

TWIN VISES

Range of products



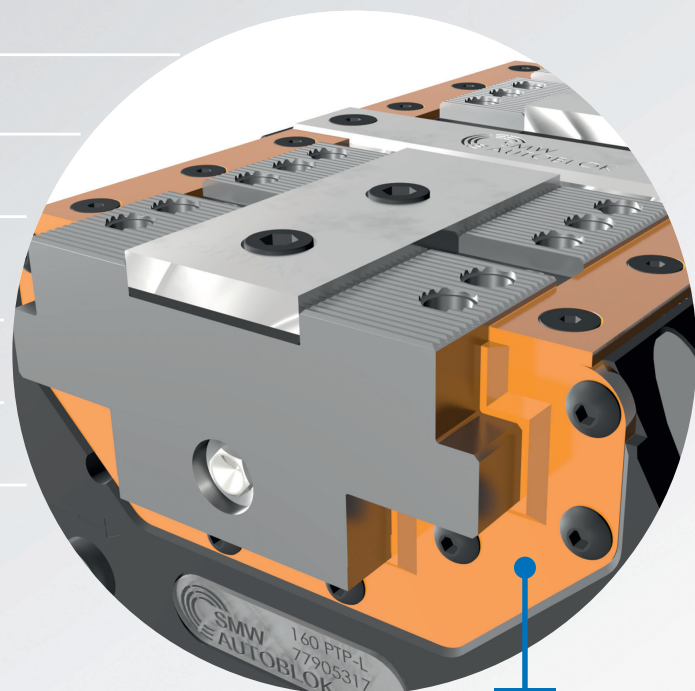
Industry 4.0
Product



1 PT - PROTECTED TWIN VISES

SIZES AVAILABLE 100-125-160-200-250

- ▶ Pneumatic and Hydraulic Version
- ▶ Pneumatic Valve (optional)
- ▶ Air Sensing
- ▶ Master jaws guide protected against swarf and chips **1.1**
- ▶ Normal Stroke
- ▶ Long Stroke
- ▶ Fixed Jaw

