



# GERARDI

# FOCUS

VICES AND FIXTURES FOR WORKPIECES POSITIONING AND CLAMPING



**AUTOMATIC  
VISE**

**INTERFACE  
PLATE**

**GRIPPER**

**ZERO POINT  
PLATE**

## **NEW**

### **5G Vises**

Advanced technology for 5 axis machine

### **Magnetic Chucks**

Electro-permanent system for milling operation

## **TOOLING**

### **Angle Heads**

More than 700 models available

### **Driven Tools**

Upgrade your lathe and boost productivity!

## **AUTOMATION**

### **GripMatic Vises**

The automatic & self-centering

### **Grippers**

Pneumatic grippers: high performance & accuracy









# PRECISION MODULAR VISES



## — STD SERIES



Accuracy  
 $\pm 0,02\text{mm}$



Hardened  
HRC 58 $\pm 2$

## THE ORIGINAL & MOST COPIED VISE IN THE WORLD!

### TECHNICAL FEATURES & ADVANTAGES

- No wear: high alloyed quality resistance steel, case hardened HRC 60  $\pm 2$ ,
- Quick clamping
- Modularity & versatility
- Highest accuracies  $\pm 0,02\text{ mm}$
- Rigidity & safety
- Space saving design & handy

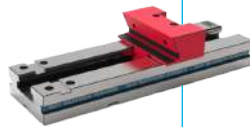
### PRISMATIC JAW

The prismatic jaw allows the clamping and machining of round workpieces or drill through operation  
Art. 217



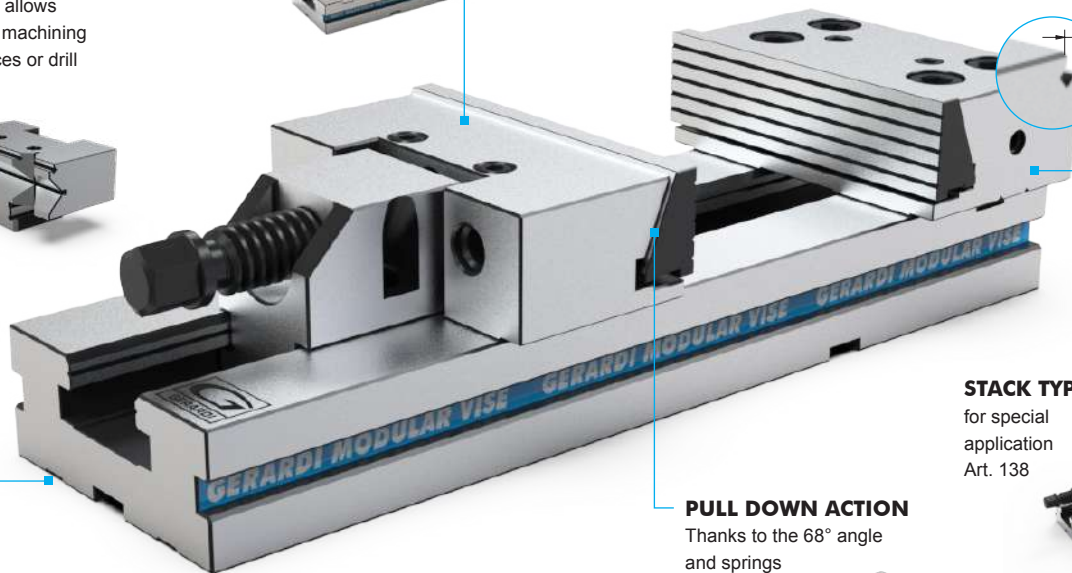
### SOLID GUIDED JAWS

Both jaws bodies are built in one solid piece in order to guarantee higher rigidity & no bendings. Both jaw plates are manufactured with a pull down angle



### Supplied with Gerardi Standard Series Machine Vise:

- 1x workstop ART.370
- 1x pair of positioning key-nuts for 16 mm slot ART. 297
- 1x box wrench ART.375
- 1x T wrench ART.376



5 mm

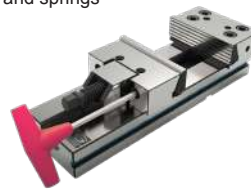
### STACK TYPE JAW

for special application  
Art. 138



### PULL DOWN ACTION

Thanks to the 68° angle and springs



Release the screw so the jaw plate will drag downway the workpiece

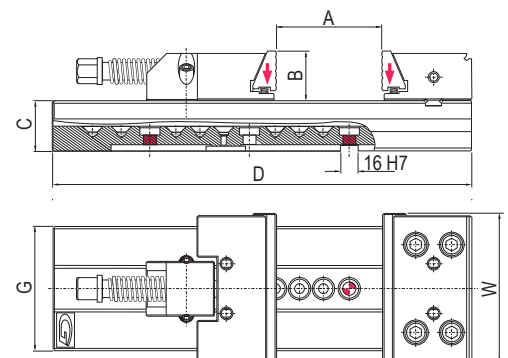
### HIGHEST ACCURACIES $\pm 0,02\text{mm}$

