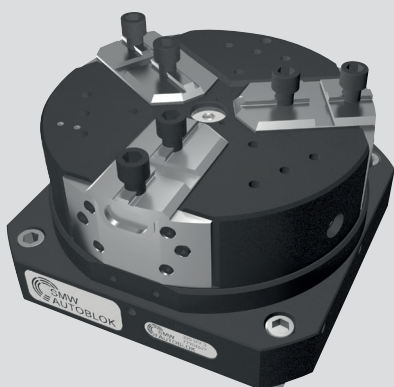


STV-3N / STV-3L

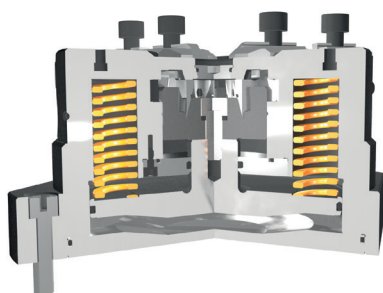
Spring and air operated Twin Vise

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

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



proofline® series
fully sealed – low maintenance



Application/customer benefits

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

Technical features

- Spring to clamp, pneumatic open
- **proofline®** = fully sealed - low maintenance **1**
- Increase of the clamping force via Turbo function
- Housing and functional parts hardened for high precision and long life
- Ready for air purge
- 3 jaw interfaces: Tongue & groove
- OD clamping only
- Safety valve SAB-1 **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

Standard equipment

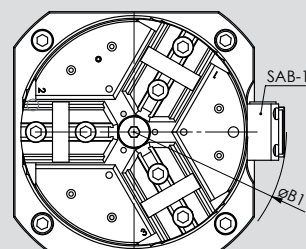
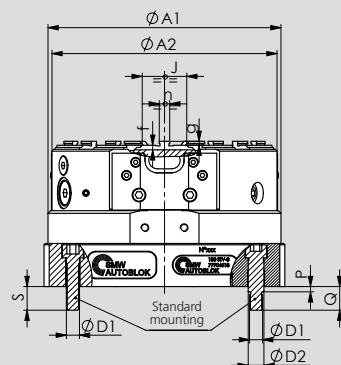
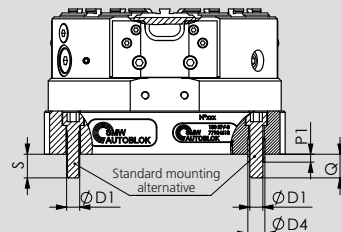
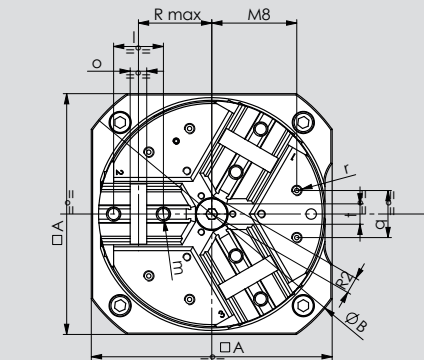
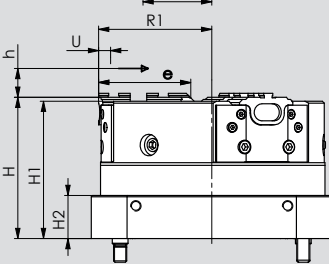
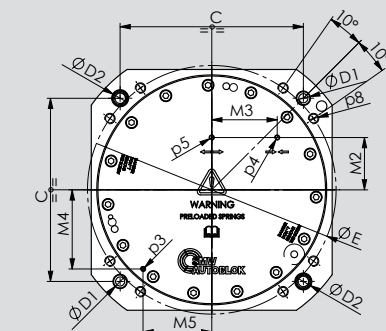
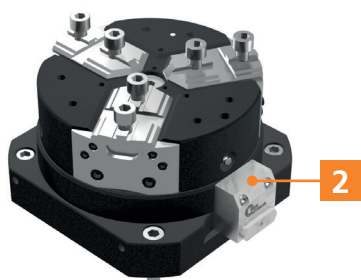
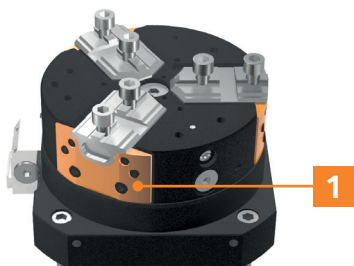
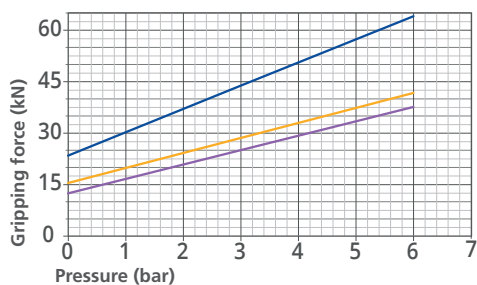
Self-centering vise without top jaws
All bolts and centering bushings included

