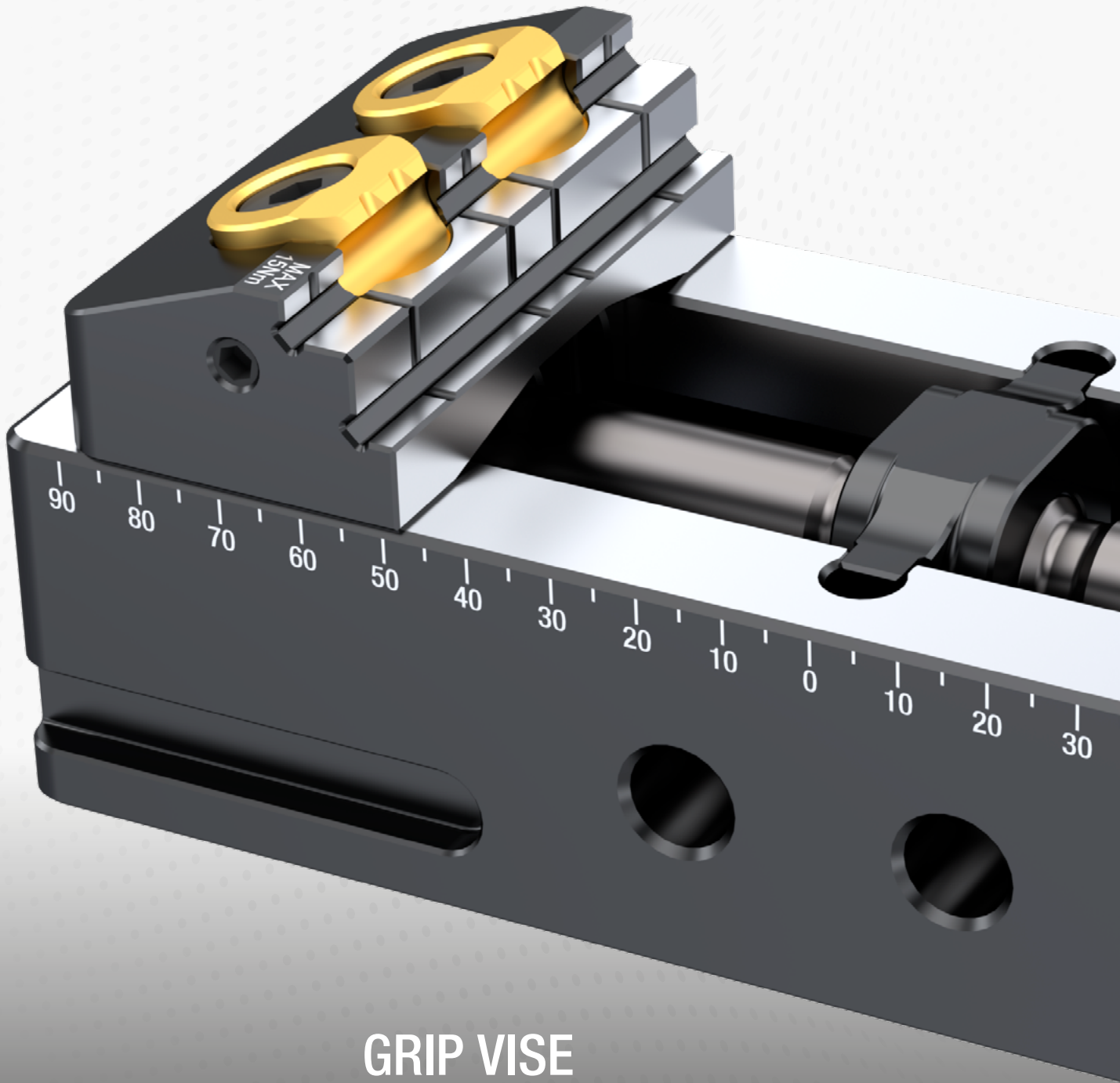




Integrated systems for production




## GRIP VISE

Seatless pressure clamping



**Integrated systems for production**

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# INTRODUCTION AND KEY FEATURES

# INTRODUCTION AND KEY FEATURES

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SYSTEM GRIP VISES

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MODULAR GRIP VISES

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ACCESSORIES  
SPARE PARTS

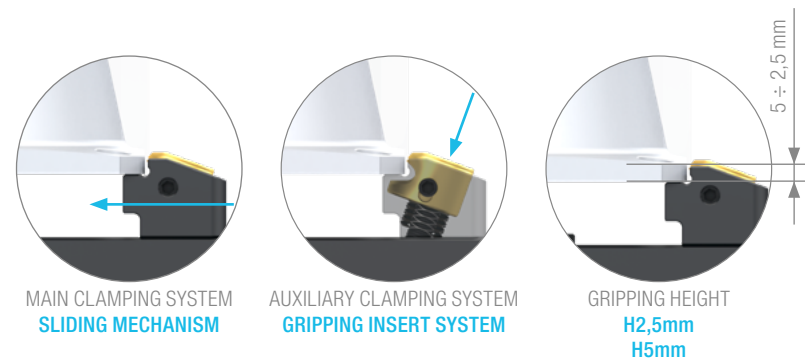
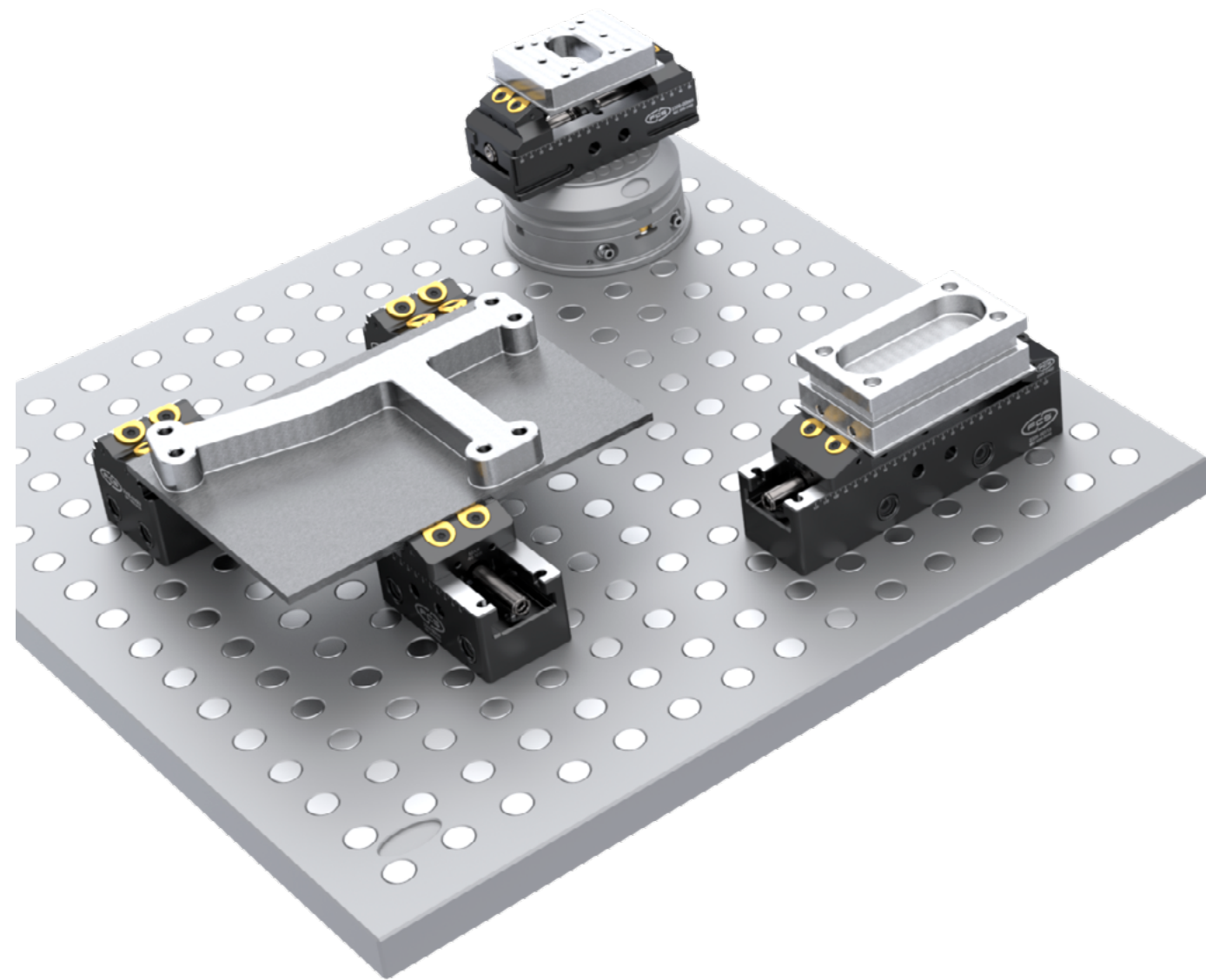
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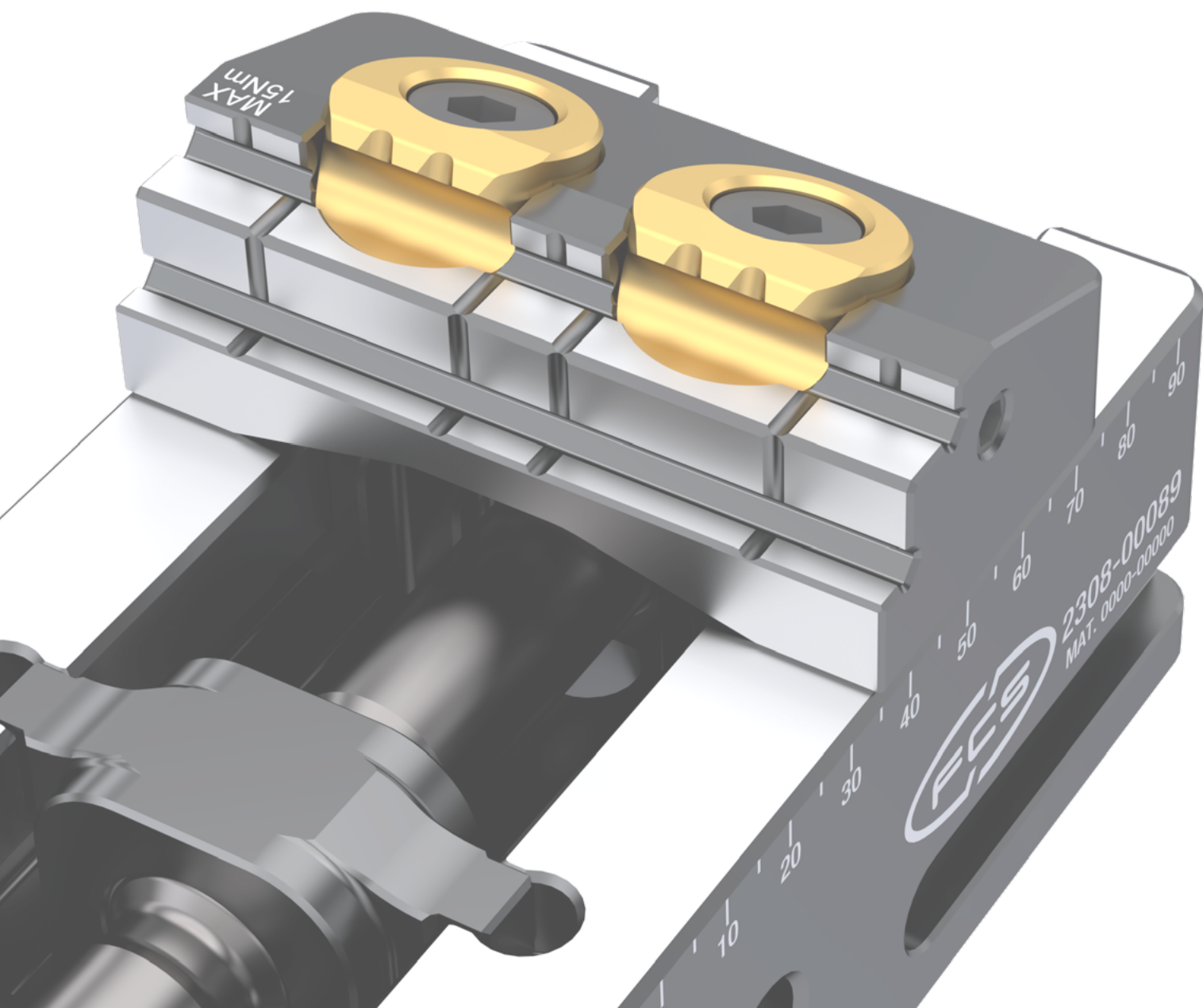


## MODULAR GRIP VISES





# SYSTEM GRIP VISES

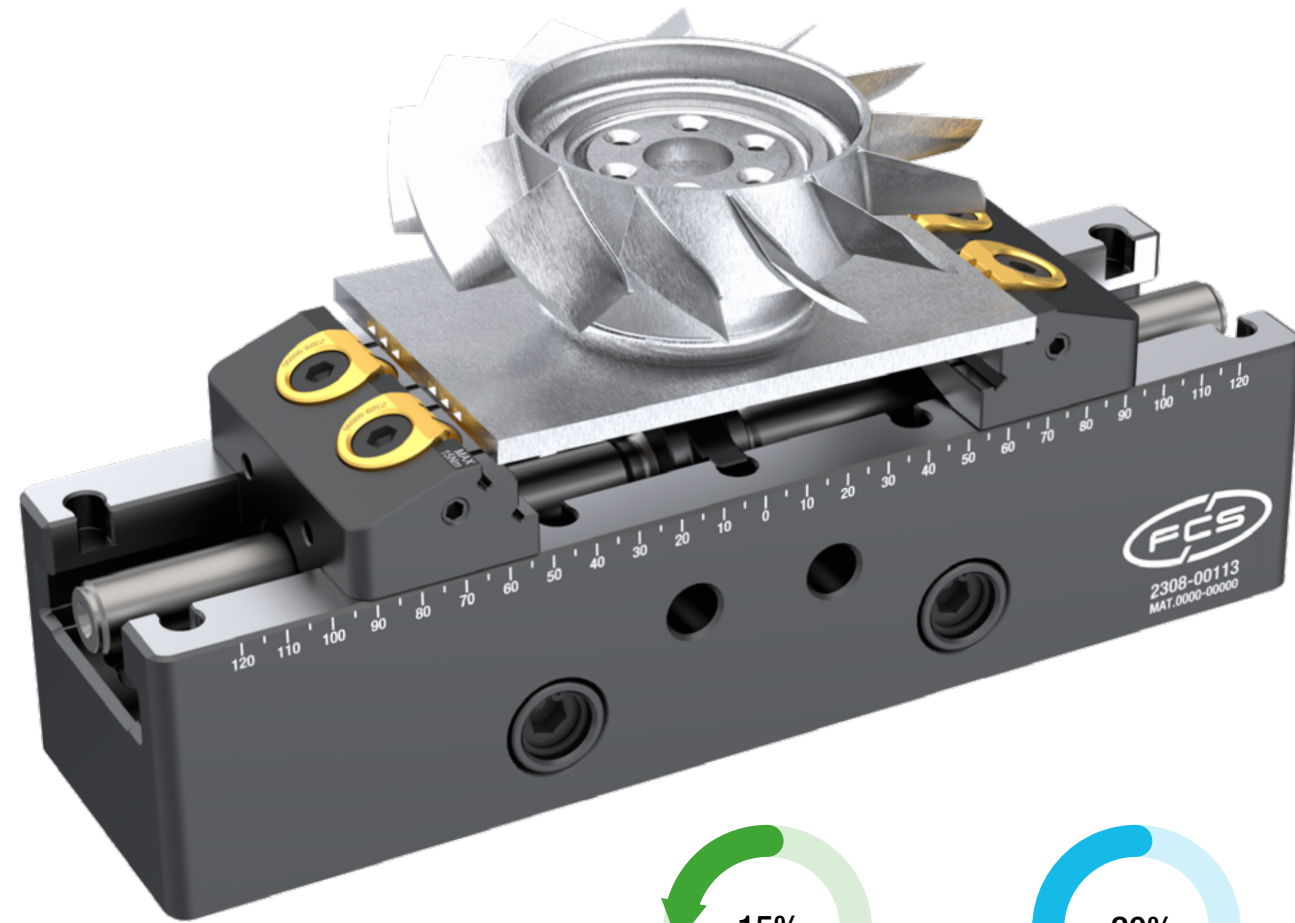


Integrated systems for production

# INTRODUCTION AND KEY FEATURES

# APPLICATION EXAMPLES

## SYSTEM GRIP VISE



Grip height reduction



Set-up time reduction

### Key strengths and main features

Compact grip starting from 2,5mm and higher workable surface of the workpiece

No preliminary work of the part to be clamped is required

Strong workpiece grip with minimal deformation

Each insert can be adjusted independently assuring adherence on irregular surface as well

High gripping flexibility:

- different size of gripping jaws
- floating jaws available
- different type of inserts (for finished and not finished surfaces)
- high gripping range

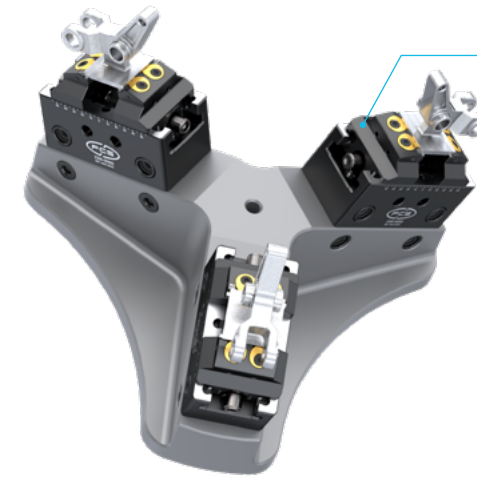
Easy to be fixed and centered

Option to raise the vises in a higher position on FCS clamping supports

Workpiece position accuracy:  $\pm 0,02\text{mm}$

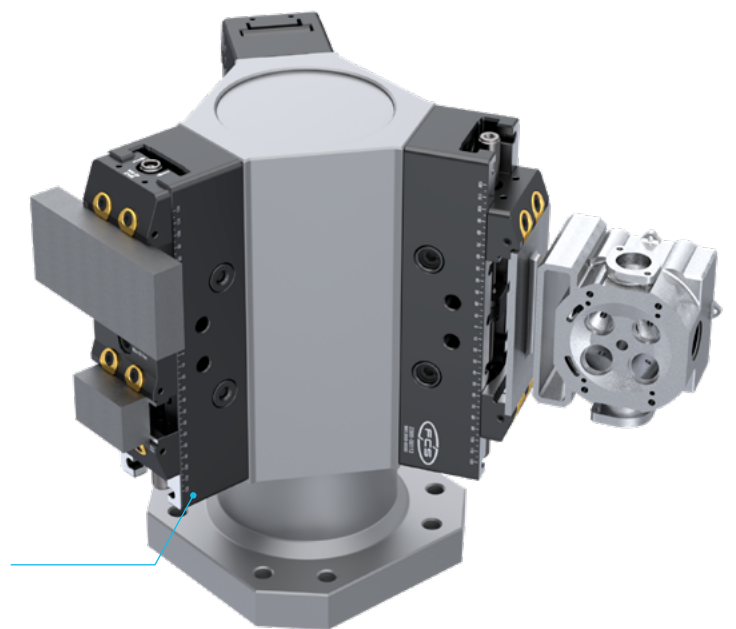
Movable on the FCS grid M16 step 50 and M12 step 25

### SELF-CENTERING CLAMP



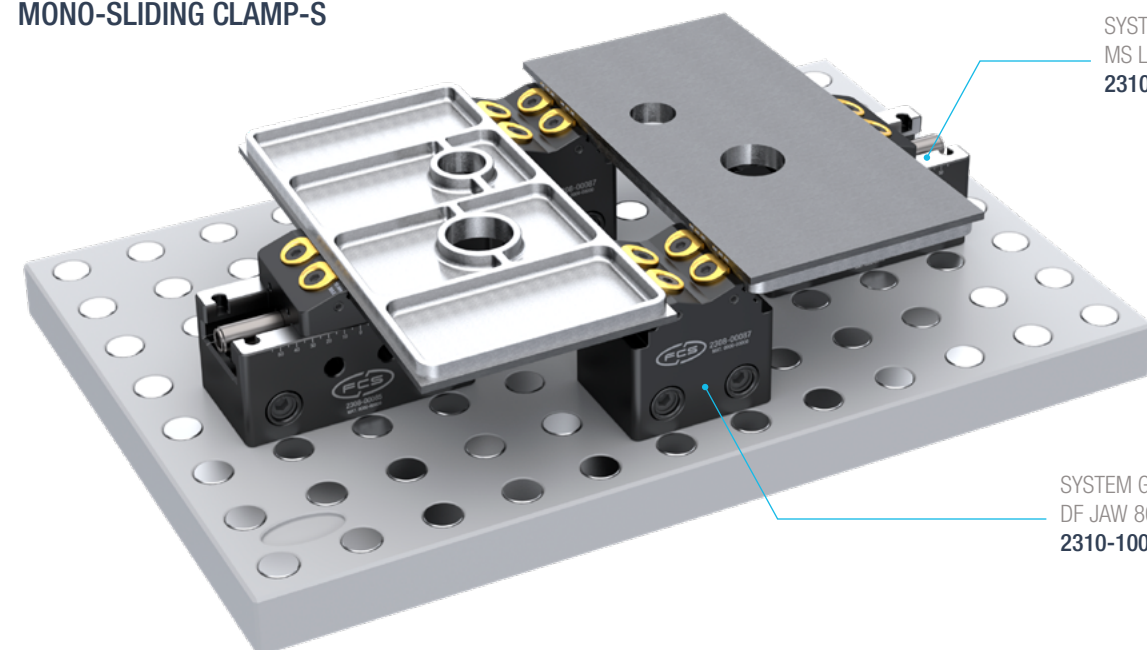
SYSTEM GRIP VISE 150x80  
SC L150 JAW 55 H2.5  
2310-15002

### SELF-CENTERING CLAMP and MONO-SLIDING CLAMP



SYSTEM GRIP VISE 280x80  
MS-SF L105 JAW 80 H5  
2310-30051

### MONO-SLIDING CLAMP-S



SYSTEM GRIP VISE 150x80  
MS L150 JAW 80 H5  
2310-15051

SYSTEM GRIP VISE 100x80  
DF JAW 80 H5  
2310-10001



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# INTRODUCTION AND KEY FEATURES

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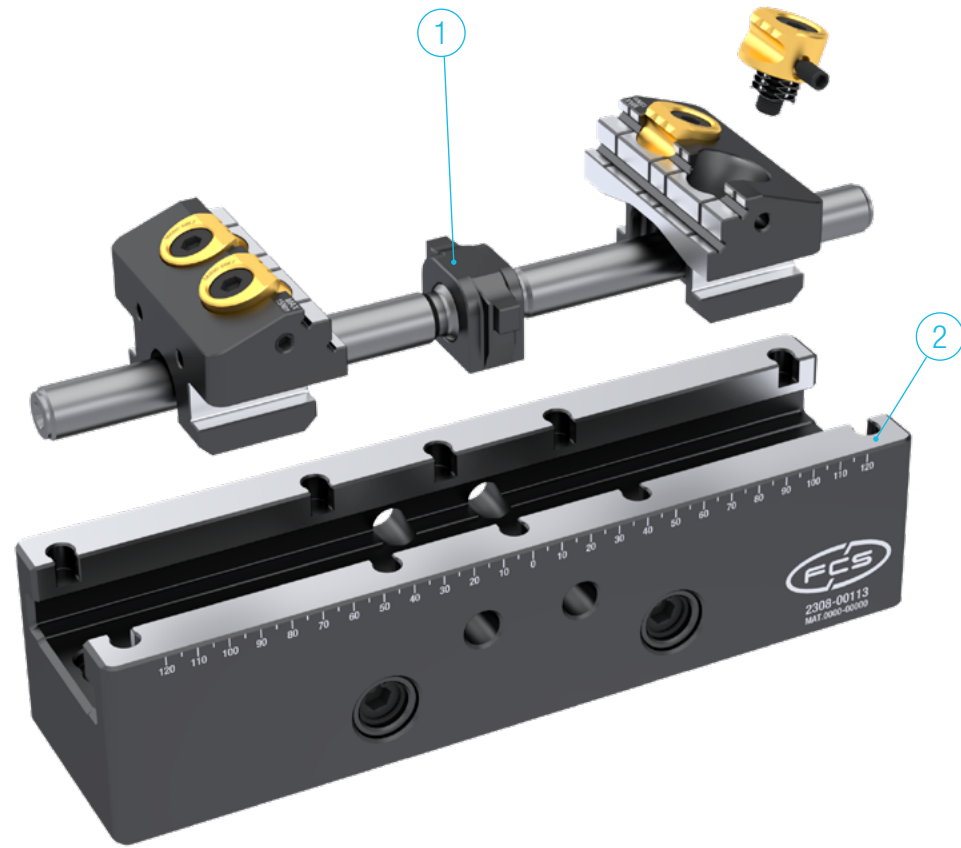
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### ASSEMBLY STRUCTURE:

