

27534 - 27536 Machine Vises/Quick-Action Vises



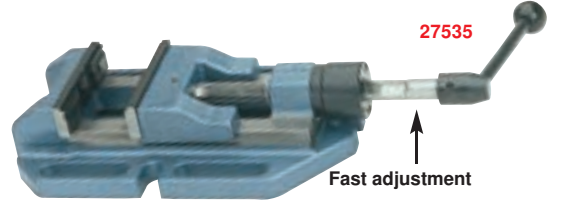
27534 - 27535

Type
With **large chucking capacity**. One clamping surface, **long flat guides**. **High clamping force** and clamping security. The rear jaw also has horizontal and vertical prism apertures.

27534
Type
Adjustment by means of **screw spindle**.

27535
Type
One-hand rapid clamping with serrated push bar. Without screw spindle.

27536
Spare jaws
Type
Prism jaws and normal jaw with workpiece mounting, soft and burnished, in pairs.



Jaws-Width mm	Clamping-wide mm	Jaws-Height mm	Overall Height mm	Clamping-Nominal Width mm	Base plate L x W mm	Weight approx. kg	Bench vise 27534	...	Bench vise 27535	...	Spare jaws 27536	...	
90	90	25	60.0	14	195 x 145	5.5	☒	101			☒	101	
110	130	32	72.5	17	315 x 175	9.5	☒	102		☒	101	☒	102
135	160	40	80.5	17	365 x 205	13.5	☒	103		☒	102	☒	103
160	220	50	95.5	17	445 x 245	25.0	☒	104			☒	104	

27537 Vee-Block Machine Vises

Type
Multi-purpose use. **large clamping width**, flat type. The **reversible jaws** are **hardened and ground**. One jaw with horizontal and vertical prism for round material. The other jaw is grooved. Both **jaws** with one smooth face and can be **reversed**. For clamping flat parts **both jaws are recessed on the top**. Open base plate with 8 cutting flutes.

Quality
Base and moving parts made of special cast iron.

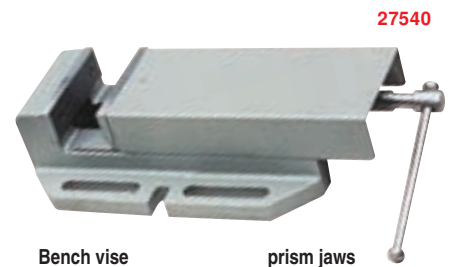


Jaw width mm	Clamping width mm	Jaw height mm	Overall height mm	Weight kg	27537	...
110	130	32	72.5	9.5	☒	101
135	160	40	80.5	14.0	☒	102
160	220	50	95.5	25.5	☒	103

27540 - 27541 Machine bench vises

27540
Machine bench vises
Type
Made of grey cast iron, **heavy-duty type**, with **dust cover** for protection against dirt and metal chips.

27541
Combined stepped prism jaws
Pairs.

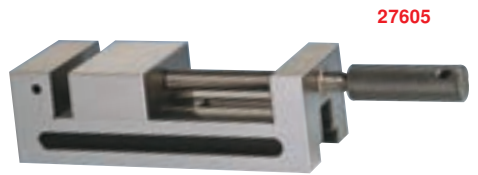


Jaw width mm	Clamping width mm	Jaw height mm	Overall height mm	Base plate L x W mm	Weight approx. kg	Bench vise 27540	...	prism jaws 27541	...
90	150	38	80	285 x 170	10	☒	101	☒	101
110	160	45	95	325 x 170	17	☒	102	☒	102
130	190	52	105	365 x 230	22	☒	103	☒	103
160	220	56	120	420 x 260	36	☒	104	☒	104

27605 Master Precision Vises

Type
Manufactured with **high precision**. Made of one piece, **hardened, parallel and true to angles**

(3 μ across all dimensions) ground on 5 sides.



Size	Jaw width mm	Clamping wide mm	L x W x H mm	Jaw height mm	Weight approx. kg	27605	...
0	50	0 - 50	125 x 50 x 40	20	1.7	☒	201
1	65	0 - 80	180 x 65 x 65	30	4.7	☒	202
2	100	0 - 125	266 x 100 x 82	40	12.2	☒	203

Clamping Technology

27610

Adjustable angle prisms

Type

Accuracy +/- 0.1
mm, angle accuracy +/- 10 min.

