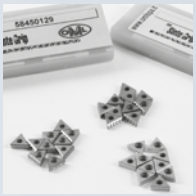
VP-N

NC Clamping Vice

VP-N
NC Clamping Vice

Page 9.2.4



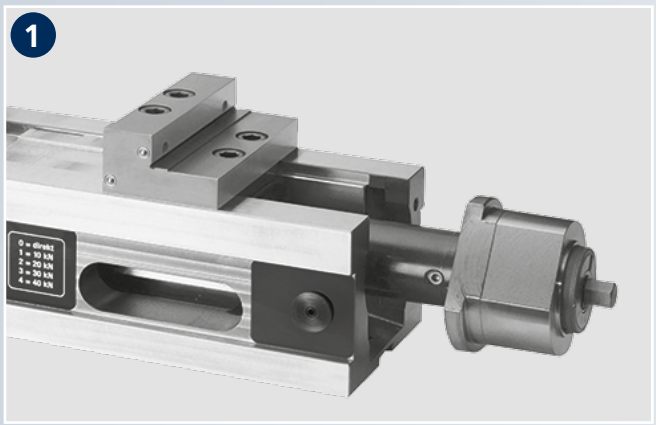
VP-N
SINTERGRIP

Page 9.2.9

VP-N
Accessories

Page 9.2.6

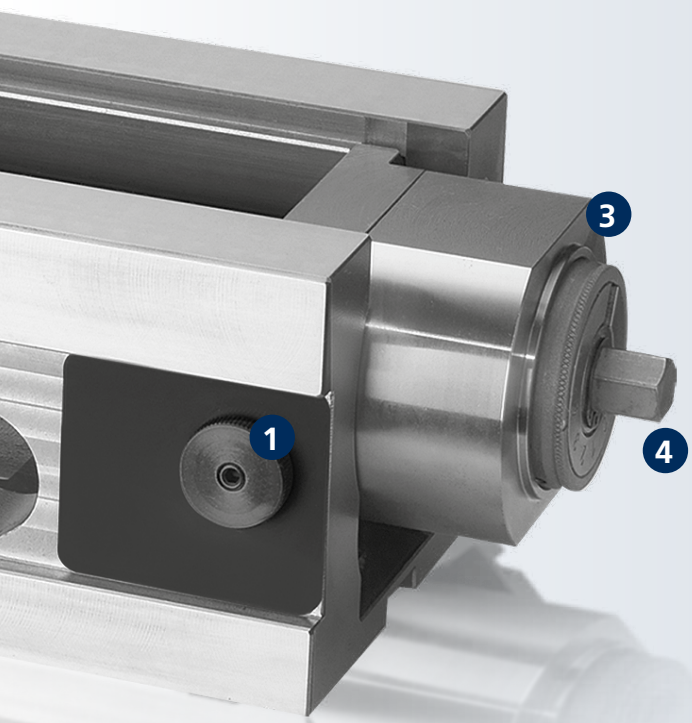
Quick change system of the spindle unit
Disassembling of the spindle unit without tools
Easy and quick cleaning of the vice



Parallels with quick change system
Mounting of parallels without tools
No penetration of chips below parallels

VP-N

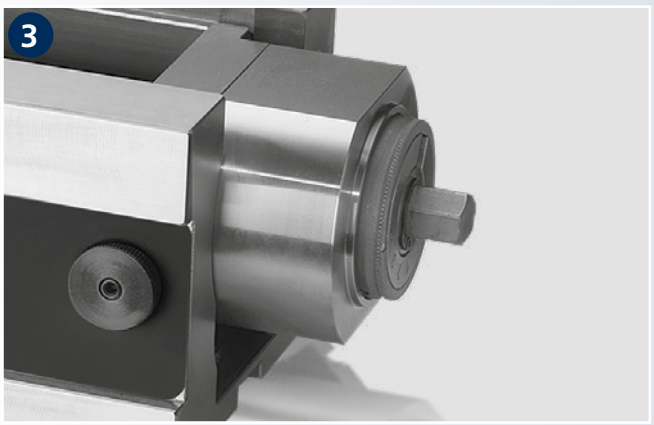
NC Clamping Vice



Interface for zero point clamping systems APS I WPS
as a standard for highest efficiency while set-up

SinterGrip
Jaws for SinterGrip clamping inserts as an accessory for
OP 10 operations available