1. KIT JAW (interchangeable)
2. VISE BASE

### CLAMPING SYSTEMS

Vises equipped with two different clamping mechanisms to reach a high workpiece grip without forcing its geometry:

- Main clamping system: sliding jaw mechanism (Figure 1)
- Auxiliary clamping system: gripping insert system (Figure 2)

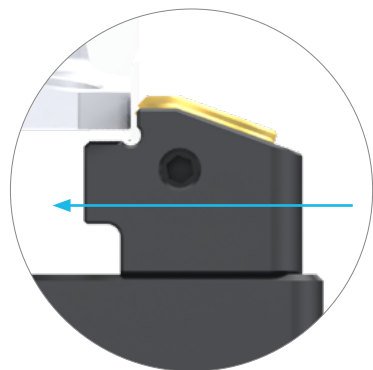


Figure 1: MAIN CLAMPING SYSTEM  
SLIDING JAW MECHANISM

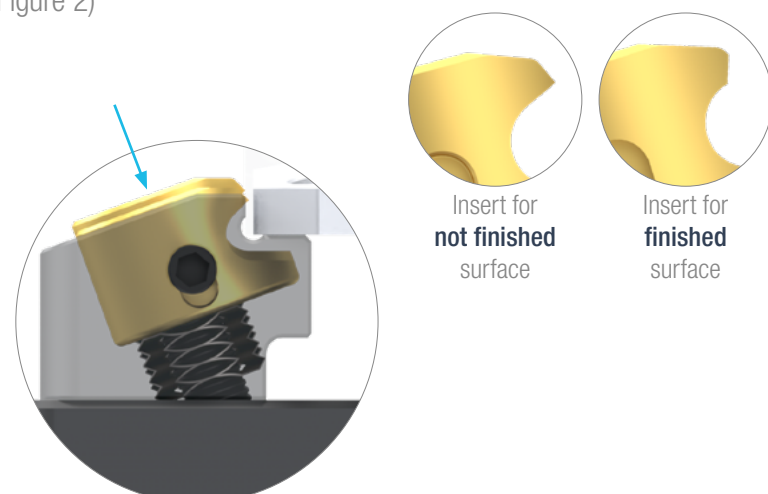
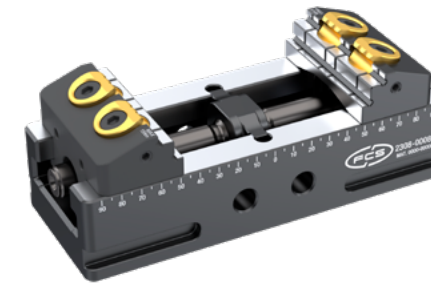


Figure 2: AUXILIARY CLAMPING SYSTEM  
GRIPPING INSERT SYSTEM

### CONFIGURATION TYPES



SELF CENTERING

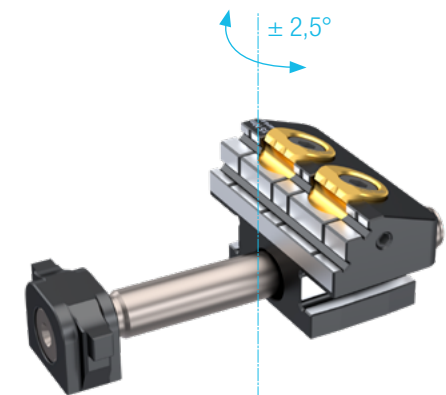


SELF CENTERING

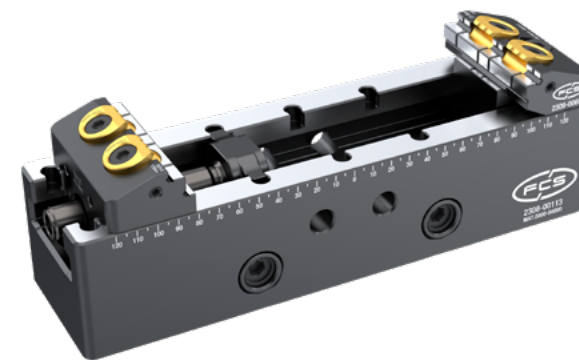


MONOSLIDING AND DOUBLE FIX

(by means two different vise bodies)



JAW 80 H5 SELF-FLOAT



MONOSLIDING AND SINGLE FIX

(integrated in the same VISE BASE)



KIT DF JAW 80 H2.5

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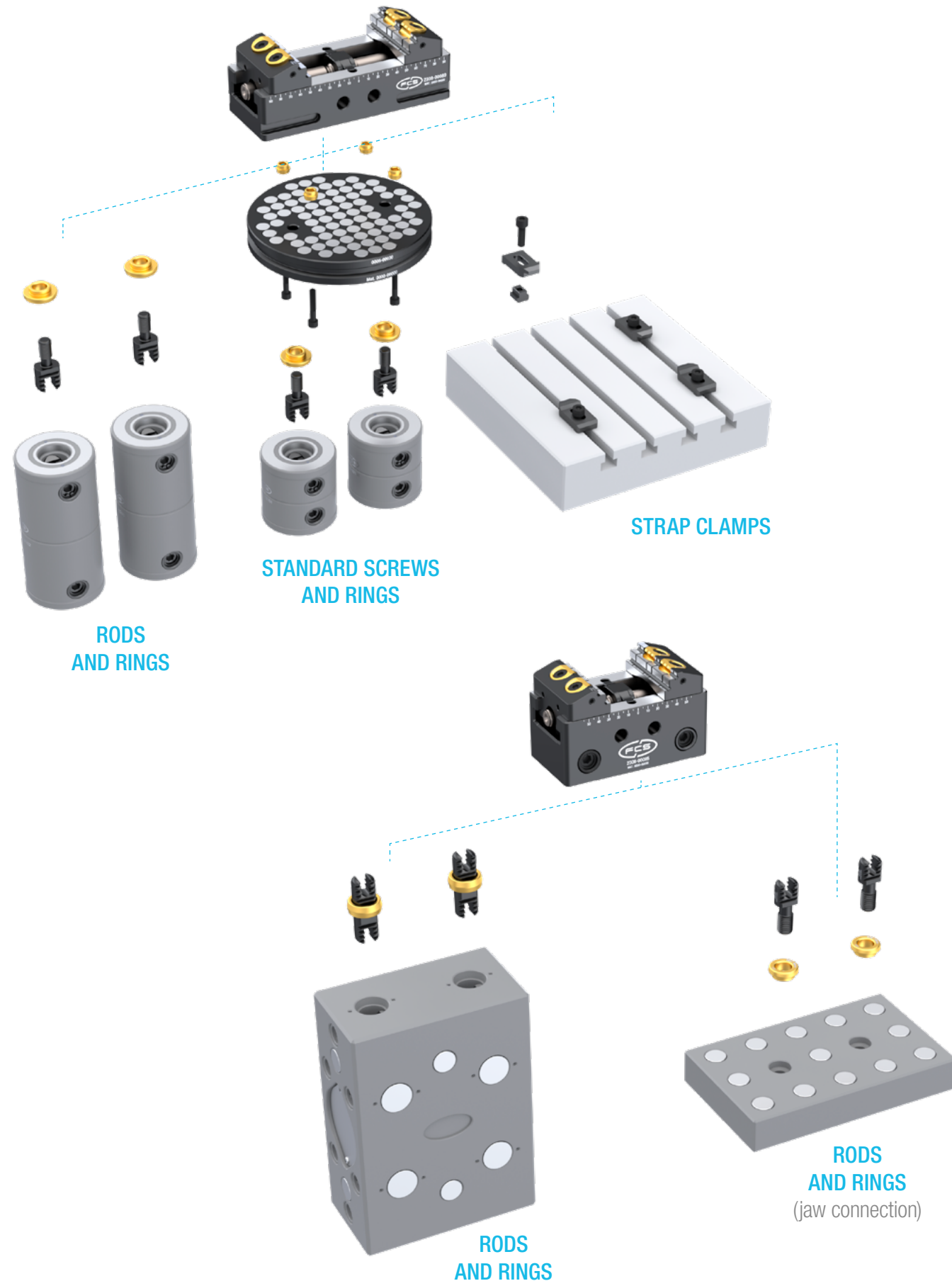
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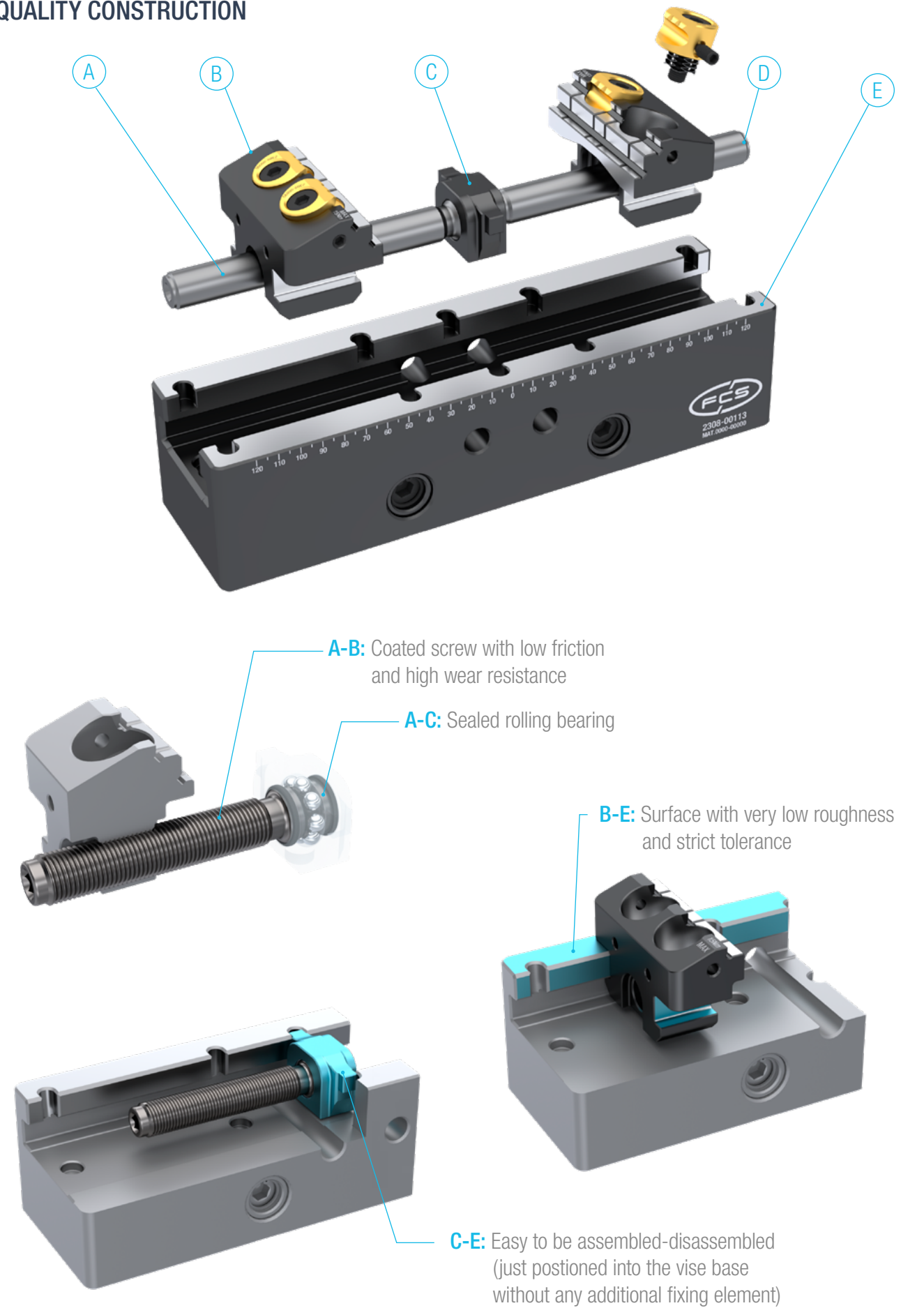
# INTRODUCTION AND KEY FEATURES

## BOTTOM FIXING TYPES

The bottom connection of the Vise can be of different types (depending on the VISE BASE):



## QUALITY CONSTRUCTION





# PRODUCT RANGE OVERVIEW

# PRODUCT RANGE OVERVIEW

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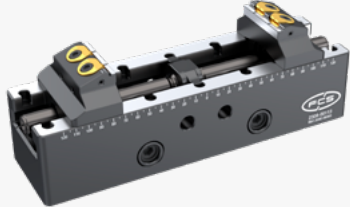
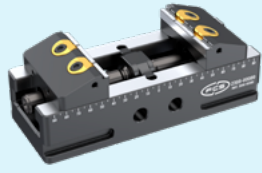
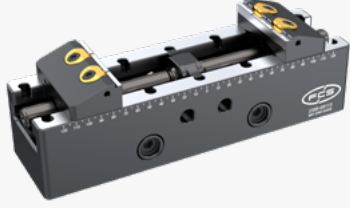
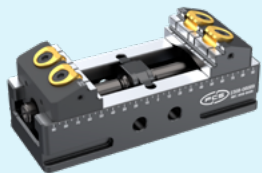

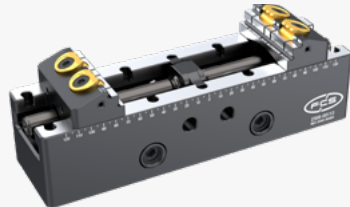
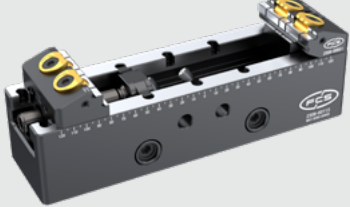
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	<b>SELF-CENTERING</b> Range (mm) Min 13 ÷ Max 155	<b>SELF-CENTERING CLAMP</b> Min 13 ÷ Max 105      Min 13 ÷ Max 235		<b>MONO-SLIDING CLAMP</b> Min 30 ÷ Max 220	<b>MONO-SLIDING CLAMP-S</b> Min 40*	
<b>H2.5 W55</b>	 SYSTEM GRIP VISE 200x80 SC L200 JAW 55 H2.5 2310-20002	 SYSTEM GRIP VISE 150x80 SC L150 JAW 55 H2.5 2310-15002	 SYSTEM GRIP VISE 280x80 SC L280 JAW 55 H2.5 2310-30002			
<b>H2.5 W80</b>	 SYSTEM GRIP VISE 200x80 SC L200 JAW 80 H2.5 2310-20003	 SYSTEM GRIP VISE 150x80 SC L150 JAW 80 H2.5 2310-15003	 SYSTEM GRIP VISE 280x80 SC L280 JAW 80 H2.5 2310-30003	 SYSTEM GRIP VISE 280x80 MS-SF L105 JAW 80 H2.5 2310-30052	 SYSTEM GRIP VISE 100x80 DF JAW 80 H2.5 2310-10002	 SYSTEM GRIP VISE 150x80 MS L150 JAW 80 H2.5 2310-15052
<b>H5 W80</b>	 SYSTEM GRIP VISE 200x80 SC L200 JAW 80 H5 2310-20001	 SYSTEM GRIP VISE 150x80 SC L150 JAW 80 H5 2310-15001	 SYSTEM GRIP VISE 280x80 SC L280 JAW 80 H5 2310-30001	 SYSTEM GRIP VISE 280x80 MS-SF L105 JAW 80 H5 2310-30051	 SYSTEM GRIP VISE 100x80 DF JAW 80 H5 2310-10001	 SYSTEM GRIP VISE 150x80 MS L150 JAW 80 H5 2310-15051

## HOW TO CHOOSE A PROPER VISE



\* The max value is not definable because depends mainly on:

- The workpiece geometry and material type
- Machining operation type

# KIT VISE CONFIGURATION

# KIT VISE CONFIGURATION

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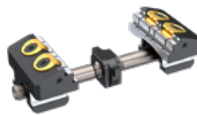


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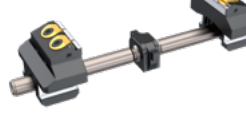

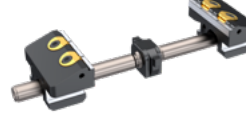

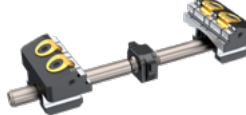
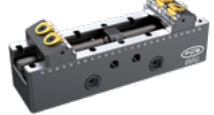






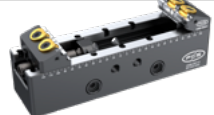

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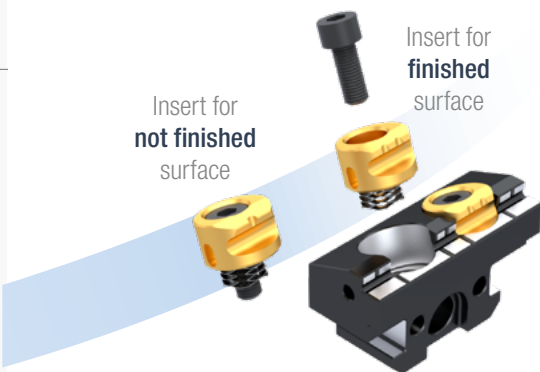
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WISE BASE	KIT VISE	SET VISE
 <p>WISE BASE M6-M12 200x80 H46 2308-00089</p>	 <p>KIT SC L200 JAW 55 H2.5 2309-00402</p>	 <p>SYSTEM GRIP VISE 200x80 SC L200 JAW 55 H2.5 2310-20002</p>
	 <p>KIT SC L200 JAW 80 H2.5 2309-00403</p>	 <p>SYSTEM GRIP VISE 200x80 SC L200 JAW 80 H2.5 2310-20003</p>
	 <p>KIT SC L200 JAW 80 H5 2309-00401</p>	 <p>SYSTEM GRIP VISE 200x80 SC L200 JAW 80 H5 2310-20001</p>
	 <p>KIT SC L200 JAW 80 H5 SELF-FLOAT 2309-00404</p>	-

WISE BASE	KIT VISE	SET VISE
 <p>WISE BASE 150x80 H65 2309-00200</p>	 <p>KIT SC L150 JAW 55 H2.5 2309-00302</p>	 <p>SYSTEM GRIP VISE 150x80 SC L150 JAW 55 H2.5 2310-15002</p>
	 <p>KIT SC L150 JAW 80 H2.5 2309-00303</p>	 <p>SYSTEM GRIP VISE 150x80 SC L150 JAW 80 H2.5 2310-15003</p>
	 <p>KIT SC L150 JAW 80 H5 2309-00301</p>	 <p>SYSTEM GRIP VISE 150x80 SC L150 JAW 80 H5 2310-15001</p>
	 <p>KIT SC L150 JAW 80 H5 SELF-FLOAT 2309-00304</p>	-
	 <p>KIT MS L150 JAW 80 H2.5 2309-00352</p>	 <p>SYSTEM GRIP VISE 150x80 MS L150 JAW 80 H2.5 2310-15052</p>
	 <p>KIT MS L150 JAW 80 H5 2309-00351</p>	 <p>SYSTEM GRIP VISE 150x80 MS L150 JAW 80 H5 2310-15051</p>
 <p>KIT MS L150 JAW 80 H5 SELF-FLOAT 2309-00353</p>	-	

WISE BASE	KIT VISE	SET VISE	
 <p>WISE BASE 280x80 H65 2309-00203</p>	 <p>KIT SC L280 JAW 55 H2.5 2309-00502</p>	 <p>SYSTEM GRIP VISE 280x80 SC L280 JAW 55 H2.5 2310-30002</p>	
	 <p>KIT SC L280 JAW 80 H2.5 2309-00503</p>	 <p>SYSTEM GRIP VISE 280x80 SC L280 JAW 80 H2.5 2310-30003</p>	
	 <p>KIT SC L280 JAW 80 H5 2309-00501</p>	 <p>SYSTEM GRIP VISE 280x80 SC L280 JAW 80 H5 2310-30001</p>	
	 <p>KIT SF JAW 80 H2.5 2309-00652</p>	 <p>KIT MS L105 JAW 80 H2.5 2309-00602</p>	 <p>SYSTEM GRIP VISE 280x80 MS-SF L105 JAW 80 H2.5 2310-30052</p>
	 <p>KIT DF JAW 80 H2.5 2309-00654</p>	-	
	 <p>KIT SF JAW 80 H5 2309-00651</p>	 <p>KIT MS L105 JAW 80 H5 2309-00601</p>	 <p>SYSTEM GRIP VISE 280x80 MS-SF L105 JAW 80 H5 2310-30051</p>
	 <p>KIT DF JAW 80 H5 2309-00653</p>	-	



		INSERT H2,5	INSERT H5
INSERT FOR	not finished surface	 <p>INSERT D.20 H13 NF 2309-00113</p>	 <p>INSERT D.24 H15 NF 2309-00090</p>
	finished surface	 <p>INSERT D.20 H13 F 2309-00112</p>	 <p>INSERT D.24 H15 F 2309-00089</p>

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# SELF-CENTERING

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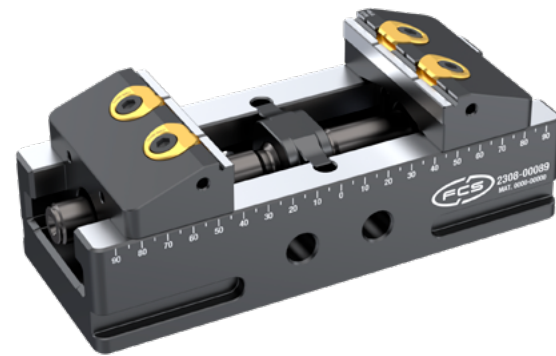
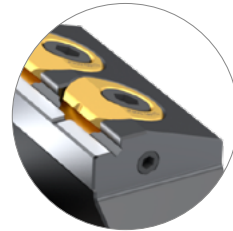
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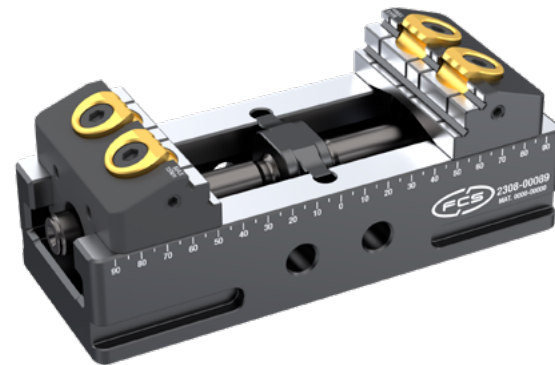
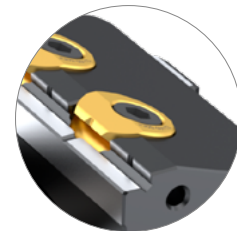
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SYSTEM GRIP VISE 200x80  
SC L200 JAW 55 H2.5  
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SYSTEM GRIP VISE 200x80  
SC L200 JAW 80 H2.5  
2310-20003



