

TWIN VISES

Range of products



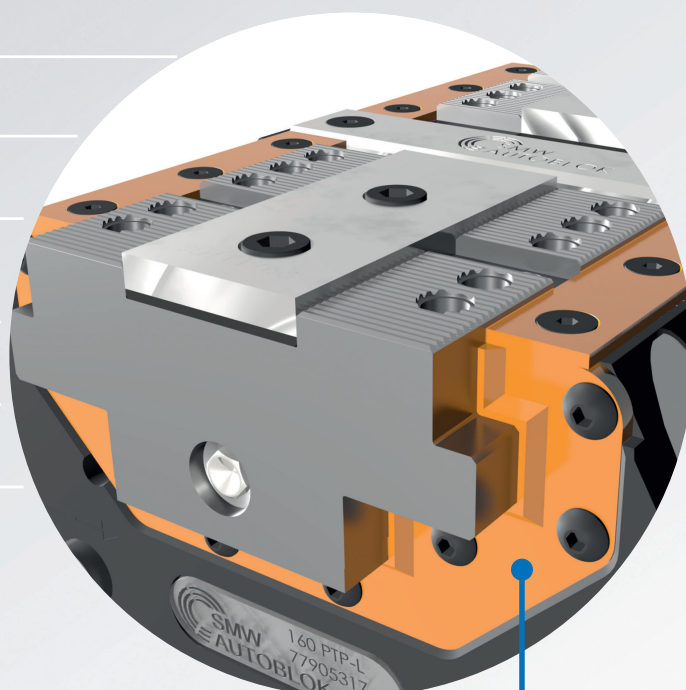
Industry 4.0
Product



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

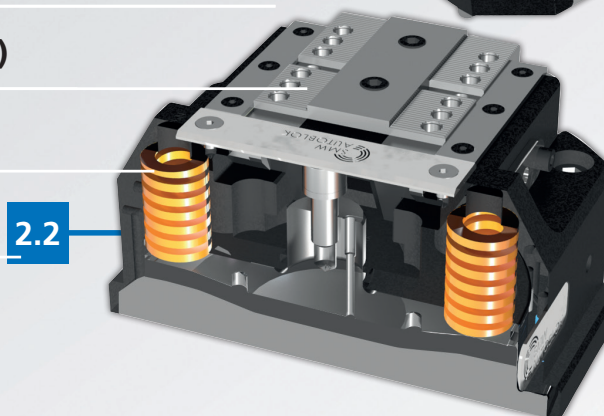
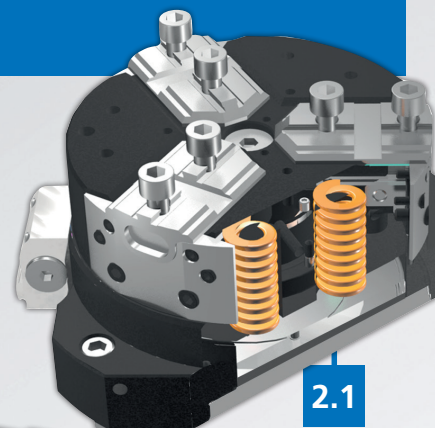


1.1

2 STV - SPRING AND AIR OPERATED TWIN VISES

SIZES AVAILABLE 180-225

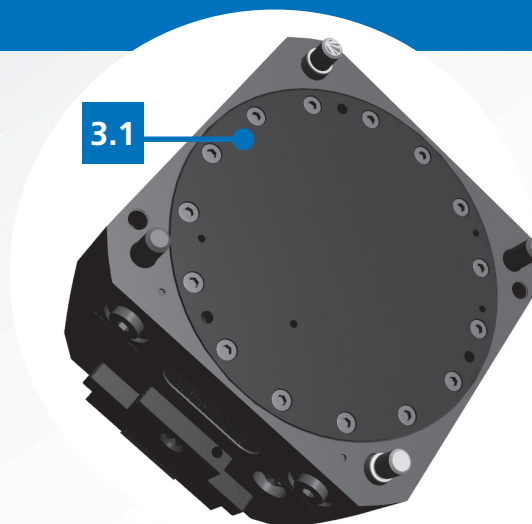
- ▶ STV 2 Jaws (also 125) and STV 3 Jaws
- ▶ Air Sensing
- ▶ Master jaws guide protected against swarf and chips
- ▶ Spring Clamped and Air Operated **2.1** **2.2**
- ▶ Safety Valve SAB-1 (optional)
- ▶ Pneumatic Valve (optional)
- ▶ Normal stroke **2.2**
- ▶ Long stroke



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

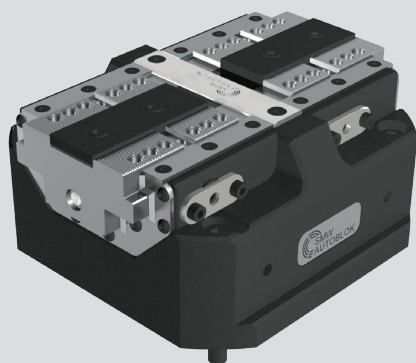
- ▶ Pneumatic and Hydraulic Version
- ▶ Long stroke
- ▶ OD and ID Clamping

STV-2N / STV-2L

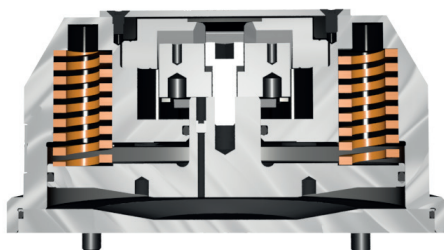
Spring and air operated Twin Vise

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

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



proofline® series
fully sealed – low maintenance



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

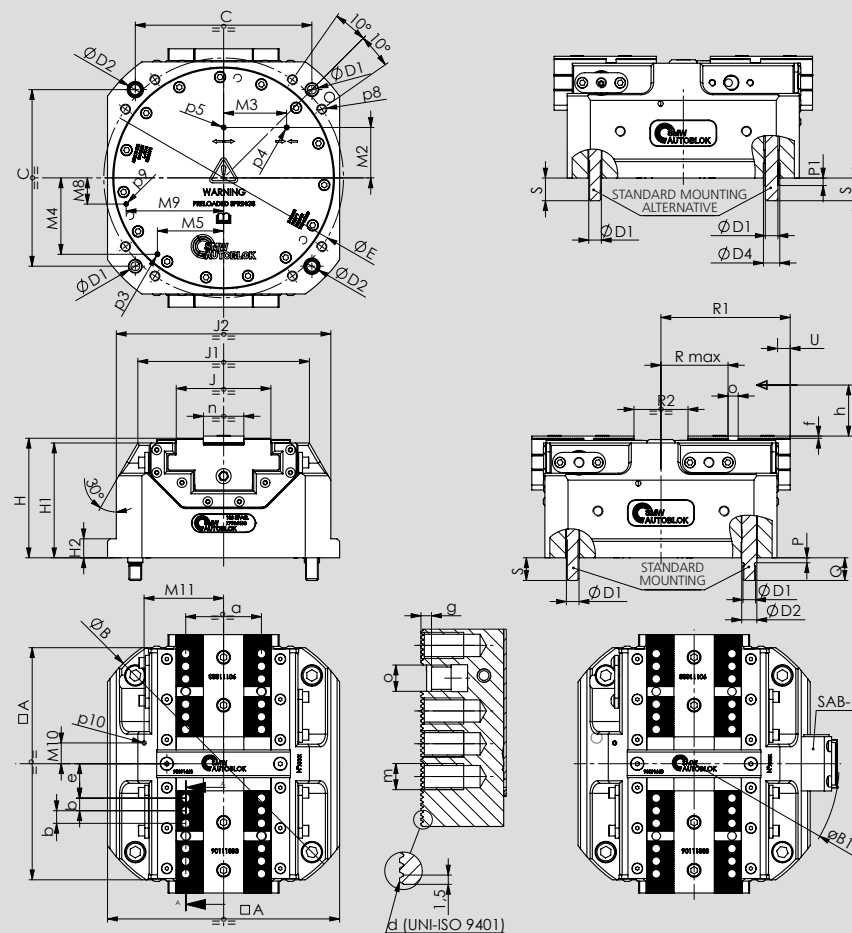
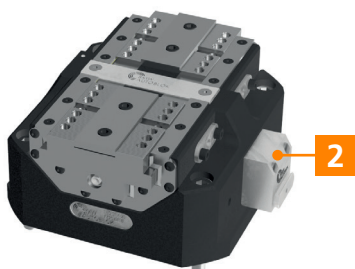
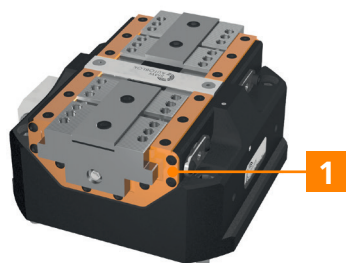
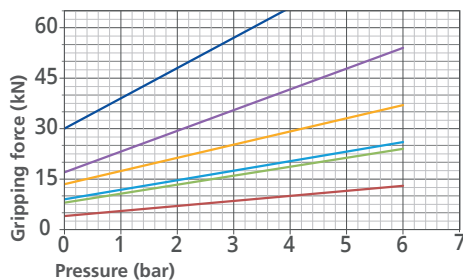
Self-centering vise without top jaws
All bolts and centering bushings included