Protected spindle with mechanical power intensifier
Exact pre-select of the clamping force (up to 11 steps)
Constant clamping force for maximum process reliability



Angle drive (accessory)
Easy use on the machine table
Best accessibility for the setting of the clamping force

VP-N

NC Clamping Vice

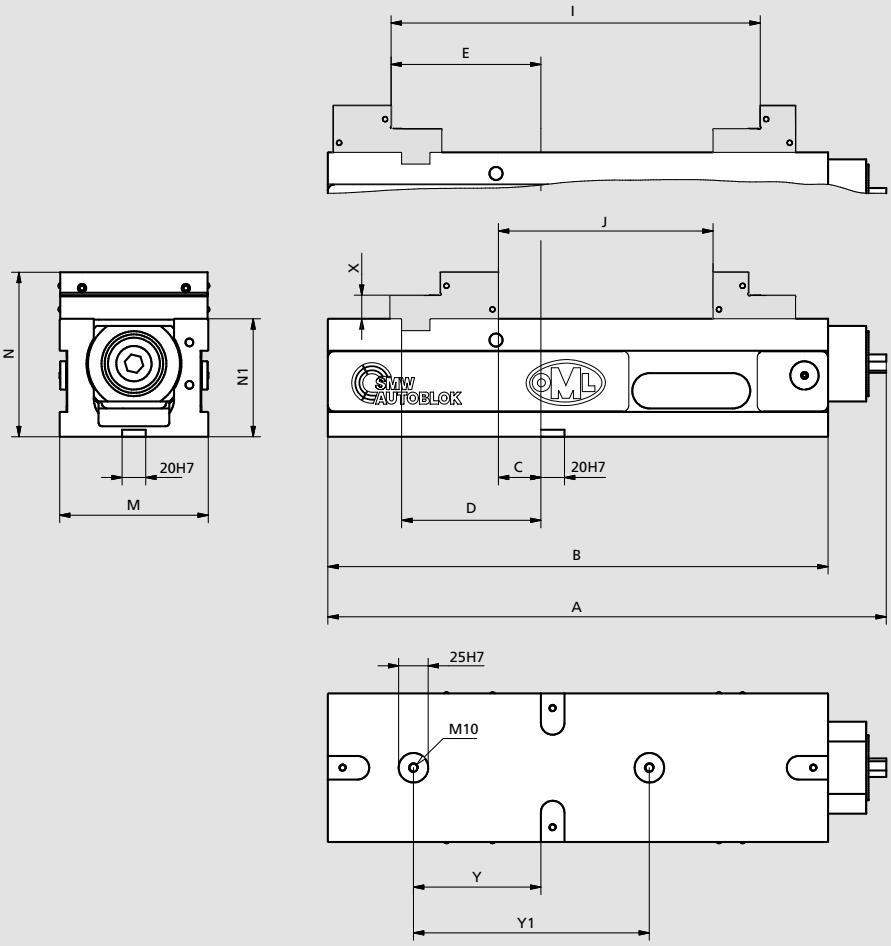
- With precision power transmitter
- Clamping against fixed jaw

Technical features

- High clamping forces (up to 60 kN)
- 3 different sizes
- Precision guideway hardened and ground
- Interface for zero point clamping systems
- APS / WPS as a standard

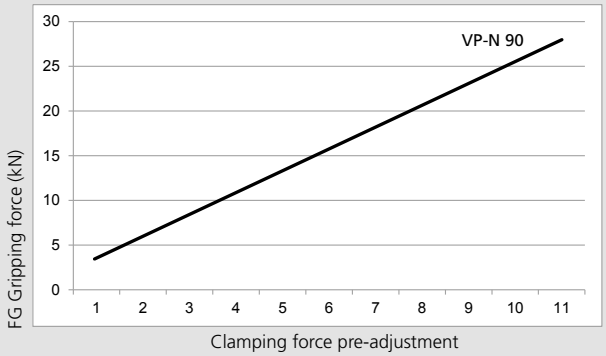
Standard equipment

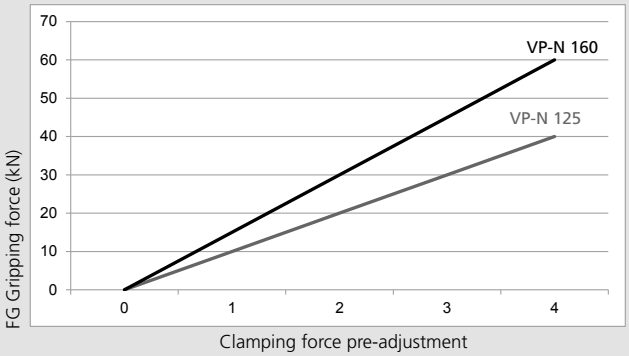
VP-N clamping vice together with hand crank
4 pieces clamps for fixing