SYSTEM GRIP VISE 200x80  
SC L200 JAW 80 H5  
2310-20001

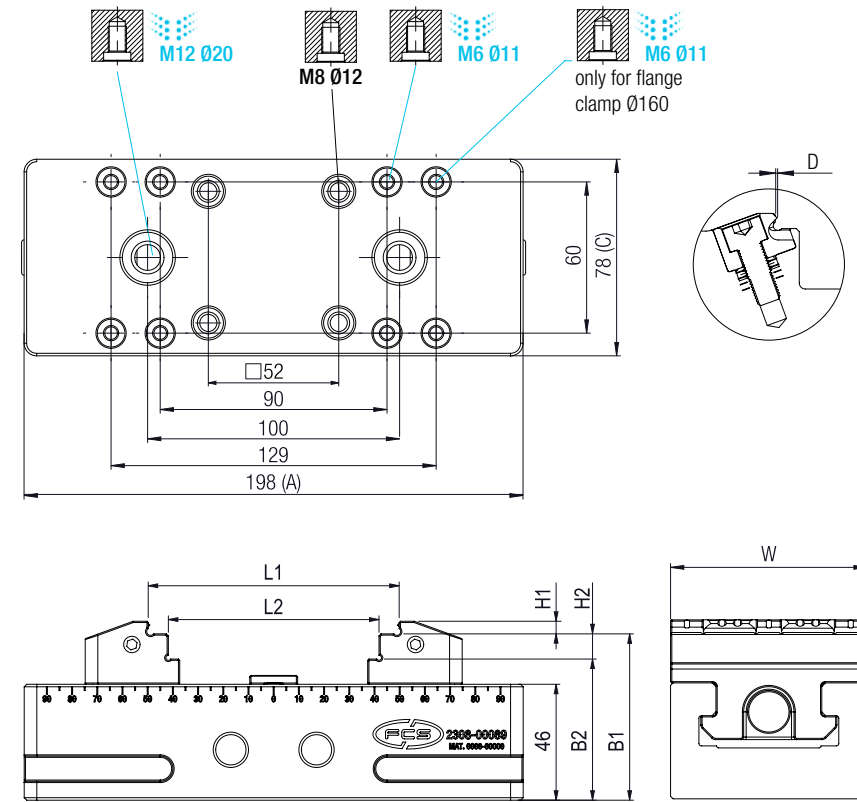


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(Nm)  
Max 60

**TORQUE FOR INSERT\***  
(Nm)  
Max 15

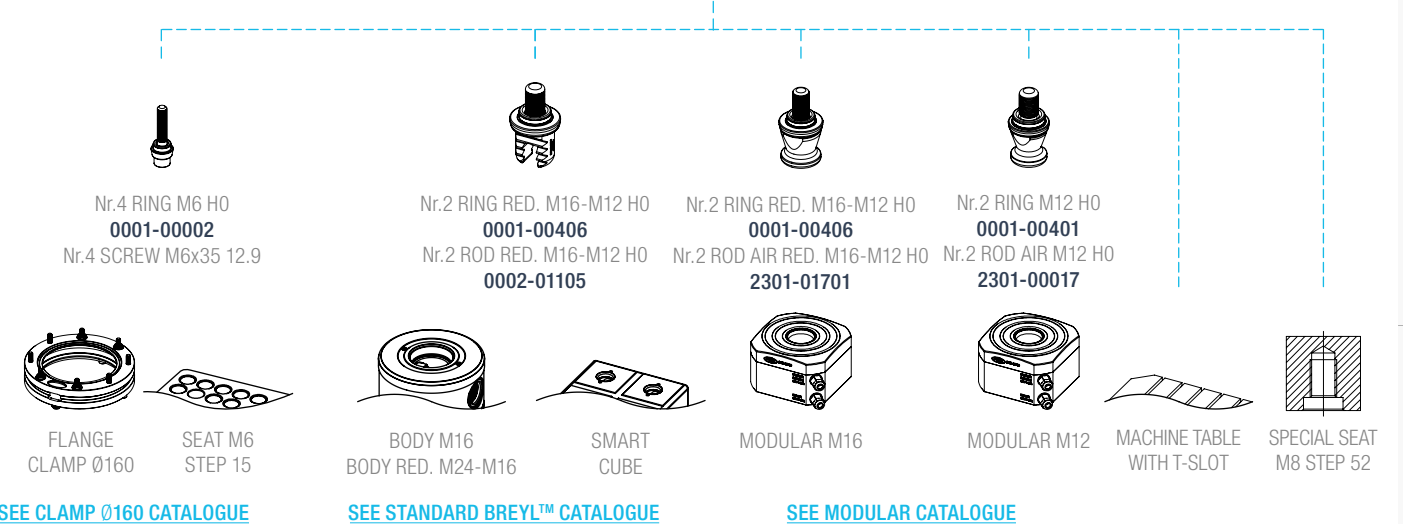
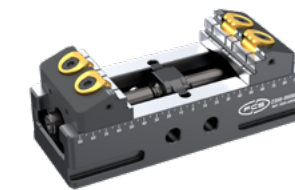
**CLAMPING FORCE**  
(N)  
20000

**ACCURACY**  
(mm)  
±0,02



SET CODE	H1 (mm)	H2 (mm)	W (mm)	L1 (mm)	L2 (mm)	A (mm)	B1 (mm)	B2 (mm)	C (mm)	D (mm)	SET WEIGHT (kg)
2310-20002	2,5	-	55	13 ÷ 127	-	198	76	-	78	0,6	5
2310-20003	2,5	-	78	20 ÷ 127	-	198	66	-	78	0,6	4.7
2310-20001	5	10	78	25 ÷ 140	10 ÷ 124	198	66	56	78	0,6	4.9

## BOTTOM CONNECTIONS INTERFACE



\* For details see the [TIGHTENING TORQUES AND CLAMPING FORCE PAGES](#)



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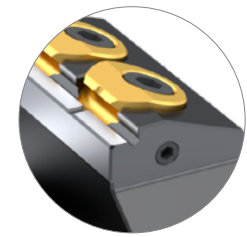
SYSTEM GRIP VISES

MODULAR GRIP VISES

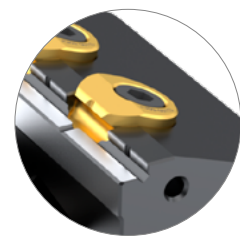
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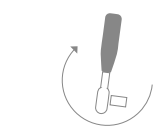
SYSTEM GRIP VISE 150x80  
SC L150 JAW 55 H2.5  
2310-15002



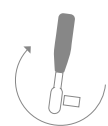
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SC L150 JAW 80 H2.5  
2310-15003



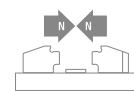
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SC L150 JAW 80 H5  
2310-15001



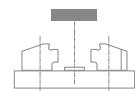
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Max 60



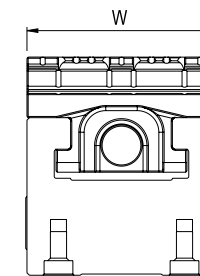
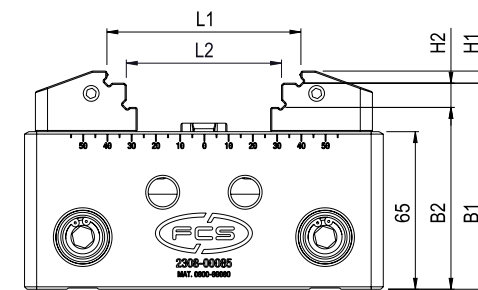
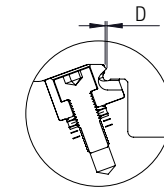
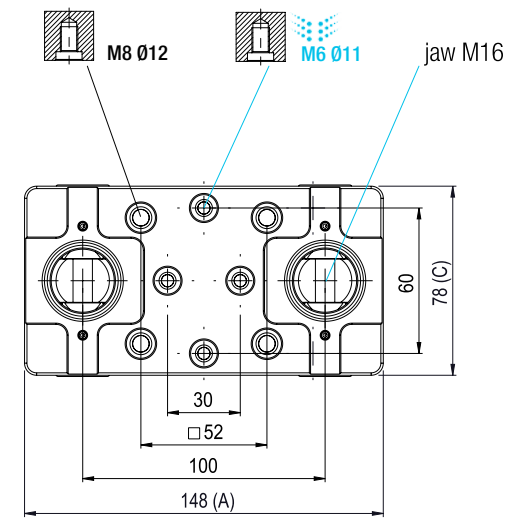
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(Nm)  
Max 15



**CLAMPING FORCE**  
(N)  
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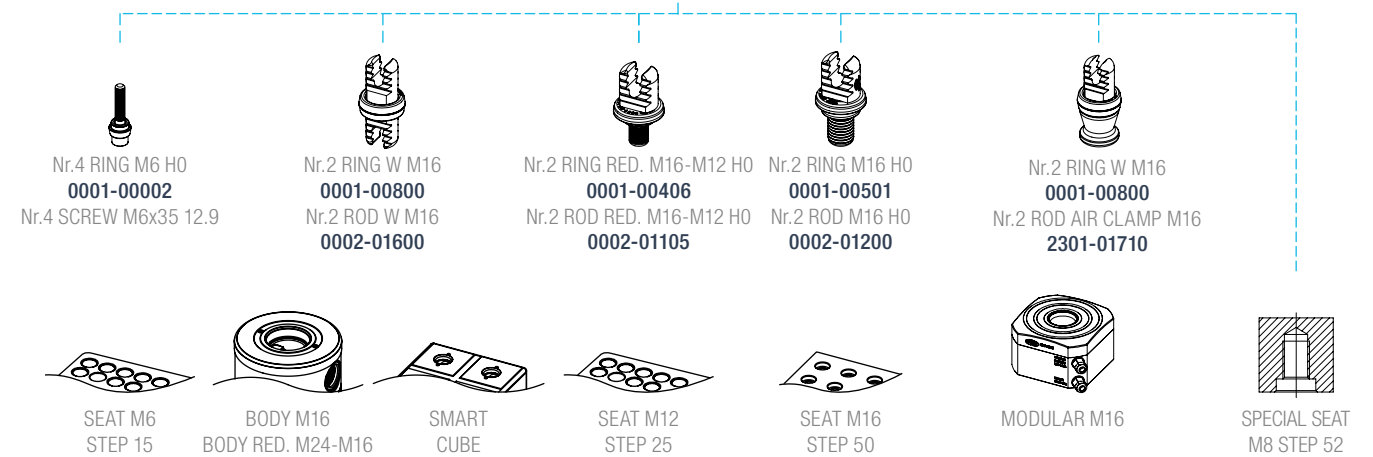


**ACCURACY**  
(mm)  
±0,02



SET CODE	H1 (mm)	H2 (mm)	W (mm)	L1 (mm)	L2 (mm)	A (mm)	B1 (mm)	B2 (mm)	C (mm)	D (mm)	SET WEIGHT (kg)
2310-15002	2,5	-	55	13 ÷ 77	-	148	95	-	78	0,6	5.1
2310-15003	2,5	-	78	20 ÷ 77	-	148	85	-	78	0,6	5.5
2310-15001	5	10	78	25 ÷ 90	10 ÷ 74	148	85	75	78	0,6	5.4

## BOTTOM CONNECTIONS INTERFACE



SEE STANDARD BREYL™ CATALOGUE

SEE MODULAR CATALOGUE

\* For details see the [TIGHTENING TORQUES AND CLAMPING FORCE PAGES](#)



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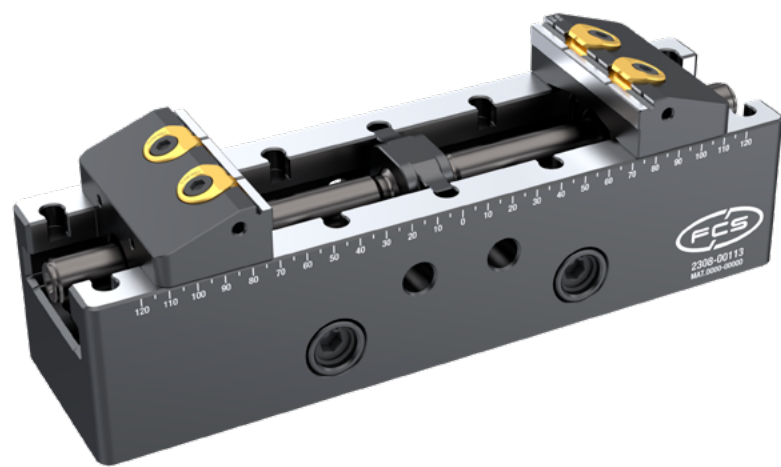
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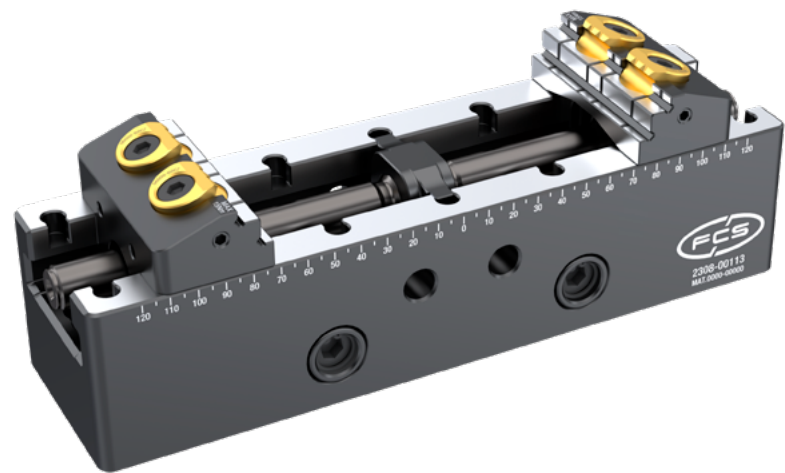
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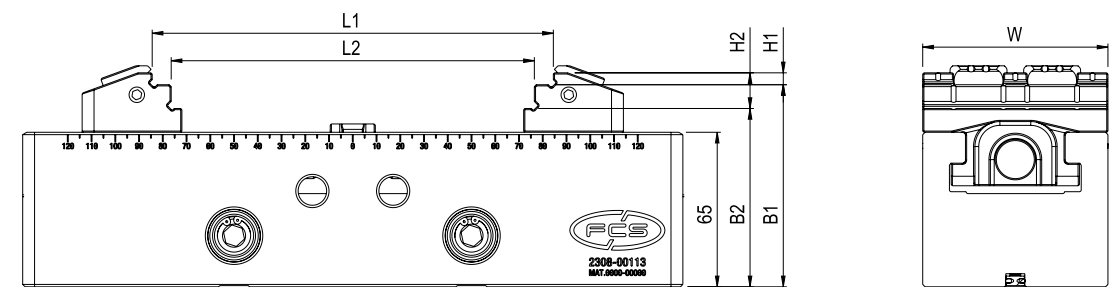
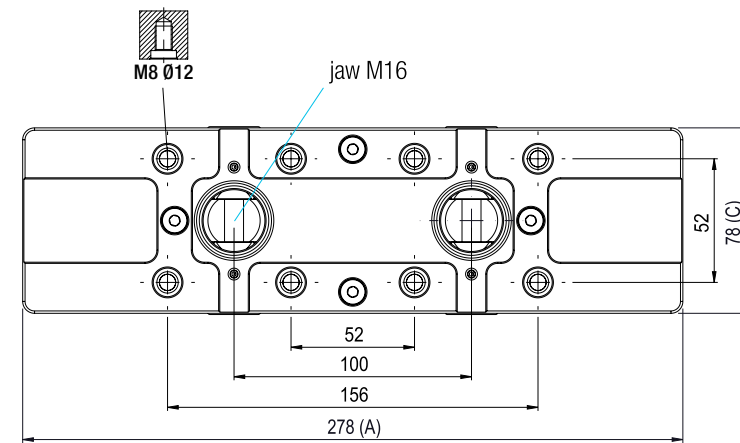
SYSTEM GRIP VISE 280x80  
SC L280 JAW 55 H2.5  
2310-30002



SYSTEM GRIP VISE 280x80  
SC L280 JAW 80 H2.5  
2310-30003

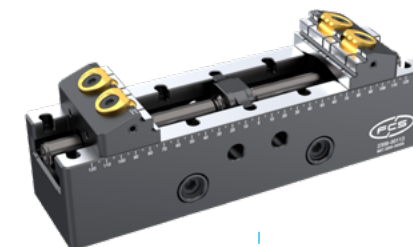


SYSTEM GRIP VISE 280x80  
SC L280 JAW 80 H5  
2310-30001



SET CODE	H1 (mm)	H2 (mm)	W (mm)	L1 (mm)	L2 (mm)	A (mm)	B1 (mm)	B2 (mm)	C (mm)	D (mm)	SET WEIGHT (kg)
2310-30002	2,5	-	55	13 ÷ 207	-	278	95	-	78	0,6	9.5
2310-30003	2,5	-	78	20 ÷ 207	-	278	85	-	78	0,6	9.2
2310-30001	5	10	78	25 ÷ 220	10 ÷ 204	278	85	75	78	0,6	9.5

## BOTTOM CONNECTIONS INTERFACE



Nr.2 RING W M16  
0001-00800  
Nr.2 ROD W M16  
0002-01600

Nr.2 RING RED. M16-M12 HO  
0001-00406  
Nr.2 ROD RED. M16-M12 HO  
0002-01105

Nr.2 RING M16 HO  
0001-00501  
Nr.2 ROD M16 HO  
0002-01200

Nr.2 RING W M16  
0001-00800  
Nr.2 ROD AIR CLAMP M16  
2301-01710

BODY M16  
BODY RED. M24-M16

SMART  
CUBE

SEAT M12  
STEP 25

SEAT M16  
STEP 50

MODULAR M16

SPECIAL SEAT  
M8 STEP 52

SEE STANDARD BREYL™ CATALOGUE

SEE MODULAR CATALOGUE

TORQUE FOR JAW\*  
(Nm)  
Max 60

TORQUE FOR INSERT\*  
(Nm)  
Max 15

CLAMPING FORCE  
(N)  
20000

ACCURACY  
(mm)  
±0,02

\* For details see the [TIGHTENING TORQUES AND CLAMPING FORCE PAGES](#)

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# MONO-SLIDING CLAMP

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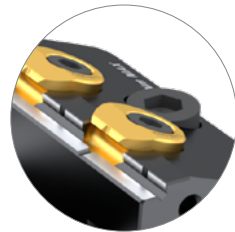
SYSTEM GRIP VISES

MODULAR GRIP VISES

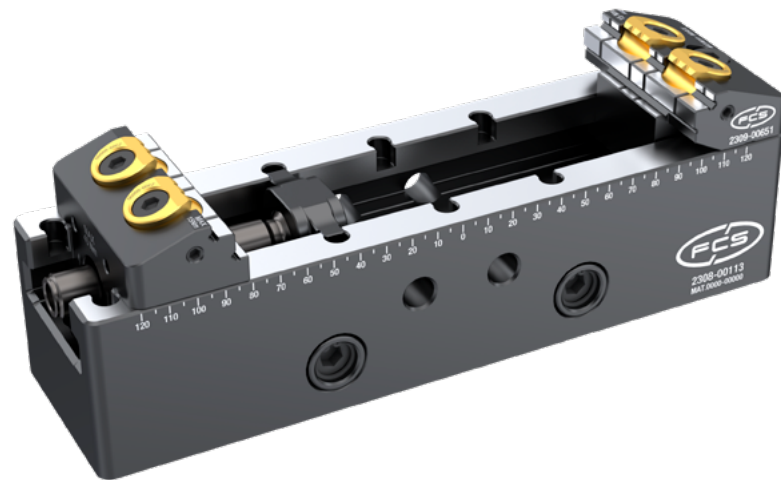
ACCESSORIES  
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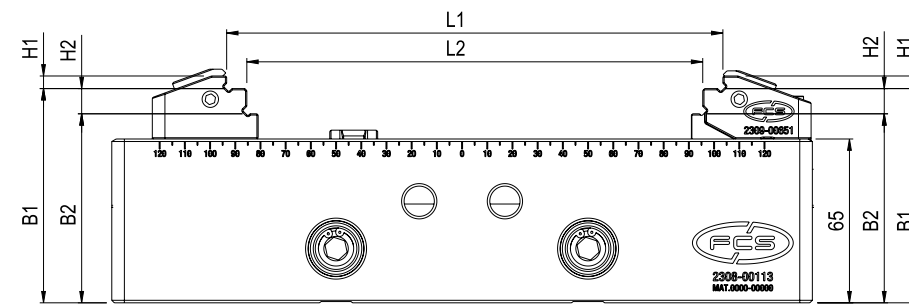
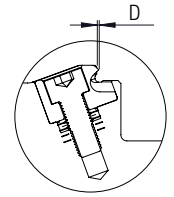
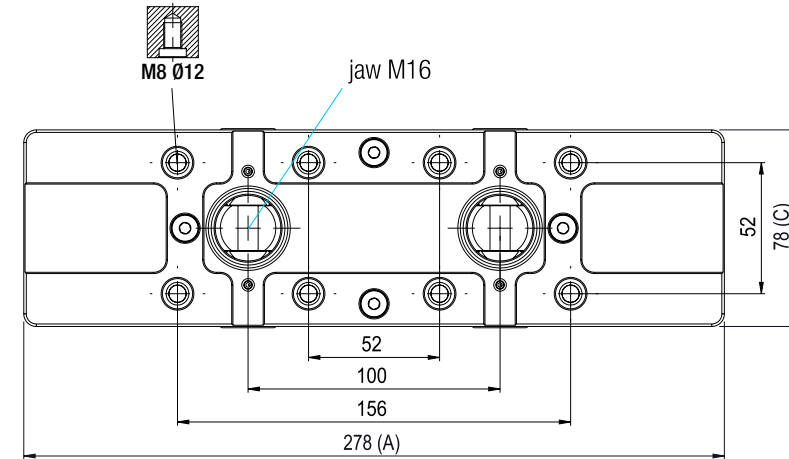
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SYSTEM GRIP VISE 280x80  
MS-SF L105 JAW 80 H2.5  
2310-30052

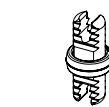
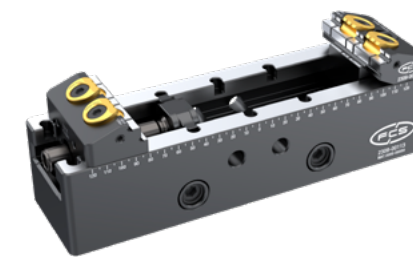


SYSTEM GRIP VISE 280x80  
MS-SF L105 JAW 80 H5  
2310-30051



SET CODE	H1 (mm)	H2 (mm)	W (mm)	L1 (mm)	L2 (mm)	A (mm)	B1 (mm)	B2 (mm)	C (mm)	D (mm)	SET WEIGHT (kg)
2310-30052	2,5	-	78	27 ÷ 205	-	278	85	-	78	0,6	9.1
2310-30051	5	10	78	30 ÷ 214	58 ÷ 198	278	85	75	78	0,6	9.3

## BOTTOM CONNECTIONS INTERFACE



Nr.2 RING W M16  
0001-00800  
Nr.2 ROD W M16  
0002-01600



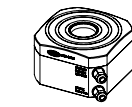
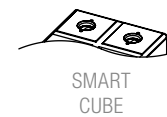
Nr.2 RING RED. M16-M12 H0  
0001-00406  
Nr.2 ROD RED. M16-M12 H0  
0002-01105



Nr.2 RING M16 H0  
0001-00501  
Nr.2 ROD M16 H0  
0002-01200

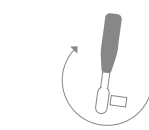


Nr.2 RING W M16  
0001-00800  
Nr.2 ROD AIR CLAMP M16  
2301-01710

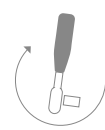


SEE STANDARD BREYL™ CATALOGUE

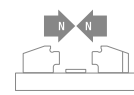
SEE MODULAR CATALOGUE



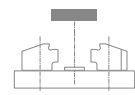
TORQUE FOR JAW\*  
(Nm)  
Max 60



TORQUE FOR INSERT\*  
(Nm)  
Max 15



CLAMPING FORCE  
(N)  
20000



ACCURACY  
(mm)  
±0,02

\* For details see the [TIGHTENING TORQUES AND CLAMPING FORCE PAGES](#)

