

## SELF-CENTERING AUTOMATIC VISE

**IDEAL FOR  
5 AXIS  
MACHINING  
CENTRES**

**HYDRAULIC or  
PNEUMATIC  
DOUBLE EFFECT**

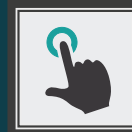
**AUTOMATIC  
CONTROL**

**5 AXIS  
MACHINE**

**OIL / AIR  
DIRECT INPUT**



**Art.670**



As all the other vises of the Multitasking Series, **GripMatic** series Art.670 is conceived for 5-axis machining centers in order to work on 5 surfaces always respecting the tight tolerances and the high rigidity. The activation is made by the oil or compressed air through a double effect piston that grants the complete managing of the vise. One of the main features is modularity that allows this kind of vise to be used on any type of machine and, thanks to its configuration and complete handling by CNC, it is also possible to automate the clamping process so increasing the productivity of your company.



Soft movable jaw

**Example 1**



Soft narrow movable jaw

**Example 2**



Soft movable jaw for width standard jaw plates

**Example 3**



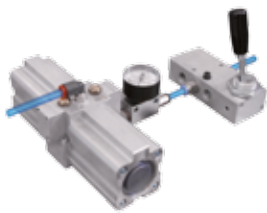
# SELF-CENTERING VISE WITH SOFT MOVABLE JAWS

Vise (type) size	1		2	
	mm	inches	mm	inches
<b>Art. 670</b> Type 3	-	-	6,4	0,25"
	-	-	25	0,98"
	-	-	80	3,15"
	-	-	106	4,17"
	-	-	49	1,93"
	-	-	10	0,39"
	-	-	90	3,54"
	-	-	20	0,79"
	-	-	74	2,91"
kg / lb	-	-	6,5 kg	14,3 lb
Code	Possible on Request		7.67.OPN20	
			7.67.OID20	
			<b>2,040</b>	



Self-centering **pneumatic or hydraulic** vise with soft movable jaws

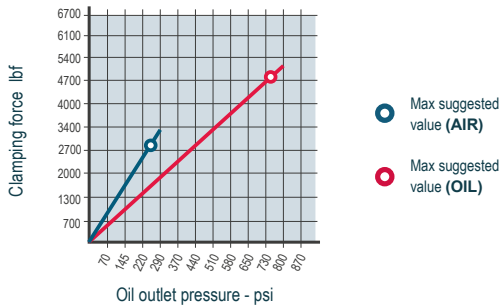
## PNEUMATIC GRIPMATIC VISE



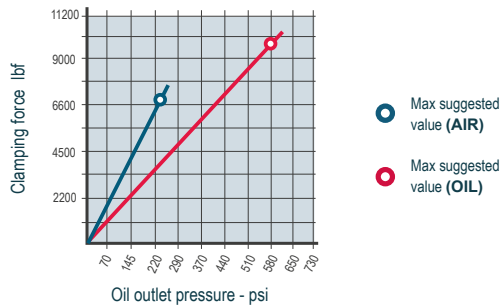
Pneumatic	Type 2	Type 3	Type 4
<b>Air Pressure Input (psi)</b>	Clamping Force (lbf)	Clamping Force (lbf)	Clamping Force (lbf)
90	1100	2700	4200
100	1300	3100	4900
120	1500	3500	5600
145	1800	4400	7000
175	2200	5300	8400
200	2600	6200	-
230	2900	7100	-

**Art. 408**  
Pressure air multiplier

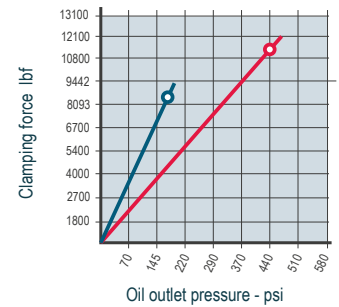
**T.2** Hydraulic cylinder Ø3,37 inches  
Effective surface 8,03 inches<sup>2</sup>



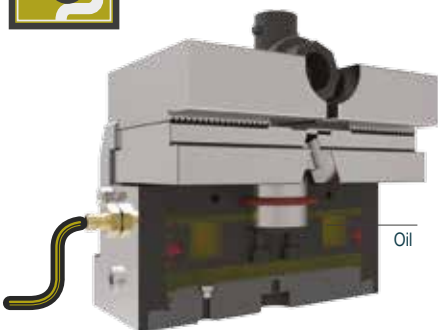
**T.3** Hydraulic cylinder Ø5,32 inches  
Effective surface 20,51 inches<sup>2</sup>



