.35.64100	2.35.64600

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

<b>Art. 313R</b> 53		<b>Art. 313R</b> 53	<b>Art. 313R</b> 53
<b>Art. 218</b> 53		<b>Art. 218</b> 53	<b>Art. 218</b> 53
<b>Art. 247</b> 53		<b>Art. 247</b> 53	<b>Art. 247</b> 53
<b>Art. 247G</b> 53		<b>Art. 247G</b> 53	<b>Art. 247G</b> 53

Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**

**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
 Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)


Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>380</b>	4.28
<b>247T</b>	4.11	<b>383</b>	4.28
<b>282</b>	4.36	<b>384</b>	4.28
<b>297</b>	4.34	<b>405</b>	4.35
<b>319</b>	4.30	<b>410</b>	4.36
<b>322</b>	4.30	<b>431</b>	4.28
<b>360</b>	4.36	<b>440</b>	4.28
<b>361</b>	4.36	-	-
<b>370A</b>	4.35	-	-
<b>375</b>	4.35	-	-
<b>376</b>	4.35	-	-



# Morse e Cubi / Vises & Vise Towers

## XL (flex)



Precisione / Accuracy  
±0,02mm



Durezza / Hardened  
HRC 58±2

**Basi extra lunghe e piastre ganasce a cambio rapido!**  
Extra long bases and quick interchangeable jaw plate !

### 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 particulars 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 ganasce) 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 intercambiabili 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.



### Portapiastre / The Rack

Completo di piastre ganasce a cambio rapido a gradino Art.230E

Complete of quick change step jaw plates Art.230E

Vedi Pag. 4.21 - See Page.4.22

**PIASTRE GANASCE DISCENDENTI INTERCAMBIABILI MANUALMENTE**  
PULL DOWN JAW PLATES INTERCHANGEABLE BY HAND



Art. 230B

Dolce  
Soft



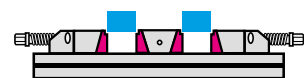
Art. 230C

Liscia  
Smooth



Art. 230D

Zigrinata  
Serrated



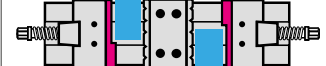
Art. 230E

Con gradino  
With step



Art. 230F

Prismatica  
Prismatic



Art. 230G

Con arresto a 90°  
With 90° stop



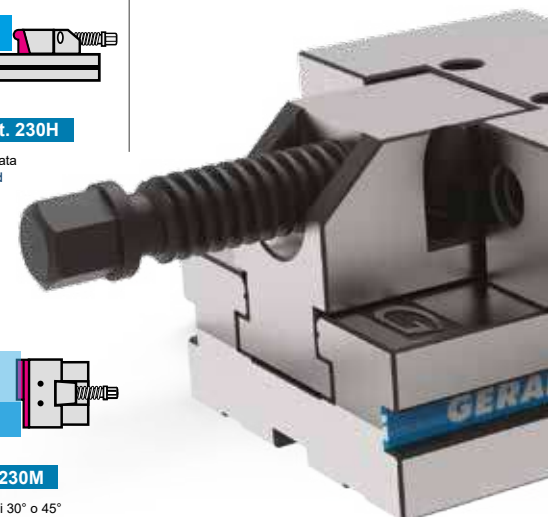
Art. 230H

Bombata  
Round



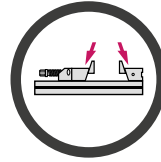
Art. 230M

Angolo di 30° o 45°  
30° or 45° angle



La morsa Gerardi XL come le sorelle più corte StandardFLEX, possono essere dotate di piastre ganasce a cambio rapido permettendo in questo modo oltre la lavorazione di un numero maggiore di pezzi sfruttando al massimo la lunghezza della tavola della macchina utensile anche la sostituzione rapida delle piastre ganasce che avviene manualmente e senza l'ausilio di alcun utensile, questo è possibile grazie al sistema Perno-molla, che consente un diverso utilizzo della morsa in tempi ridottissimi. Grazie al sistema a Pettine di rigatura prismatica delle piastre ganascia, risulta migliorato anche l'effetto discendente che durante la fase di serraggio, trascina il pezzo contro lo slittone garantendo anche una notevolissima precisione di riposizionamento.

The Gerardi XL vises as the StandardFLEX series, can be equipped with the pull down jaw plates allowing to machine more workpieces using the total length of the machine tool and the quickest jaw plate hand substitution without any tool. This is possible thanks to the new design with pin with spring which increases the standard vise versatility while the prismatic grooves allow a perfect repositioning accuracy (within microns !!).



SCAN IT TO WATCH THE



VIDEO PRESENTATION



*Dotata del geniale sistema a pettine per sostituire rapidamente la piastra ganascia discendente*

*Innovative Comb system for quick pull-down jaw plate change*



**Riconfigurazione Rapidissima**  
Quickest Vise Resetting

grazie alla piastra ganascia intercambiabile manualmente tramite sistema a pettine