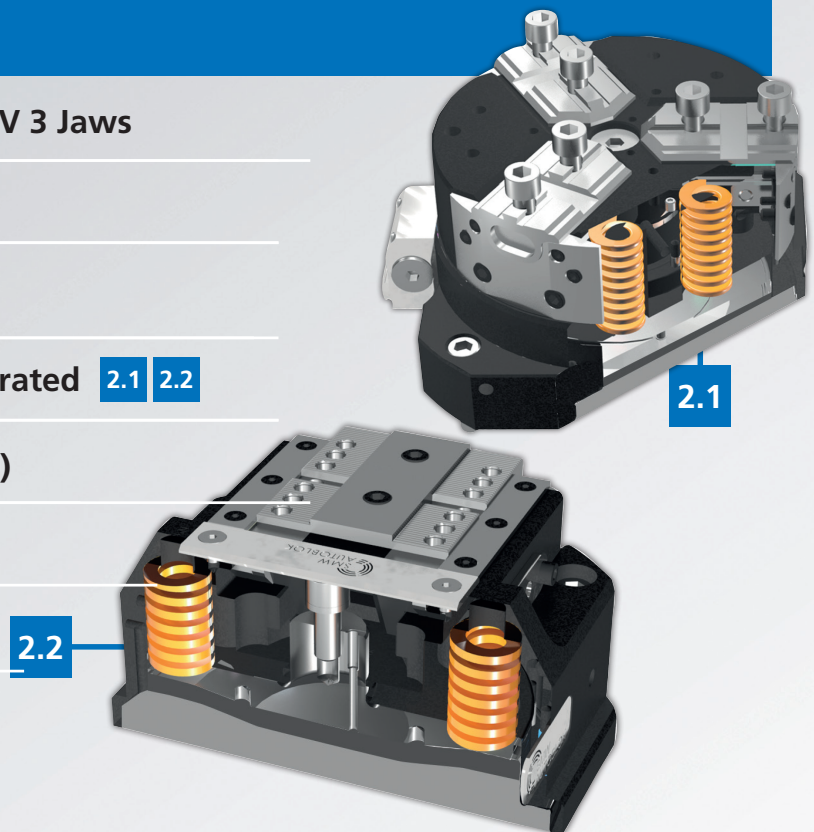


1.1

2 STV - SPRING AND AIR OPERATED TWIN VISES

SIZES AVAILABLE 180-225

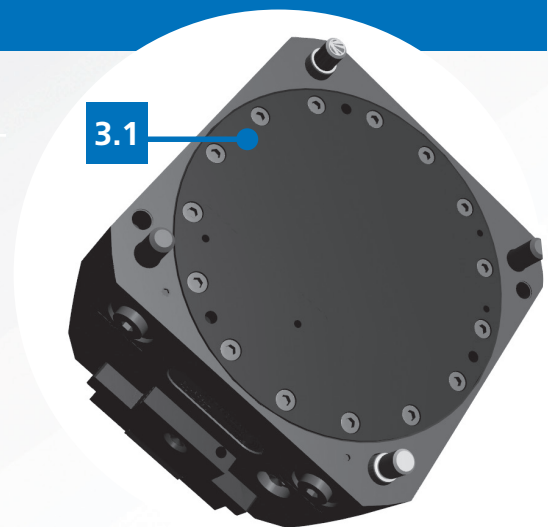
- ▶ STV 2 Jaws (also 125) and STV 3 Jaws
- ▶ Air Sensing
- ▶ Master jaws guide protected against swarf and chips
- ▶ Spring Clamped and Air Operated **2.1** **2.2**
- ▶ Safety Valve SAB-1 (optional)
- ▶ Pneumatic Valve (optional)
- ▶ Normal stroke **2.2**
- ▶ Long stroke



3 TV - STANDARD TWIN VISES

SIZES AVAILABLE 100-160-200-250-315

- ▶ Pneumatic and Hydraulic Version
- ▶ Air Sensing **3.1**
- ▶ Stroke control Proximity (optional)
- ▶ Normal Stroke
- ▶ Long Stroke
- ▶ Fixed Jaw



4 RR - QUICK JAWS CHANGE

PROTECTED TWIN VISE with QUICK CHANGE

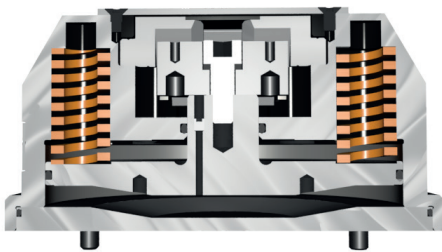
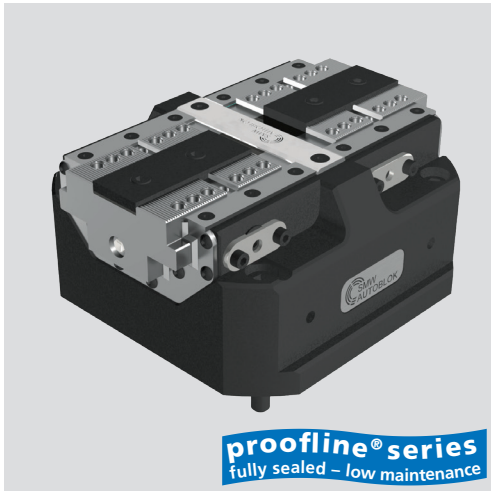
- ▶ Pneumatic and Hydraulic Version
- ▶ Long stroke
- ▶ OD and ID Clamping

STV-2N / STV-2L

Spring and air operated Twin Vise

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

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



Application/customer benefits

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

Technical features

- Spring to clamp, pneumatic open
- Protected **1**
- Increase of the clamping force via Turbo function
- Housing and functional parts hardened for high precision and long life
- Ready for air purge
- Master jaws with both tongue & groove and fine serration 1.5 mm x 60°
- OD clamping only
- Safety valve SAB-1 **2** to maintain air pressure during pallet transportation / storage and machining without feed (optional)
- Pneumatic open / close control (stroke control) master jaws valve (optional)
- Lubrication with SMW-AUTOBLOK K67 grease
- Stroke control via proximity switches (optional)
- Air sensing