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

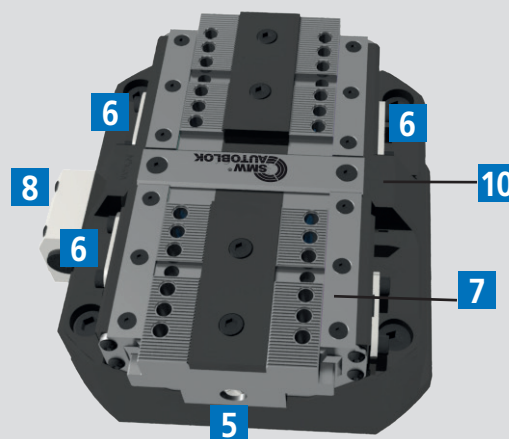
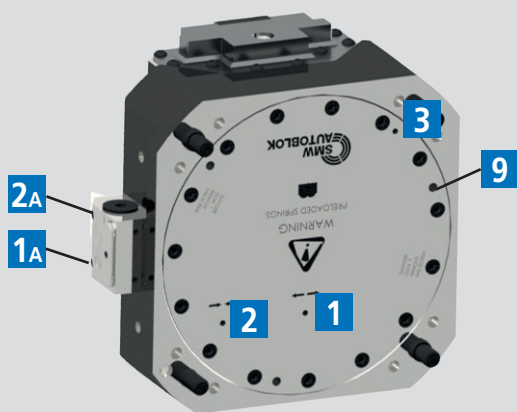
- 2 jaws
- STV-2N: Normal stroke
- STV-2L: Long stroke

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	-	-

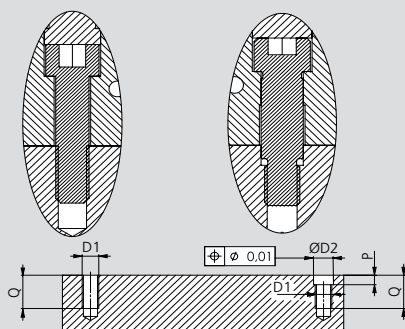
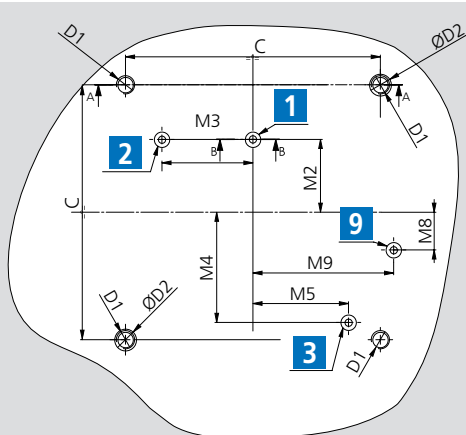
* Id. No. Twin Vise included the SAB-1. For example, 77904812 is composed by 125STV-2N Id. No. 77904312 plus SAB-1 Id. No. 27581810

STV-2			125		180		225	
SAB-1 valve overall dimension	A	mm	125		184		225	
	B (Ø)	mm	162		225		284	
	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	
Min. / max. (long stroke)	P	mm	4		4		5	
	P1	mm	4		6		6	
Min. / max. (normal stroke)	Q	mm	15		18		20	
	R max	mm	25.6 / 31.6		44.8 / 53.2		54.5 / 64.7	
Min. / max. (long stroke)	R1	mm	64.5 / 70.5		94 / 102.4		114.5 / 124.7	
	R2	mm	20 / 32		26 / 42.8		30 / 50.4	
Min. / max. (normal stroke)	S	mm	15		18		20	
	U	mm	6		8.4		10.2	
Long stroke	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°	
	e	mm	14.6 / 20.6		18.8 / 27.2		28.5 / 38.7	
Min. / max. (normal stroke)	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

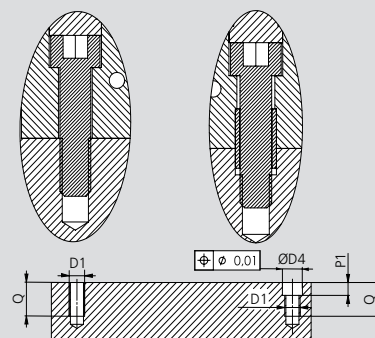
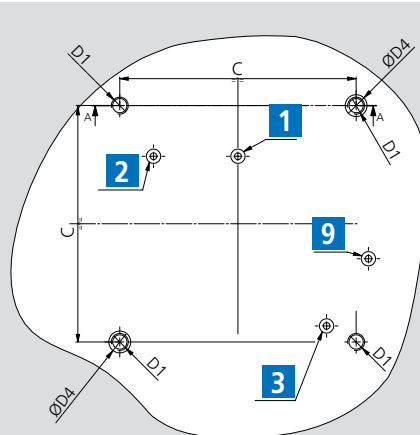
± 0,03 mm to clamping center



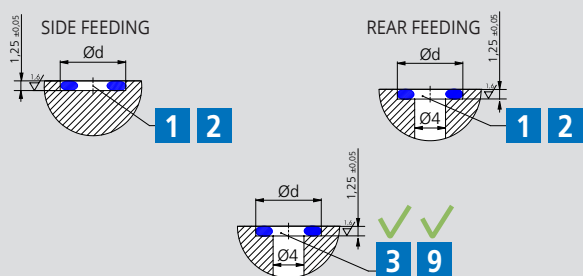
ALL BOLTS
AND
CENTERING
BUSHINGS
INCLUDED

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

Safety valve **SAB-1** (OPTIONAL)



Industry 4.0
Product



1 FEATURES

- ▶ Safety valve SAB-1 to maintain air pressure during pallet transportation/storage and machining without feed
- ▶ Easy and smart opening of the vise by air gun
- ▶ TURBO function to increase the clamping forces