# MONO-SLIDING CLAMP-S

# MONO-SLIDING CLAMP-S

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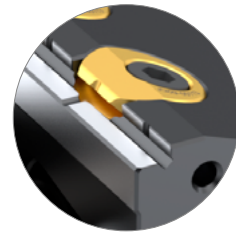
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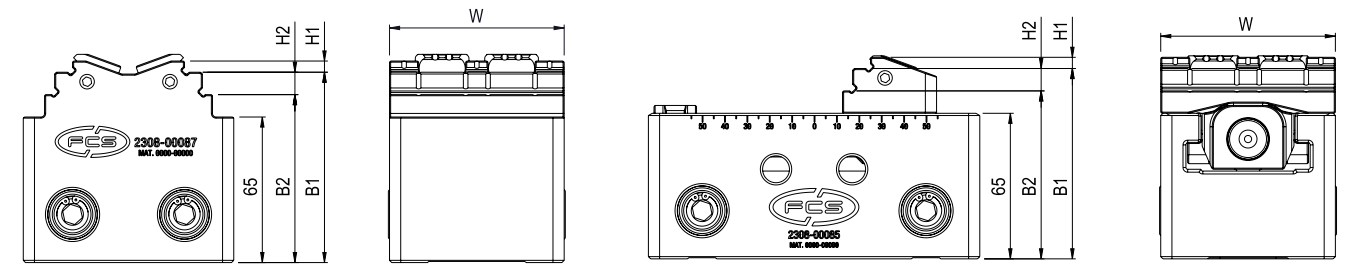
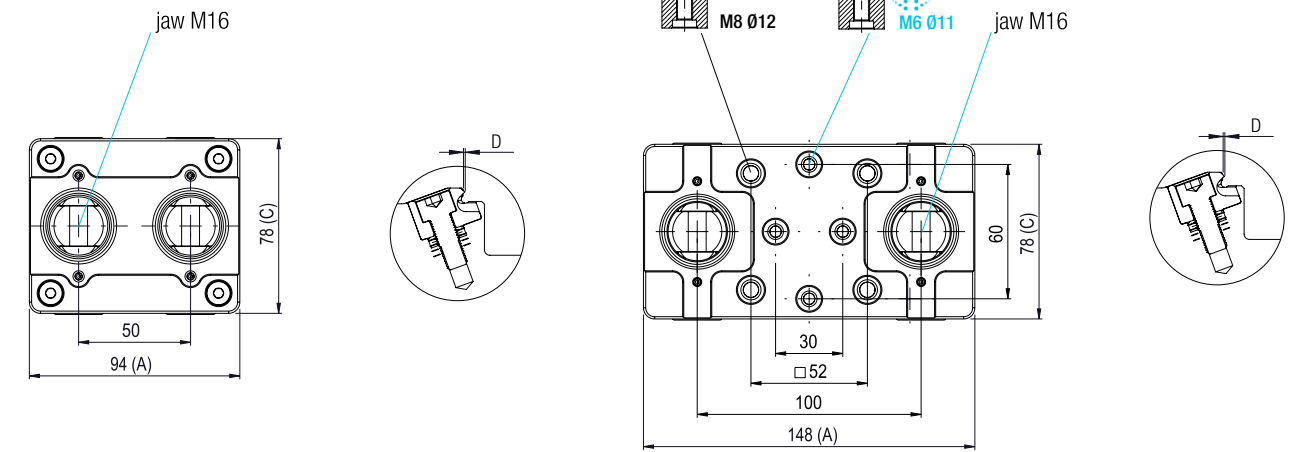
INDEX



SYSTEM GRIP VISE 100x80  
DF JAW 80 H2.5  
2310-10002



SYSTEM GRIP VISE 150x80  
MS L150 JAW 80 H2.5  
2310-15052



SET CODE	H1 (mm)	H2 (mm)	W (mm)	L (mm)	A (mm)	B1 (mm)	B2 (mm)	C (mm)	D (mm)	SET WEIGHT (kg)
2310-10002	2,5	-	78	-	98	85	-	78	0,6	4.4
2310-10001	5	10	78	-	98	85	75	78	0,6	4.5
2310-15052	2,5	-	78	-	148	85	-	78	0,6	4.7
2310-15051	5	10	78	-	148	85	75	78	0,6	4.8

## BOTTOM CONNECTIONS INTERFACE



Nr.2 RING RED. M16-M12 H0  
0001-00406  
Nr.2 ROD RED. M16-M12 H0  
0002-01105



SEAT M12  
STEP 25



Nr.2 RING M16 H0  
0001-00501  
Nr.2 ROD M16 H0  
0002-01200



SEAT M16  
STEP 50



Nr.2 RING RED. M16-M12 H0  
0001-00406  
Nr.2 ROD RED. M16-M12 H0  
0002-01105



SEAT M12  
STEP 25



Nr.2 RING M16 H0  
0001-00501  
Nr.2 ROD M16 H0  
0002-01200



SEAT M16  
STEP 50



SPECIAL SEAT  
M8 STEP 52

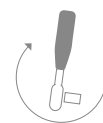
SEE STANDARD BREYL™ CATALOGUE



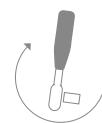
SYSTEM GRIP VISE 100x80  
DF JAW 80 H5  
2310-10001



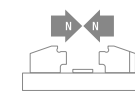
SYSTEM GRIP VISE 150x80  
MS L150 JAW 80 H5  
2310-15051



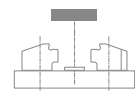
TORQUE FOR JAW\*  
(Nm)  
Max 40



TORQUE FOR INSERT\*  
(Nm)  
Max 15



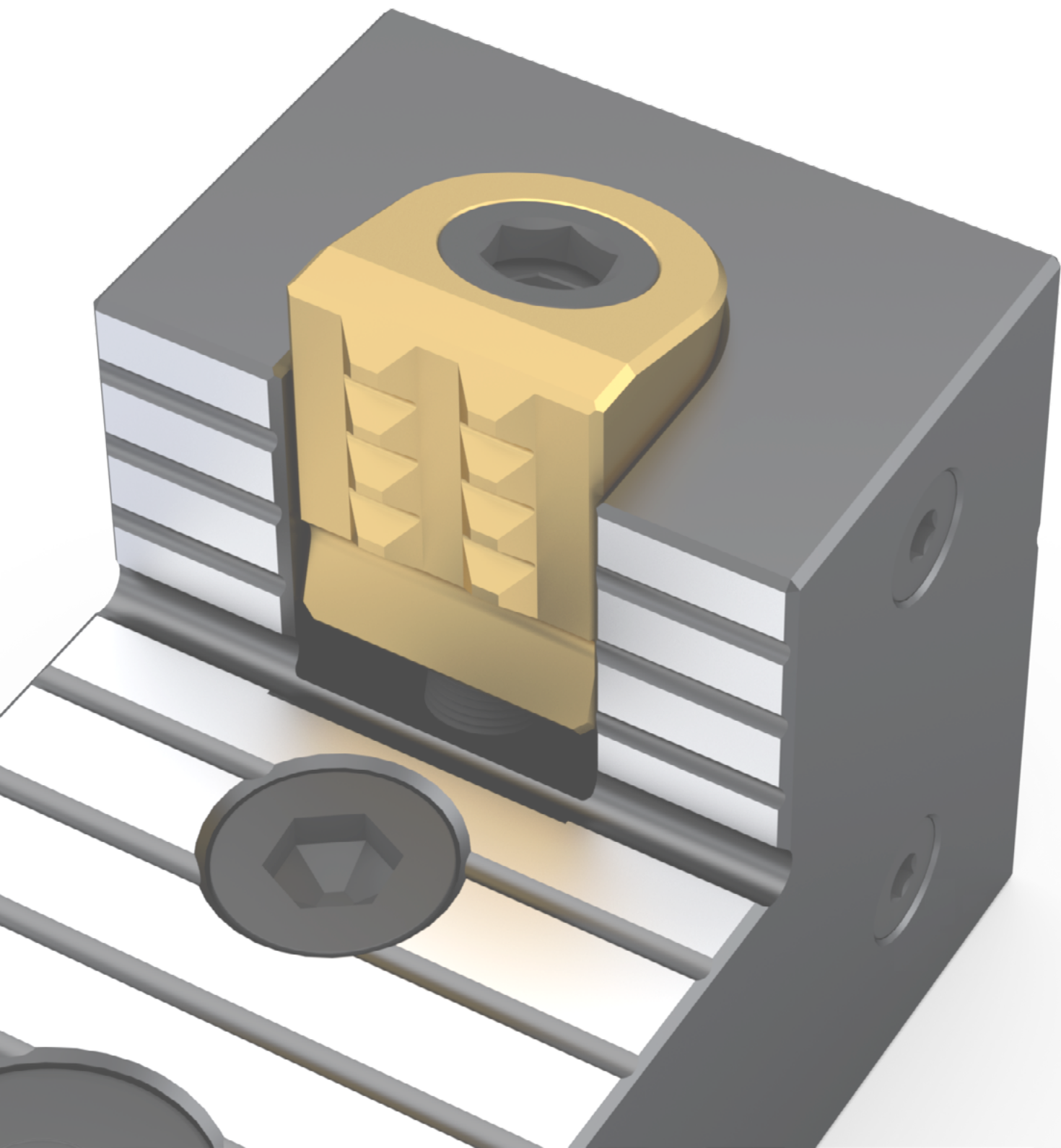
CLAMPING FORCE  
(N)  
20000



ACCURACY  
(mm)  
±0,02

\* For details see the [TIGHTENING TORQUES AND CLAMPING FORCE PAGES](#)





# MODULAR GRIP VISES



Integrated systems for production



# INTRODUCTION AND KEY FEATURES

# APPLICATION EXAMPLES

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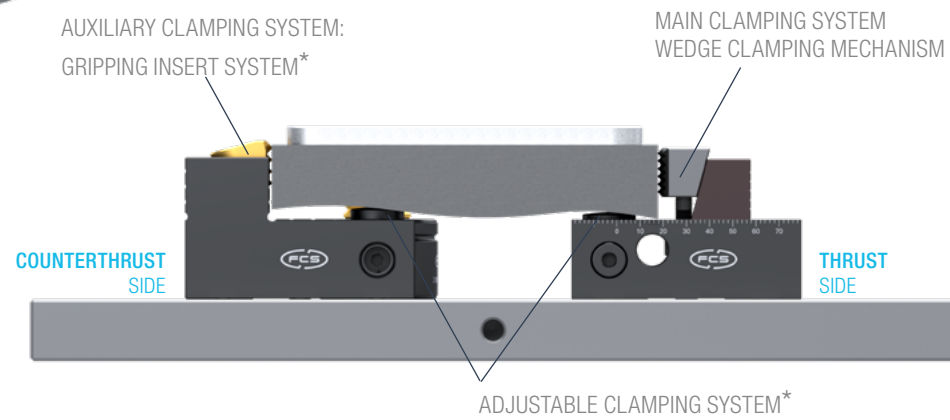
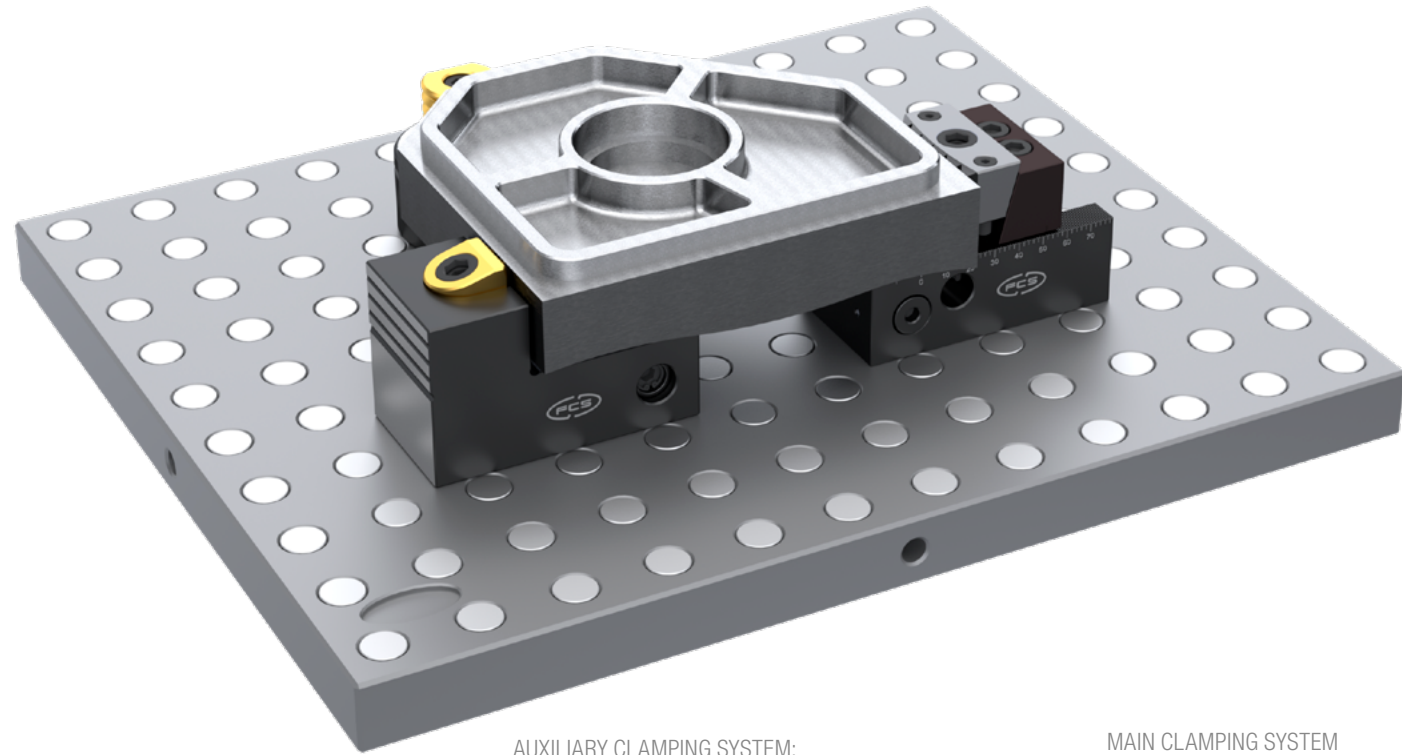
SYSTEM GRIP VISES

MODULAR GRIP VISES

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## Key strengths and main features

Gripping height range: 40 and 100mm

Strong workpiece grip and stability by the following:

- Main clamping system: wedge clamping mechanism with the option to transfer the clamping force only horizontally
- Auxiliary clamping system: gripping insert system\*
- Adjustable levelling system\* (the piston can lift the workpiece or compensate the surface irregularity)

High gripping flexibility:

- different shape of gripping jaws
- different type of inserts (for finished and not finished surfaces)\*

Easy to be fixed and centered

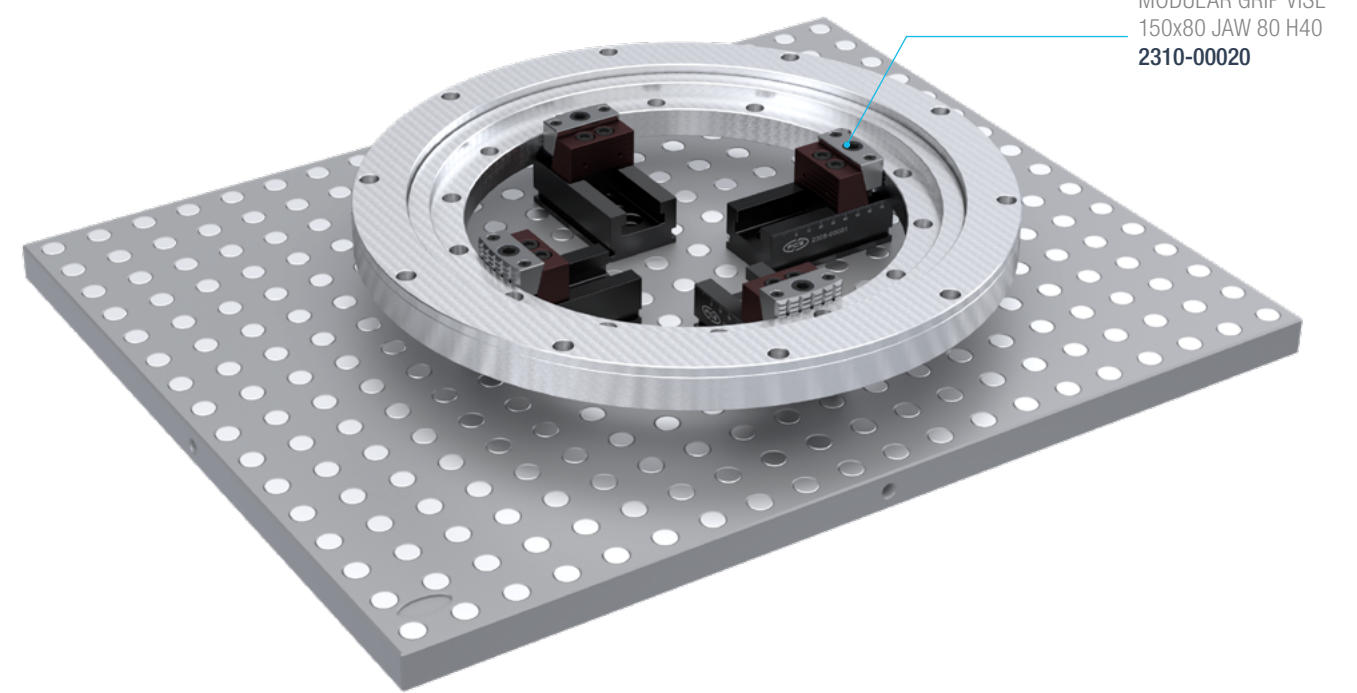
Movable on the FCS grid M16 step 50 and M12 step 25

No preliminary work of the part to be clamped is required

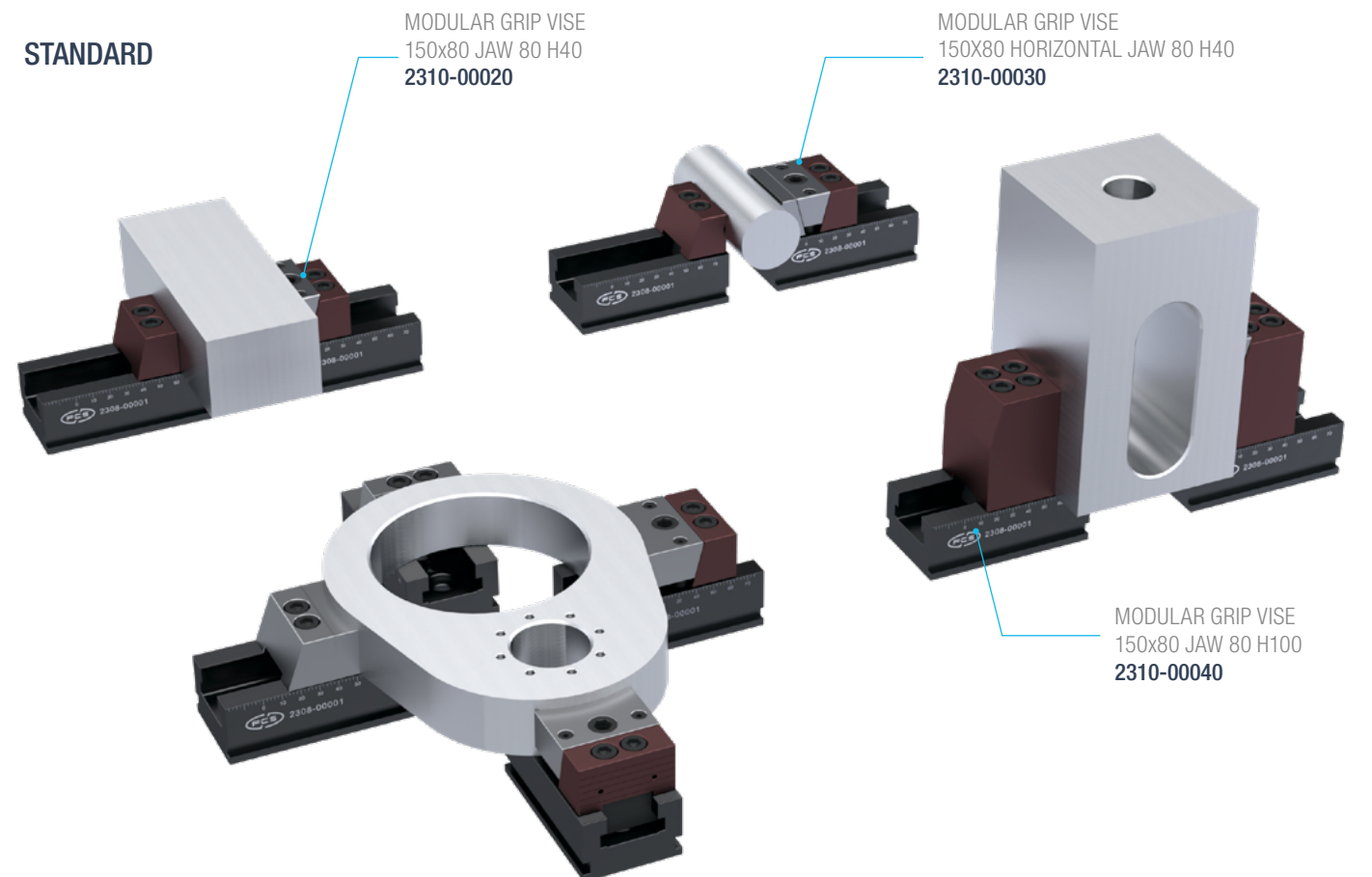
Option to raise the vises in a higher position on FCS clamping supports