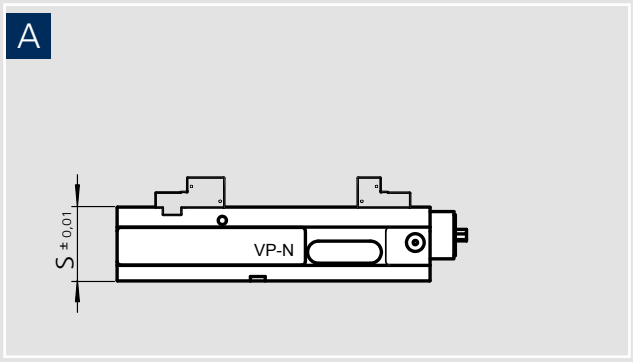
Id. no	Type	A	B	C	D	E	J	I	M	N	N1	X	Y	Y1	Clamping force	Weight
															kN	Kg
46 27 34	VP-N 90	340	305	15	73	75	0-126	91-217	90	114,0	80	16	58	200	28	15
46 27 35	VP-N 125	483	424	36	118	127	0-182	131-313	126	139,5	100	20	108	200	40	35
46 27 36	VP-N 160	616	560	70	164	178	17-263	187-433	164	164,8	115	25	114	300	60	60

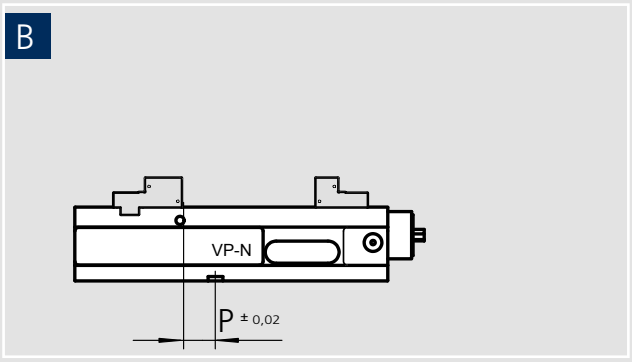
Clamping force diagrams

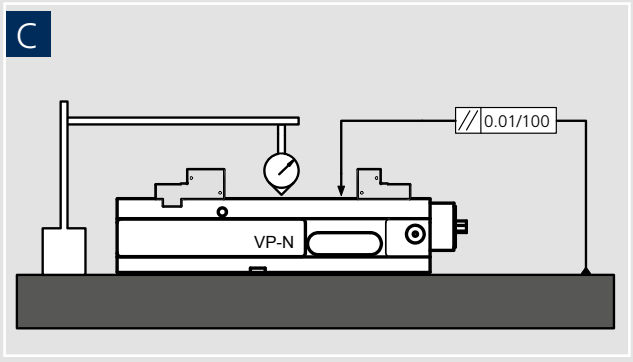


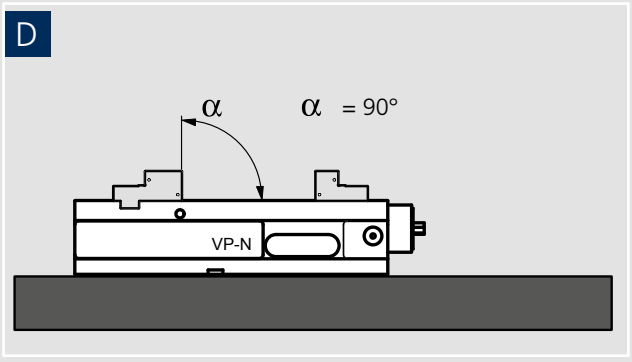


Manufacturing tolerances for all types of vices

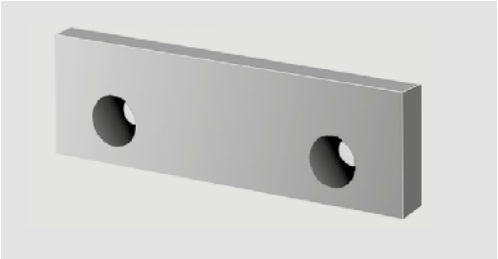








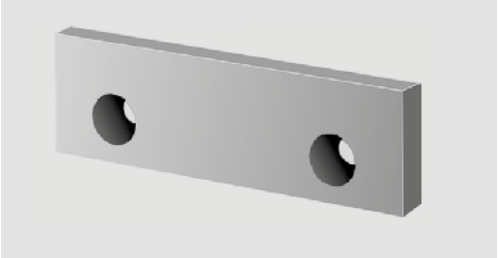
Flat clamping jaw hardened and grinded



Id. No.	Type	Height	Depth
		mm	mm
46 27 38	VP-N 90	34.0	10
46 27 39	VP-N 125	39.2	12
46 27 40	VP-N 160	49.2	16

Consisting of: 1 piece clamping jaw

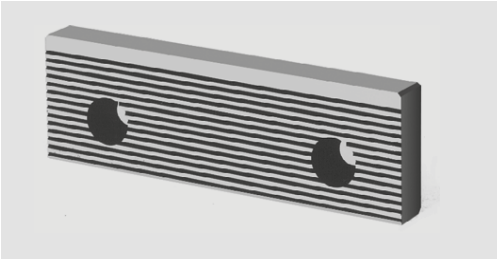
Flat clamping jaw soft (material 1.2842)



Id. No.	Type	Height	Depth
		mm	mm
46 27 41	VP-N 90	34.0	10
46 27 42	VP-N 125	39.2	12