**T.4** Hydraulic cylinder Ø6,69 inches  
Effective surface 32,47 inches<sup>2</sup>



## HYDRAULIC GRIPMATIC VISE



Hydraulic	Type 2	Type 3	Hydraulic	Type 4
<b>Oil Pressure Input (psi)</b>	Clamping Force (lbf)	Clamping Force (lbf)	<b>Oil Pressure Input (psi)</b>	Clamping Force (lbf)
145	950	2500	145	3900
290	1900	5000	217,5	5800
440	2900	7400	290	7800
580	3800	9900	362,5	9700
725	4800	-	435	11.700

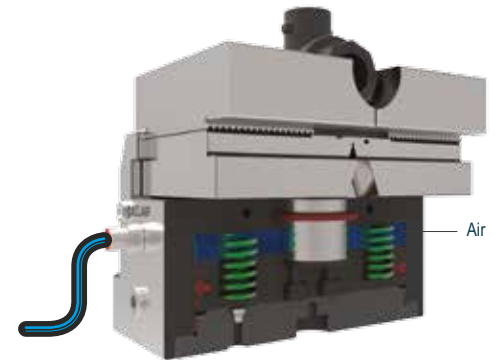
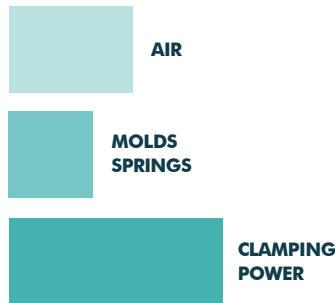
# IDEAL FOR 5 AXIS MACHINING CENTRES

3		4		5	
mm	inches	mm	inches	mm	inches
8,5	0,33"	12	0,47"	-	-
30	1,18"	35	1,38"	-	-
105	4,13"	130	5,12"	-	-
166	6,54"	206	8,11"	-	-
79	3,11"	96	3,78"	-	-
12	0,47"	16	0,63"	-	-
140	5,51"	170	6,69"	-	-
20	0,79"	20	0,79"	-	-
99	3,90"	124	4,88"	-	-
20 kg	44,1 lb	38 kg	83,8 lb	-	-
7.67.OPN30		7.67.OPN40			
7.67.OID30		7.67.OID40			
<b>2,720</b>		<b>3,640</b>		<b>Possible on Request</b>	

Thanks to the internal mold springs, Art.670

**GripMatic** pneumatic vise allows to obtain better clamping parameters, in respect to the normal functioning.

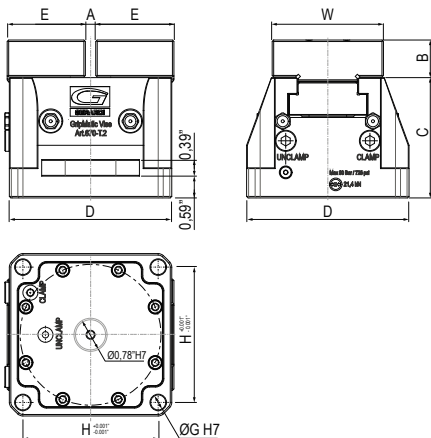
This system guarantees a higher safety level as it clamps the workpiece even in case of pressure loss and so avoiding fixtures damages and workers injuries



**Designed for 5 axis machines, GripMatic series of vises allow machining operations on the 5 workpieces sides with perfect alignment in a space saving design, extremely high wear resistance, with reduced deflection.**

- Possibility to manage the opening/closing by oil or compressed air
- Configuration of the lower surface to allow the addition of the oil / compressed air through an interface plate directly from the machine spindle
- High level of sliding of the internal rails ensured thanks to an anti-friction treatment and specific lubricants always for max performances also with pneumatic use.

- It is possible to apply a proximity detector for the correct handling of the automatism.
- Soft workable jaws, narrow-width workable jaws, jaws configured for the use of specific jaw plates (smooth, grip, serrated...)
- The vise is equipped with covering carters that shelter the item from chips.



## Tipo Type 2

USE SIDE CLAMPS  
Art.298 - Type 1xM10 / 1xM12 / 1xM16

### STANDARD EQUIPMENT

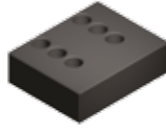


# JAWS & JAW PLATES FOR GRIPMATIC VISES

## GripMatic Jaws

### Art. 671A

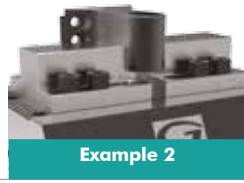
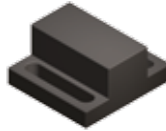
Soft movable jaw  
Not Hardened