\*Only for models which are equipped with

## STANDARD



## STANDARD

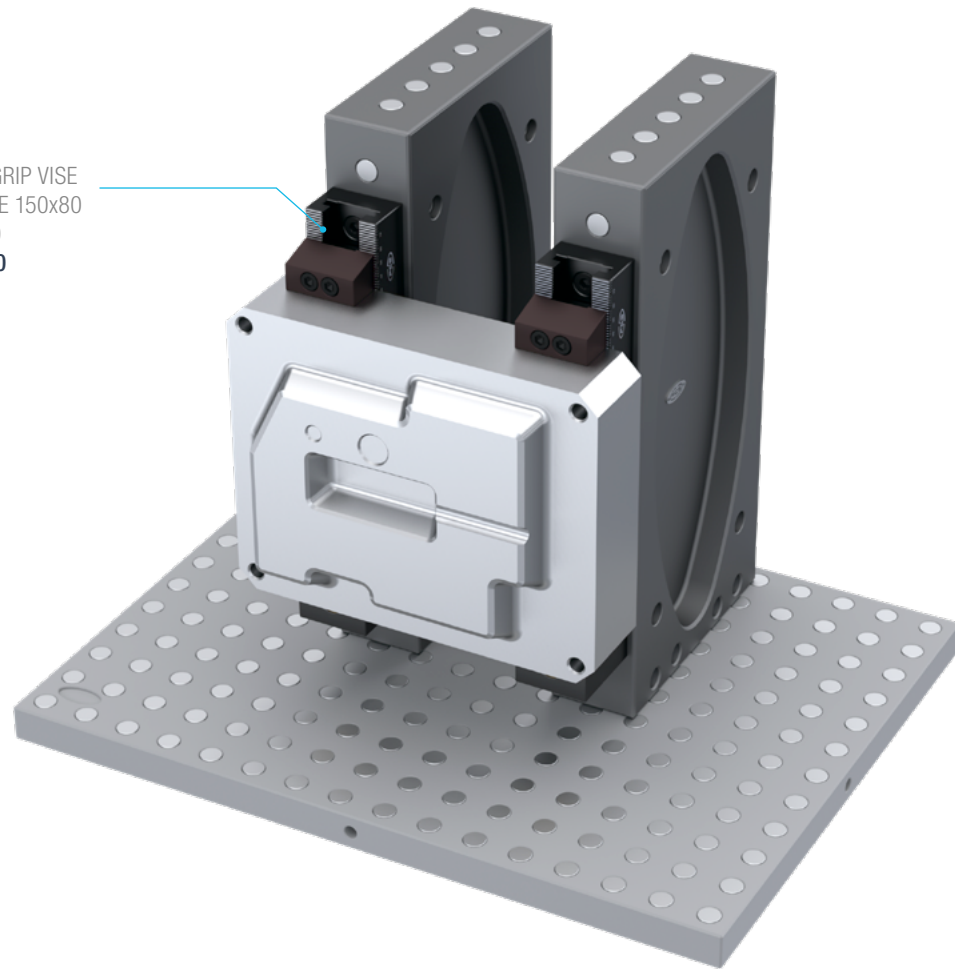


# APPLICATION EXAMPLES

# APPLICATION EXAMPLES

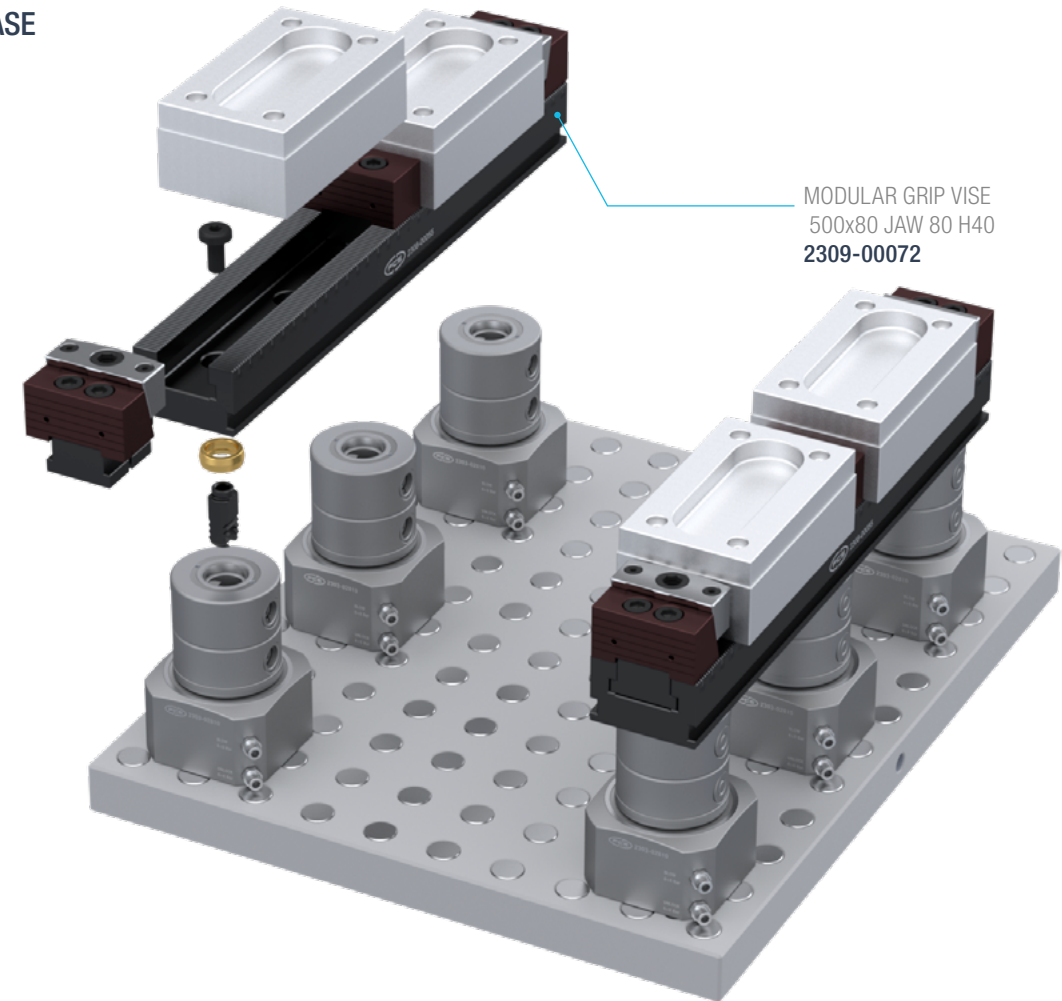
## ADJUSTABLE

MODULAR GRIP VISE  
ADJUSTABLE 150x80  
JAW 80 H40  
2310-00060



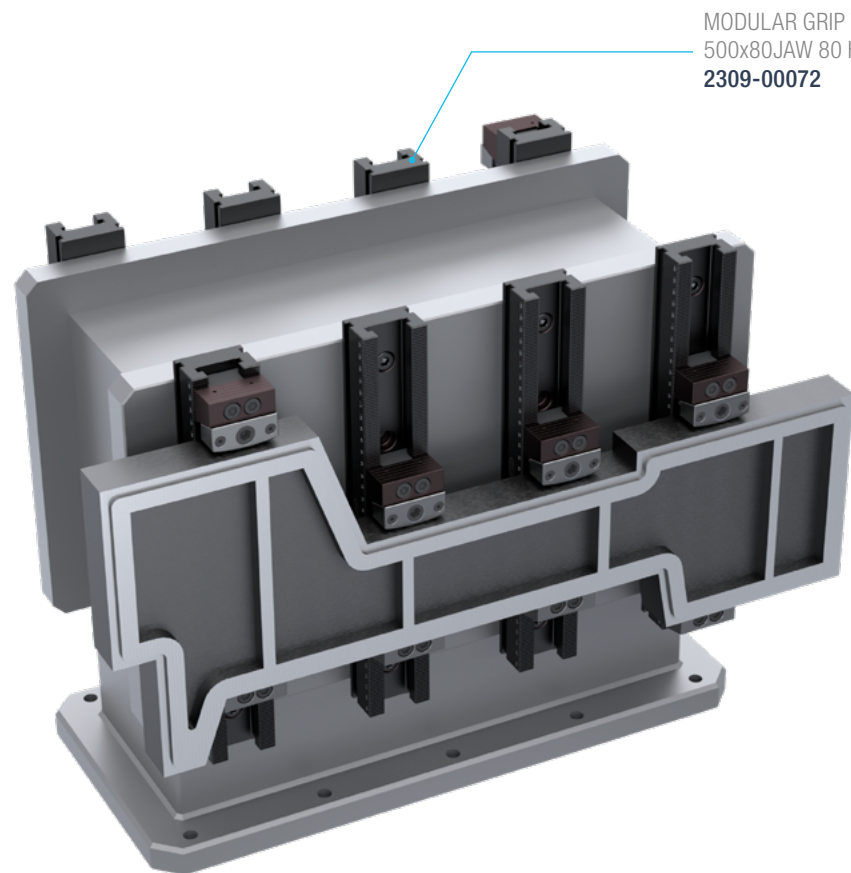
## LONG BASE

MODULAR GRIP VISE  
500x80 JAW 80 H40  
2309-00072



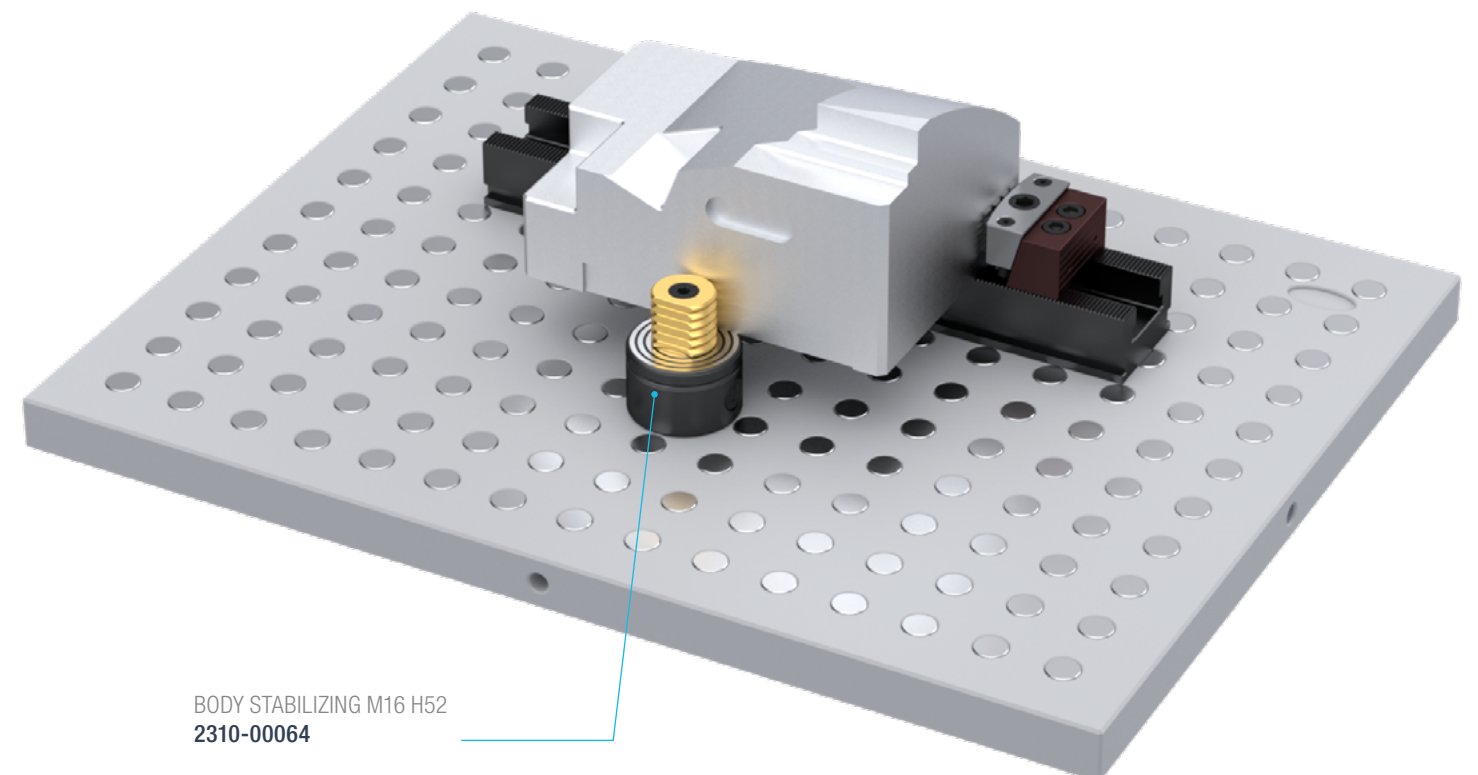
## LONG BASE

MODULAR GRIP VISE  
500x80JAW 80 H40  
2309-00072



## BODY STABILIZING

BODY STABILIZING M16 H52  
2310-00064





# PRODUCT RANGE OVERVIEW

# PRODUCT RANGE OVERVIEW

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MODULAR GRIP VISES

MODULAR GRIP VISES

Range (mm)	STANDARD Min 10*	ADJUSTABLE Min 140*	LONG BASE Min 10 ÷ Max 395
H40 W80	 <p>MODULAR GRIP VISE 150x80 JAW 80 H40 <b>2310-00020</b></p>  <p>MODULAR GRIP VISE 150x80 HORIZONTAL JAW 80 H40 <b>2310-00030</b></p>	 <p>MODULAR GRIP VISE ADJUSTABLE 150x80 JAW 80 H40 <b>2310-00060</b></p>	 <p>MODULAR GRIP VISE 500x80 JAW 80 H40 <b>2309-00072</b></p>
H100 W80	 <p>MODULAR GRIP VISE 150x80 JAW 80 H100 <b>2310-00040</b></p>		

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SPARE PARTS

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## HOW TO CHOOSE A PROPER VISE



\* The max value is not definable because depends mainly on:

- The workpiece geometry and material type
- Machining operation type

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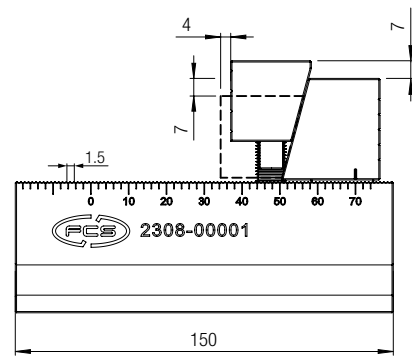
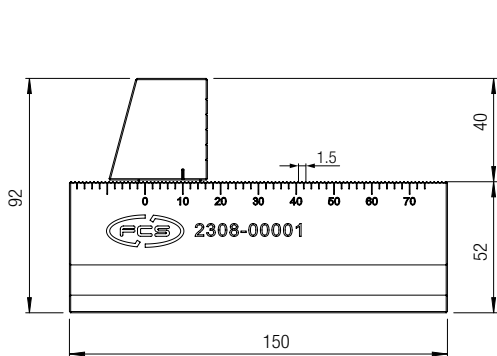
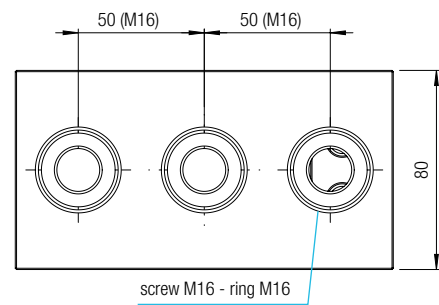
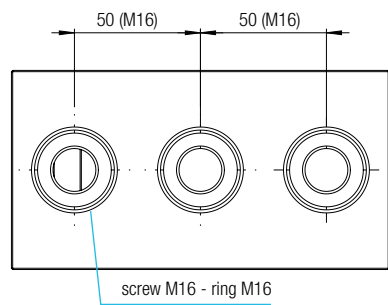
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MODULAR GRIP VISE  
150x80 JAW 80 H40  
2310-00020

Description	Qty	CODE
1 VISE BASE M16 150x80 H52	2	2308-00001
2 FIXED JAW 80 H40	2	2309-00022
3 DESCENDING JAW 80 H32	1	2309-00024
4 RING M16 D.24 H0	4	0001-00501
5 SPECIAL SCREW M16	4	4521-00001

set weight 8.8 kg



TORQUE FOR JAW\*  
(Nm)

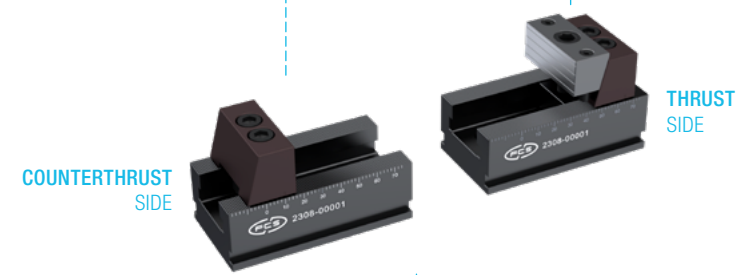
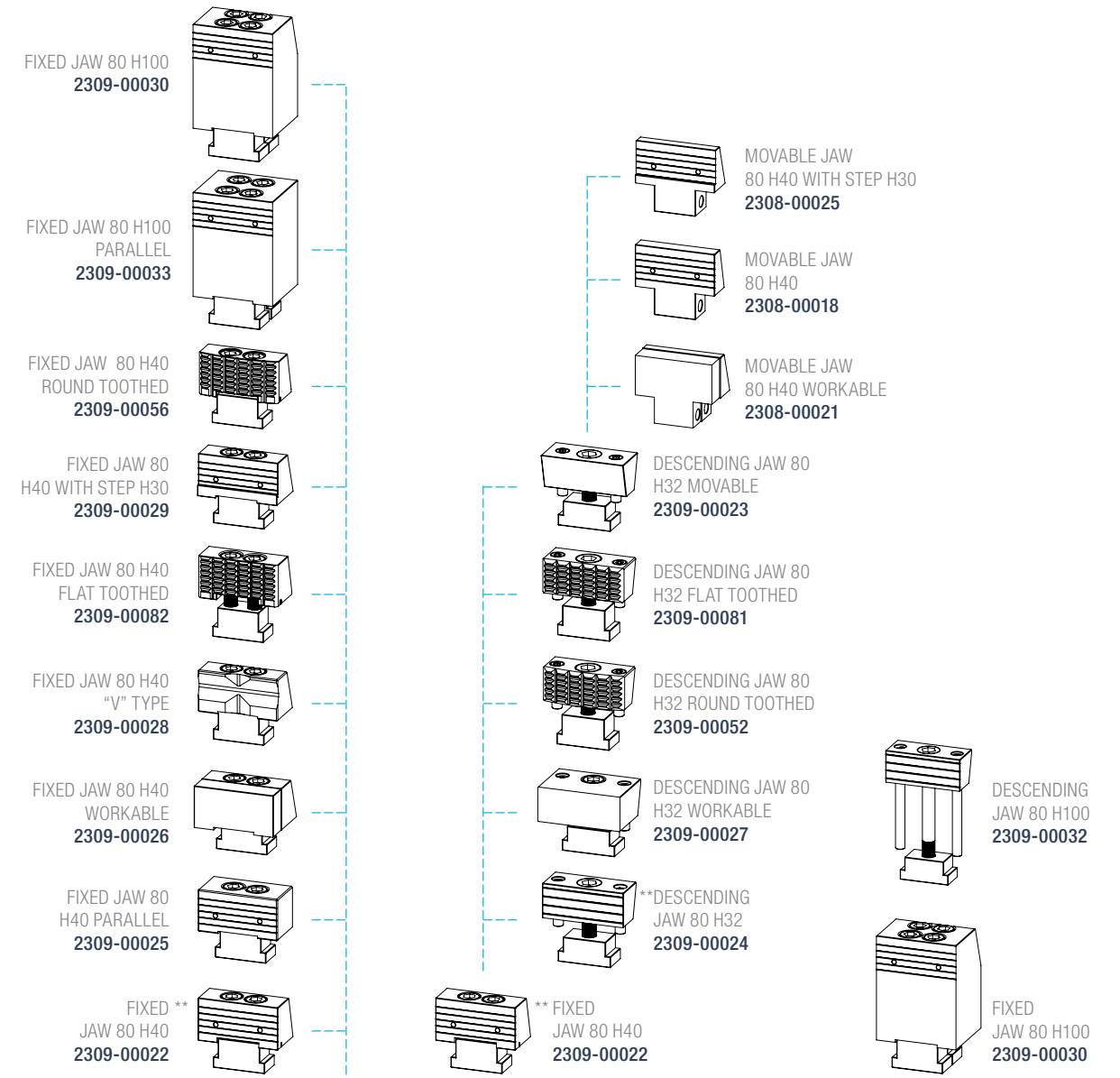
Max 100

CLAMPING FORCE  
(N)

20000

ACCURACY  
(mm)

±0,02



Nr.4 RING RED. M16-M12 H0  
0001-00406  
Nr.4SPECIAL SCREW M12  
4521-00016



Nr.4 RING M16 H0  
0001-00501  
Nr.4 SPECIAL SCREW M16  
4521-00001



SEE STANDARD BREYL™ CATALOGUE

\*\*Already included in the Set

\* For details see the [TIGHTENING TORQUES AND CLAMPING FORCE PAGES](#)



# STANDARD

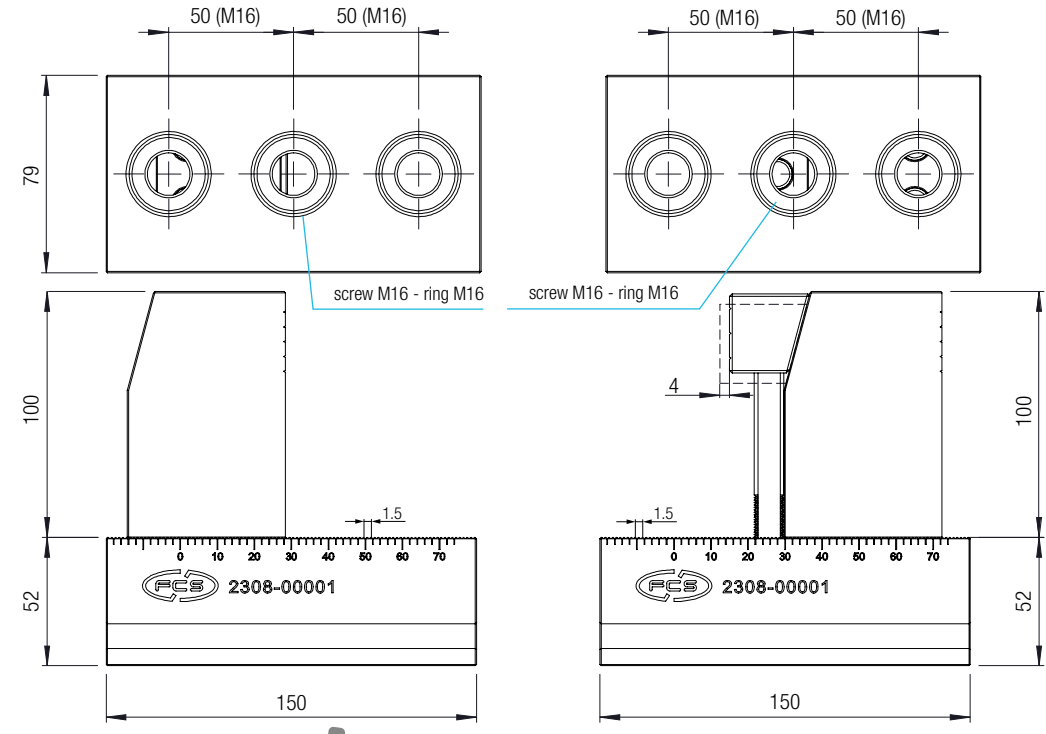
# STANDARD



MODULAR GRIP VISE  
150x80 JAW 80 H100  
2310-00040

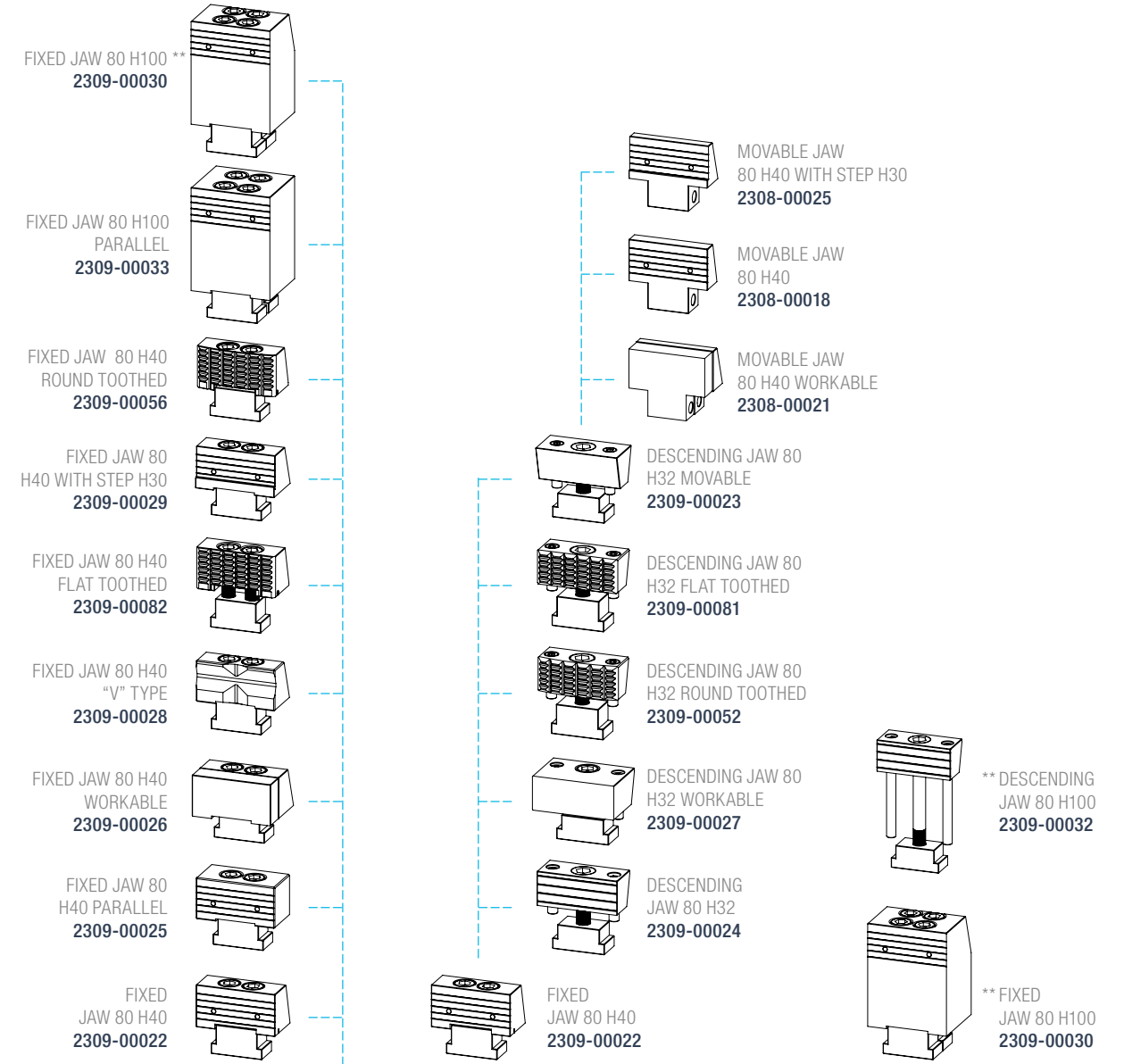
Description	Qty	CODE
1 VISE BASE M16 150x80 H52	2	2308-00001
2 DESCENDING JAW 80 H100	1	2309-00032
3 FIXED JAW 80 H100	2	2309-00030
4 RING M16 D.24 H0	4	0001-00501
5 SPECIAL SCREW M16	4	4521-00001

set weight 15.0 kg



- TORQUE FOR JAW\* (Nm)**  
Max 100
- CLAMPING FORCE (N)**  
20000
- ACCURACY (mm)**  
±0,02

\* For details see the [TIGHTENING TORQUES AND CLAMPING FORCE PAGES](#)