Thanks to the quick interchangeable jaw plate through ground comb system



**Altissima ripetibilità di posizionamento**  
Highest repositioning accuracy

**±0,005mm**

Veloce e preciso grazie alla forma rettificata del sistema a pettine

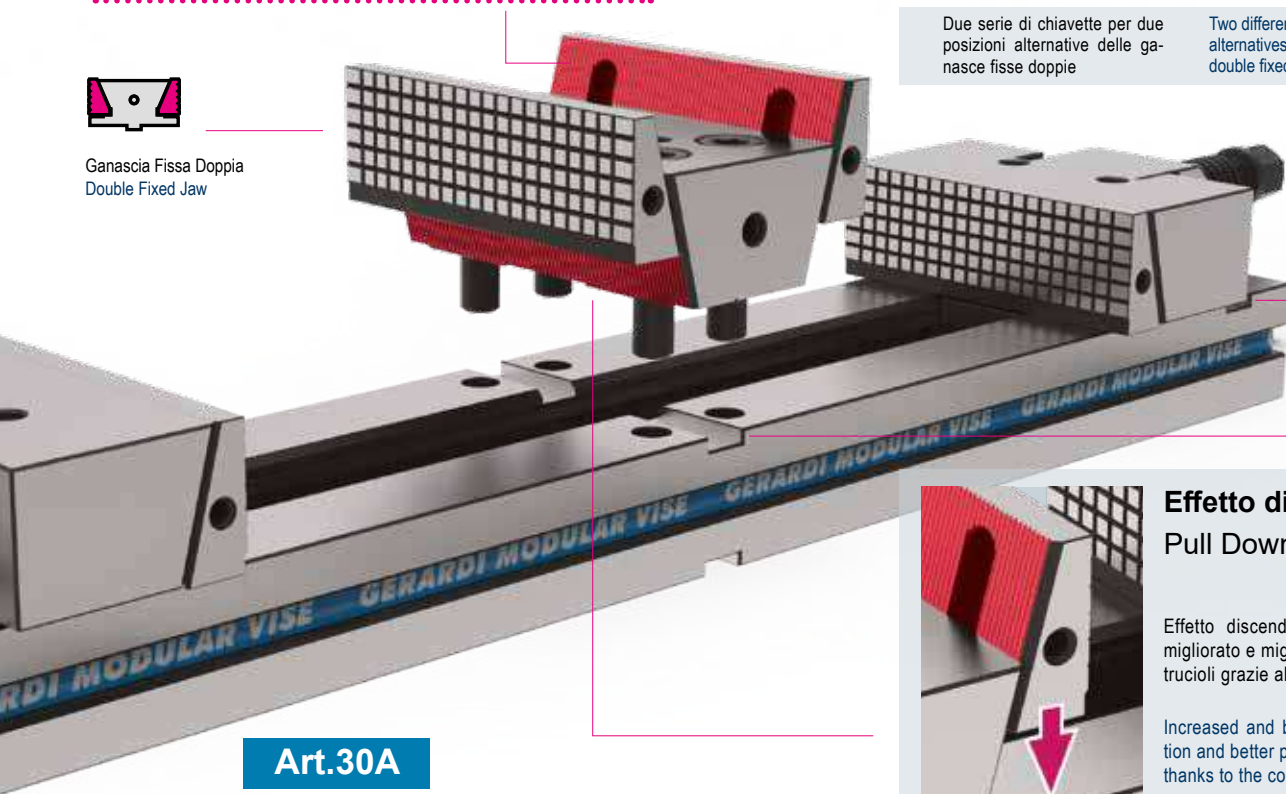
Quick and accurate jaw plate thanks the grid shape of the comb system

Due serie di chiavette per due posizioni alternative delle ganasce fisse doppie

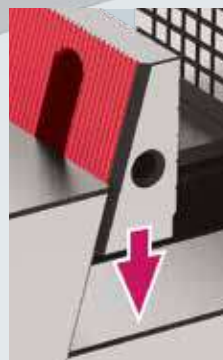
Two different keyways for two alternatives positions of the double fixed jaw



Ganascia Fissa Doppia  
Double Fixed Jaw



**Art.30A**



**Effetto discendente**  
Pull Down Action

Effetto discendente amplificato e migliorato e migliore protezione dai trucioli grazie al sistema a pettine

Increased and better pull down action and better protection from chips thanks to the comb system

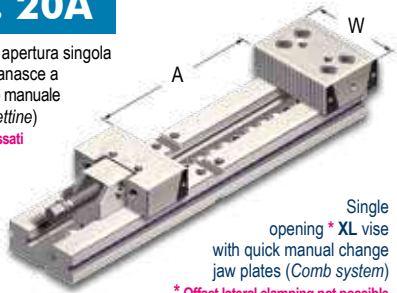
**2**

Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4	
		16 kN	25 kN	30 kN	30 kN	30 kN	30 kN	30 kN	30 kN
Apertura massima / Maximum spread	A	290	320	360	460	400	500	600	700
	W	96	121	146			171		
	B	28	38	48			58		
	C	35	40	50			58		
	D	460	520	580	680	666	766	866	966
	G	75	95	125			145		
	kg	6.8	12.9	25.5	29	37	42	47	52
	Cod.	2.20.A1290	2.20.A2320	2.20.A3360	2.20.A3460	2.20.A4400	2.20.A4500	2.20.A4600	2.20.A4700

**Art. 20A**

Morsa \*XL a apertura singola con piastre ganasce a cambio rapido manuale (Sistema a pettine)

\* Serraggi disassati lateralmente non possibili



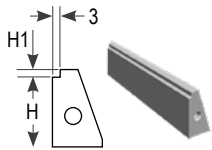
Single opening \*XL vise with quick manual change jaw plates (Comb system)

\* Offset lateral clamping not possible

**AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !**
**Art. 230E**

Piastra ganasce intercambiabile Interchangeable jaw plate

Vedi pagina 4.21 per altezze disponibili See page 4.21 for available height



	Cod.	4.23.0E101	4.23.0E201	4.23.0E301	4.23.0E401
H		23	33	43	53
H1		5	5	5	5

**Art. 212**

Ganasce mobile intermedia (da usare con Art. 230E)

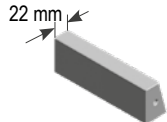
Intermediate movable jaw (to be used with Art. 230E)



	Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000

**Art. 230B**

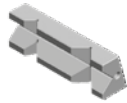
Piastra ganasce intercambiabile dolce Soft interchangeable jaw plate