Standard equipment

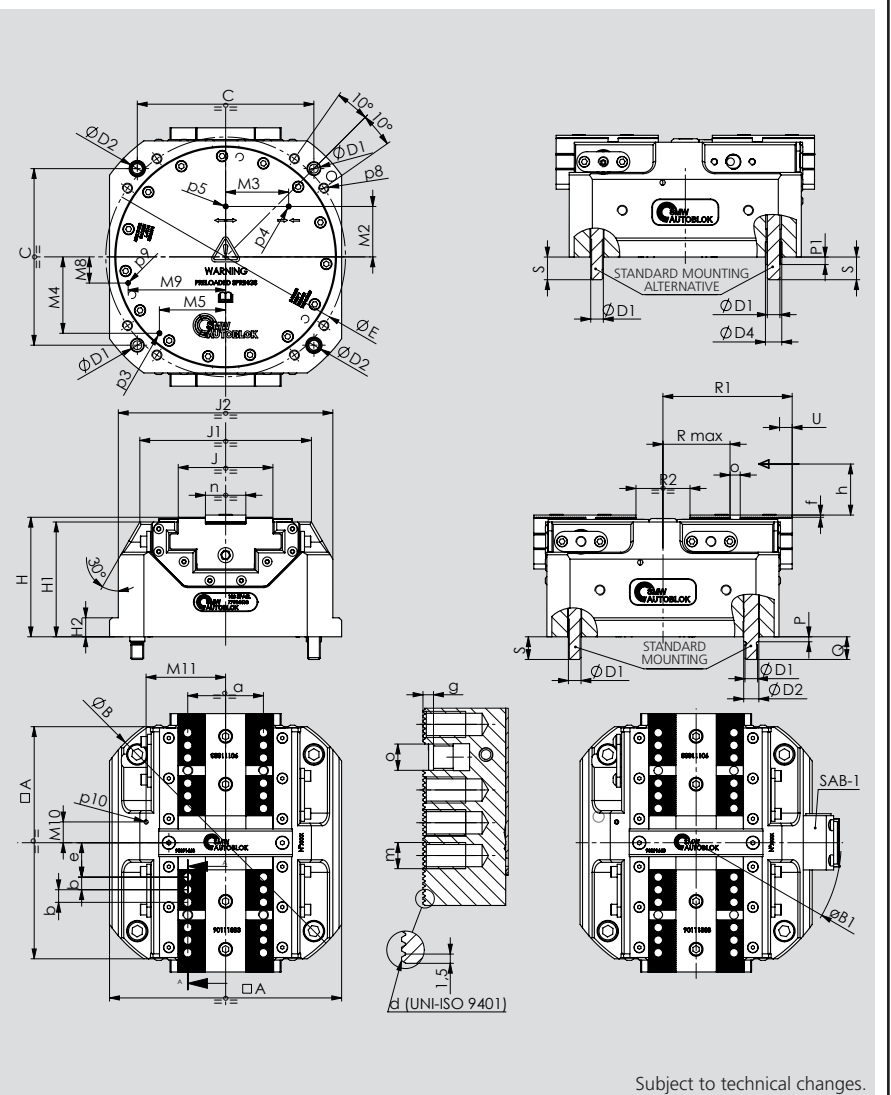
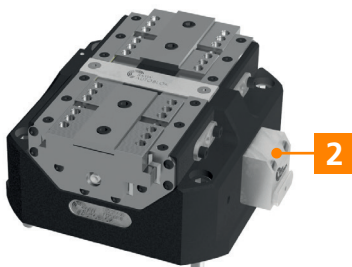
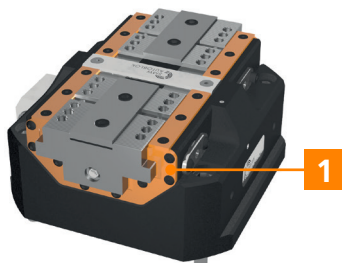
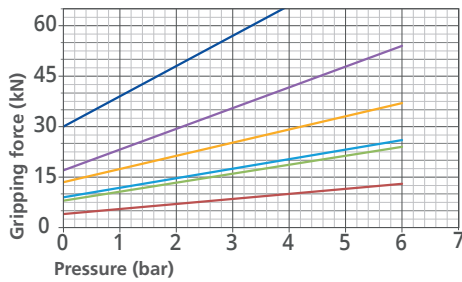
Self-centering vise without top jaws
All bolts and centering bushings included

ROTATION USE

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

Gripping force diagrams

STV-2N ■ 225 ■ 180 ■ 125
STV-2L ■ 225 ■ 180 ■ 125



Subject to technical changes.