Solid vise base. Every sliding and coupling surface is ground. Centesimal tollerances are guaranteed by checking cycles with CNC measuring machine



## STANDARD SERIES VISES - ART. 1

	A	W	B	C	D	G	Kg	Cod.
1 (16kN)	100	100	30	35	270	75	6.8	3.01.00000
	150	125	40	40	345	95	12.9	3.02.10000
3 (30kN)	200	150	50	50	420	125	25.5	3.03.20000
	300	200	60	60	520	175	42	3.04.30000
4 (30kN)	200	175	60	58	455	145	37	3.04.20000
	300	200	65	65	555	170	42	3.04.30000
5 (40kN)	400	200	65	70	655	195	47	3.04.40000
	500	250	70	75	595	220	69	3.05.30000
6 (40kN)	400	200	65	70	695	170	74	3.05.40000
	500	250	70	75	795	195	79	3.05.50000
6 (40kN)	600	300	80	78	935	195	135	3.06.60000
	700	350	80	78	1035	195	145	3.06.70000
	800	400	80	78	1135	195	155	3.06.80000





# PRECISION MODULAR VISES



## — STDFLEX SERIES



Accuracy  
 $\pm 0,02\text{mm}$



Hardened  
HRC 58 $\pm 2$

## QUICKEST JAW PLATES CHANGE!

### TECHNICAL FEATURES & ADVANTAGES

- No wear
- Quick clamping
- Modularity & versatility
- Highest accuracies  $\pm 0,02\text{ mm}$
- Rigidity & safety
- Space saving design & handy

**HIGHEST REPOSITIONING ACCURACY  $\pm 0,005\text{mm}$**

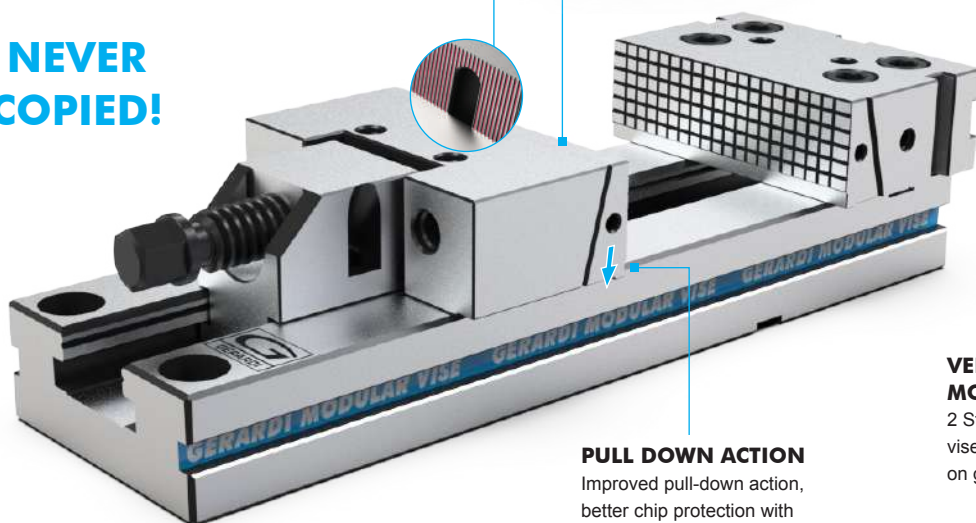
### QUICKEST VISE RESETTNG

Thanks to the quick interchangeable jawplate through ground comb system

### Supplied with Gerardi StandardFLEX Machine Vise:

- 1x workstop ART.370
- 1x pair of positioning key-nuts for 16 mm slot ART. 297
- 1x box wrench ART.375
- 1x T wrench ART.376

**NEVER COPIED!**



### PULL DOWN ACTION

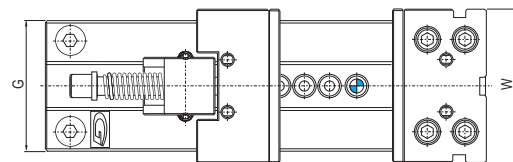
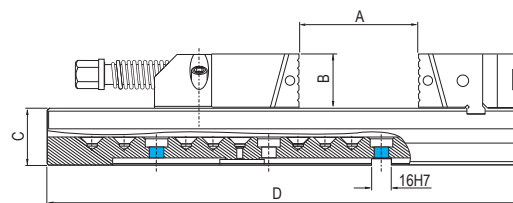
Improved pull-down action, better chip protection with the comb system and greater efficiency in clamping