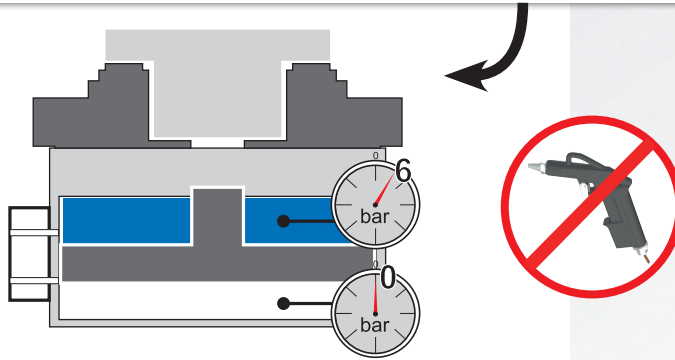
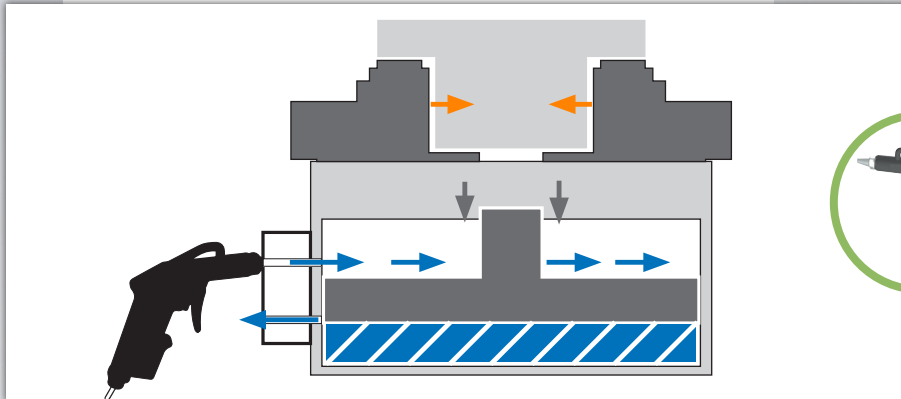
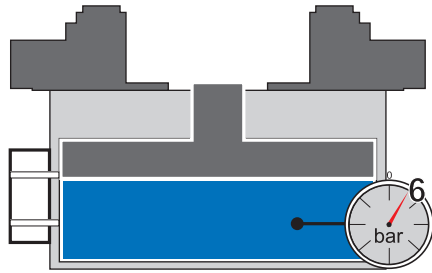
ONLY FOR
STV-2
STV-3

PNEUMATIC GUN

WITH STEEL NOZZLE



2 OPERATION

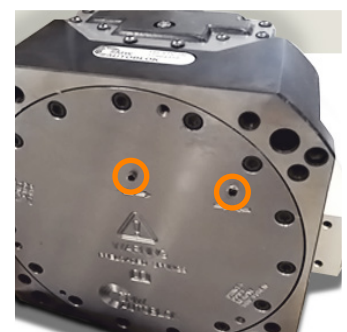


3 MOUNTING

IN CASE OF SEPARATE PURCHASE

- ▶ **3.1** Before install the **SAB-1** please remember to remove the two set screws, because from factory default setting, the air connection is ready to be used from the bottom side.
- ▶ **3.2** After that you need close the two holes located on the bottom side using the same set screws or an o-ring.

If the SAB-1 is purchased together with the Twin Vises, the assembly and adjustment are done by SMW-Autoblok personnel at our factories.

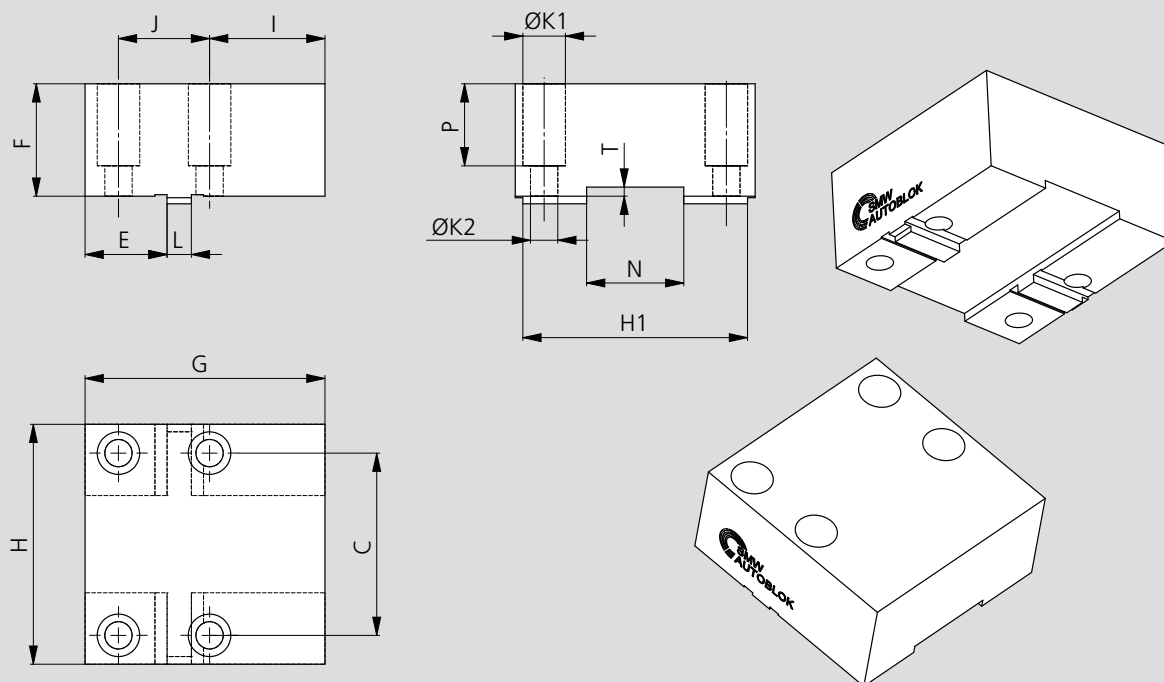


SOFT TOP JAWS

for Twin Vises

- Soft blank top jaws
- Tongue & Groove

Material: C40 UNI7847

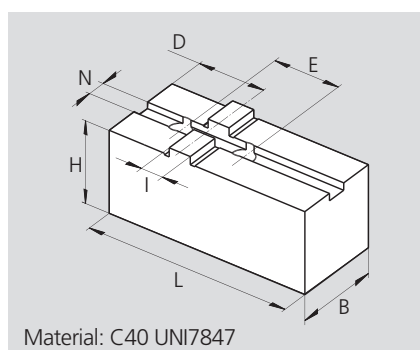


Subject to technical changes.

SOFT BLANK TOP JAWS, TONGUE & GROOVE

Type	Id. No.*	C	E	F	G	H	H1	I	J	K1	K2	L	N	P	T	Clamping range [mm]	Weight [kg]
100 TV / PT	90711063	35	18	27.5	49	54.5	45	21	21	11	7	6h7	20h8	20	3	0 - 70	0.5
125 STV-2 / PT	90711283	35	33	27.5	64	54.5	45	21	35	11	7	6h7	20h8	20	3	0 - 100	0.65
100 TV / PT	90721063	35	18	47.5	49	54.5	45	21	21	11	7	6h7	20h8	40	3	0 - 70	0.85
125 STV-2 / PT	90721283	35	33	47.5	64	54.5	45	21	35	11	7	6h7	20h8	40	3	0 - 100	1.15
160 TV / PT	90711663	60	27	37	79	79	74	38	30	14	9	8h7	32h8	27	3	0 - 120	1.6
180 STV-2 / PT	90711883	60	41	37	93	79	74	38	40	14	9	8h7	32h8	27	3	0 - 140	1.9
160 TV / PT	90721663	60	27	76.5	79	79	74	38	30	14	9	8h7	32h8	66.5	3	0 - 120	3.3
180 STV-2 / PT	90721883	60	41	76.5	93	79	74	38	40	14	9	8h7	32h8	66.5	3	0 - 140	4
200 TV / PT	90712063	80	37	47	98.5	109	92	47.5	40	14	9	8h7	40h8	37	3.5	0 - 150	3.6
200 TV / PT	90722063	80	37	86.5	98.5	109	92	47.5	40	14	9	8h7	40h8	76.5	3.5	0 - 150	6.8
225 STV-2	90712283	80	52	47	113.5	109	92	47.5	50	14	9	8h7	40h8	37	3.5	0 - 170	4.2
225 STV-2	90722283	80	52	86.5	113.5	109	92	47.5	50	14	9	8h7	40h8	76.5	3.5	0 - 170	7.9
250 TV	90712563	90	59	47	120	124	/	44	48	18	11	10h7	50h8	31	3.5	0 - 180	5
250 TV	90722563	90	59	97.5	120	124	/	44	48	18	11	10h7	50h8	81.5	3.5	0 - 180	10.5
315 TV	90713163	120	54	57	150	160	/	75	60	20	13.5	12h7	60h8	42	3.5	0 - 240	10
315 TV	90723163	120	54	102.5	150	160	/	75	60	20	13.5	12h7	60h8	87.5	3.5	0 - 240	18

*The Id. No. refers to one single piece.