ROTATION USE

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

Gripping force diagrams

STV-3N ■ 180 ■ 225
STV-3L ■ 225



Subject to technical changes.

STV-3N / STV-3L

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

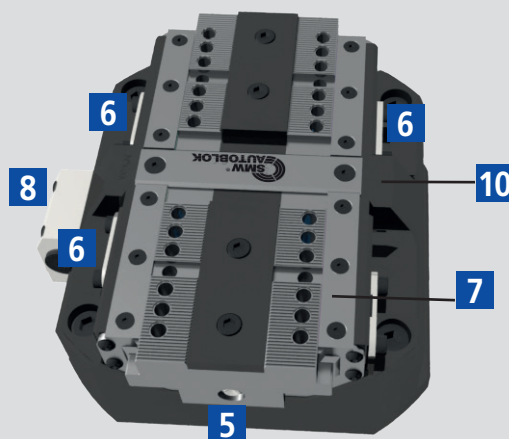
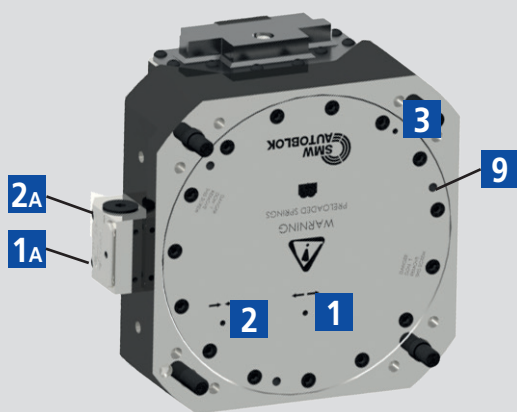
- 3 jaws
- STV-3N: Normal stroke
- STV-3L: Long stroke

Spring and air operated Twin Vise

Type	Id. No.	Stroke type	Max. clamping force middle stroke [kN]		Stroke / jaw [mm]	Piston area [cm²]	Re-opening pressure [bar]	Max. operating pressure [bar]	Min. / max. operating pressure [bar]	Weight [kg]
			Only springs	Springs + Turbo						
180 STV-3N	77904618	Normal	13	38	3.8	170	5	6	-	18
225 STV-3N	77904622	Normal	24	64	4.2	250	6	6	-	29.5
225 STV-3L	77904722	Long	16	42	8	250	6	6	-	29.5
180 STV-3N + SAB-1	77905018*	Normal	-	-	-	-	-	-	3.5 / 6	-
225 STV-3N + SAB-1	77905022*	Normal	-	-	-	-	-	-	3.5 / 6	-
225 STV-3L + SAB-1	77905122*	Long	-	-	-	-	-	-	3.5 / 6	-

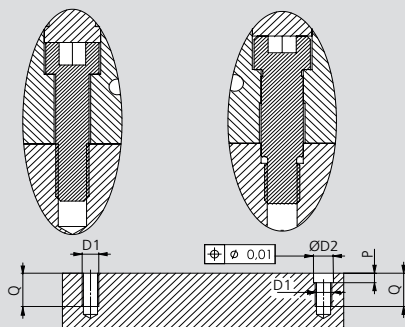
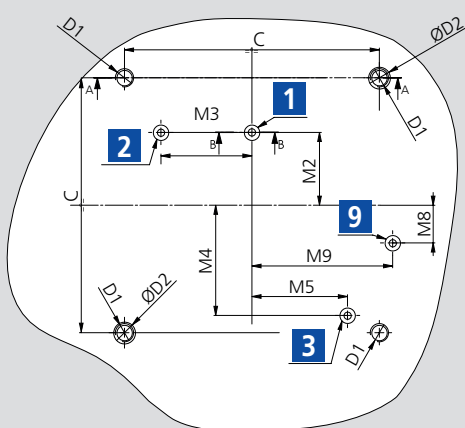
* Id. No. Twin Vise included the SAB-1. For example, 77905018 is composed by 180STV-3N Id. No. 77904618 plus SAB-1 Id. No. 27581810