### VERTICAL MOUNTING

2 StandardFlex vises back to back on grid base

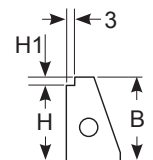
## STANDARD FLEX VISES - ART.1A

	A	W	B	C	D	G	Kg	Cod.
1 (16kN)	100	96	28	35	270	75	6,8	1.1A.10000
	150	121	38	40	345	95	12,9	1.1A.20000
3 (30kN)	200	146	48	50	420	125	25,5	1.1A.32000
	300				29		1.1A.33000	
4 (30kN)	200	171	58	58	455	145	37	1.1A.42000
	300				42		1.1A.43000	
	400				47		1.1A.44000	
5 (40kN)	200	196	63	70	495	170	64	1.1A.52000
	300				69		1.1A.53000	
	400				74		1.1A.54000	
6 (40kN)	400	296	78	78	735	195	115	1.1A.64000
	500				125		1.1A.65000	
	600				135		1.1A.66000	

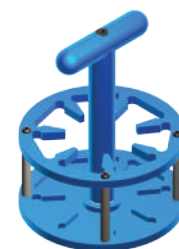


## STEP COMB INTERCHANGEABLE JAW PLATE - ART.230E

	H	H1	B	H1 - Heights Step Jaws Included in the set								Cod.
1 (95)	23	5	28	3x2	5x2	8x2	13x2	-	-	-	-	4.23.0E101
2 (120)	33	5	38	3x2	5x2	8x2	13x2	18x2	23x2	-	-	4.23.0E201
3 (145)	43	5	48	3x2	5x2	8x2	13x2	18x2	23x2	28x2	-	4.23.0E301
4 (170)	53	5	58	3x2	5x2	8x2	13x2	18x2	23x2	28x2	-	4.23.0E401
5 (195)	53	10	63	3x2	5x2	10x2	13x2	18x2	23x2	28x2	-	4.23.0E501
6 (295)	68	10	78	3x2	5x2	10x2	13x2	18x2	23x2	28x2	-	4.23.0E601



Always specify H1 DIMENSION



ART.320 - Rack



FIND OUT MORE

# Innovative comb system for quick pull-down jaw plate changes: the perfect mix of price+quality

## XL SERIES VISES FOR THE LARGEST WORKPIECES

### XL SINGLE OPENING (ART.20A) + DOUBLE OPENING (ART.30A) VISES

Vise Size	A	W	B	C	D	G	ART. 20A		ART. 30A		
							Kg	Cod. 21	A1	Kg	Cod. 30
1 (16kN)	290	96	28	35	460	75	6.8	2.20.A1290	2 x 90	8,1	2.30.A1900
	320	121	38	40	520	95	12.9	2.20.A2320	2 x 100	15,8	2.30.A2100
3 (30kN)	360	146	48	50	580	125	25.5	2.20.A3360	2 x 110	31,5	2.30.A3110
	29						2.20.A3460	2 x 160	35	2.30.A3160	
4 (30kN)	400	171	58	58	766	145	37	2.20.A4400	2 x 120	46,3	2.30.A4120
	500						42	2.20.A44500	2 x 170	51,3	2.30.A4170
	600						47	2.20.A4600	2 x 220	56,3	2.30.A4220
5 (40kN)	600	196	63	70	1005	170	69	2.20.A5600	2 x 200	84	2.30.A5200
	700						74	2.20.A5700	2 x 250	89	2.30.A5250
6 (40kN)	900	296	78	78	1200	195	84	2.20.A5900	2 x 350	99	2.30.A5350
	700						115	2.20.A6700	2 x 260	145	2.30.A6260
	800						125	2.20.A6800	2 x 310	155	2.30.A6310
	900				1300		135	2.20.A6900	2 x 360	165	2.30.A6360

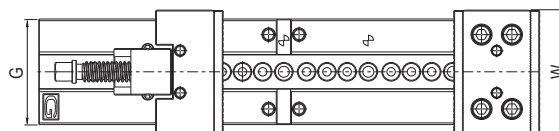
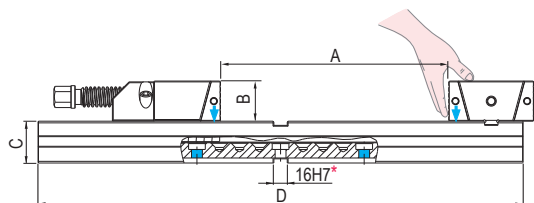