Material: C40 UNI7847

TONGUE & GROOVE SOFT BLANK TOP JAWS "C" FOR TWIN VISE STV-3

Type	Id. No.*	B	H	L	N	D	E	I	Clamping range [mm]	Weight [kg]
180 STV-3	12041660	30	32	80	7.94	30	38.1	12.68	0 - 140	0.58
225 STV-3	12042060	35	37	100	7.94	35	44.4	12.68	0 - 170	0.92

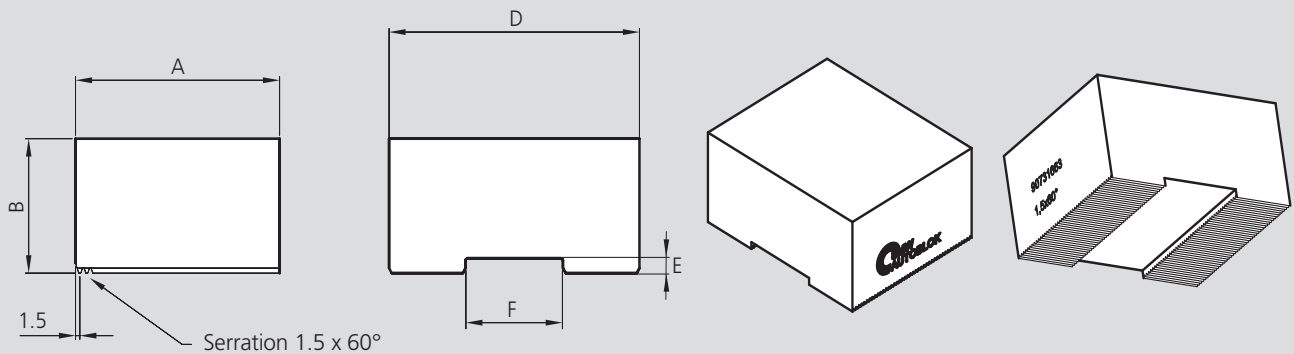
*The Id. No. refers to one single piece.

SOFT TOP JAWS

- Soft blank top jaws
- Fine serration 1.5mmx60°

for Twin Vises

Material: C40 UNI7847



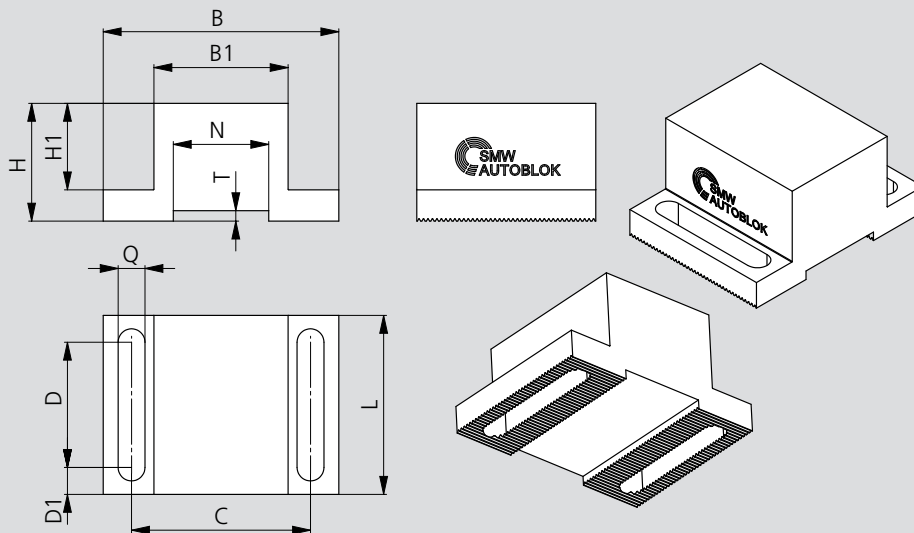
Subject to technical changes.

SOFT BLANK TOP JAWS, FINE SERRATION 1.5 mm x 60°

Type	Id. No.*	A	B	D	E	F	Weight [kg]
100-125 TV	90731063	42	29.5	54.5	3.5	20H8	0.5
100-125 TV	90741063	47	49.5	54.5	3.5	20H8	0.95
160-180 TV	90731663	66	39.5	79	3.5	32H8	1.5
160-180 TV	90741663	76	79	79	3.5	32H8	3.6
200-225 TV	90732063	87	49.5	109	4	40H8	3.5
200-225 TV	90742063	87	89	109	4	40H8	6.5
250 TV	90732563	108	49.5	124	4	50H8	5
250 TV	90742563	108	99	124	4	50H8	10.2
315 TV	90733163	160	49.5	160	4	60H8	9.6
315 TV	90743163	160	105	160	4	60H8	20.7

*The Id. No. refers to one single piece.

Material: C40 UNI7847



Subject to technical changes.

SOFT BLANK TOP JAWS, FINE SERRATION 1.5 mm x 60°

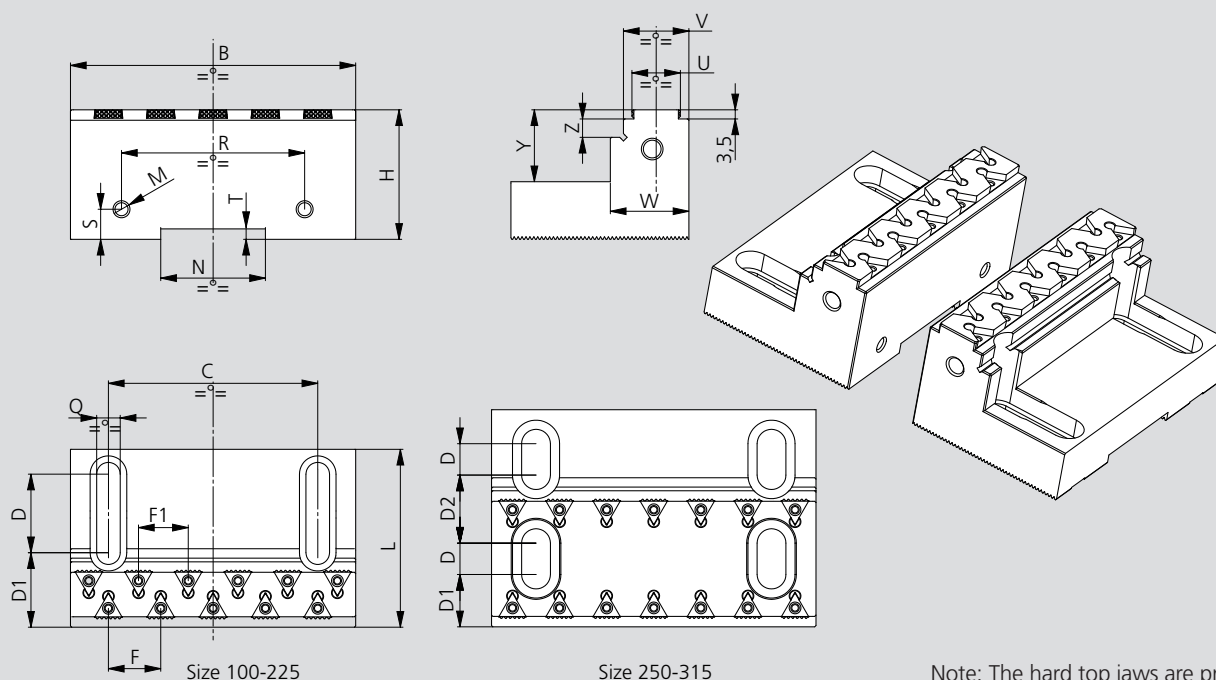
Type	Id. No.*	B	B1	C	D	D1	H	H1	L	N	Q	T	Weight [kg]
100-125 TV	90751063	54.5	24	35	30	6	29.5	21.5	42	20H8	6.6	3.5	0.25
160-180 TV	90751663	79	45	60	42	9	39.5	29	60	32H8	9	3.5	0.9
200-225 TV	90752063	109	65	80	62	9	49.5	39	80	40H8	9	4	2
250 TV	90752563	124	72	90	62	14	49.5	33	90	50H8	11	4	2.7
315 TV	90753163	160	90	120	82	12	49.5	31.5	106	60H8	13.5	4	4.2

*The Id. No. refers to one single piece.