46 27 43	VP-N 160	49.2	16

Consisting of: 1 piece clamping jaw

Clamping jaw with groove



Id. No.	Type	Height	Depth
		mm	mm
46 27 44	VP-N 90	34.0	10
46 27 45	VP-N 125	39.2	12
46 27 46	VP-N 160	49.2	16

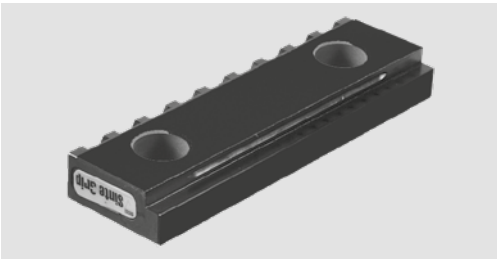
Consisting of: 1 piece clamping jaw

Parallel with quick change system

Id. No.	Type	Height	Depth
		mm	mm
46 27 47	VP-N 90	14	3
46 27 48	VP-N 90	30	3
46 27 49	VP-N 125	39	3
46 27 50	VP-N 125	35	3
46 27 51	VP-N 125	15	3
46 27 52	VP-N 160	14	3
46 27 53	VP-N 160	30	3
46 27 54	VP-N 160	44	3

Consisting of: 1 piece level bar

SinterGrip clamping jaw



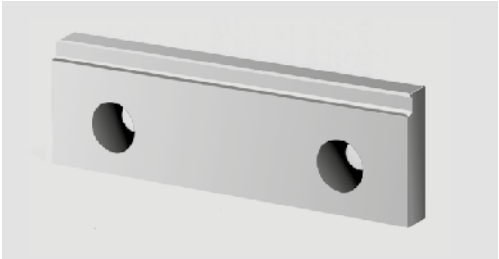
Id. No.	Type	Nr. Sintergrip per jaw	Height	Depth
			mm	mm
46 27 55	VP-N 125	9	39.5	12
46 27 56	VP-N 160	11	49.8	12

Consisting of: 1 piece SinterGrip clamping jaw (without clamping inserts)

Smooth clamping jaw with step

Id. No.	Type	Step	Height	Depth
		mm	mm	mm
46 27 57	VP-N 125	3 x 6	34.0	10
46 27 58	VP-N 125	5 x 10	39.2	12
46 27 59	VP-N 160	5 x 8	49.2	16