	Cod.	4.23.0B101	4.23.0B201	4.23.0B301	4.23.0B401

**Art. 230F**

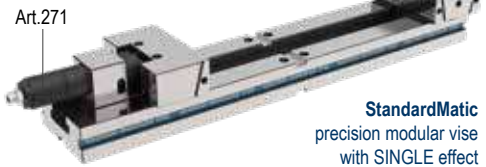
Piastra ganasce intercambiabile prismatica Prismatic interchangeable jaw plate



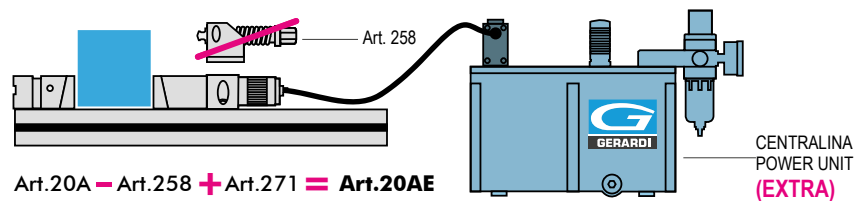
	Cod.	4.23.0F101	4.23.0F201	4.23.0F301	4.23.0F401

**Art.20AE**
**NEW 2024**

Morsa modulare StandardMatic con cilindro idraulico a SINGOLO effetto

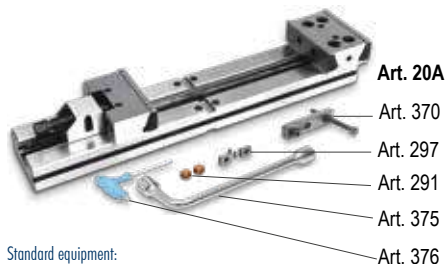


StandardMatic precision modular vise with SINGLE effect hydraulic cylinder

**MORSE StandardMatic**


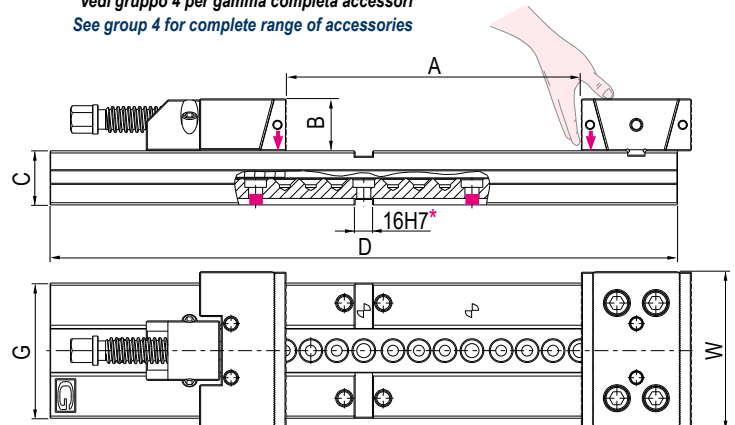
Dotazione standard:

- 1 arresto laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 2 tappi Art. 291 ■ 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
Extra per ogni chiave (tolleranza H7)



Standard equipment:

- 1 workshop Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 2 inserts Art. 291 ■ 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
Extra charge for each calibrated key nut (F7 tolerance)

 Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories

 \* Versione normale: Cava da 16H7 e fori calibrati Ø8F7 (t.1) - Ø16F7 (t. 2-3-4-5-6)  
\* Normal version: 16H7 slot and calibrated holes Ø8F7 (t.1) - Ø16F7 (t. 2-3-4-5-6)

	5 40 kN					6 40 kN						
	A	500	600	700	800	900	500	600	700	800	900	1000
W	196					296						
B	63					78						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	64	69	74	79	84	95	105	115	125	135	145	155
Cod.	2.20.A5500	2.20.A5600	2.20.A5700	2.20.A5800	2.20.A5900	2.20.A6500	2.20.A6600	2.20.A6700	2.20.A6800	2.20.A6900	2.20.A6100	2.20.A6110