ART. 20A



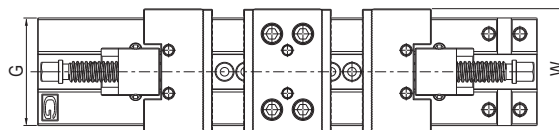
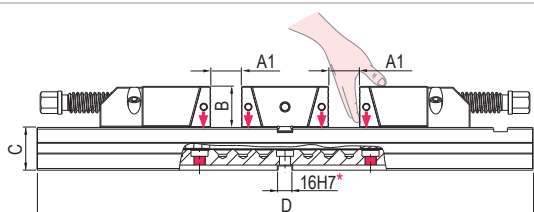
ART. 30A

ART. 20A



\* Normal version: 16H7 slot and calibrated holes Ø8F7 (t.1) - Ø16F7 (t. 2-3-4-5-6)  
Add 1 movable jaw to turn into a double XL vise

ART. 30A



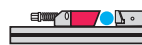
\* Normal version: 16H7 slot and calibrated holes Ø8F7 (t.1) - Ø16F7 (t. 2-3-4-5-6)  
Remove 1 movable jaw to turn into a single XL vise

### SPARE PARTS

#### PULL DOWN JAWS PLATES INTERCHANGEABLE BY HAND



**ART.242G/246G**  
With grip inserts with magnetic parallel. Normal & Narrow Width



**ART.210**  
Solid guided movable for round workpieces



**ART.160**  
Fixed machineable. Normal width (W3)



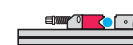
**ART.192**  
Floating movable with two floating elements and spherical smooth points



**ART.200**  
Fixed. Normal width (W3)



**ART.212**  
Intermediate movable (to be used with Art. 313)



**ART.217**  
Prismatic guided movable



**ART.313/314**  
Pair of guided parallels magnetic. Normal & angular

#### JAW PLATES COMPATIBLE ONLY WITH STDFLEX VISES



**ART.230SLD**  
Discharged comb jaw plate



**ART.230B**  
Soft comb interchangeable jaw plate



**ART.230C**  
Smooth comb interchangeable jaw plate



**ART.230D**  
Serrated comb interchangeable jaw plate



**ART.230E**  
Step comb interchangeable jaw plate



**ART.230F**  
Prismatic comb interchangeable jaw plate



**ART.230G**  
90° interchangeable comb jaw plate



**ART.230H**  
Round comb interchangeable jaw plate

# PRECISION MODULAR VISES



## MODULAR ELEMENTS



Accuracy  
 $\pm 0,02\text{mm}$



Hardened  
HRC 58 $\pm$ 2

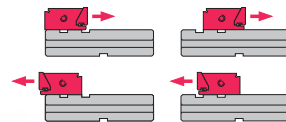
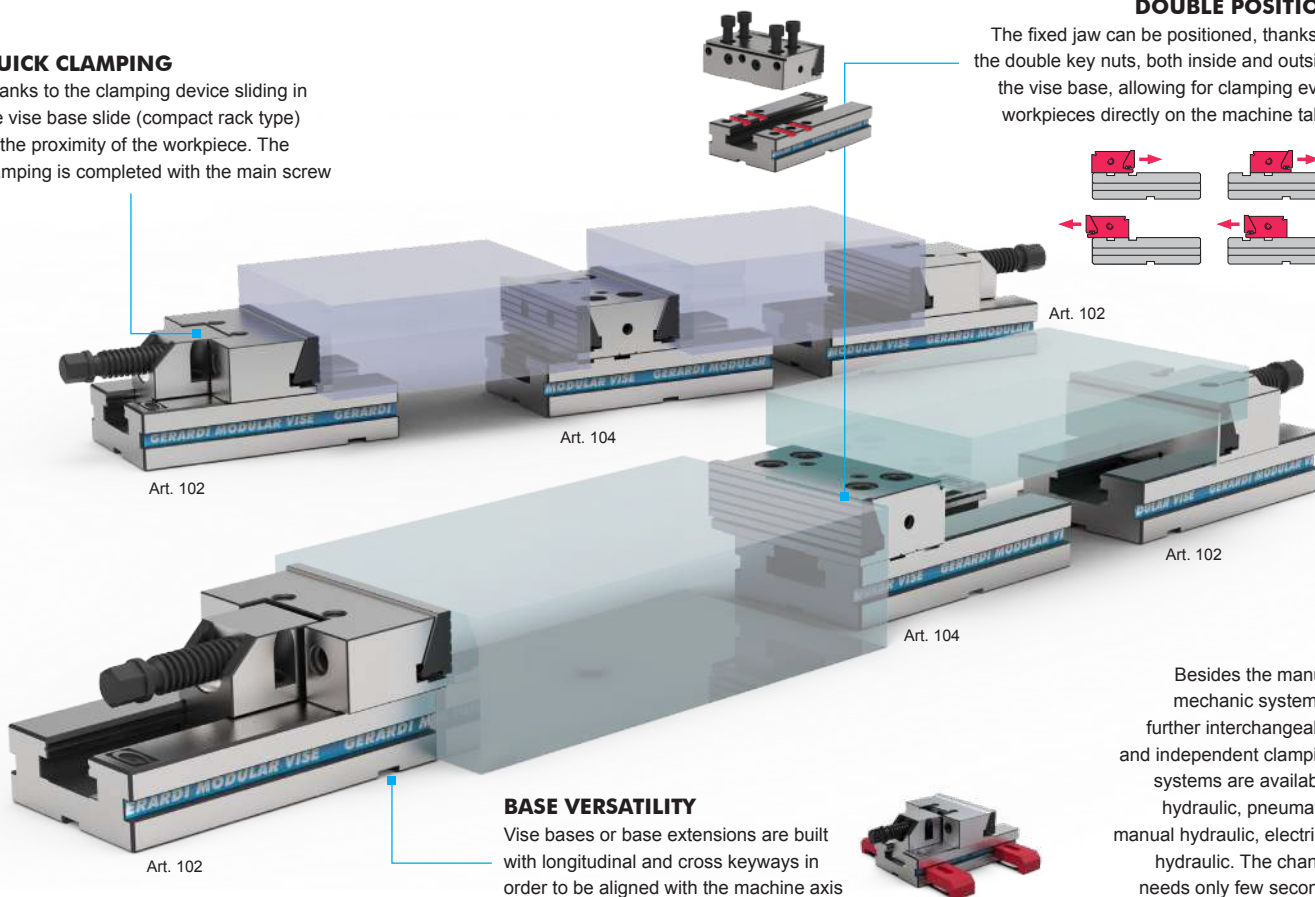
## VISE SECTIONS FOR SPECIAL APPLICATIONS