Use

Universal use for grinding, boring, measuring and scribing. The prism is clamped in a vise. The desired angle is set and is blocked by a retaining screw.

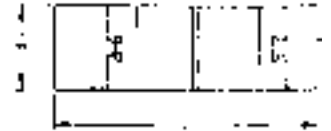
Quality

Alloyed tool steel, hardened to HRC 55.



27610

Length mm	W mm	H mm	h mm	Weight ca. g	27610	...
75	25	33	23	380		101
102	30	46	29	850		102



27617

Precision Clamp

Type

Surface precision ground.

Rectangularity: 0.005/100

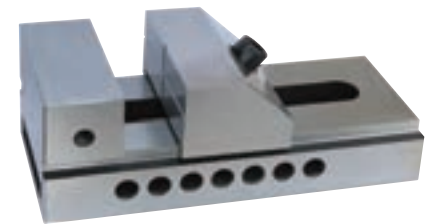
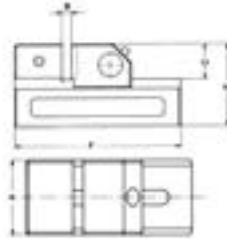
mm. Parallelism: 0.005/100 mm.

Use

For precise clamping on NC machines during grinding, erosion, measurement and milling work.

Quality

Tool steel, hardened to HRC 58.



27617

Clamping width B mm	A mm	C mm	E mm	F mm	Weight approx. kg	27617	...
65	50	25	50	140	1.4		101
100	73	35	67	190	4.1		102
125	100	45	90	245	7.3		103

27620

Precision Grinding and Control Vises

Type

Surface precision ground. The true to angle design allows for machining the workpieces from 4 sides. perpendicularity: 0.002/100 mm.

Parallelism: 0.002/100 mm.

Use

For precise machining of workpieces - grinding, drilling, milling, measuring - on all precision machine tools.

Quality

Tool steel, hardened to HRC 60.

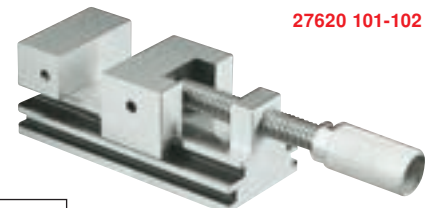
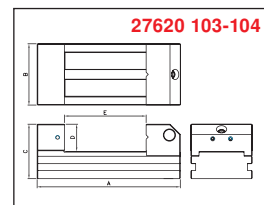
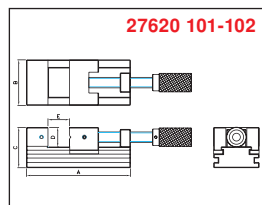
27620 101-102

With thread spindle.

27620 103-104

With quick-adjustment (without spindle).

The movable jaw is drawn down by the effected clamping pressure on a prism guide bar towards the workpiece and is clamped by a screw.



27620 101-102



27620 103-104

Clamping width E mm	A mm	B mm	C mm	D mm	Weight kg	27620	...
0 - 35	90	60	50	25	1.6		101
0 - 80	160	70	62	30	4.3		102
0 - 80	160	70	62	30	3.3		103
0 - 120	210	90	80	40	8.3		104

27622

Sine Vises

Type

Surface precision ground.

Rectangularity: 0.005/100 mm.

Parallelism: 0.005/100 mm.

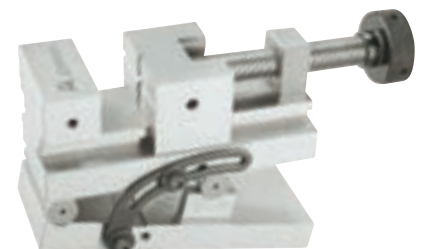
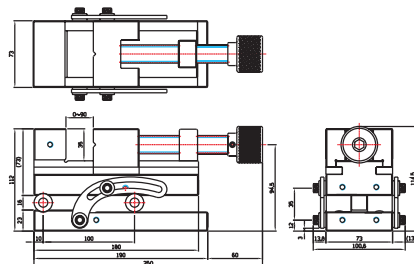
distance between axes: 100 mm.

Use

For precise machining of workpieces - grinding, drilling, milling, measuring - on all precision machine tools. For precise clamping, swivellable around the pitch axis.

Quality

Tool steel, hardened to HRC 58.



27622

Clamping width mm	Length mm	Width mm	Height mm	Weight kg	27622	...
0 - 90	190	73	112	10		101