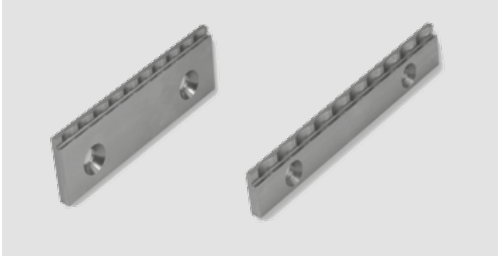
Consisting of: 1 piece clamping jaw



Step jaw for raw parts VP-N 125

Id. No.	Type	Model	Height	Step
		mm	mm	mm
46 27 60	VP-N 125	High step	39.5	1.4 x 4.5
46 27 61	VP-N 125	Low step	19.5	2.0 x 4.5

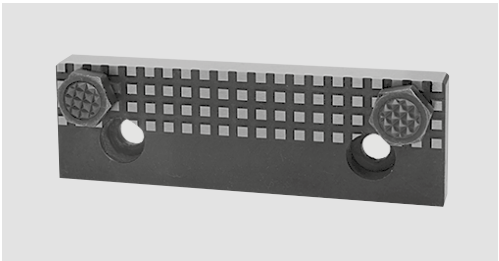
Consisting of: 1 piece step jaw



Serrated Clamping jaw with grippers

Id. No.	Type	Height	Depth	Thread	Id. No. Grippers
		mm	mm	mm	
46 27 62	VP-N 90	34	12	M10	46 27 62
46 27 63	VP-N 125	40	12	M10	46 27 63
46 27 64	VP-N 160	50	16	M12	46 27 64

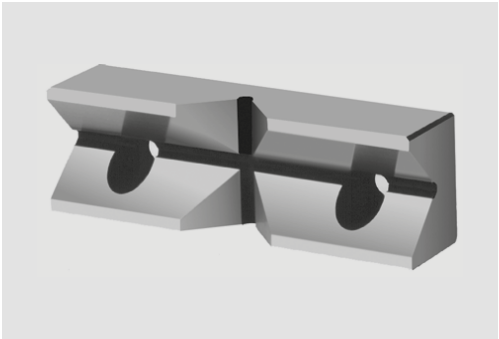
Consisting of: 1 piece clamping jaw



Prismatic jaw horizontal and vertical prisma 90° hardened and grinded

Id. No.	Type	Height	Depth	Clamping min/max mm	
		mm	mm	1 ganascia	2 ganascie
46 27 65	VP-N 90	36.0	17	ø 12-14	ø 18-42
46 27 66	VP-N 125	39.2	28	ø 15-42	ø 24-42
46 27 67	VP-N 160	49.2	32	ø 18-50	ø 28-50

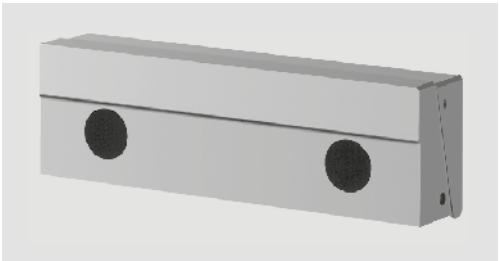
Consisting of: 1 piece clamping jaw



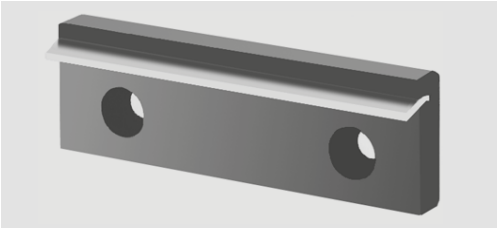
Pull-down jaw with interchangable insert

Id. No.	Type	Height	Depth
		mm	mm
46 27 68	VP-N 90	34.0	24
46 27 69	VP-N 125	39.2	25
46 27 70	VP-N 160	49.2	28

Consisting of: 1 piece clamping jaw



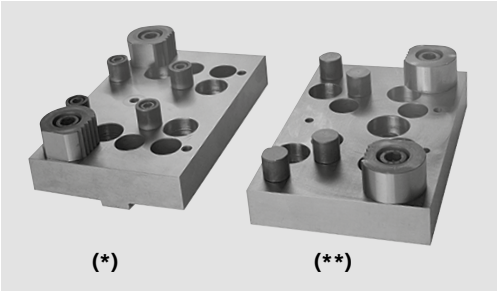
Pull-down jaw for raw parts with spring blade