### QUICK CLAMPING

Thanks to the clamping device sliding in the vise base slide (compact rack type) till the proximity of the workpiece. The clamping is completed with the main screw

### DOUBLE POSITION

The fixed jaw can be positioned, thanks to the double key nuts, both inside and outside the vise base, allowing for clamping even workpieces directly on the machine table



Art. 102

Art. 104

Art. 102

Art. 104

Art. 102

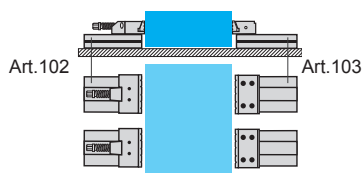
Art. 102

### BASE VERSATILITY

Vise bases or base extensions are built with longitudinal and cross keyways in order to be aligned with the machine axis

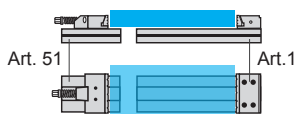
Besides the manual mechanic system, 4 further interchangeable and independent clamping systems are available: hydraulic, pneumatic, manual hydraulic, electrical hydraulic. The change needs only few seconds

## CLAMPING APPLICATIONS



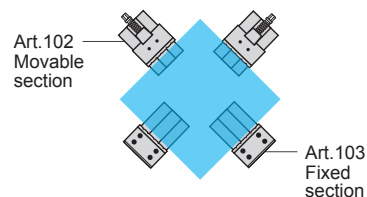
### EXAMPLE #1

Huge workpieces clamped directly on the machine table



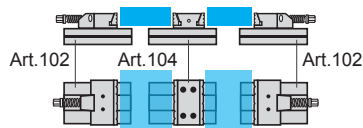
### EXAMPLE #2 ART.1 + ART.51

Art.258 + Art.127 assemble them on a extension base Art.51 for long workpieces



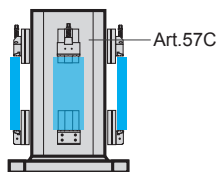
### EXAMPLE #3

Medium size workpieces clamped directly on the vise sections



### EXAMPLE #4

Double fixed vise section Art.104 + 2 movable vise sections Art.102



### EXAMPLE #5

Modular elements assembled on cross cube type Art.57C

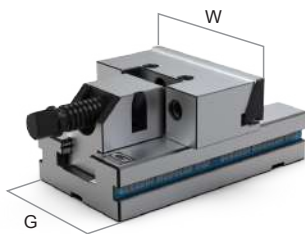
**CUSTOMIZED SOLUTIONS FOR ALL YOUR CLAMPING PROBLEMS**