WIDE HARD TOP JAWS

TOP JAWS SinterGrip

- Hard top jaws with SinterGrip inserts
- Metric serrated 1.5 mm x 60°



Subject to technical changes.

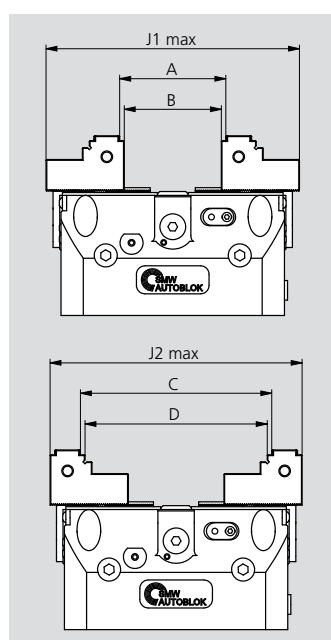
Note: The hard top jaws are provided with Id. No. 58450129 inserts mounted only on one side.

WIDE HARD TOP JAWS DIMENSIONS

Type	Id. No. set of 2 top jaws	B [mm]	C [mm]	D [mm]	D1 [mm]	D2 [mm]	F [mm]	F1 [mm]	H [mm]	L [mm]	M [mm]	N [mm]	Q [mm]	R [mm]	S [mm]	T [mm]	U [mm]	V [mm]	W [mm]	Y [mm]	Z [mm]	No. inserts provided	*No. seat inserts	Weight [kg]
100-125 TV-STV-PT	58454115	72	35	21	9	/	12/23	12/23	26	39	M5	20H8	6,6	60	10	3,5	21,5	28	33	13	5	8	16	0.7
160-180 TV-STV-PT	58454125	104	60	30	14	/	15/28	15/28	34,5	57	M6	32H8	9	86	11,5	3,5	21,5	28	33	15,5	5	10	20	2
200-225 TV-STV-PT	58454135	109	80	30	29	/	20	19	34,5	68	M6	40H8	9	70	11,5	4	18,5	25	30	15,5	7	12	22	2.3
250 TV-PT	58454145	124	90	12	20	26	18	18	39,5	83	M8	50H8	11	80	15	4	45,5	52	57	17,5	7	14	28	4.3
315 TV	58454155	160	120	15	23,5	35	20	20	44,5	105	M8	60H8	13	80	15	4	55,5	62	67	17,5	7	16	32	8.3

*The number of seats inserts indicated refers to set of 2 top jaws

WIDE HARD TOP JAWS CLAMPING RANGES for long and normal stroke Twin Vise models



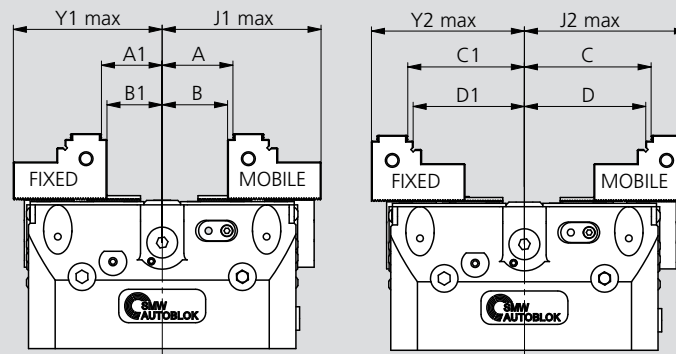
** the maximum gripping force values are indicative since they depend on the number of inserts used.

***with 200 TV-PN and 200 PT-N models it is not possible to clamp workpieces with dimensions between from 93 to 96 mm.

Id. No. set of 2 top jaws	Type	A [mm]	B [mm]	J1 max. [mm]	C [mm]	D [mm]	J2 max. [mm]	Gripping force max. [kN]**
58454115	100 TV-N	10 - 32	4 - 25	106	32 - 70	25 - 63	122	13
	100 TV-L							
	100 PT-N	10 - 46	4 - 40	120	32 - 83	25 - 76	135	13
	100 PT-L							
	125 PT-N	10 - 60	4 - 53	134	32 - 98	25 - 91	150	22
	125 PT-L							
58454125	125 STV-N	10 - 60	4 - 53	134	32 - 98	25 - 91	150	26
	125 STV-L							
	160 TV-N	10 - 70	4 - 63	180	66 - 138	59 - 131	190	40
	160 TV-L							
	160 PT-N	10 - 70	4 - 63	180	66 - 138	59 - 131	190	40
	160 PT-L							
58454135	180 STV-N	10 - 85	4 - 78	195	66 - 160	59 - 153	213	54
	180 STV-L							
	200 TV-N	10 - 93 (***)	4 - 86	225	96 - 175	89 - 168	220	60
	200 TV-L	10 - 96	4 - 89	228				
	200 PT-N	10 - 93 (***)	4 - 86	225	96 - 175	89 - 168	220	60
	200 PT-L	10 - 96	4 - 89	228				
58454145	225 STV-N	10 - 96	4 - 89	228	96 - 202	89 - 196	250	66
	225 STV-L							
	250 TV-N	10 - 88	4 - 82	250	88 - 192	82 - 186	292	60
	250 TV-L	10 - 106	4 - 100	270				
	250 PT-N	10 - 88	4 - 82	250	88 - 192	82 - 186	292	60
	250 PT-L	10 - 106	4 - 100	270				
58454155	315 TV-N	18 - 108	12 - 102	315	104 - 246	98 - 240	366	100
	315 TV-L	18 - 132	12 - 126	338	120 - 255	114 - 248	375	

- Hard top jaws with SinterGrip inserts
- Metric serrated 1.5 mm x 60°

TOP JAWS SinterGrip



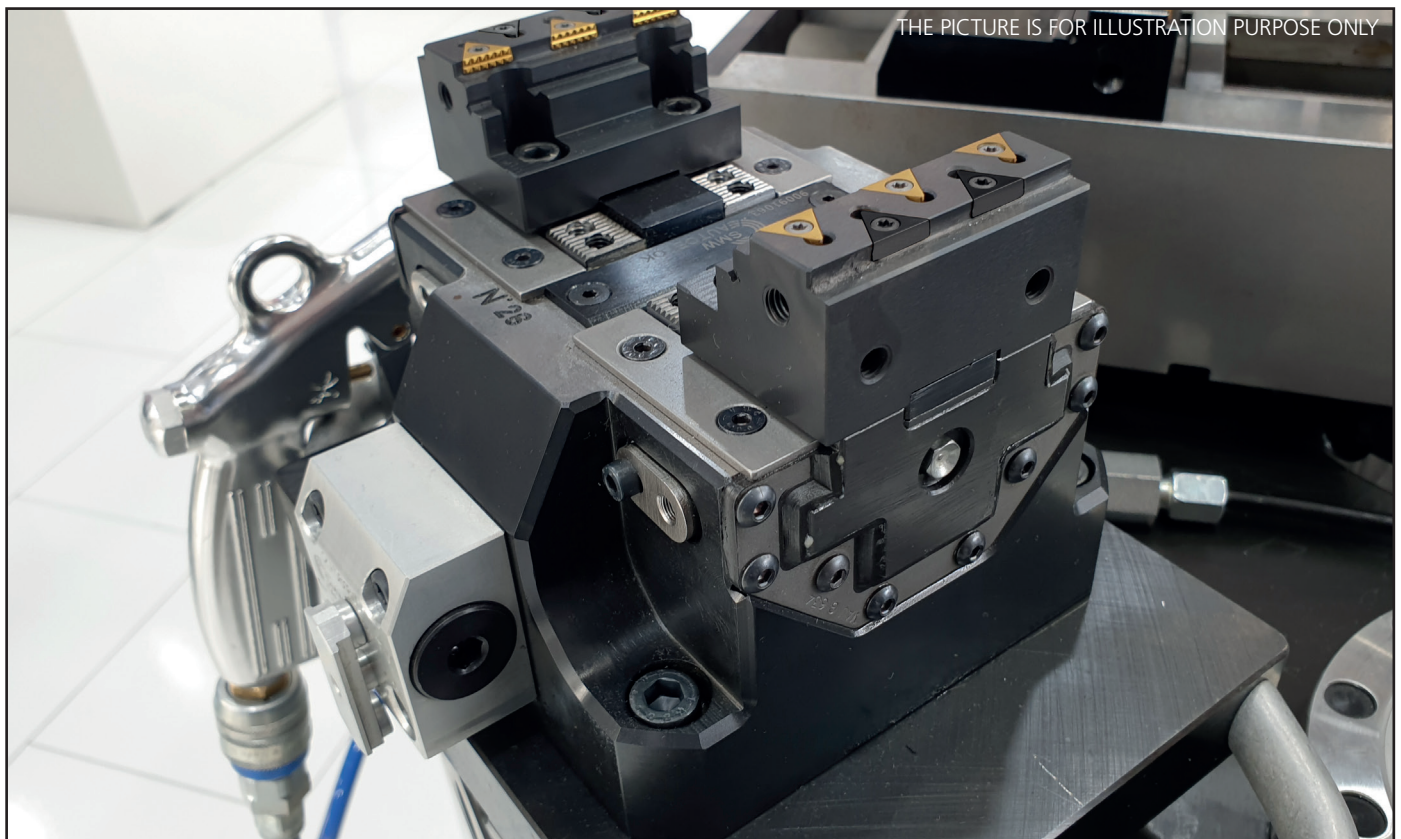
Note: the A1 - B1 - C1 - D1 dimensions for fixed jaws clamping range have tolerance ± 0.75 mm due to the serration pitch 1.5 mm.