Code	Type	Height	Depth
		mm	mm
46 27 71	VP-N 90	34	18
46 27 72	VP-N 125	40	21
46 27 73	VP-N 160	50	24

Consisting of: 1 piece clamping jaw

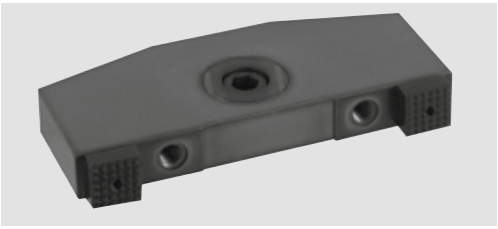
Fixed jaw with grippers, Floating jaw with gripper



Code	Type	Height	Width	Lenght
		mm	mm	mm
46 27 74	VP-N 90 (*)	25	145	90
46 27 75	VP-N 125 (*)	25	170	105
46 27 76	VP-N 160 (*)	25	200	115
46 27 86	VP-N 90 (**)	25	145	90
46 27 87	VP-N 125 (**)	25	170	105
46 27 88	VP-N 160 (**)	25	200	115

Consisting of: 1 piece clamping jaw (*****) fixed jaw - (******) movable jaw

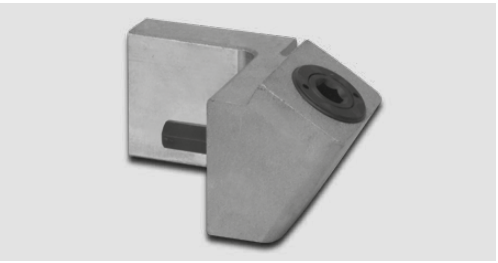
Floating jaw



Code	Type	Width	Lenght	Height
		mm	mm	mm
46 27 77	VP-N 90	50	141	20
46 27 78	VP-N 125	65	156	20
46 27 79	VP-N 160	76	196	23

Consisting of: 1 piece clamping jaw

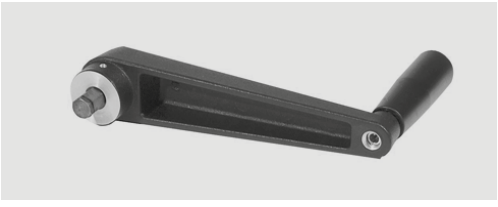
Angle drive for VP-N NC Clamping vices



Code	Type	Lenght	SW
		mm	
46 27 80	VP-N 90	12	SW 12
46 27 81	VP-N 125	33	SW 14
46 27 82	VP-N 160	49	SW 14

Consisting of: 1 piece angle jaw

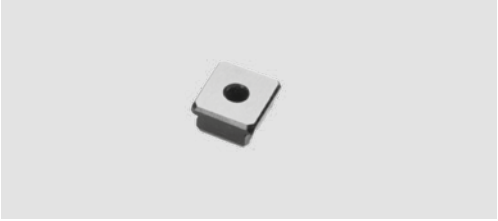
Hand crank standard versione for VP-N NC Clamping vices



Code	Type	Lenght	SW
		mm	
46 27 83	VP-N 90	160	SW 12
46 27 84	VP-N 125	160	SW 14
46 27 85	VP-N 160	160	SW 14

Consisting of: 1 piece hand crank

Positioning Key with screw



Code	Type
	mm
46 26 38	20 x 12
46 26 39	20 x 14
46 26 40	20 x 16
46 26 41	20 x 18
46 26 42	20 x 20
46 26 43	20 x 22