STV-2N / STV-2L

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

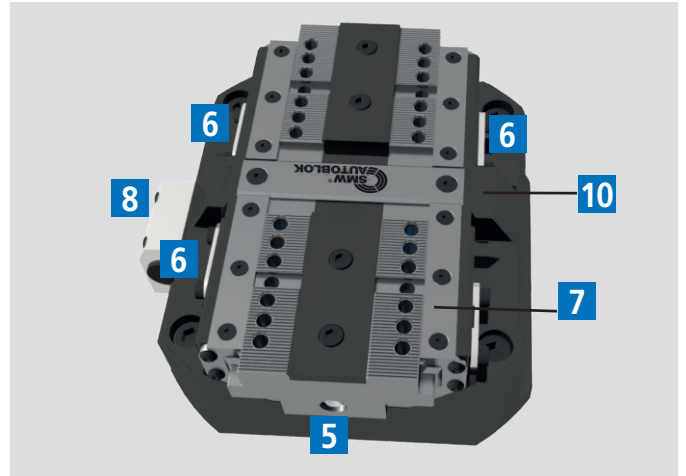
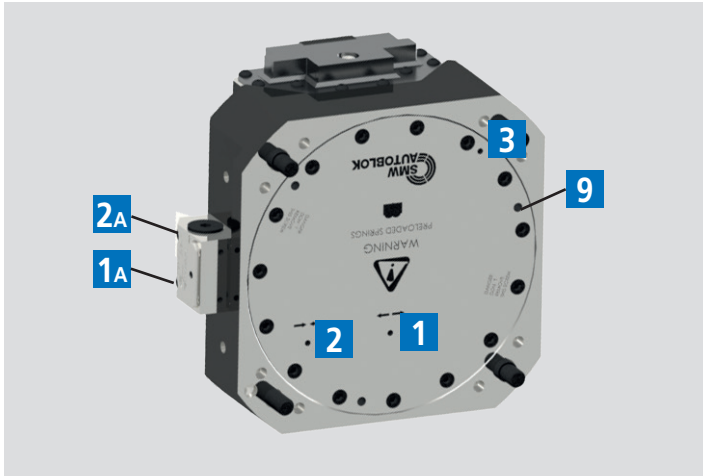
- 2 jaws
- STV-2N: Normal stroke
- STV-2L: Long stroke

SPRING AND AIR OPERATED SPRING VISE

Type	Id. No.	Type stroke	Max. Clamping force middle stroke [kN]		Piston area [cm]	Re-opening pressure [bar]	Operating pressure max. [bar]	Min. / max. Operating pressure [bar]	Repeatability [mm]	Weight [kg]
			Only springs	Springs + Turbo						
125 STV-2N	77904312	NORMAL	9	26	78	5	6	-	0.01	7
125 STV-2L	77904412	LONG	4	13						
180 STV-2N	77904318	NORMAL	17	54	170	5	6	-	0.01	17.5
180 STV-2L	77904418	LONG	8	24						
225 STV-2N	77904322	NORMAL	30	66	250	6	4	-	0.02	28
225 STV-2L	77904422	LONG	13.5	37			6			
125 STV-2N + SAB-1	77904812*	NORMAL	-	-	-	-	-	3.5 / 6	-	-
125 STV-2L + SAB-1	77904912*	LONG	-	-	-	-	-	3.5 / 6	-	-
180 STV-2N + SAB-1	77904818*	NORMAL	-	-	-	-	-	3.5 / 6	-	-
180 STV-2L + SAB-1	77904918*	LONG	-	-	-	-	-	3.5 / 6	-	-
225 STV-2N + SAB-1	77904822*	NORMAL	-	-	-	-	-	3.5 / 4	-	-
225 STV-2L + SAB-1	77904922*	LONG	-	-	-	-	-	3.5 / 6	-	-