Subject to technical changes.

WIDE HARD TOP JAWS CLAMPING RANGES for one fixed jaw Twin Vise models

Id. No. set of 2 top jaws	Type	A [mm]	B [mm]	A1 [mm]	B1 [mm]	J1 max. [mm]	Y1 max. [mm]	C [mm]	D [mm]	C1 [mm]	D1 [mm]	J2 max. [mm]	Y2 max. [mm]	Gripping force max. [kN]**
58454115	100 TV-F	5 - 16	2 - 13	5 - 16	2 - 13	53	52	16 - 35	13 - 32	16 - 35	13 - 32	61	60	13
	100 PT-F	5 - 23	2 - 20	5 - 23	2 - 20	60	59	16 - 41	13 - 38	16 - 41	13 - 38	67	66	13
	125 PT-F	5 - 30	2 - 27	5 - 30	2 - 27	67	66	16 - 49	13 - 46	16 - 49	13 - 46	75	74	15
58454125	160 TV-F	5 - 35	2 - 32	5 - 35	2 - 32	90	89	33 - 69	30 - 66	33 - 69	30 - 66	95	93	32
	160 PT-F	5 - 35	2 - 32	5 - 35	2 - 32	90	89	33 - 69	30 - 66	33 - 69	30 - 66	95	93	32
58454135	200 TV-F	5 - 48	2 - 45	5 - 48	2 - 45	114	113	48 - 87	45 - 84	48 - 87	45 - 84	110	109	44
	200 PT-F	5 - 48	2 - 45	5 - 48	2 - 45	114	113	48 - 87	45 - 84	48 - 87	45 - 84	110	109	44
58454145	250 TV-F	5 - 53	2 - 50	5 - 53	2 - 50	135	134	44 - 101	41 - 98	44 - 88	41 - 85	151	137	40
58454155	315 TV-F	9 - 66	6 - 63	9 - 66	6 - 63	169	168	60 - 127	57 - 124	60 - 112	57 - 109	187	171	65

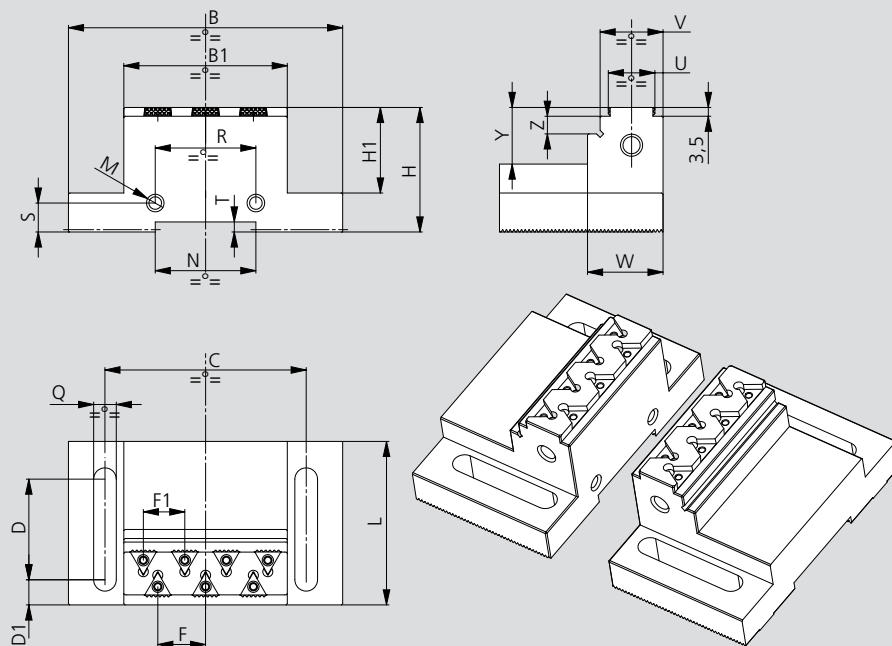
** the maximum gripping force values are indicative since they depend on the number of inserts used.



NARROW HARD TOP JAWS

TOP JAWS SinterGrip

- Hard top jaws with SinterGrip inserts
- Metric serrated 1.5 mm x 60°



Subject to technical changes.

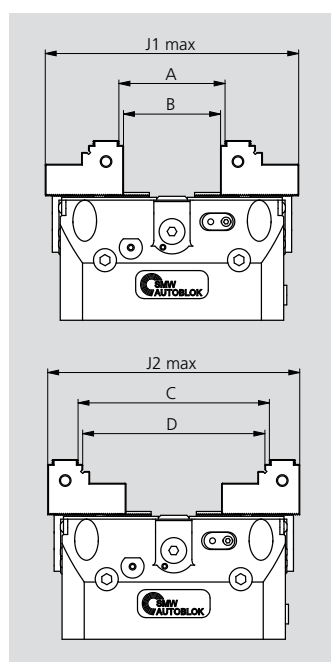
Note: the hard top jaws are provided with Id. No. 58450129 inserts mounted only on one side.

NARROW HARD TOP JAWS DIMENSIONS

Type	Id. No. set of 2 top jaws	B [mm]	B1 [mm]	C [mm]	D [mm]	D1 [mm]	F [mm]	F1 [mm]	H [mm]	H1 [mm]	L [mm]	M [mm]	N [mm]	Q [mm]	R [mm]	S [mm]	T [mm]	U [mm]	V [mm]	W [mm]	Y [mm]	Z [mm]	No. inserts provided	*No. seat inserts	Weight [Kg]
100-125 TV-STV-PT	58454215	54.5	24	35	27	6	12	12	29.5	20	39	-	20H8	6.6	-	-	3.5	21.5	28	33	17.5	7	4	8	0.4 kg
160-180 TV-STV-PT	58454225	79	45	60	38	9	20	15.5	39.5	26	56	M6	32H8	9	26	11.5	3.5	18.5	25	30	17.5	7	6	10	1.3 kg
200-225 TV-STV-PT	58454235	109	65	80	40	10	19	16.5	44.5	27.5	65	M6	40H8	9	40	11.5	4	18.5	25	30	18.5	7	8	14	2.5 kg
250 TV-PT	58454245	124	72	90	48	14	14	14	49.5	34	76	M6	50H8	11	40	11.5	4	21.5	28	33	20.5	7	10	20	3.5 kg
315 TV	58454255	160	90	120	60	15	15	15	49.5	32	90	M6	60H8	13	60	15	4	27.5	34	39	19.5	7	12	24	5.5 kg

*The number of seats inserts indicated refers to set of 2 top jaws

NARROW HARD TOP JAWS CLAMPING RANGES for long and normal stroke Twin Vise models



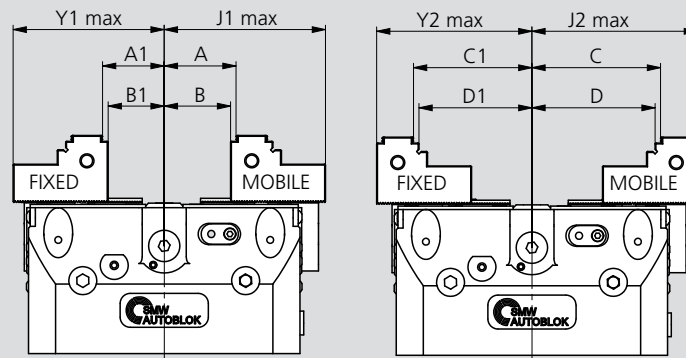
**the maximum gripping force values are indicative since they depend on the number of inserts used.