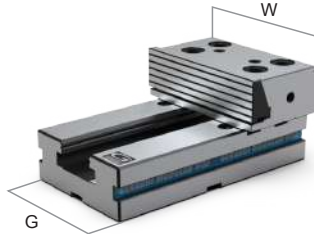
FIND OUT MORE

# Wide range of standard elements to clamp special applications

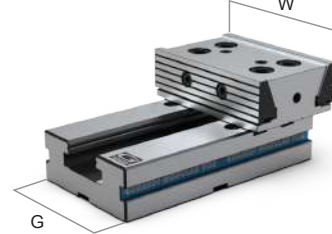
## INDEPENDENT ELEMENTS FOR SPECIAL APPLICATIONS



ART. 102



ART. 103



ART. 104

ART. 102A

ART. 103A

ART. 104A

Vise Size	W	G
	1	100
2	125	95
3	150	125
4	175	145
5	200	170
6	300	195

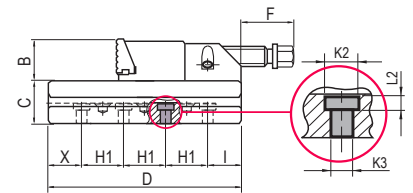
Gerardi modular elements allow perfect clamping of big workpieces which need the heaviest machining using the machine table as surface. Modular Elements are a solution for a wide range of applications and, with the many reference points available, it is a perfect complement or alternative to single or double vises.

- No Wear - 100% HRC60 Hardened Steel
- Modularity & Versatility
- Rigidity & Safety
- Quick Clamping
- Highest Accuracies  $\pm 0.02$  mm
- Space Saving Design

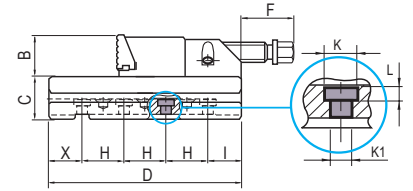
Also available in **StandardFlex** versions with quick-change jaw plates: Art.102i / Art.102Ai, Art.103i / Art.103Ai, Art.104i / Art.104Ai

### MOVABLE JAW SECTION - ART.102/102A (GRID)

Vise Size	ART. 102												ART. 102A											
	B	C	D	F	Kg	H	I	K1	KØ	L	X	M*	Cod. 102	H1	I	K2	K3	L2	X	M*	Cod. 102A			
1	30	35	140	55	3,4	40	29	6,5	10,5	4,5	31	3	2.10.21000	50	54	25	16 <sup>F7</sup>	8	36	2	2.10.2A100			
2	40	40	160	83	6,3	40	39	8,5	13,5	5,5	41	3	2.10.22000	50	39	25	16 <sup>F7</sup>	8	21	3	2.10.2A200			
3	50	50	230	82	14,2	50	40	13	19	8,5	40	4	2.10.23000	50	40	25	16 <sup>F7</sup>	10	40	4	2.10.2A300			
4	60	58	240	62	20,8	50	82,5	13	19	8,5	57,5	3	2.10.24000	50	57,5	25	16 <sup>F7</sup>	10	32,5	4	2.10.2A400			
5	65	70	300	92	35	100	50	17	26	17	50	5	2.10.25000	100	69	25	16 <sup>F7</sup>	10	31	3	2.10.2A500			
6	80	78	350	70	60	100	83	17	26	17	67	5	2.10.26000	100	83	25	16 <sup>F7</sup>	10	67	3	2.10.2A600			



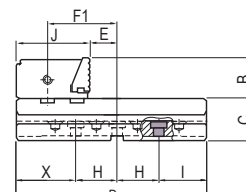
ART. 102A



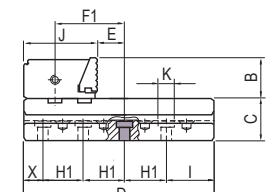
ART. 102

### FIXED JAW SECTION - ART.103/103A (GRID)

Vise Size	ART. 103								ART. 103A				
	J	E	F1	I	Kg	X	H	M*	Cod. 103	X	H1	M*	Cod. 103A
1	77,9		76	29	3,3	31	40	3	2.10.31000	61	50	2	2.10.3A100
2	89,4		76	49	5,8	31	40	3	2.10.32000	21	50	2	2.10.3A200
3	89,4	33,6	84,5	57,5	12,6	72,5	50	3	2.10.33000	72,5	50	3	2.10.3A300
4	96,9		89	61	17,8	79	50	4	2.10.34000	29	50	4	2.10.3A400
5	113,4		100	55	29,8	45	100	5	2.10.35000	45	100	3	2.10.3A500
6	120,4		107	95	50,5	52	100	5	2.10.36000	52	100	3	2.10.3A600