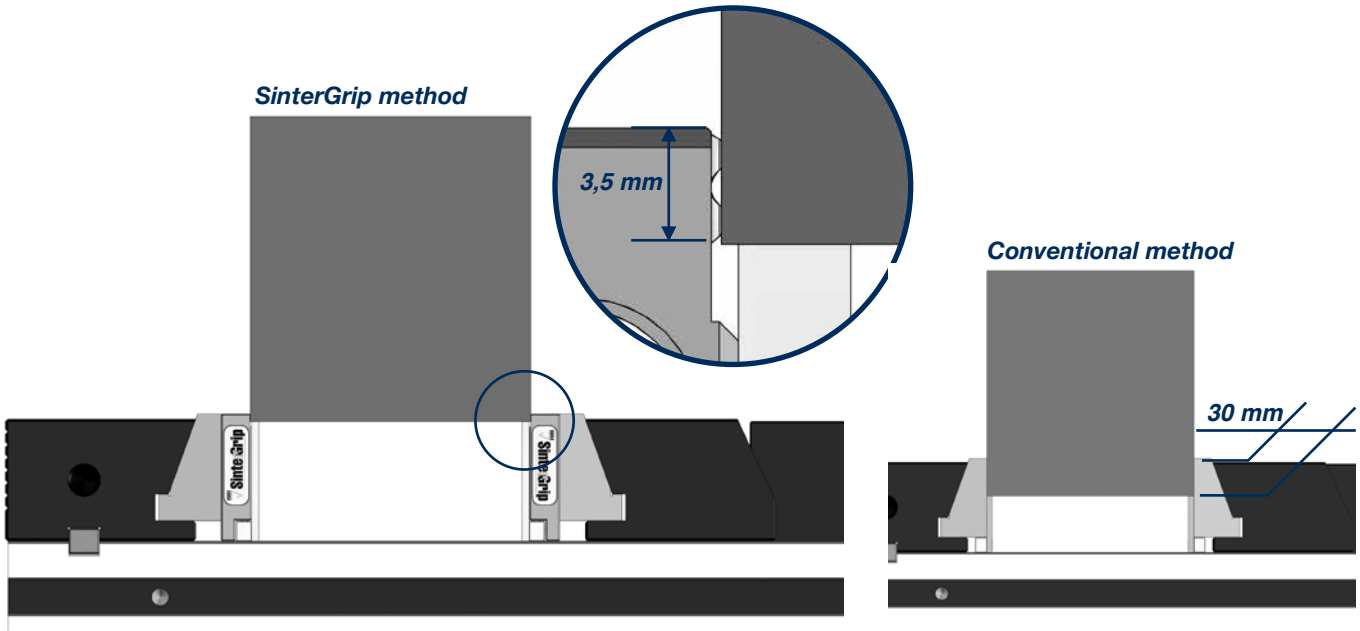
Our new product **SinterGrip** is born to satisfy the current need to clamp a workpiece for very few millimeters (with SinterGrip 3,5 mm clamping surface), and this for the following reasons:

1) In order to machine the workpiece completely in a single operation (especially for 5 axis machines);
2) In order to save money for the raw materials, especially when they have a big impact on the price (aluminum, titanium, etc.)

Indirectly to these reasons, and in order to improve the performance of the machine tool and the tools

higher cutting speed + higher feed rate =
bigger volume of metal removed =
less time to machine the workpiece

the market requires safe clamping, which could at the same time possibly avoid the deformations of the piece itself.



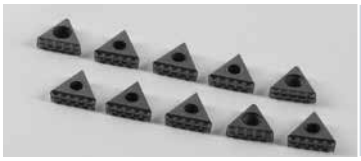
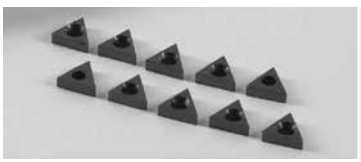
Only 3,5 mm clamping surface, no need of pre-machining the workpiece, clamping stability, higher cutting rate: SinterGrip brings only advantages compared to the traditional systems.

On the contrary, traditional systems need, for the clamping of the workpiece, a bigger clamping surface, with the result of waste of raw materials and greater possibility of deformation of the workpiece.

Working example: jaws mounted on a TC clamp

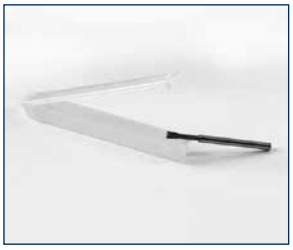
Working example: inserts SinterGrip mounted.

SinterGrip

	Id. No.	Description
	58 45 01 19	Set of 10 SinterGrip inserts **STD** for steel
	58 45 01 29	set of 10 SinterGrip inserts **HRC** for hardened steel / titanium until 50-54 HRC
	58 45 01 39	Set of 10 SinterGrip inserts for **ALU**
	58 45 02 19	Kit 10VTX30 for inserts SINTERGRIP
	58 45 05 19	Kit 10 protection inserts in aluminum

Find out more

code	description
58450320	Wrench TORX T9



code	description
58450410	Special cutting tool D3

NOTES