Id. No. set of 2 top jaws	Type	A	B	J1 max.	C	D	J2 max.	Gripping force max. [kN]**
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	
58454215	100 TV-N	10-32	4-25	106	32-75	25-68	127	13
	100 TV-L							
	100 PT-N	10-46	4-40	120	32-85	25-78	137	13
	100 PT-L							
	125 PT-N	10-60	4-53	134	32-100	25-93	152	22
	125 PT-L							
	125 STV-N	10-60	4-53	134	32-100	25-93	152	26
125 STV-L								
58454225	160 TV-N	10-74	4-67	182	74-140	67-133	188	40
	160 TV-L							
	160 PT-N	10-74	4-67	182	74-140	67-133	188	40
	160 PT-L							
	180 STV-N	10-88	4-82	196	74-160	67-153	208	54
180 STV-L	10-98	4-92	206					
58454235	200 TV-N	10-93	4-87	220	93-175	87-168	220	60
	200 TV-L							
	200 PT-N	10-93	4-87	220	93-175	87-168	220	60
	200 PT-L							
	225 STV-N	10-110	4-104	237	93-202	87-196	250	66
225 STV-L	10-120	4-114	247					
58454245	250 TV-N	22-108	16-102	255	108-218	102-212	272	60
	250 TV-L	22-122	16-116	270				
	250 PT-N	22-108	16-102	255	108-218	102-212	272	60
	250 PT-L	22-122	16-116	270				
58454255	315 TV-N	30-138	23-132	315	138-275	132-268	340	100
	315 TV-L	30-162	23-156	338	160-275	154-268	340	

NARROW HARD TOP JAWS

TOP JAWS SinterGrip

- Hard top jaws with SinterGrip inserts
- Metric serrated 1.5 mm x 60°



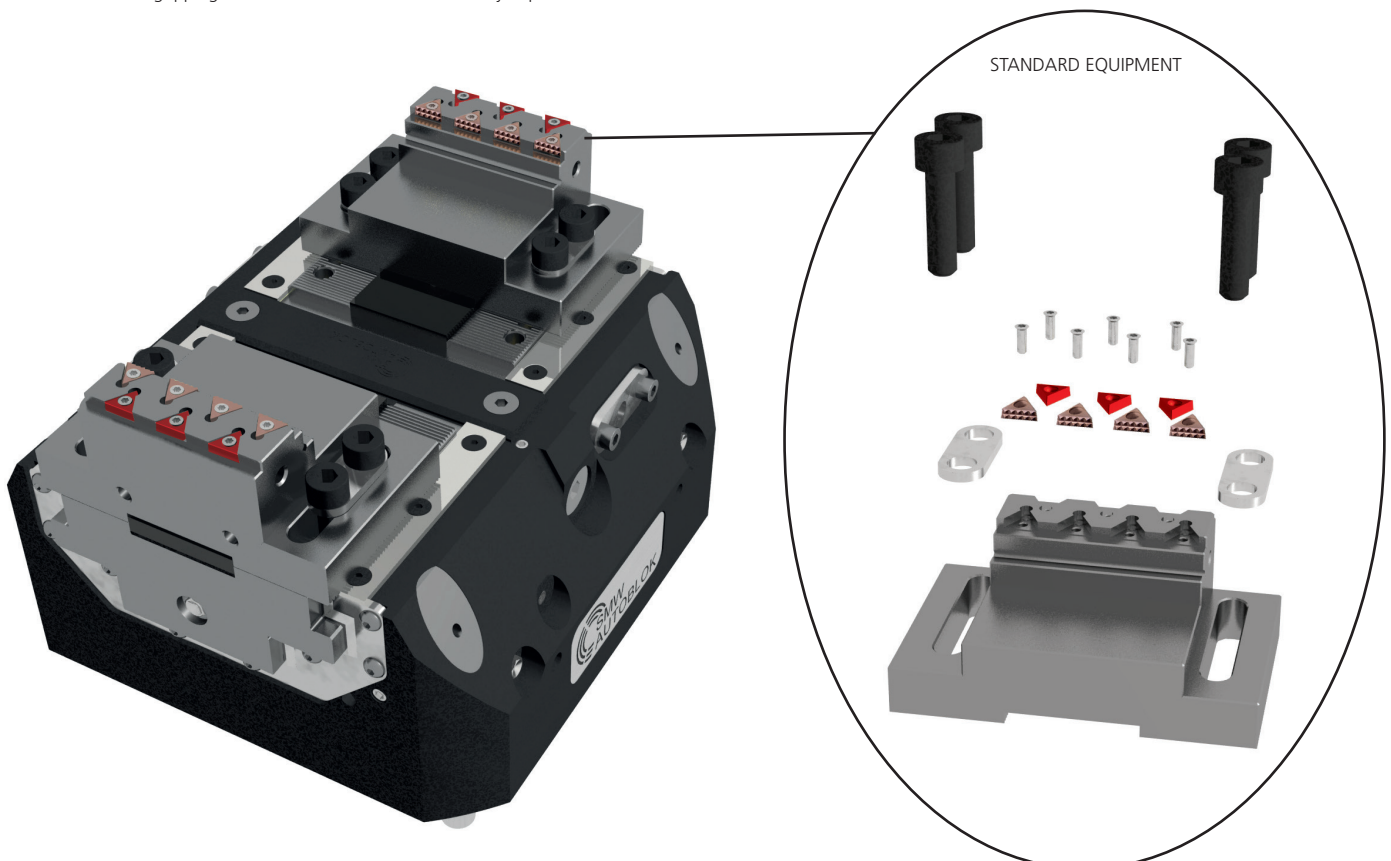
Note: the A1 - B1 - C1 - D1 dimensions for fixed jaws clamping range have tolerance ± 0.75 mm due to the serration pitch 1.5 mm

Subject to technical changes.

NARROW HARD TOP JAWS CLAMPING RANGES for fixed jaw Twin Vise models

Id. No. set of 2 top jaws	Type	A [mm]	B [mm]	A1 [mm]	B1 [mm]	J1 max. [mm]	Y1 max. [mm]	C [mm]	D [mm]	C1 [mm]	D1 [mm]	J2 max. [mm]	Y2 max. [mm]	Gripping force max. [kN]**
58454215	100 TV-F	5 - 16	2 - 13	5 - 16	2 - 13	53	52	16 - 38	13 - 34	16 - 38	13 - 34	64	63	13
	100 PT-F	5 - 23	2 - 20	5 - 23	2 - 20	60	59	16 - 43	13 - 40	16 - 43	13 - 40	69	68	13
	125 PT-F	5 - 30	2 - 27	5 - 30	2 - 27	67	66	16 - 50	13 - 47	16 - 50	13 - 47	76	75	15
58454225	160 TV-F	5 - 37	2 - 34	5 - 37	2 - 34	91	90	37 - 70	34 - 67	37 - 70	34 - 67	94	92	32
	160 PT-F	5 - 37	2 - 34	5 - 37	2 - 34	91	90	37 - 70	34 - 67	37 - 70	34 - 67	94	92	32
58454235	200 TV-F	5 - 47	2 - 44	5 - 47	2 - 44	110	109	47 - 87	44 - 84	47 - 87	44 - 84	110	109	44
	200 PT-F	5 - 47	2 - 44	5 - 47	2 - 44	110	109	47 - 87	44 - 84	47 - 87	44 - 84	110	109	44
58454245	250 TV-F	11 - 61	8 - 58	11 - 61	8 - 58	135	134	54 - 109	51 - 106	54 - 109	51 - 106	136	134	40
58454255	315 TV-F	15 - 81	12 - 78	15 - 81	12 - 78	169	168	80 - 137	77 - 134	80 - 137	77 - 134	170	168	65