- Nr.4 RING RED. M16-M12 H0  
**0001-00406**  
Nr.4 SPECIAL SCREW M12  
**4521-00016**
- Nr.4 RING M16 H0  
**0001-00501**  
Nr.4 SPECIAL SCREW M16  
**4521-00001**
- SEAT M12 STEP 25
- SEAT M16 STEP 50

SEE STANDARD BREYLM™ CATALOGUE

\*\*Already included in the Set

# STANDARD

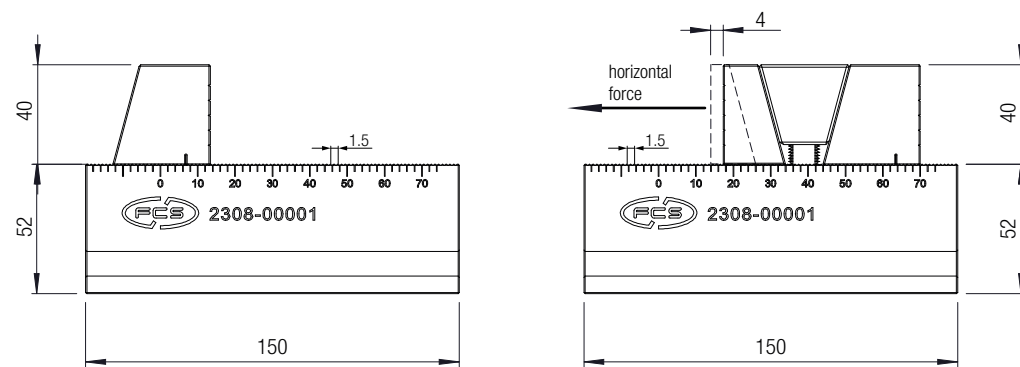
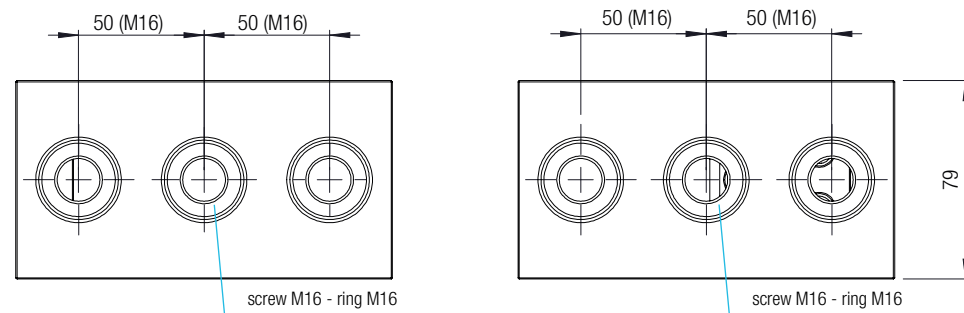
# STANDARD



MODULAR GRIP VISE  
150x80 HORIZONTAL JAW 80 H40  
2310-00030

Description	Qty	CODE
1 VISE BASE M16 150x80 H52	2	2308-00001
2 MOVABLE JAW 80 H32 DOUBLE WEDGE	1	2309-00023
3 FIXED JAW 80 H40	2	2309-00022
4 MOVABLE JAW 80 H40	1	2308-00018
5 RING M16 D.24 H0	4	0001-00501
6 SPECIAL SCREW M16	4	4521-00001

set weight 9.6 kg



TORQUE FOR JAW\*  
(Nm)

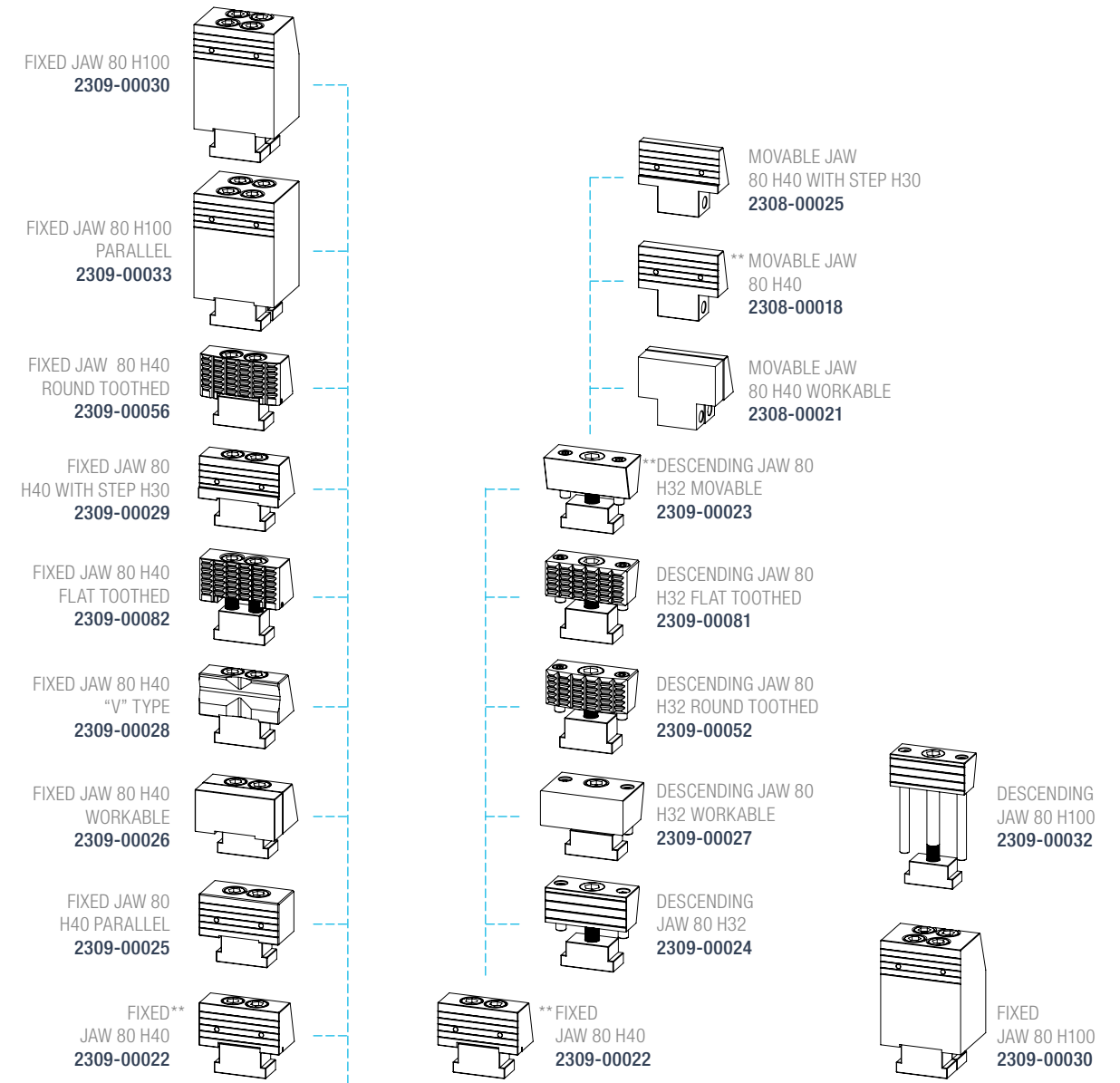
Max 100

CLAMPING FORCE  
(N)

20000

ACCURACY  
(mm)

±0,02



COUNTERTHRUST  
SIDE

THRUST  
SIDE

Nr.4 RING RED. M16-M12 H0  
0001-00406  
Nr.4 SPECIAL SCREW M12  
4521-00016



SEE STANDARD BREYL™ CATALOGUE

Nr.4 RING M16 H0  
0001-00501  
Nr.4 SPECIAL SCREW M16  
4521-00001



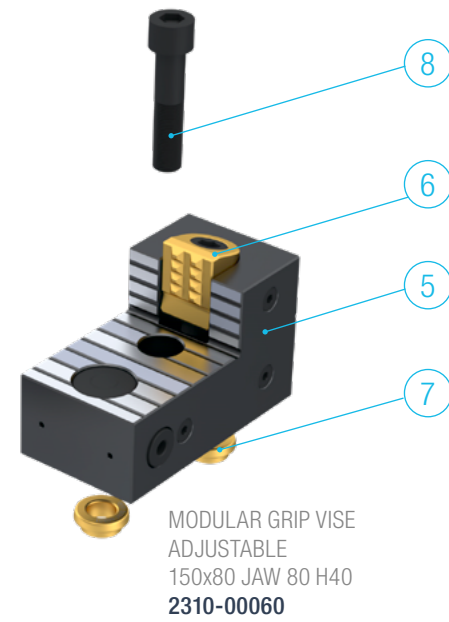
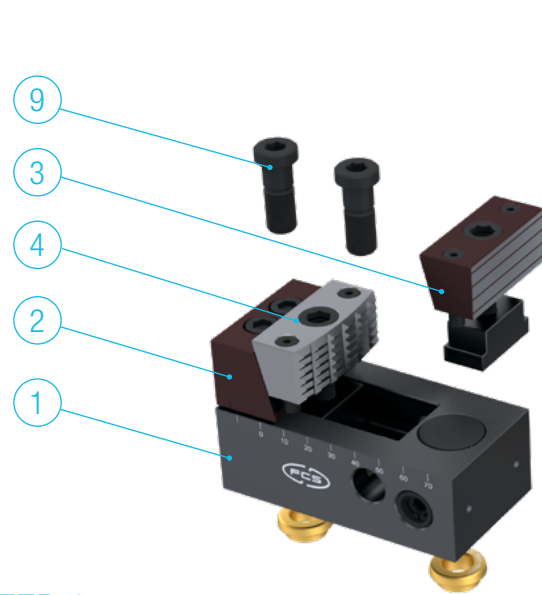
SEAT M16  
STEP 50

\* For details see the [TIGHTENING TORQUES AND CLAMPING FORCE PAGES](#)

\*\*Already included in the Set

# ADJUSTABLE

# ADJUSTABLE

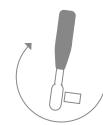
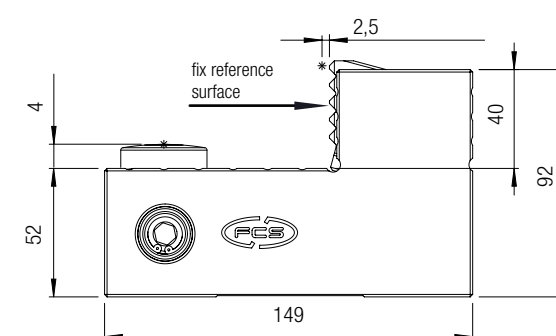
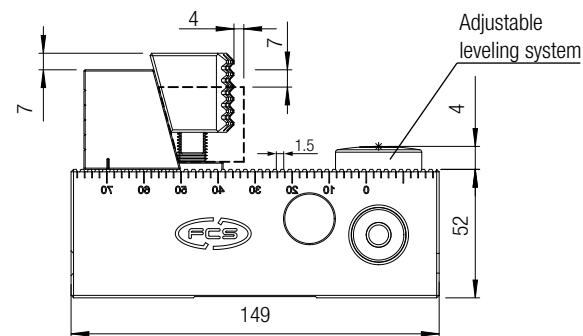
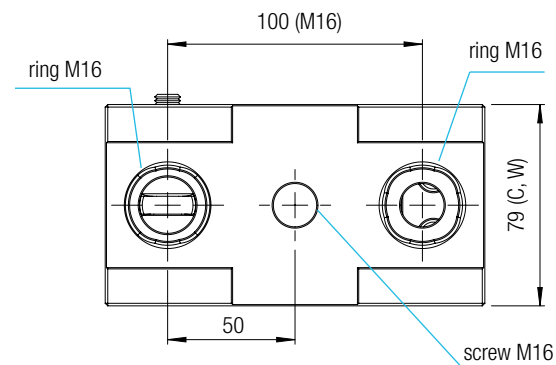
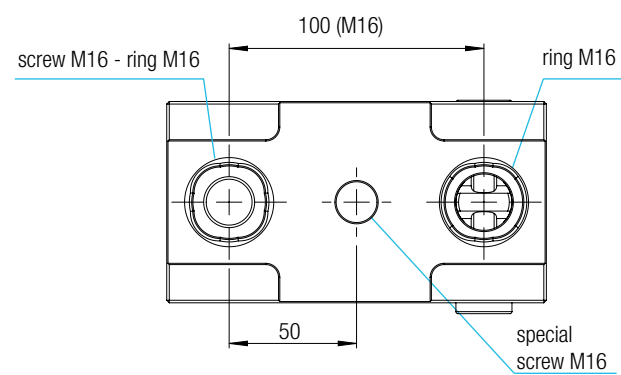


## PATENTED

Description	Qty	CODE
1 VISE BASE ADJUSTABLE 150x80 H52	1	2309-00105
2 FIXED JAW 80 H40	1	2309-00022
3 DESCENDING JAW 80 H32	1	2309-00024
4 DESCENDING JAW 80 H32 ROUND TOOTHED	1	2309-00052
5 VISE BASE ADJUSTABLE 150x80 H92	1	2309-00104

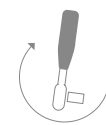
Description	Qty	CODE
6 INSERT 40x35 H45 NF	1	2309-00094
7 RING M16 D.24 H0	4	0001-00501
8 SCREW M16x70 12.9 BURNISHED	1	4521-16070
9 SPECIAL SCREW M16	2	4521-00001

set weight 11.8 kg



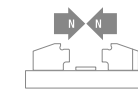
TORQUE FOR JAW\*  
(Nm)

Max 100



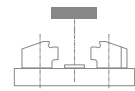
TORQUE FOR INSERT\*  
(Nm)

Max 60



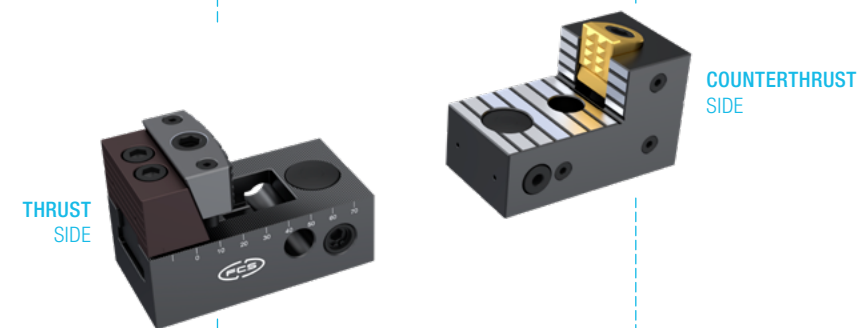
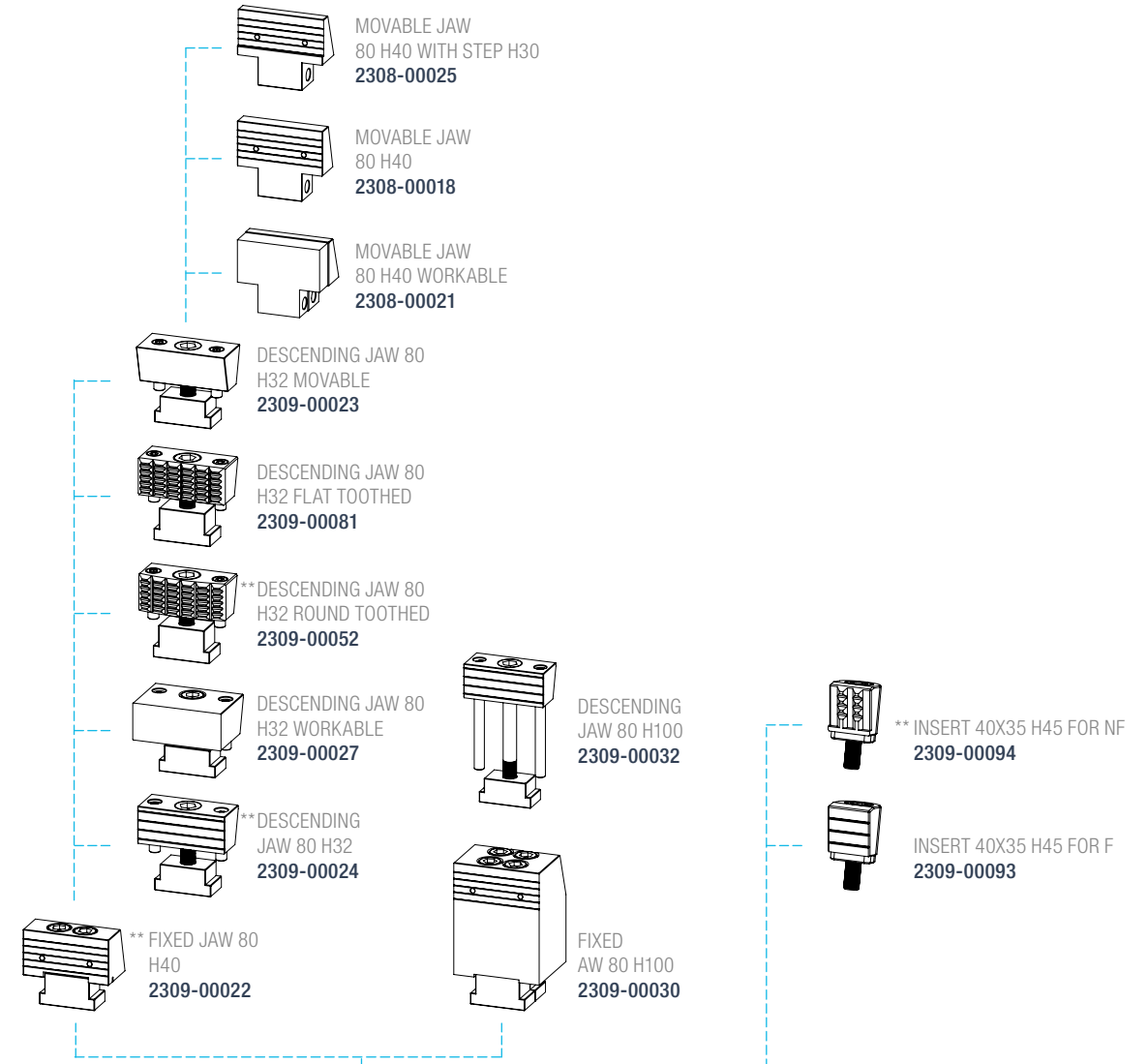
CLAMPING FORCE  
(N)

20000



ACCURACY  
(mm)

±0,02



Nr.2 RING M16 H0  
0001-00501  
Nr.2 SPECIAL SCREW M16  
4521-00001



Nr.2 RING RED. M16-M12 H0  
0001-00406  
Nr.2 SPECIAL SCREW M12  
4521-00016



Nr.2 RING M16 H0  
0001-00501  
Nr.1 SCREW M16x70 12.9  
4521-16070



Nr.2 RING RED. M16-M12 H0  
0001-00406  
Nr.1 SPECIAL SCREW  
M16-M12x65 12.9  
4521-00005



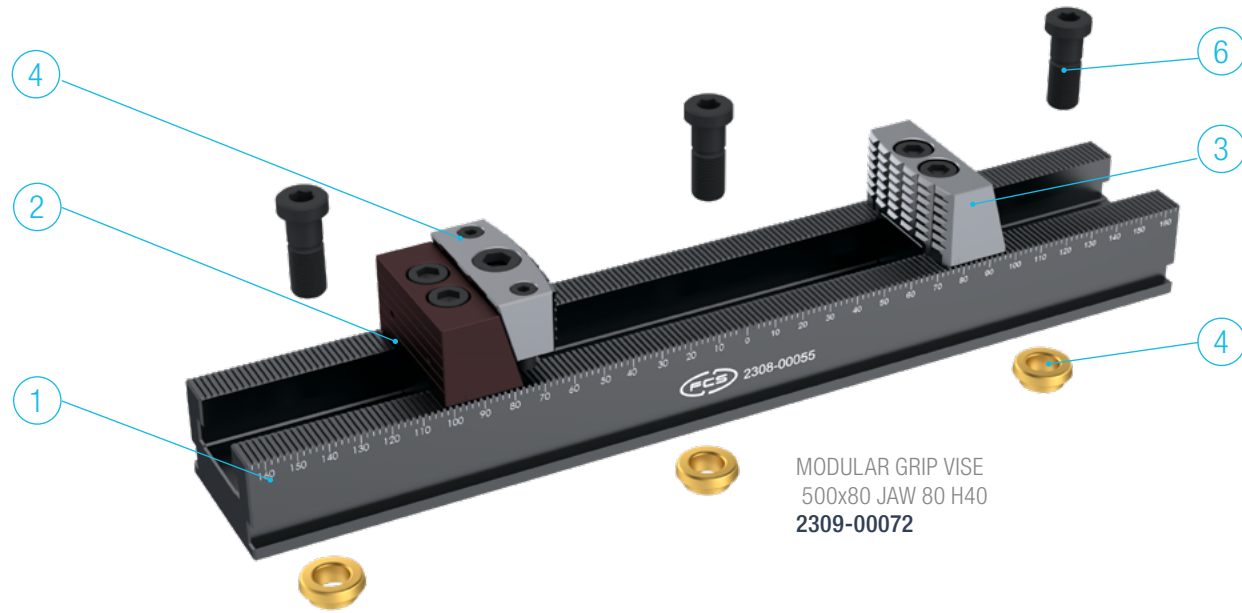
SEE STANDARD BREYLL™ CATALOGUE

\*\*Already included in the Set



# LONG BASE

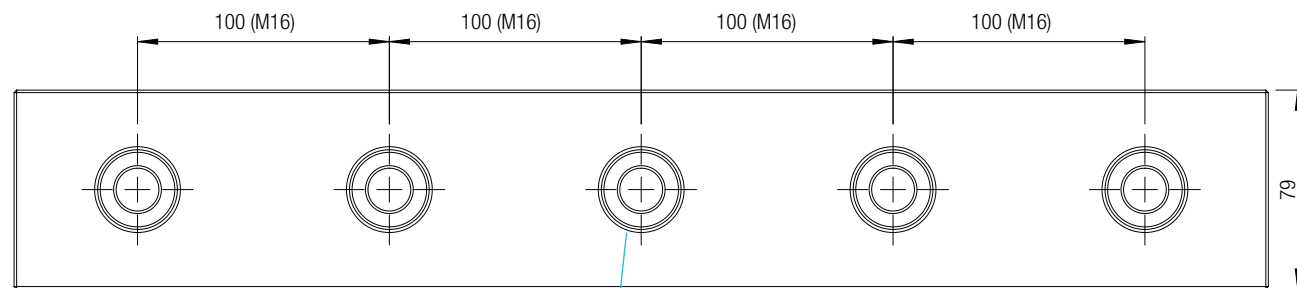
# LONG BASE



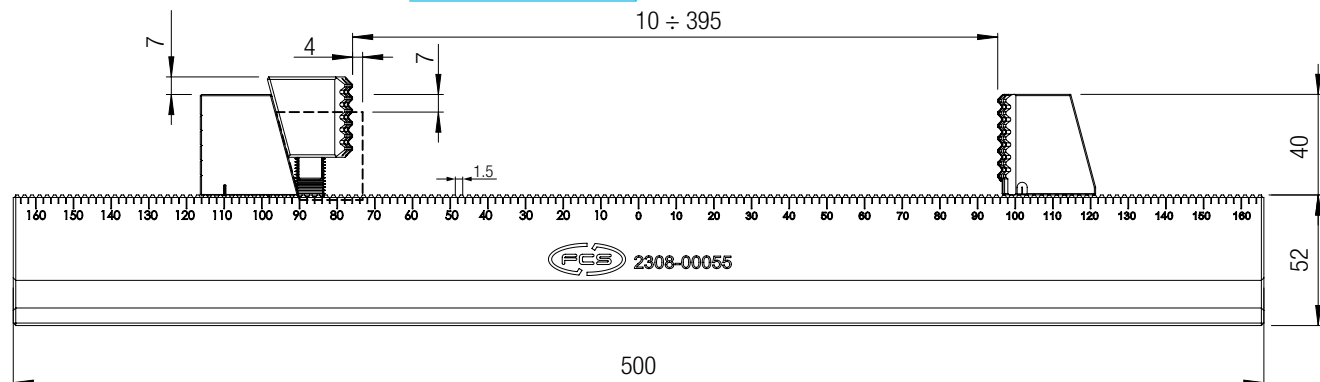
MODULAR GRIP VISE  
500x80 JAW 80 H40  
2309-00072