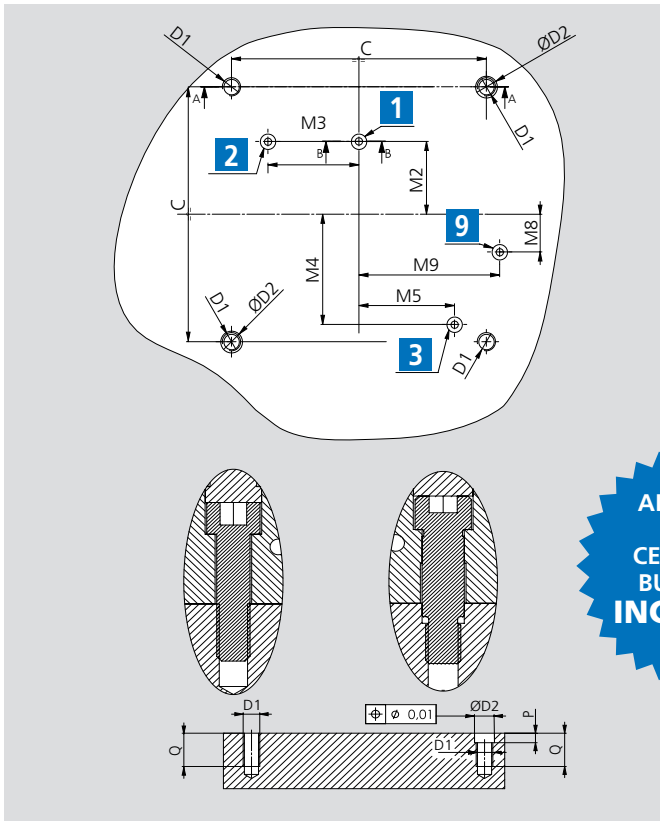
* Id. No. Twin Vise included the SAB-1. For example, 77904812 is composed by 125STV-2N Id. No. 77904312 plus SAB-1 Id. No. 27581810

STV-2			125	180	225
	A	mm	125	184	225
	B (Ø)	mm	162	225	284
SAB-1 valve overall dimension	B1 (Ø)	mm	186	230	276
	C	mm	100	140	180
	D1(Ø)	mm	M8	M10	M12
	D2 (Øf7)	mm	10	12	14
	D4 (Øjs7)	mm	11	13	16
	E (ø)	mm	136	190	240
	H	mm	80.5	94.7	102
	H1	mm	77	91	98
	H2	mm		15	15
	J	mm	47	75	94
	J1	mm	100	136	172
	J2	mm	125	170	216
	M2	mm	32	40	50
	M3	mm	29.5	50	65
	M4	mm	40.5	60.5	79
	M5	mm	38.5	52.5	63
	M8	mm	10.6	20.7	15
	M9	mm	54.5	77.3	99.9
	M10	mm	10.5	16.5	15
	M11	mm	46	63	81
	P	mm	4	4	5
	P1	mm	4	6	6
	Q	mm	15	18	20
Min. / max. (long stroke)	R max	mm	25.6 / 31.6	44.8 / 53.2	54.5 / 64.7
Min. / max. (normal stroke)	R max	mm	25.4 / 28	45 / 48	54.5 / 58.7
Min. / max. (long stroke)	R1	mm	64.5 / 70.5	94 / 102.4	114.5 / 124.7
Min. / max. (normal stroke)	R1	mm	64.4 / 67	94.5 / 97.5	114.8 / 119
Min. / max. (long stroke)	R2	mm	20 / 32	26 / 42.8	30 / 50.4
Min. / max. (normal stroke)	R2	mm	19.8 / 25	26 / 32	30.6 / 39
	S	mm	15	18	20
Long stroke	U	mm	6	8.4	10.2
Normal stroke	U	mm	2.6	3	4.2
	a	mm	35	60	80
	b	mm	7	10	10
Serration	d	mm	1.5 x 60°	1.5 x 60°	1.5 x 60°
Min. / max. (long stroke)	e	mm	14.6 / 20.6	18.8 / 27.2	28.5 / 38.7
Min. / max. (normal stroke)	e	mm	14.4 / 17	19 / 22	28.5 / 32.7
	f	mm	1.8	1.8	2
	g	mm	2.7	3.2	4
	h	mm	16	25	35
	m	mm	M6x10	M8x12	M8x12
	n (g6)	mm	20	32	40
	o (H7)	mm	6	8	8
Pneumatic open / close stroke control or air purge	p3	mm	M4	M4	M4
Vise closed	p4	mm	M4	M4	M4
Vise open	p5	mm	M4	M4	M4
	p8	mm	M6x12	M8x16	M10x18
	p9	mm	M4	M4	M4
	p10	mm	M4	M4	M4