** the maximum gripping force values are indicative since they depend on the number of inserts used.

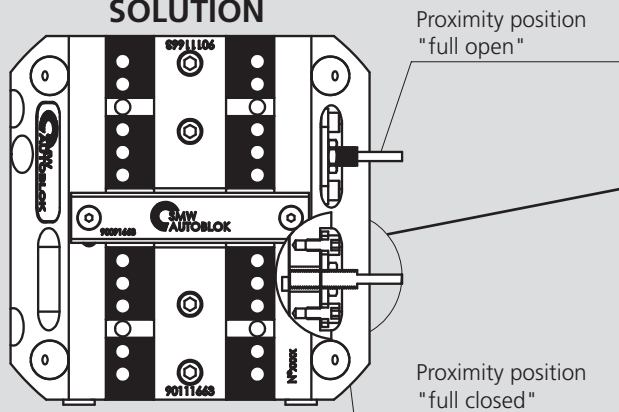


Stroke control proximities

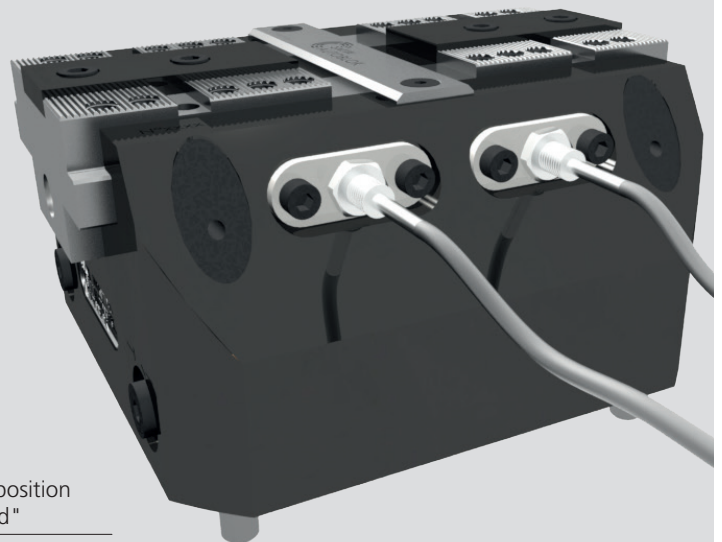
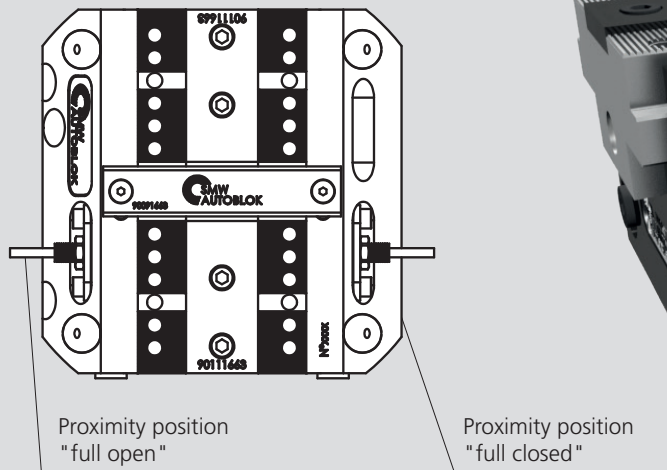
(OPTIONAL)

■ Pneumatic jaw stroke control valve

2 SLIDING JAWS SOLUTION



1 FIXED JAW SOLUTION



Twin Vise Type	Thread	Balluff sensor*	Omron sensor (alternative)	Telemecanique sensor (alternative)	S	L
100 TV	M5x0.5	BES516-3005-G-E4-C-PU02	E2EX1-B1	XS1N05PA310	0.5	20
160-200-250 TV	M8x1	BES516-324-G-E4-C-PU02	E2AS08KS02-WP-B12M	XS508B1PAL2	1	30
315 TV	M8x1	BESE08EF-PSC20B-BP02	E2AS08LS02-WP-BI2M	XS508BLPAL2	1	40
125 STV-2	M5x0.5	BES516-3005-G-E4-C-PU02	E2EX1-B1	XS1N05PA310	0.5	20
180-225 STV-2	M8x1	BES516-324-G-E4-C-PU02	E2AS08KS02-WP-B12M	XS508B1PAL2	1	30
100-125 PT	M5x0.5	BES516-3005-G-E4-C-PU02	E2EX1-B1	XS1N05PA310	0.5	20
160-200-250 PT	M8x1	BES516-324-G-E4-C-PU02	E2AS08KS02-WP-B12M	XS508B1PAL2	1	30

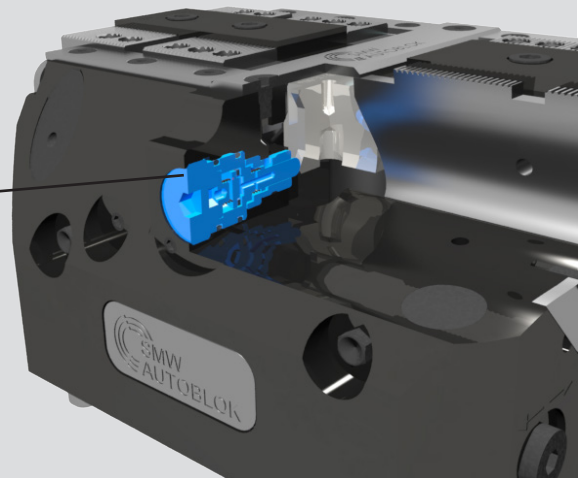
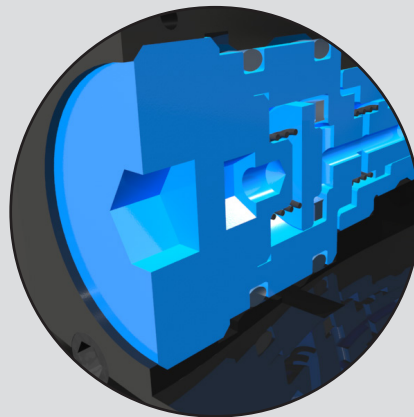
* Recommended by SMW-AUTOBLOK

Pneumatic valve

■ Pneumatic jaw stroke control valve

(OPTIONAL)

Available for
STV-2 STV-3
PTP PTH



Twin Vise type	Id. No.
125 STV-2	90902283
180 STV-2	90902283
225 STV-2	90902283
180 STV-3	97901801
225 STV-3	97902204
100 PTP PTH	90901163
125 PTP PTH	90901763
160 PTP PTH	90901763
200 PTP PTH	90901763
250 PTH	90901763

The pneumatic open / close stroke control valve signals the locking jaws end-of-stroke positions, both in fully opened and fully closed positions.

The valve needs a pneumatic line with **filtered and lubricated air** and a **pressure of 0,5-1 bar**.

- when the locking jaws are in one of the end stroke position (fully opened or closed), the valve is open causing a pressure drop in the pneumatic line or the beginning of an air flow.
- when the locking jaws are in the working stroke, the valve is closed and there is no pressure drop in the pneumatic line and there is no air flow.

ONLY THE PTP AND PTH VISES

The vises can be supplied (when requested) with the **opposite functioning** of the valve: that is closed valve at the end of the strokes and open in the working / middle stroke.

3

Safety valve SAB-1

(OPTIONAL)

Pneumatic gun

with steel nozzle



ONLY FOR
STV-2
STV-3

SAB-1 Valve
Id. No. 27581810
weight 0,150 kg



Id. No.
41702140

The Safety valve SAB-1 maintains air pressure in the cylinder pallet transportation / storage or machining without feed.