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

4.23.0E501

**Art. 230E**

H	53
H1	10



4.23.0E601

H	68
H1	10

1.21.25000

**Art. 212**



1.21.26000

4.23.0B501

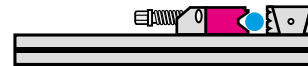
**Art. 230B**



4.23.0B601

4.23.0F501

**Art. 230F**



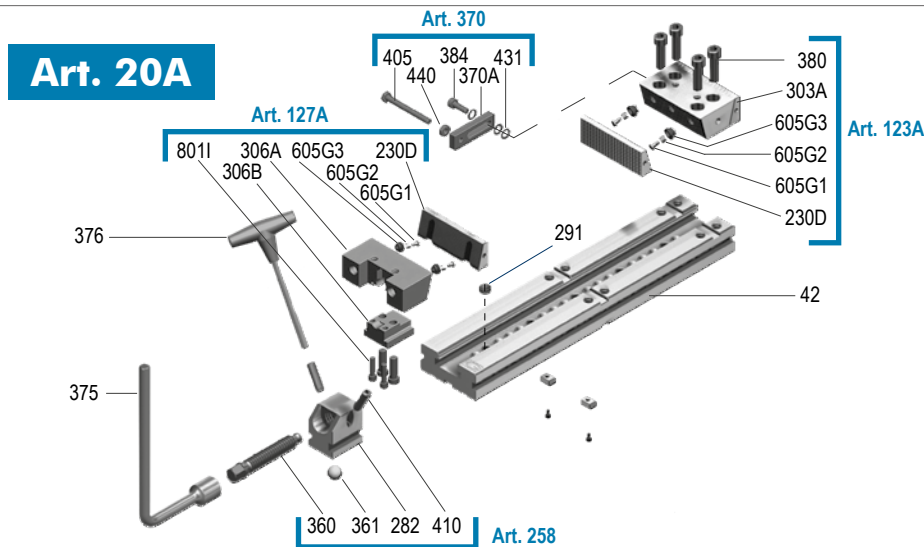
4.23.0F601

Cod. Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41

**StandardMatic VISES**



**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)



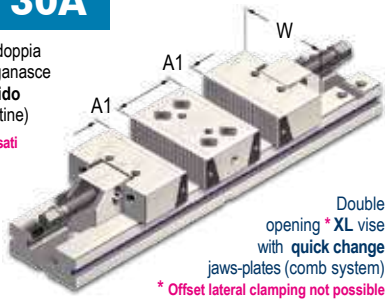
Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>376</b>	4.35
<b>230D</b>	4.21	<b>380</b>	4.28
<b>282</b>	4.36	<b>384</b>	4.28
<b>291</b>	4.35	<b>405</b>	4.35
<b>297</b>	4.34	<b>410</b>	4.36
<b>303A</b>	4.30	<b>431</b>	4.28
<b>306A</b>	4.30	<b>440</b>	4.28
<b>306B</b>	4.30	<b>605G1</b>	4.22
<b>360</b>	4.36	<b>605G2</b>	4.22
<b>361</b>	4.36	<b>605G3</b>	4.22
<b>370A</b>	4.35	<b>801I</b>	5.61
<b>375</b>	4.35	-	-

Tipo (grandezza) morsa / Vise type (size)	kN	1		2		3		4	
		16 kN	25 kN	30 kN	30 kN	30 kN	30 kN	30 kN	
Apertura massima / Maximum spread	A1	2 x 90	2 x 100	2 x 110	2 x 160	2 x 120	2 x 170	2 x 220	2 x 270
	W	96	121	146			171		
	B	28	38	48			58		
	C	35	40	50			58		
	D	460	520	580	680	666	766	866	966
	G	75	95	125			145		
	kg	6.8	12.9	25.5	29	37	42	47	52
	Cod.	2.30.A1900	2.30.A2100	2.30.A3110	2.30.A3160	2.30.A4120	2.30.A4170	2.30.A4220	2.30.A4270

### Art. 30A

Morsa \*XL a doppia apertura con ganasce a cambio rapido (sistema a pettine)

\* Serraggi disassati lateralmente non possibili

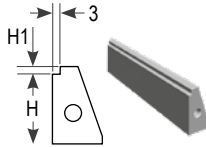


## AMPLIA LE TUE APPLICAZIONI TRAMITE GLI ACCESSORI MODULARI !

### Art. 230E

Piastra ganascia intercambiabile  
Interchangeable jaw plate

Vedi pagina 4.21 per altezze disponibili  
See page 4.21 for available height



Cod.	4.23.0E101	4.23.0E201	4.23.0E301	4.23.0E401
H	23	33	43	53
H1	5	5	5	5

### Art. 212

Ganascia mobile intermedia  
(da usare con Art. 230E)

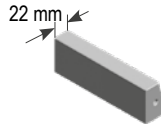
Intermediate movable jaw (to be used with Art. 230E)



Cod.	1.21.21000	1.21.22000	1.21.23000	1.21.24000
H				

### Art. 230B

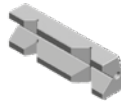
Piastra ganascia intercambiabile dolce  
Soft interchangeable jaw plate



Cod.	4.23.0B101	4.23.0B201	4.23.0B301	4.23.0B401
H				

### Art. 230F

Piastra ganascia intercambiabile prismatica  
Prismatic interchangeable jaw plate



Cod.	4.23.0F101	4.23.0F201	4.23.0F301	4.23.0F401
H				

### Art.30AE

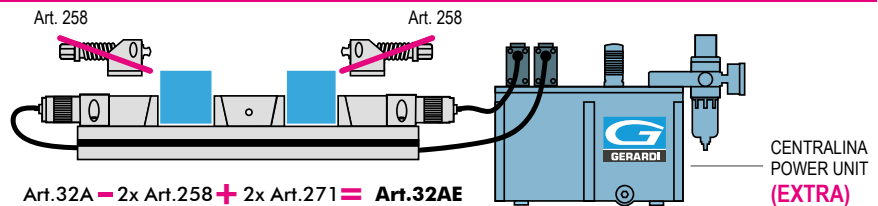
**NEW 2024**

Morsa modulare StandardMatic  
con cilindro idraulico a SINGOLO effetto



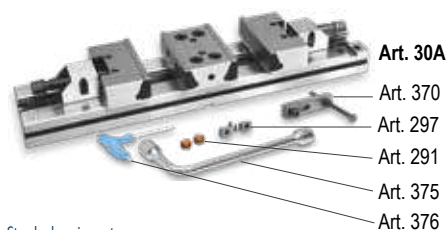
StandardMatic precision modular vise with SINGLE effect hydraulic cylinder

### MORSE StandardMatic



Dotazione standard:

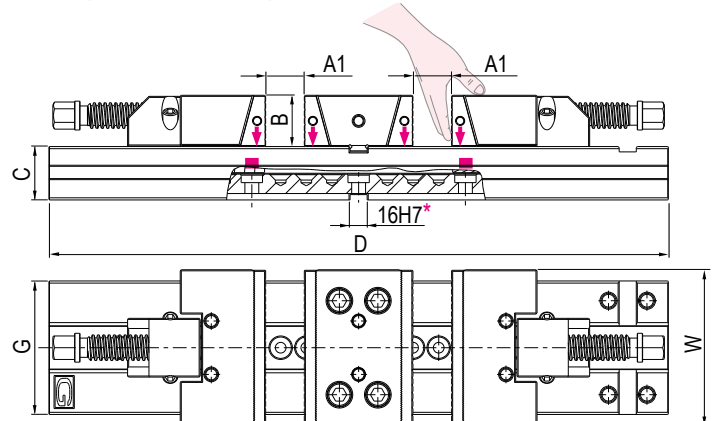
- 1 arresto laterale Art. 370
  - 1 coppia di tasselli di posizionamento per cava da 16 mm Art. 297
  - 2 tappi Art. 291 ■ 1 chiave a pipa Art. 375 ■ 1 chiave a "T" Art. 376
- Extra per ogni foro calibrato (tolleranza F7)  
Extra per ogni chiave (tolleranza H7)