Example 1

### Art. 671B

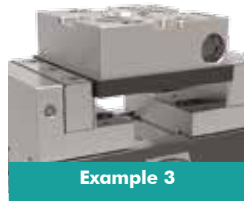
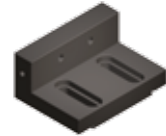
Soft narrow movable jaw  
Not Hardened



Example 2

### Art. 671C

Soft movable jaw for width  
standard jaw plates  
Not Hardened



Example 3



### Art. 243

Grooved straight plate



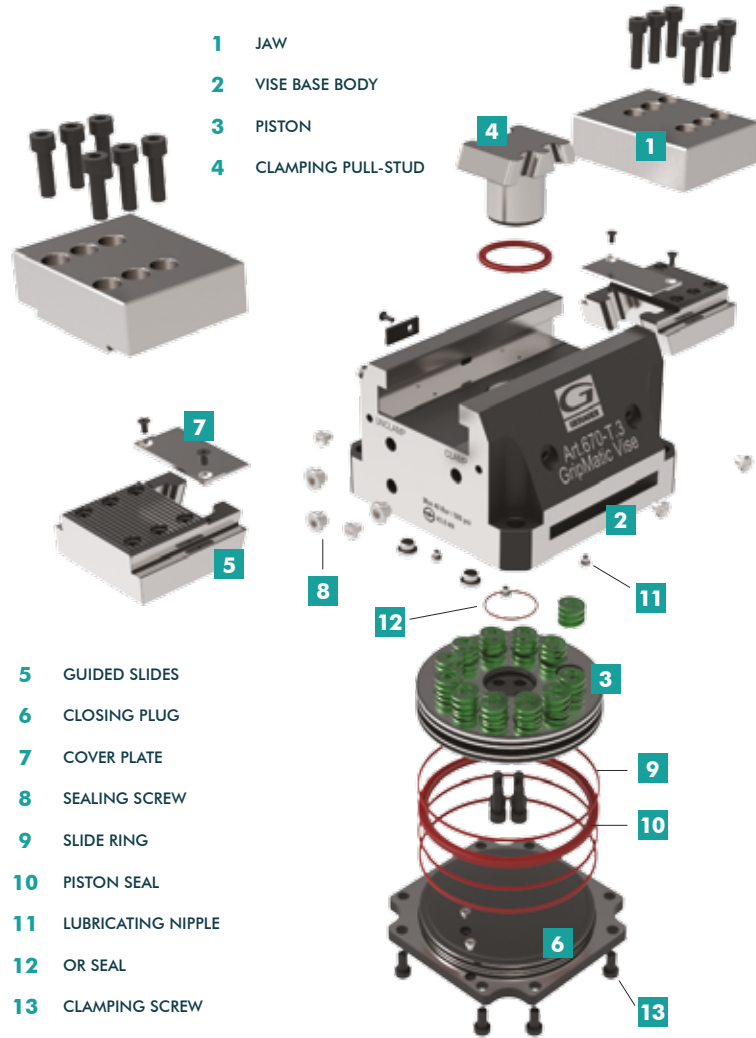
### Art. 245

Smooth straight jaw plate



### Art. 247G

Straight plate with GRIP inserts



- 1 JAW
- 2 VISE BASE BODY
- 3 PISTON
- 4 CLAMPING PULL-STUD

- 5 GUIDED SLIDES
- 6 CLOSING PLUG
- 7 COVER PLATE
- 8 SEALING SCREW
- 9 SLIDE RING
- 10 PISTON SEAL
- 11 LUBRICATING NIPPLE
- 12 OR SEAL
- 13 CLAMPING SCREW



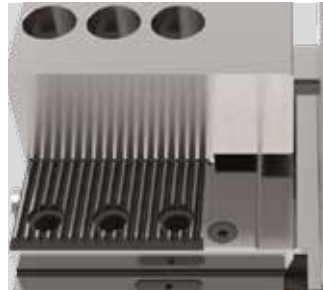
### Automatic vise

- Unattended use possible
- CNC manageable
- Ideal for automatic workpiece loading by robot



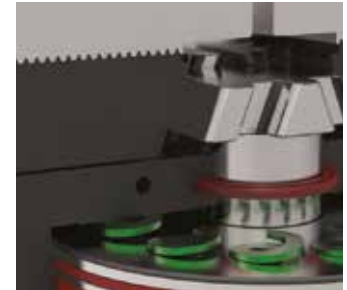
### Direct Oil / Air input

Oil / Compressed air addition directly from the machine spindle



### Versatility

Max versatility thanks to the comb system, the wide jaw range and to the hydraulic or pneumatic jaws opening



### Clamping Power

	ID	PN
T.2	4800 psi	2900 lbf
T.3	9800 psi	7100 lbf
T.4	11700 psi	8400 lbf