ART. 103



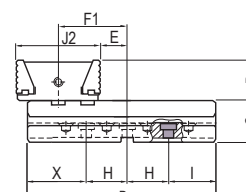
ART. 103A

W, G, B, C & D are as the table above

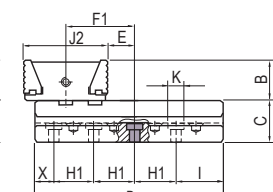
\*M = Number of Holes

### DOUBLE FIXED JAW SECTION - ART.104/104A (GRID)

Vise Size	ART. 104				ART. 104A		
	J2	E	Kg	M*	Cod. 104	M*	Cod. 104A
1	84,8		3,4	3	2.10.41000	2	2.10.4A100
2	101,8		6	3	2.10.42000	2	2.10.4A200
3	101,8	33,6	13,3	3	2.10.43000	3	2.10.4A300
4	110,8		18,8	4	2.10.44000	4	2.10.4A400
5	132,8		30	5	2.10.45000	3	2.10.4A500
6	146,8		52,5	5	2.10.46000	3	2.10.4A600



ART. 104



ART. 104A

W, G, B, C, D, F1, X, H & I are as the tables above

\*M = Number of Holes

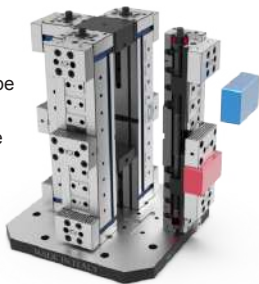




## SPECIFIC FOR HORIZONTAL AND VERTICAL MACHINE CENTRES

### THIRD HAND SERVICE

It allows the first workpiece loaded to be clamped lightly while the second workpiece is being loaded on vertical set ups



### HIGHEST RIGIDITY

Higher vise base in order to guarantee a better rigidity



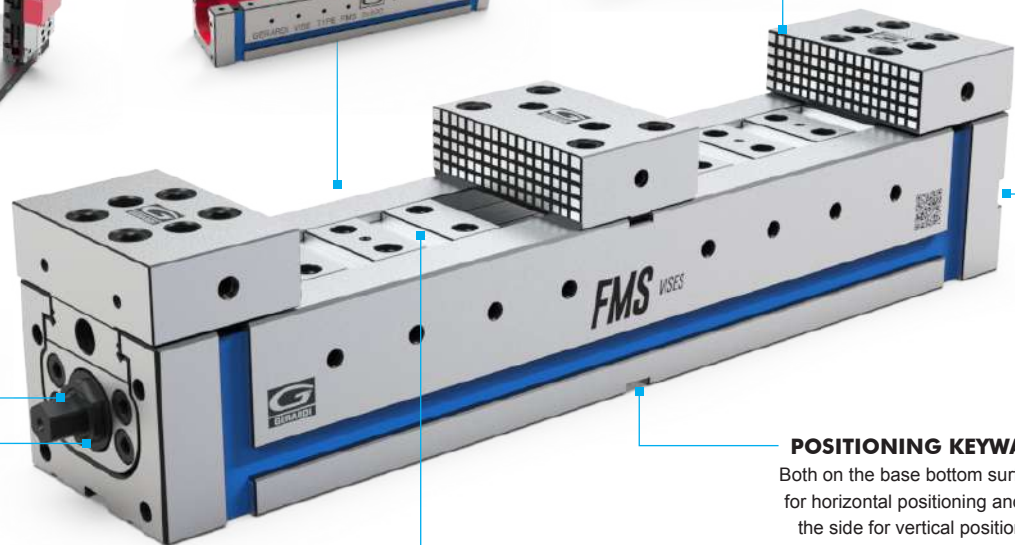
### QUICKEST VISE RESETTNG

Through ground comb system



### 3 VISES IN ONE

Single / Double / Self-Centering



### POSITIONING KEYWAYS

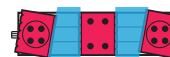
Both on the base bottom surface for horizontal positioning and on the side for vertical positioning

### DOUBLE THREAD SPINDLE

Completely protected main spindle with left and right thread



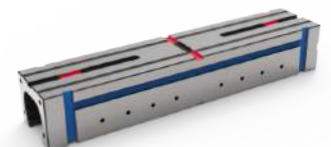
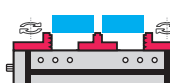
Floating Movable Jaws for irregular workpieces