Standard equipment:

- 1 workstop Art. 370
  - 1 pair of positioning key-nuts for 16 mm slot Art. 297
  - 2 inserts Art. 291 ■ 1 box wrench Art. 375 ■ 1 T-wrench Art. 376
- Extra charge for each calibrated hole (F7 tolerance)  
Extra charge for each calibrated key nut (F7 tolerance)

Vedi gruppo 4 per gamma completa accessori  
See group 4 for complete range of accessories



\* Versione normale: Cava da 16H7 e fori calibrati Ø8F7 (t.1) - Ø16F7 (t.2-3-4-5-6)  
\* Normal version: 16H7 slot and calibrated holes Ø8F7 (t.1) - Ø16F7 (t.2-3-4-5-6)

	5 40 kN					6 40 kN						
A1	2 x 150	2 x 200	2 x 250	2 x 300	2 x 350	2 x 160	2 x 210	2 x 260	2 x 310	2 x 360	2 x 410	2 x 460
W	196					296						
B	63					78						
C	70					78						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
G	170					195						
kg	64	69	74	79	84	95	105	115	125	135	145	155
Cod.	2.30.A5150	2.30.A5200	2.30.A5250	2.30.A5300	2.30.A5350	2.30.A6160	2.30.A6210	2.30.A6260	2.30.A6310	2.30.A6360	2.30.A6410	2.30.A6460

**UPGRADE YOUR VISE APPLICATIONS THROUGH MODULAR ACCESSORIES !**

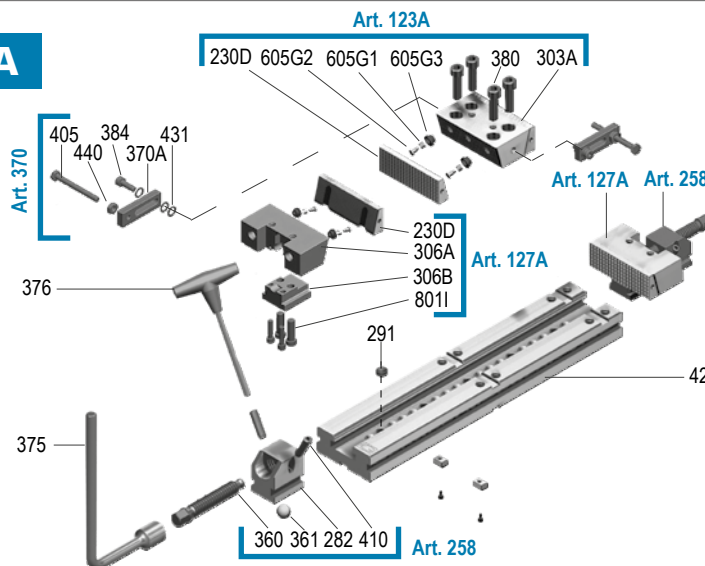
4.23.0E501		4.23.0E601	
<b>Art. 230E</b>			
H	53		68
H1	10		10
1.21.25000		1.21.26000	
<b>Art. 212</b>			
4.23.0B501		4.23.0B601	
<b>Art. 230B</b>			
4.23.0F501		4.23.0F601	
<b>Art. 230F</b>			
Cod.	Vedi pag. 4.40 - 4.41 - See pag. 4.40 - 4.41		

**StandardMatic VISES**



**Centralina Pneumoidraulica Art.393/394/395 (EXTRA)**  
Pneumohydraulic Power Unit Art.393/394/395 (EXTRA)

**Art. 30A**



Art.	Pag.	Art.	Pag.
<b>42</b>	2.32	<b>376</b>	4.35
<b>230D</b>	4.21	<b>380</b>	4.28
<b>282</b>	4.36	<b>384</b>	4.28
<b>291</b>	4.35	<b>405</b>	4.35
<b>297</b>	4.34	<b>410</b>	4.36
<b>303A</b>	4.30	<b>431</b>	4.28
<b>306A</b>	4.30	<b>440</b>	4.28
<b>306B</b>	4.30	<b>605G1</b>	4.22
<b>360</b>	4.36	<b>605G2</b>	4.22
<b>361</b>	4.36	<b>605G3</b>	4.22
<b>370A</b>	4.35	<b>801I</b>	5.61
<b>375</b>	4.35	-	-

**Tipo (grandezza) / Type (size)**
**Art. 42**

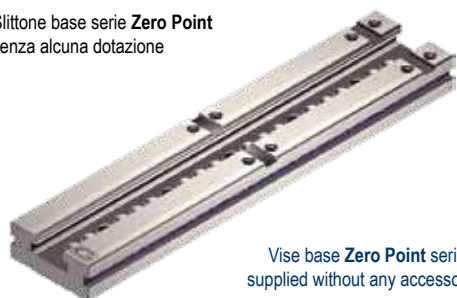
 Slittone base serie **XL**  
 senza alcuna dotazione

 Vise base **XL** series  
 supplied without any accessory

	1	2	3	4				
D	450	520	580	680	666	766	866	966
kg	6.6	10.7	20.7	24.7	30.2	34.8	39.3	43.8
Cod.	1.80.11460	1.80.21520	1.80.31580	1.80.31680	1.80.41666	1.80.41766	1.80.41866	1.80.41966

 Versione normale: Cave da 16 mm (H7)  
 Versione opzionale: Fori rettificati e calibrati con tolleranza F7  
 Extra per ogni foro calibrato (Tolleranza F7)