Description	Qty	CODE
1 VISE BASE M16 500x80 H52	1	2308-00055
2 FIXED JAW 80 H40	1	2309-00022
3 FIXED JAW 80 H40 ROUND TOOTHED	1	2309-00056
4 DESCENDING JAW 80 H32 ROUND TOOTHED	1	2309-00052
5 RING M16 D.24 H0	3	0001-00501
6 SPECIAL SCREW M16	3	4521-00001

set weight 13.1 kg



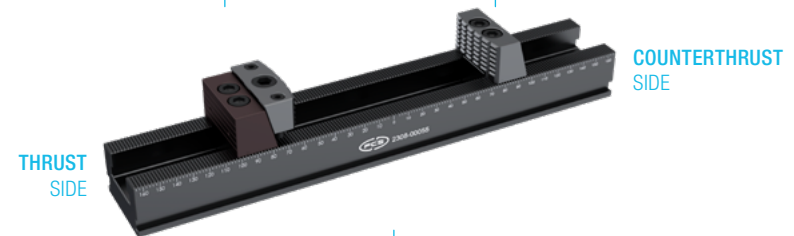
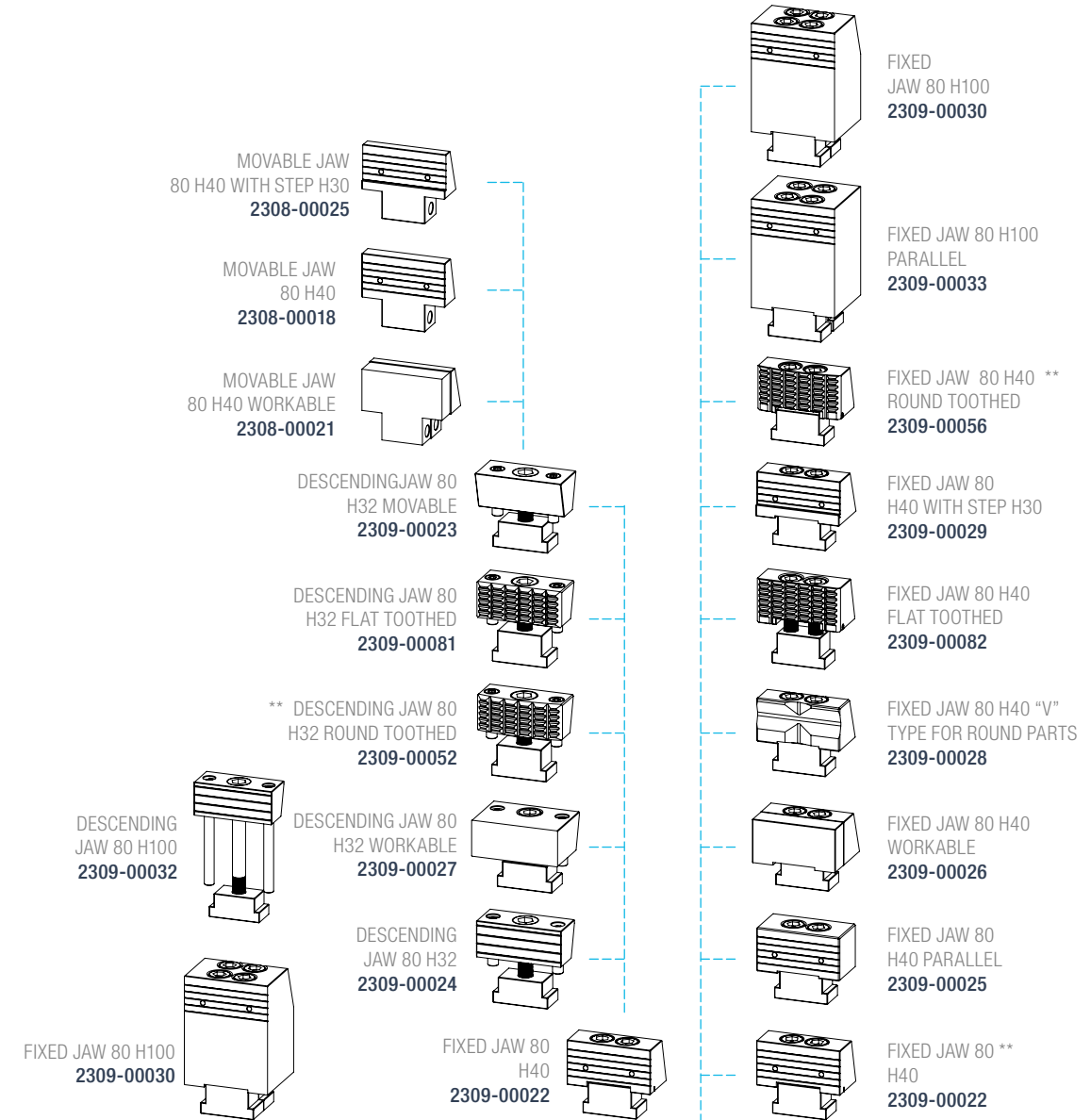
screw M16 - ring M16



**TORQUE FOR JAW\***  
(Nm)  
Max 100

**CLAMPING FORCE**  
(N)  
20000

**ACCURACY**  
(mm)  
±0,02



Nr.3 RING RED. M16-M12 H0  
0001-00406  
Nr.3 SPECIAL SCREW M12  
4521-00016

Nr.3 RING M16 H0  
0001-00501  
Nr.3 SPECIAL SCREW M16  
4521-00001

Nr.3 RING W M16  
0001-00800  
Nr.3 SPECIAL SCREW M12 - VISE  
4521-00015  
Nr.3 ROD W M16 - VISE  
0002-00008

SEAT M12  
STEP 25

SEAT M16  
STEP 50

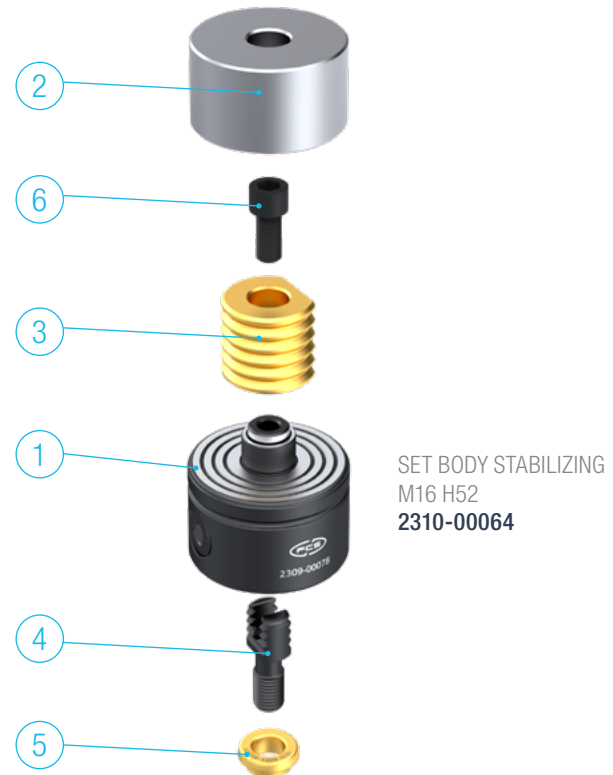
BODY M16  
BODY RED. M24-M16

SEE STANDARD BREYL™ CATALOGUE

\*\*Already included in the Set

# ACCESSORIES

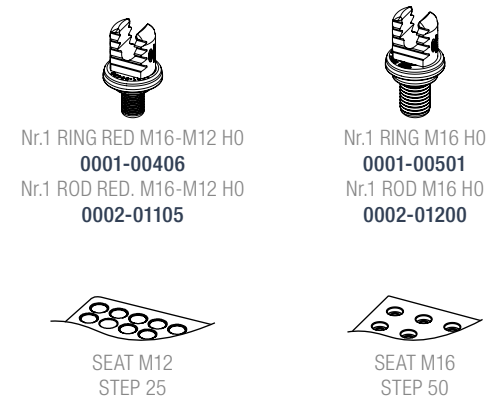
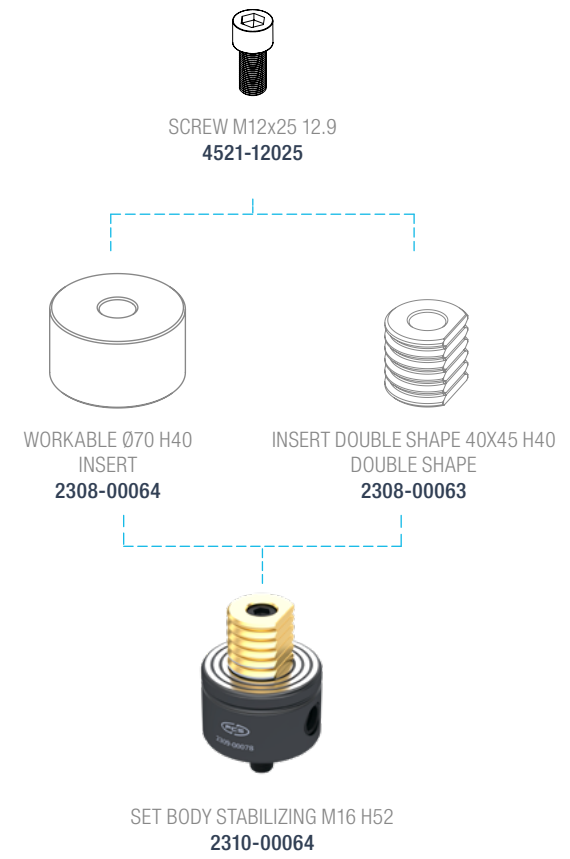
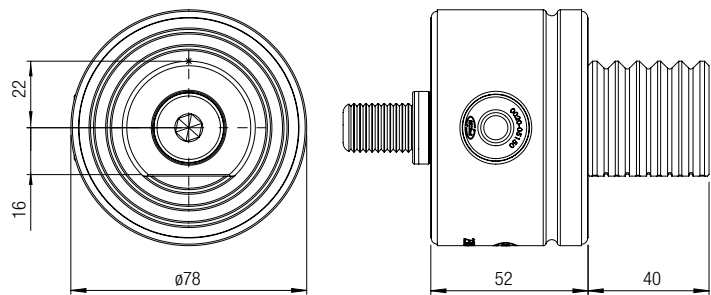
# ACCESSORIES



SET BODY STABILIZING  
M16 H52  
2310-00064

Description	Qty	CODE
1 BODY STABILIZING M16 H52	1	2309-00078
2 INSERT 40x45 H40 DOUBLE SHAPE	1	2308-00063
3 INSERT D.70 H40 WORKABLE	1	2308-00064
4 ROD M16 L35 H0	1	0002-01200
5 RING M16 D.24 H0	1	0001-00501
6 SCREW M12x25 12.9 BURNISHED	1	4521-12025

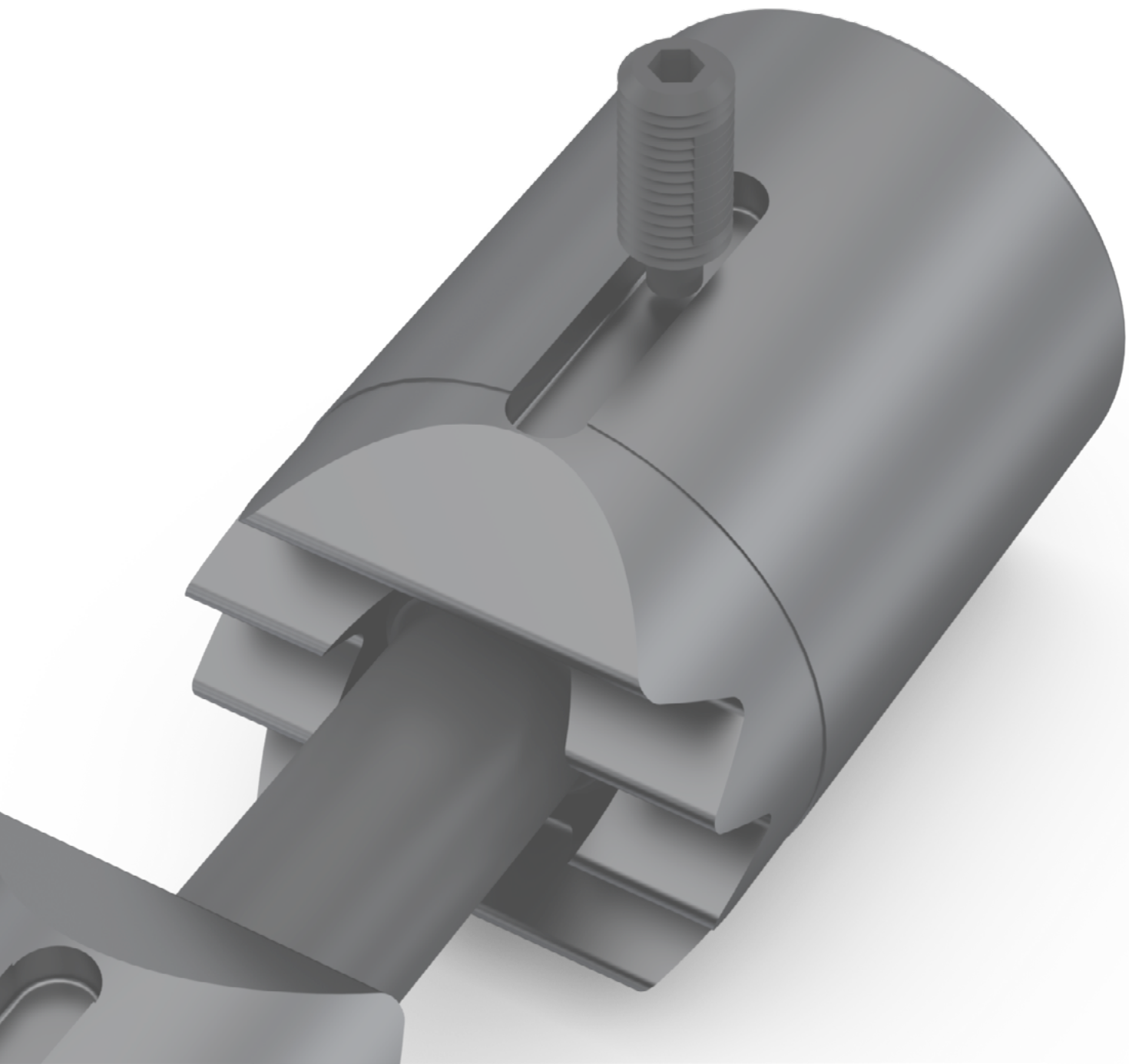
set weight 2.3 kg



\* For details see the [TIGHTENING TORQUES AND CLAMPING FORCE PAGES](#)

[SEE STANDARD BREYL™ CATALOGUE](#)

# ACCESSORIES SPARE PARTS



Integrated systems for production

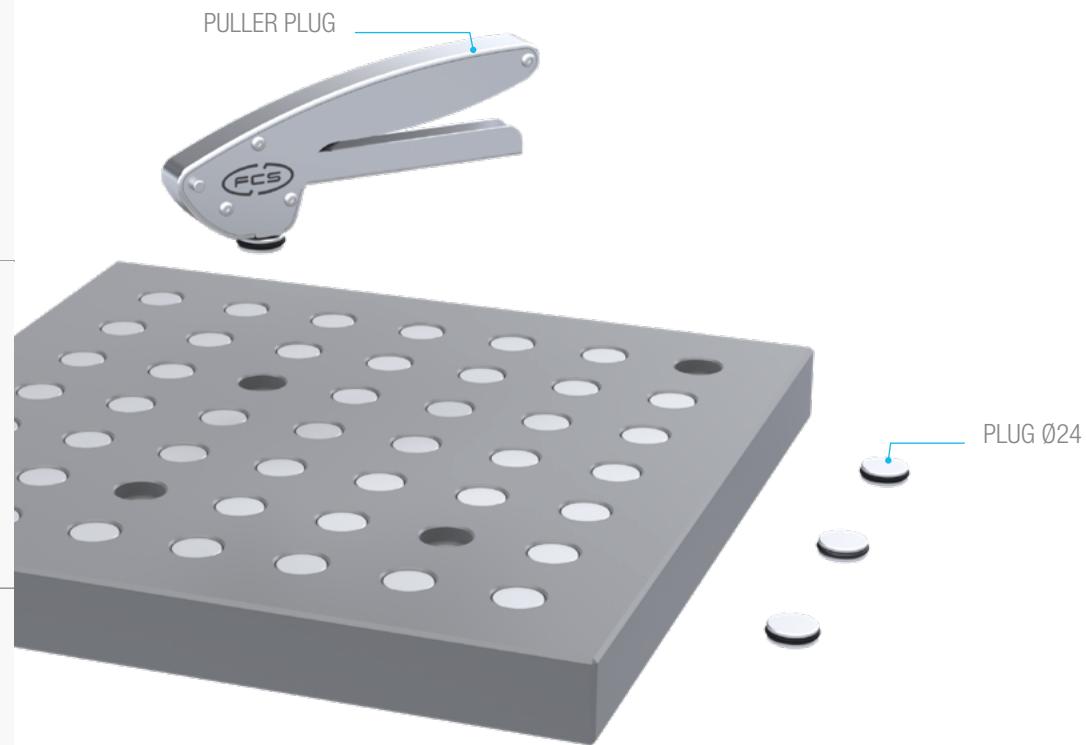


# PULLER PLUGS AND PULLER RINGS

# ACCESSORIES

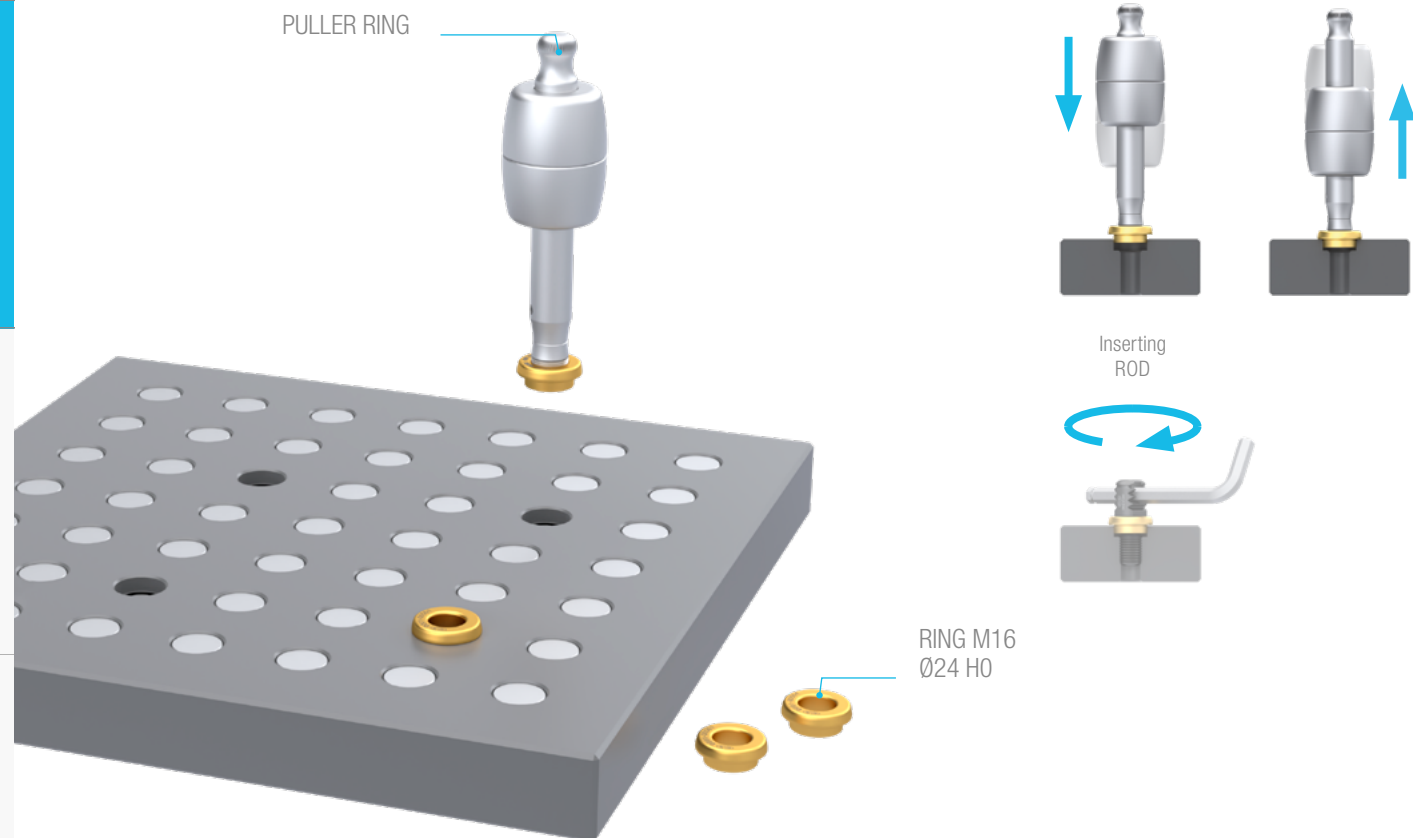
## PULLER PLUG

Dedicated tool for removing plugs

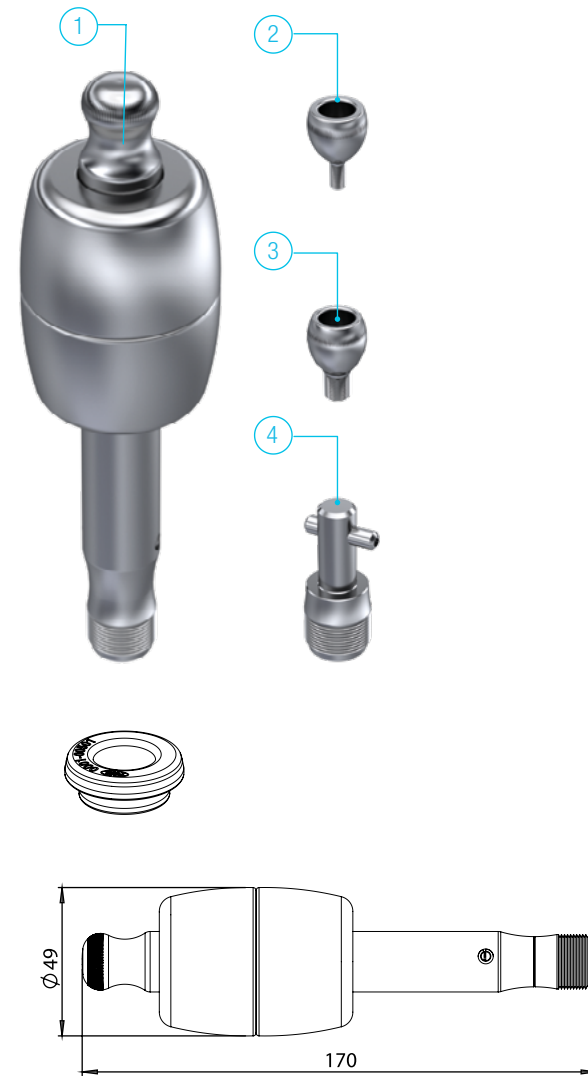


## PULLER RING

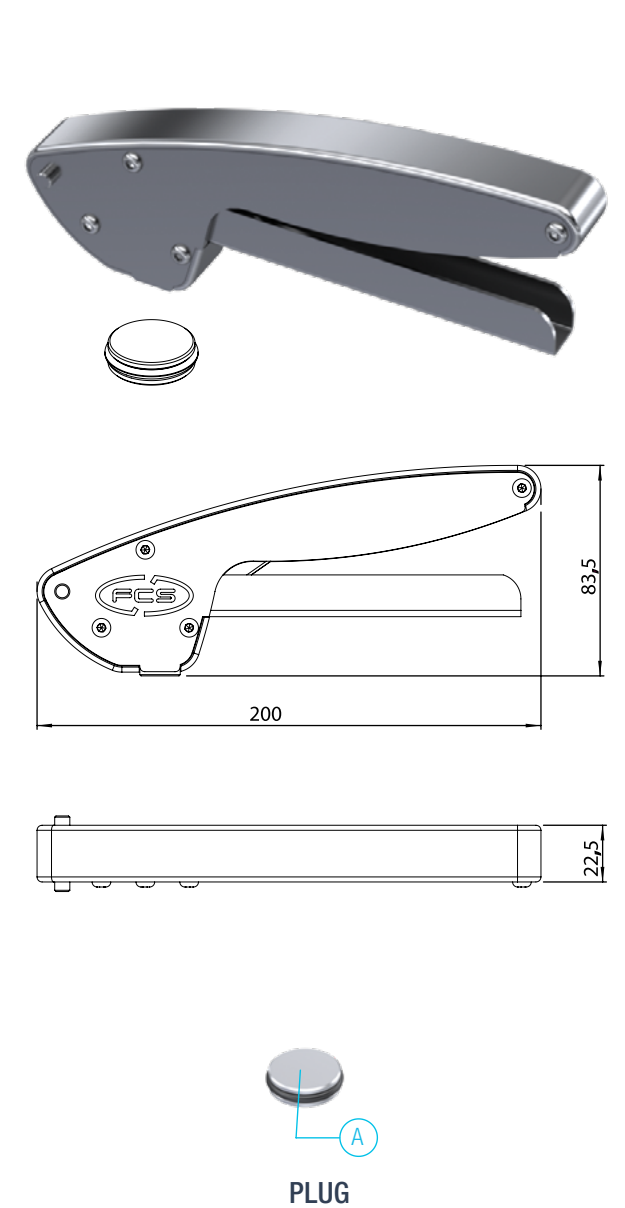
Dedicated tool for inserting or removing rings