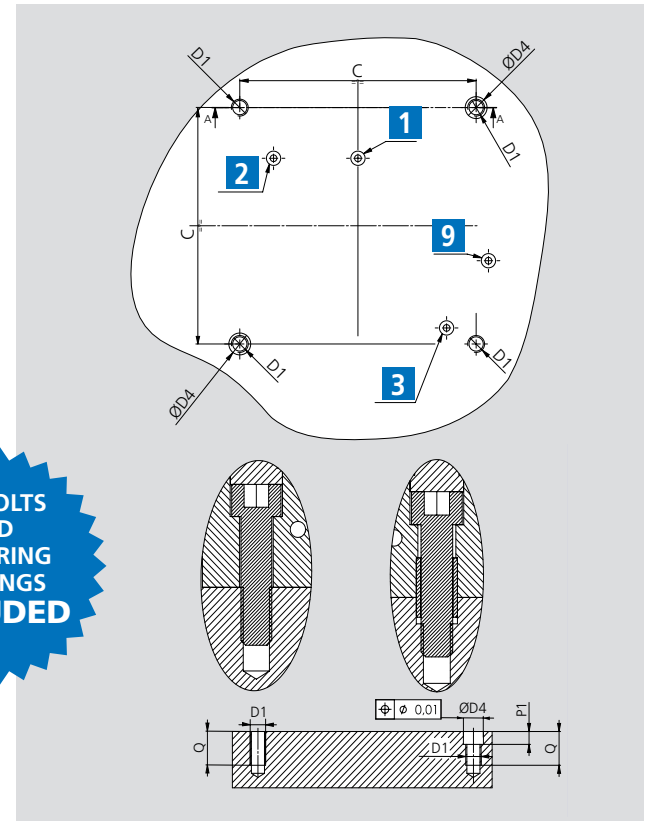
SOLUTION 1 STANDARD

± 0,03 mm to clamping center



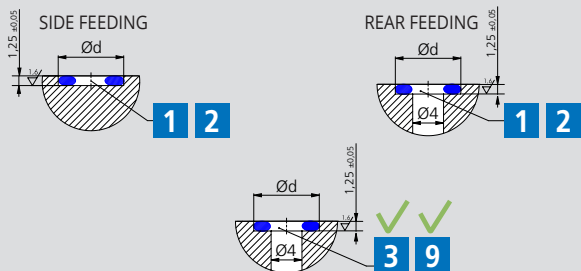
SOLUTION 2 STANDARD

± 0,025 mm to clamping center



ALL BOLTS AND CENTERING BUSHINGS INCLUDED

FEEDING SEATS: OBLIGATED EXECUTION



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

* The air purge can be used only without the valve.
** Points 9 and 10 only available on STV-2.

STV	C	D1	D2H7	D4H7	M2	M3	M4	M5	M8	M9	P	P1	Q	Ød	OR
125	100	M8	10	11	32	29.5	40.5	38.5	10.6	54.5	6	6	18	8	OR2018
180	140	M10	12	13	40	50	60.5	52.5	20.7	77.3	6	7	21	8.8	OR2021
225	180	M12	14	16	50	65	79	63	15	99.9	7	7	24	8.8	OR2021