**Art. 42Z**

 Slittone base serie **Zero Point**  
 senza alcuna dotazione

 Vise base **Zero Point** series  
 supplied without any accessory

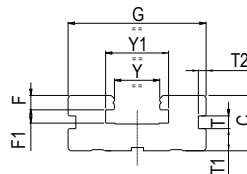
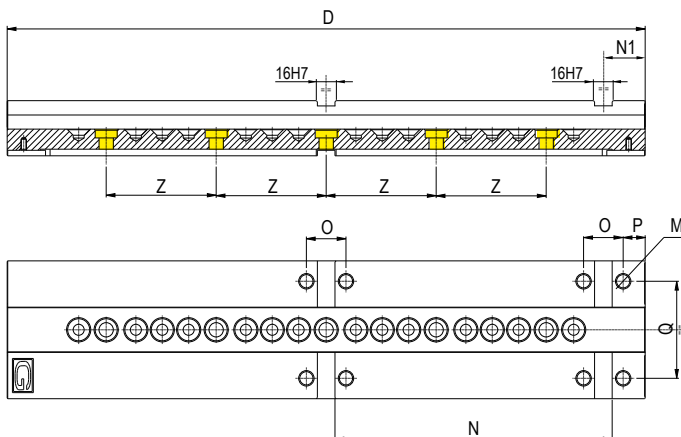
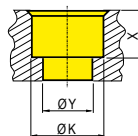
	1	2	3	4				
D	450	520	580	680	666	766	866	966
kg	6.4	10.5	20.5	24.5	29.9	34.5	39	43.5
Cod.	2.42.Z1460	2.42.Z2520	2.42.Z3580	2.42.Z3680	2.42.Z4666	2.42.Z4766	2.42.Z4866	2.42.Z4966

**Tolleranza / Tolerance**

- 0,02

C	35	40	50		38			
D	450	520	580	680	666	766	866	966
F	10	12	13				15	
F1	10	10	12				18	
G	75	95	125				145	
Y	21	28	41				51	
Y1	31	41	57				70	
M	M10	M12	M14				M16	
N	195	225	252	302	293	343	393	443
N1	35	35	38				40	
O	32	32	36				36	
P	19	19	20				22	
Q	50	62	88				100	
T	9,5	9,5	11,5				11,5	
T1	15	15	20				20	
T2	5	5	7				7	
Z	100	100	100				100	

**Art. 42**

 Slittone base serie **XL** / Vise base **XL** series

**Dettaglio foro per vite TCEI / TCEI screw hole details**


Type	1	2	3	4	5	6
X	4,5	5,5	8	8	17	17
ØY	6,5	8,5	13	13	17	17
ØK	10,5	13,5	19	19	26	26



	5					6						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300*	1400*	1500*
kg	64	69	74	79	84	95	105	115	125	135	145	155
Cod.	1.80.51805	1.80.51905	1.80.51005	1.80.51105	1.80.51205	1.80.61900	1.80.61000	1.80.61100	1.80.61200	1.80.61300	1.80.61400	1.80.61500

Normal version: 16 mm slots (H7)  
 Optional version: Ground calibrated holes F7 tolerance  
 Extra for each calibrated hole (F7 tolerance)

\* Base composta da 2 pezzi uniti  
 Base made of 2 spliced pieces

D	805	905	1005	1105	1205	900	1000	1100	1200	*1300	*1400	*1500
kg	60	65	70	75	80	91	101	111	121	131	141	151
Cod.	2.42.Z5805	2.42.Z5905	2.42.Z5005	2.42.Z5105	2.42.Z5205	2.42.Z6900	2.42.Z6100	2.42.Z6110	2.42.Z6120	2.42.Z6130	2.42.Z6140	2.42.Z6150

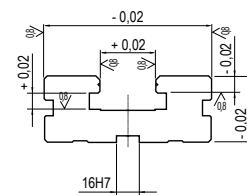
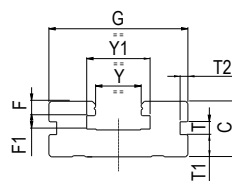
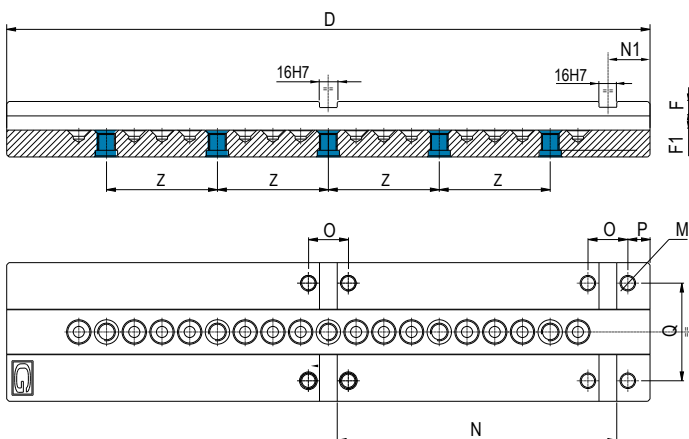
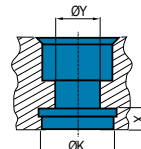
\* Base composta da 2 pezzi uniti  
 Base made of 2 spliced pieces

C	70					58						
D	805	905	1005	1105	1205	900	1000	1100	1200	1300	1400	1500
F	20					20						
F1	18					18						
G	170					195						
Y	61					71						
Y1	80					90						
M	M20					M20						
N	357,5	407,5	457,5	507,5	557,5	405	455	505	555	605	655	707
N1	45					45						
O	44					44						
P	23					23						
Q	120					133						
T	17,5					17,5						
T1	26					26						
T2	10					10						
Z	100					100						