## PULLER RING SET CODE 0014-00010



## PULLER PLUG 0015-04800



	DESCRIPTION	QTY	CODE
1	PULLER RING	1	0014-04600
2	PULLER ADAPTER M6	1	0014-04610
3	PULLER ADAPTER M12	1	0014-04640
4	THREADED SPARE PART (puller ring)	1	0014-00003

	DESCRIPTION	CODE
A	PLUG Ø20	0015-04501
A	PLUG Ø24	0015-04500

# SPARE PARTS

# SPARE PARTS

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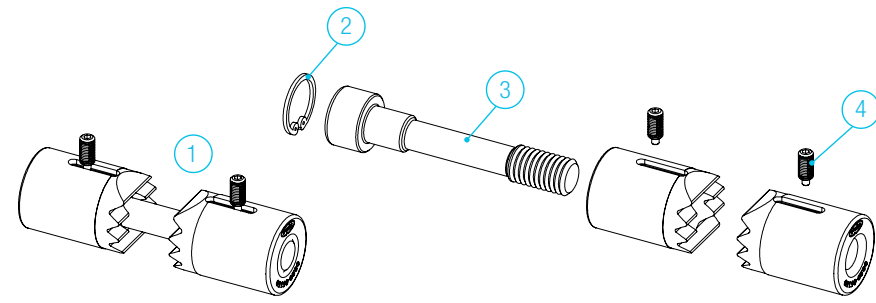
SYSTEM GRIP VISES

MODULAR GRIP VISES

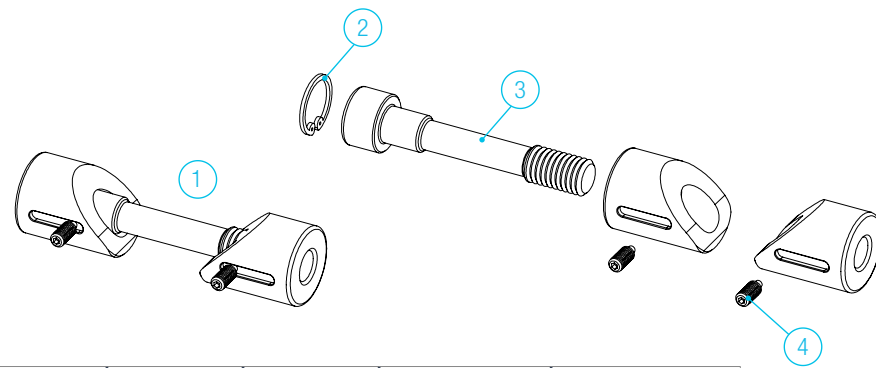
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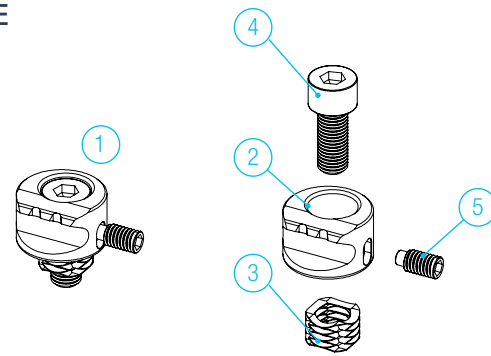
DESCRIPTION	1 KIT CODE	2 SEEGER	3 SCREW	4 GRUB SCREW
JAW M16	0020-05150	J16 4529-20016	4521-05122	4521-05124



DESCRIPTION	1 KIT CODE	2 SEEGER	3 SCREW	4 GRUB SCREW
JAW M16 LEVELING	0020-05100	J16 4529-20016	4521-05122	4521-05124

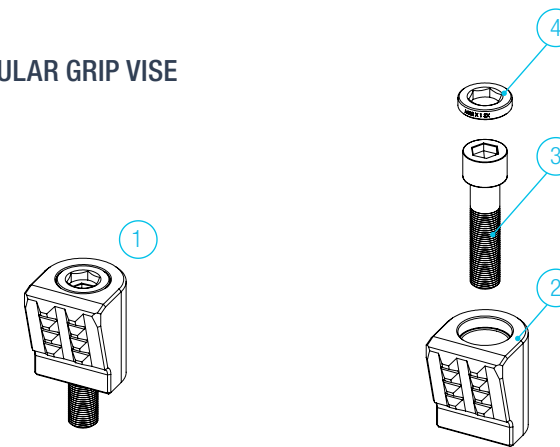
2 EN ISO 4762 BURNISHED  
3 DIN 472  
6 EN ISO 4762

## INSERT SYSTEM GRIP VISE



DESCRIPTION	1 KIT CODE	2 INSERT	3 SPRING	4 SCREW	5 GRUB SCREW
INSERT D.24 H15 F	2309-00089	2308-00079	4527-00064	4521-08020	4521-05124
INSERT D.24 H15 NF	2309-00090	2308-00080	4527-00064	4521-08020	4521-05124
INSERT D.20 H13 F	2309-00112	2308-00123	4527-00108	4521-06016	4521-05125
INSERT D.20 H13 NF	2309-00113	2308-00109	4527-00108	4521-06016	4521-05125

## INSERT MODULAR GRIP VISE



DESCRIPTION	1 KIT CODE	2 INSERT	3 SCREW	4 SCREW THREAD
INSERT 40x35 H45 F	2309-00093	2308-00083	4521-12050	2308-00059
INSERT 40x35 H45 NF	2309-00094	2308-00084	4521-12050	2308-00059

# APPENDIX



Integrated systems for production



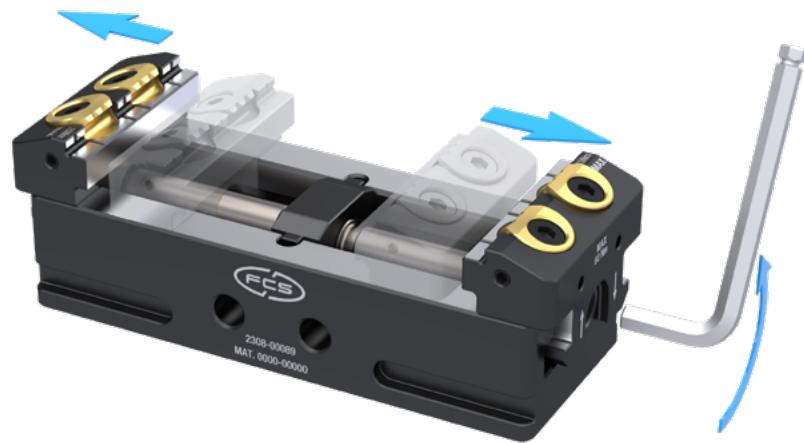
# KIT JAW REPLACING PROCEDURE

# KIT JAW REPLACING PROCEDURE

## REMOVAL OF THE EXISTING KIT

1

### STEP 1



Unscrew counterclockwise the main screw till the jaws will be completely extracted.

2

### STEP 2



Remove the bearing support together with the main screw lifting it up simultaneously on the sides.

Note: If the kit vise of the original grip vise is replaced with another compatible it vise, the position accuracy range of the workpiece can increase.

## ASSEMBLING OF THE NEW KIT

3

### STEP 3



Extract the jaws from the screw.  
Place the new bearing support with the main screw into the central vise body seat.  
Place the two jaws closer to the main screw sides paing attention that jaws watch perfectly with the vise body.

4

### STEP 4



In order to be sure that jaws are coupled simultaneously with the main screw properly, the procedure is the following:

1. Keep the two jaws in contact with the main screw and at the same time turn the screw counterclockwise two turns.
2. Screw clockwise the main screw.

For further information of the Clamping procedure see the Clamps section in [STANDARD BREYL™ CATALOGUE](#)

# CLAMPING FORCE AND TIGHTENING TORQUES

# CLAMPING FORCE AND TIGHTENING TORQUES

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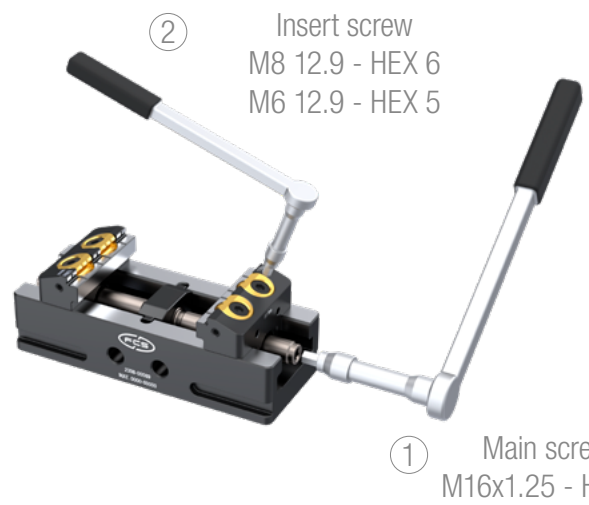
SYSTEM GRIP VISES

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SCREWS	HEX (mm)	TORQUE (Nm)*
M6 12.9	5	12
M8 12.9	6	30
M10 12.9	8	60

JAW SIZE	HEX (mm)	TORQUE (Nm)*
JAW M16	8	55

RODS	TORQUE (Nm)*
M12-M16	40

SCREWS	HEX (mm)	TORQUE (Nm)*	
		HARD MATERIAL 30<HRC<65	SOFT MATERIAL HRC<30
1 M16x1.25	8	60	50
2 M8 12.9	6	10	15
2 M6 12.9	5		
CLAMPING FORCE (N)**		20000	17000

SCREWS	HEX (mm)	TORQUE (Nm)*	
		HARD MATERIAL 30<HRC<65	SOFT MATERIAL HRC<30
1 M16x1.25	8	40	
2 M8 12.9	6	10	15
2 M6 12.9	5		
CLAMPING FORCE (N)**		13200	13500

For finishing operations it is recommended to use the inserts for finished surface and to tighten the corresponding M6 or M8 screws with a lower (5÷10Nm) and suitable torque to minimize any local deformation of the workpiece in the area in contact with the inserts.  
 \* Max recommended torque based on a full workpiece with rectangular solid shape, according to internal test. The actual value can vary depending on the specific application.  
 \*\* Guide value. The actual value depends on the friction condition. These value are reactable by the main screw only.



SCREWS	HEX (mm)	TORQUE (Nm)
M12 SPECIAL	10	60
M16 SPECIAL	10	60

SCREWS	HEX (mm)	TORQUE (Nm)
M12 12.9	10	100

SCREWS	HEX (mm)	TORQUE (Nm)
M12 12.9	10	60
CLAMPING FORCE (N)**		20000

SCREWS	HEX (mm)	TORQUE (Nm)
M12 12.9	10	60
CLAMPING FORCE (N)**		20000

In order to keep the position accuracy (as per the finishing operations for example) and to minimize any local deformation of the workpiece, it is recommended (to use the insert for finished and) to apply a low and suitable torque just to move the insert until it will be in contact with the workpiece. In this case will be anyhow increased the holding capacity without influence the position accuracy of the workpiece and it will be minimize any local deformation.

# INDEX



Integrated systems for production



# INDEX - SYSTEM GRIP VISES

# INDEX - SYSTEM GRIP VISES

## SYSTEM GRIP VISE

ITEMS	DESCRIPTION	WISE BASE	KIT JAW	SYSTEM GRIP VISE
	SYSTEM GRIP VISE 100x80 DF JAW 80 H5	2309-00201	-	2310-10001
	SYSTEM GRIP VISE 100x80 DF JAW 80 H2.5	2309-00202	-	2310-10002
	SYSTEM GRIP VISE 150x80 SC L150 JAW 80 H5	2309-00200	2309-00301	2310-15001
	SYSTEM GRIP VISE 150x80 SC L150 JAW 55 H2.5		2309-00302	2310-15002
	SYSTEM GRIP VISE 150x80 SC L150 JAW 80 H2.5		2309-00303	2310-15003
	SYSTEM GRIP VISE 150x80 MS L150 JAW 80 H5		2309-00351	2310-15051
	SYSTEM GRIP VISE 150x80 MS L150 JAW 80 H2.5		2309-00352	2310-15052
	SYSTEM GRIP VISE 200x80 SC L200 JAW 80 H5		2309-00401	2310-20001
	SYSTEM GRIP VISE 200x80 SC L200 JAW 55 H2.5		2308-00089	2309-00402
	SYSTEM GRIP VISE 200x80 SC L200 JAW 80 H2.5		2309-00403	2310-20003
	SYSTEM GRIP VISE 280x80 SC L280 JAW 80 H5	2309-00203	2309-00501	2310-30001
	SYSTEM GRIP VISE 280x80 SC L280 JAW 55 H2.5		2309-00502	2310-30002
	SYSTEM GRIP VISE 280x80 SC L280 JAW 80 H2.5		2309-00503	2310-30003
	SYSTEM GRIP VISE 280x80 MS-SF L105 JAW 80 H5		2309-00601	2310-30051
			2309-00651	
	SYSTEM GRIP VISE 280x80 MS-SF L105 JAW 80 H2.5		2309-00602	2310-30052
			2309-00652	




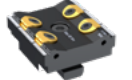
## KIT JAW

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	KIT SC L150 JAW 80 H5	JAW 80 H5	2309-00301	-
	KIT SC L150 JAW 55 H2.5	JAW 55 H2.5	2309-00302	-
	KIT SC L150 JAW 80 H2.5	JAW 80 H2.5	2309-00303	-
	KIT SC L150 JAW 80 H5 SELF-FLOAT	JAW 80 H5 SELF-FLOAT	2309-00304	-
	KIT MS L150 JAW 80 H5	JAW 80 H5	2309-00351	-
	KIT MS L150 JAW 80 H2.5	JAW 55 H2.5	2309-00352	-
	KIT MS L150 JAW 80 H5 SELF-FLOAT	JAW 80 H5 SELF-FLOAT	2309-00353	-
	KIT SC L200 JAW 80 H5	JAW 80 H5	2309-00401	-
	KIT SC L200 JAW 55 H2.5	JAW 55 H2.5	2309-00402	-
	KIT SC L200 JAW 80 H2.5	JAW 80 H2.5	2309-00403	-
	KIT SC L200 JAW 80 H5 SELF-FLOAT	JAW 80 H5 SELF-FLOAT	2309-00404	-
	KIT SC L280 JAW 80 H5	JAW 80 H5	2309-00501	-
	KIT SC L280 JAW 55 H2.5	JAW 55 H2.5	2309-00502	-
	KIT SC L280 JAW 80 H2.5	JAW 80 H2.5	2309-00503	-

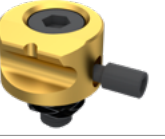
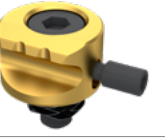


# INDEX - SYSTEM GRIP VISES

# INDEX - MODULAR GRIP VISES

## KIT JAW

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	KIT MS L105 JAW 80 H5	JAW 80 H5	2309-00601	-
	KIT SF JAW 80 H5		2309-00651	
	KIT MS L105 JAW 80 H2.5	JAW 80 H2.5	2309-00602	-
	KIT SF JAW 80 H2.5		2309-00652	
	KIT DF JAW 80 H5	JAW 80 H5	2309-00653	-
	KIT DF JAW 80 H2.5	JAW 80 H2.5	2309-00654	-





## INSERTS

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	INSERT Ø24 H15 F	Ø24 H15	2309-00089	-
	INSERT Ø24 H15 NF	Ø24 H15	2309-00090	-
	INSERT Ø20 H13 F	Ø20 H13	2309-00112	-
	INSERT Ø20 H13 NF	Ø20 H13	2309-00113	-




## MODULAR GRIP VISES

ITEMS	DESCRIPTION	WISE BASE	JAW/INSERT	MODULAR GRIP VISE
	MODULAR GRIP VISE 150x80 JAW 80 H40	2308-00001	2309-00022 2309-00024	2310-00020
	MODULAR GRIP VISE 150x80 HORIZONTAL JAW 80 H40		2309-00022 2309-00023 2308-00018	2310-00030
	MODULAR GRIP VISE 150x80 JAW 80 H100		2309-00030 2309-00032	2310-00040
	MODULAR GRIP VISE ADJUSTABLE 150x80 JAW 80 H40	2309-00104 2309-00105	2309-00022 2309-00052 2309-00024 2309-00094	2310-00060
	MODULAR GRIP VISE 500x80 JAW 80 H40	2308-00055	2309-00022 2309-00052 2309-00056	2309-00072
	BODY STABILIZING M16 H52	2309-00078	2308-00063 2308-00064	2310-00064

## INSERTS

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	INSERT 40x35 H45 F	40x35 H45	2309-00093	-
	INSERT 40x35 H45 NF	40x35 H45	2309-00094	-
	INSERT 40x45 H40 DOUBLE SHAPE	40x45 H40	2308-00063	-
	INSERT Ø70 H40 WORKABLE	Ø70 H40	2308-00064	-

## JAW

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	MOVABLE JAW 80 H40	JAW 80 H40	2308-00018	-
	MOVABLE JAW 80 H40 WORKABLE	JAW 80 H40	2308-00021	-
	MOVABLE JAW 80 H40 WITH STEP H30	JAW 80 H40	2308-00025	-


# INDEX - MODULAR GRIP VISES

# INDEX - RINGS


## JAW

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	FIXED JAW 80 H40	JAW 80 H40	2309-00022	-
	DESCENDING JAW 80 H32 MOVABLE	JAW 80 H32	2309-00023	-
	DESCENDING JAW 80 H32	JAW 80 H32	2309-00024	-
	FIXED JAW 80 H40 PARALLEL	JAW 80 H40	2309-00025	-
	FIXED JAW 80 H40 WORKABLE	JAW 80 H40	2309-00026	-
	DESCENDING JAW 80 H32 WORKABLE	JAW 80 H32	2309-00027	-
	FIXED JAW 80 H40 "V" TYPE	JAW 80 H40	2309-00028	-
	FIXED JAW 80 H40 WITH STEP H30	JAW 80 H40	2309-00029	-
	FIXED JAW 80 H100	JAW 80 H100	2309-00030	-
	DESCENDING JAW 80 H100	JAW 80 H100	2309-00032	-
	FIXED JAW 80 H100 PARALLEL	JAW 80 H100	2309-00033	-
	DESCENDING JAW 80 H32 ROUND TOOTHED	JAW 80 H32	2309-00052	-
	FIXED JAW 80 H40 ROUND TOOTHED	JAW 80 H40	2309-00056	-
	DESCENDING JAW 80 H32 FLAT TOOTHED	JAW 80 H32	2309-00081	-
	FIXED JAW 80 H40 FLAT TOOTHED	JAW 80 H40	2309-00082	-



## RING REDUCTION HO

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	RING REDUCTION M16-M12 Ø20 HO	Ø20 HO	0001-00406	-

## RING HO

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	RING M6 Ø11 HO	Ø11 HO	0001-00002	-
	RING M12 Ø20 HO	Ø20 HO	0001-00401	-
	RING M16 Ø24 HO	Ø24 HO	0001-00501	-

## RING W


ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	RING W M16	-	0001-00800	-
	RING W M16 HO ROD	-	0001-00801	-




## INDEX - RODS

## INDEX - SCREWS & ACCESSORIES



### ROD REDUCTION H0

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	ROD REDUCTION M16-M12 L28 H0	L28 H0	0002-01105	-



### ROD H0

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	ROD M16 L35 H0	L35 H0	0002-01200	-


### ROD W

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	ROD W M16 VISES	-	0002-00008	-
	ROD W M16	-	0002-01600	-


### ROD AIR

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	ROD AIR M12 L27 H0	-	2301-00017	-
	ROD AIR CLAMP M16 L66	-	2301-01710	-





### ROD AIR REDUCTION

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	ROD AIR REDUCTION M16-M12 L32 H0	L32 H0	2301-01701	-






### SCREW

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	M6x35 12.9	-	4521-06035	-
	M16x70 12.9	-	4521-16070	-



### SPECIAL SCREW

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	SPECIAL SCREW M16	-	4521-00001	-
	SPECIAL SCREW M16-M12x65 12.9	-	4521-00005	-
	SPECIAL SCREW M12 - VISE	-	4521-00015	-
	SPECIAL SCREW M12	-	4521-00016	-

### ACCESSORIES

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	PULLER PLUG	-	0015-04800	-
	PLUG Ø20	-	0015-04501	-
	PLUG Ø24	-	0015-04500	-
	PULLER RING	-	0014-04600	0014-00010
	PULLER ADAPTER M6	-	0014-04610	
	PULLER ADAPETR M12	-	0014-04640	
	THREADED SPARE PART (puller Ring)	-	0014-00003	-

### SPARE PARTS

ITEMS	DESCRIPTION	DIMENSION	CODE	SET CODE
	JAW M16	-	0020-05150	-
	JAW M16 LEVELING	-	0020-05100	-



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