SMW-AUTOBLOK Type STV-3			180	225
	A	mm	184	225
	A1	mm	178	222
	A2	mm	172	216
	B (Ø)	mm	225	284
SAB-1 valve overall dimension	B1 (Ø)	mm	233	276
	C	mm	140	180
	D1(Ø)	mm	M10	M12
	D2 (Øf7)	mm	12	14
	D4 (Øjs7)	mm	13	16
	E (ø)	mm	190	240
	H	mm	108	115
	H1	mm	105	112
	H2	mm	33	38
	J	mm	34	46
	M2	mm	40	50
	M3	mm	50	65
	M4	mm	60.5	79
	M5	mm	52.5	63
	M8	mm	65	80
	P	mm	4	5
	P1	mm	6	6
	Q	mm	18	20
Min. / max. (normal stroke)	R max	mm	52.2 / 56	67.8 / 72
Min. / max. (normal stroke)	R1	mm	82.7 / 86.5	103.8 / 108
Min. / max. (normal stroke)	R2	mm	8.7 / 12.5	12.8 / 17
Min. / max. (long stroke)	R max	mm	/	68 / 76
Min. / max. (long stroke)	R1	mm	/	104.5 / 112.5
Min. / max. (long stroke)	R2	mm	/	9 / 17
	S	mm	18	20
Normal stroke	U	mm	3,8	4.2
Long stroke	U	mm	/	8
	e	mm	70	87
	f	mm	3.5	3.5
	g	mm	3	3
	h	mm	25	35
	l	mm	38	44.4
	m	mm	M10x12	M12x14
	n (h8)	mm	7.94	7.94
	o (H7)	mm	12.68	12.68
Pneumatic open / close stroke control or air purge	p3	mm	M4	M4
Vise closed	p4	mm	M4	M4
Vise open	p5	mm	M4	M4
	p8	mm	M8x16	M10x18
	q	mm	36	45
	r	mm	M8x10	M8x10
Min. / max. (normal stroke)	t	mm	9 / 15.6	13.5 / 20.9
Min. / max. (long stroke)	t	mm	/	6.8 / 20.9



Solution 1 standard

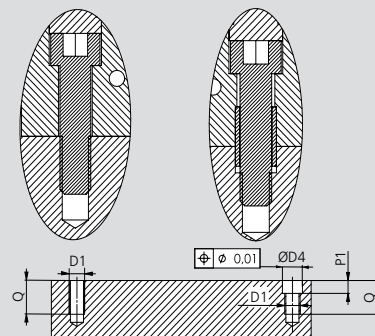
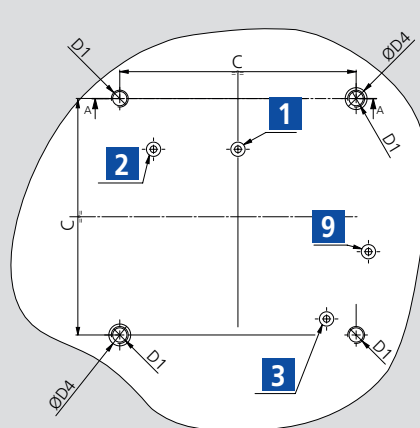
± 0,03 mm to clamping center



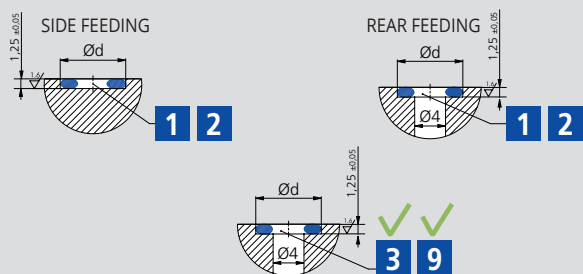
All bolts
and centering
bushings
included

Solution 2 standard

± 0,025 mm to clamping center



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