**Art. 42Z**

Slittone base serie Zero Point / Vise base Zero Point series

Tolleranze generiche per morse XL / XL vise generic tolerances




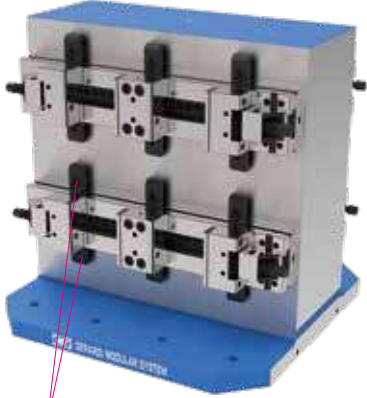

**Dettaglio foro per Zero Point / Zero Point hole details**


Type	1	2	3	4	5	6
X	6					
Y	M16	M16	M16	M16	M16	M16
ØK	20					

## PREDISPOSIZIONE e MONTAGGIO MORSE su SPALLE LAVORATE

### TOMBSTONES SET-UP and VISES MOUNTING on 2 SIDE MACHINED TOMBSTONES

2





<b>Spalla lavorata Art.55C</b> 2 sides machined tombstone Art.55C	<b>Tipo di morsa</b> Vise type	<b>Predisposizione e montaggio*</b> Set-up & Mounting*	<b>Cubo con morse</b> Cube with vises
<p>Cod. 8.55.C00191 Dim. A=800 / B=800 / C=300 / H=800</p> 	<p>Art.35 Tipo 4 2x170</p>  <p>n°morse Vises n° <b>x 4</b></p>	<p>Per morsa / each vise</p>  <p>Importo per lavorazioni necessarie per predisporre ogni faccia del cubo e montaggio più allineamento di ogni morsa. Amount needed for the set-up of each side and mounting + alignment of each vise on it.</p>	 <p>Art.296</p>

\* Predisposizione 4 facce, montaggio ed allineamento morse incluso di viti, chiavette, staffe e quant'altro necessario.  
4 Faces set-up, vises mounting including screws, keyways, holding clamps and all the necessary equipment.

Certificato di collaudo  
Certificate test

## MONTAGGIO e ALLINEAMENTO MORSE su SPALLE a RETICOLO

### ALIGNEMENT and VISES MOUNTING on 2 SIDE GRID TOMBSTONES

<b>Spalla a reticolo Art.55F</b> 2 sides grinded tombstone Art.55F	<b>Tipo di morsa</b> Vise type	<b>Montaggio e allineamento*</b> Mounting & alignment*	<b>Cubo con morse</b> Cube with vises
<p>Cod. 8.55.F00191 Dim. A=800 / B=800 / C=300 / H=800</p> 	<p>Art.35 Tipo 4 2x170</p>  <p>n°morse Vises n° <b>x 6</b></p>	<p>Per morsa / each vise</p>  <p>Importo per montaggio ed allineamento di ogni morsa. Amount need for each vise mounting and alignment.</p>	 <p>Art.83</p>

\* Montaggio e allineamento 4 morse incluso di viti, chiavette, staffe e quant'altro necessario.  
4 vises mounting and alignment includes screws, keyways, holding clamps and all the necessary equipment.

Certificato di collaudo  
Certificate test

# Diagrammi di serraggio / Clamping diagrams

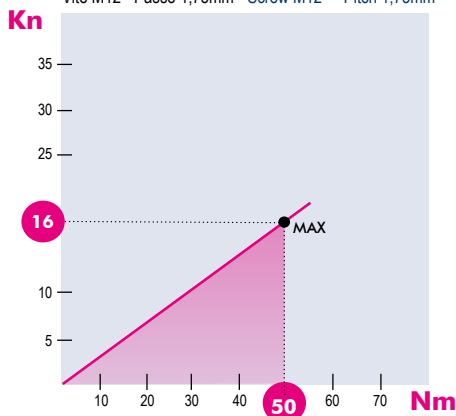
## XL extra long bases

### 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

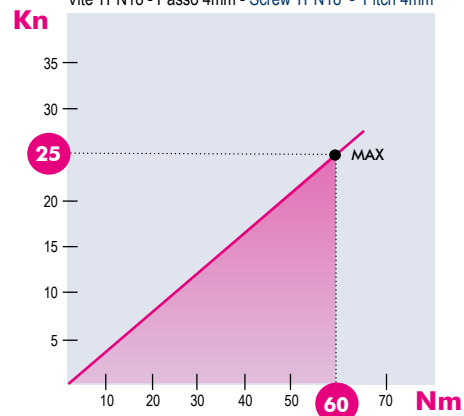


Art. 357

#### Morse tipo Vises type

**2**

Vite TPN18 - Passo 4mm - Screw TPN18 - Pitch 4mm



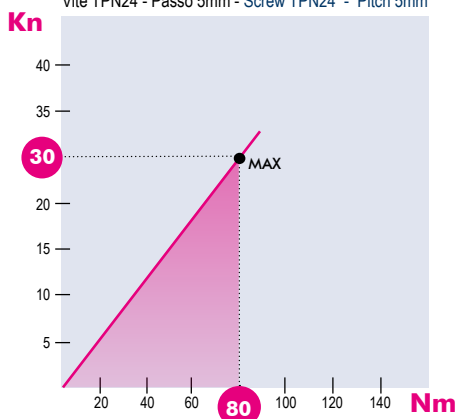
### Gruppi di serraggio meccanici (Art. 258 e similari) / Mechanical clamping devices (Art. 258 and similar)

 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

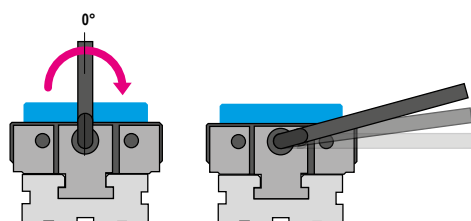
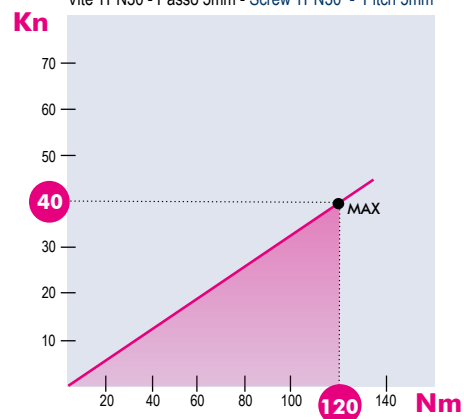


Art. 357

#### 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 ganaschia 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

## ALIGNMENT BETWEEN THE CROSS KEYWAY AND THE FIXED JAW PLATE

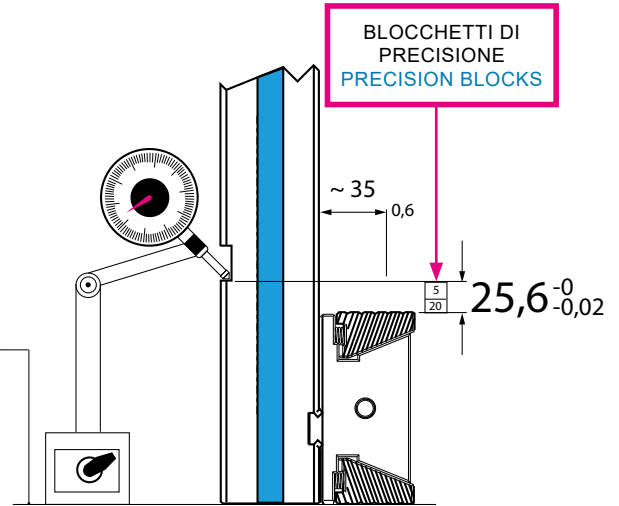
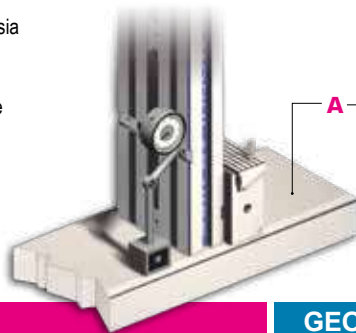
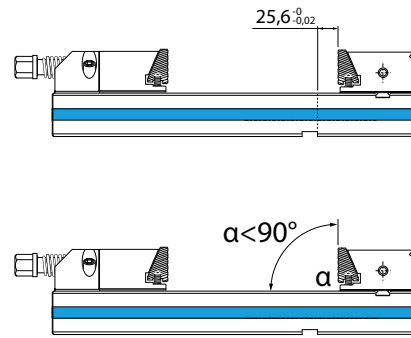
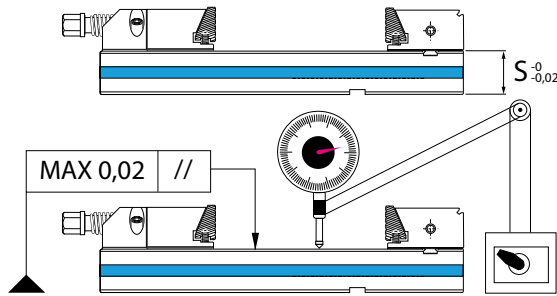
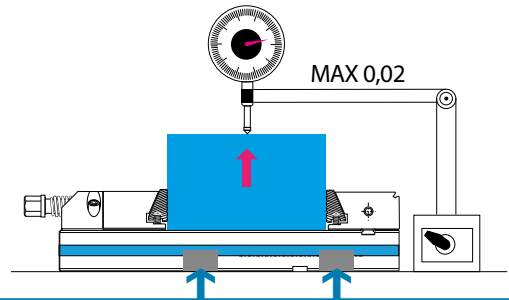
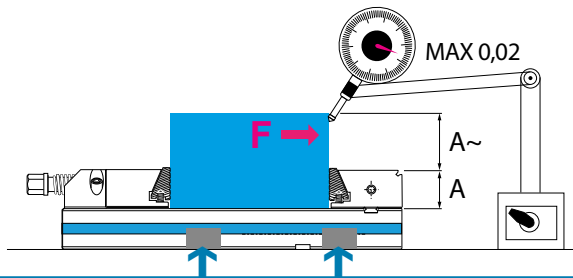
2


**Libretto Istruzioni / Instruction Book**

Scansiona il QR code e scarica le istruzioni complete

Scan the QR code to download the complete instructions

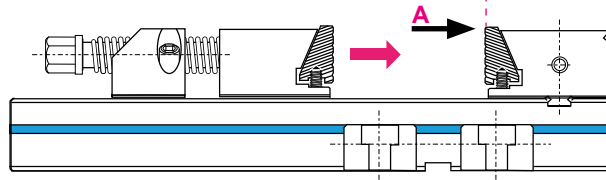
 Posizionare la morsa verticalmente assicurandosi che sia perfettamente parallela al piano di appoggio **A** nei due sensi. Successivamente, con un comparatore centesimale, controllare il parallelismo del piano cava e della ganascia fissa.

 Set the vise vertically ensuring that it is perfectly 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**

$$1 \text{ kgf} \cdot \text{m} = 9.806 \text{ Nm}$$



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

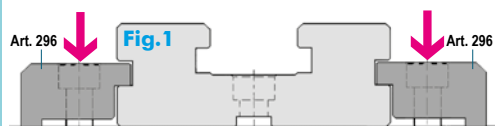
Il sistema consigliato per l'ancoraggio della morsa sulla tavola macchina è tramite STAFFE Art.296. (Fig.1)

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)

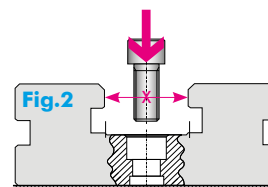
Nella tabella seguente sono riportati i valori di coppia massima applicabile mediante chiave dinamometrica

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