Workpiece clamping on the large step



Workpiece clamping on the small step

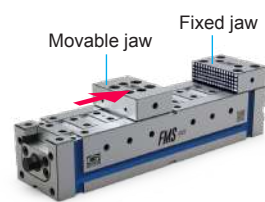


### THREE VISES IN ONE

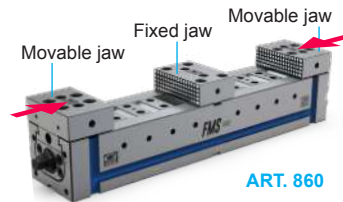


ART. 855

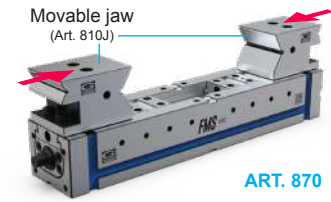
**BASE BODY ART.855**



**SINGLE CLAMPING**



**DOUBLE CLAMPING**



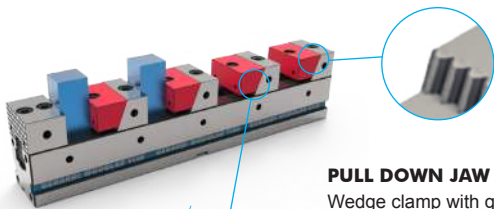
**SELF-CENTERING**



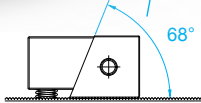
# MULTIFLEX SERIES



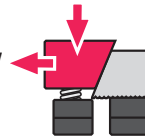
## FOR MULTIPLE CLAMPING



**PULL DOWN JAW ACTION**  
Wedge clamp with guided pull-down law action thanks to the ground comb-teeth and the 68° angle



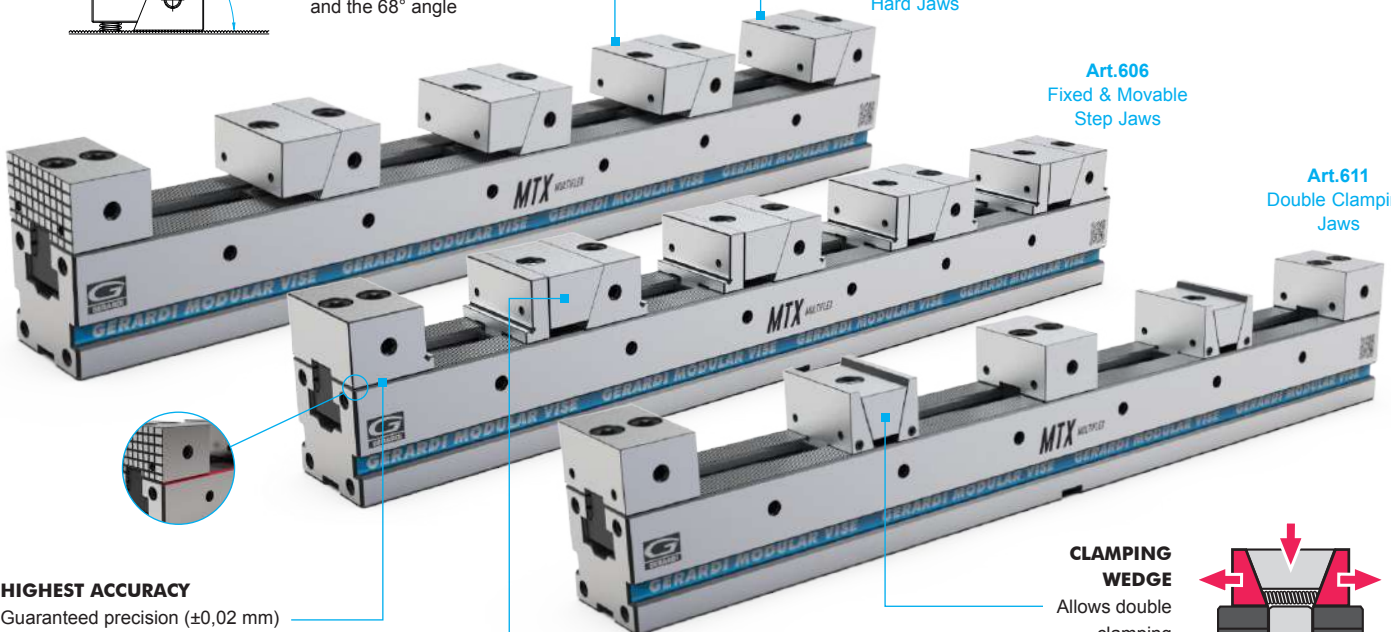
**FIXED & MOVABLE JAW**  
For workpieces clamped directly on vise base



**Art.600**  
Fixed & Movable Hard Jaws

**Supplied with Multiflex Vise:**

- 4 x workstops Art.370
- 1 x T wrench Art.376
- 1 x pair of positioning key-nuts for 16 mm slot Art. 297



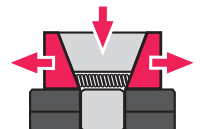
**Art.606**  
Fixed & Movable Step Jaws

**Art.611**  
Double Clamping Jaws

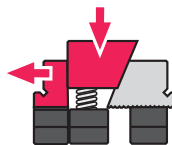
**HIGHEST ACCURACY**  
Guaranteed precision ( $\pm 0,02$  mm) in positioning and alignment, thanks to the ground rack teeth on the base and fixed jaws



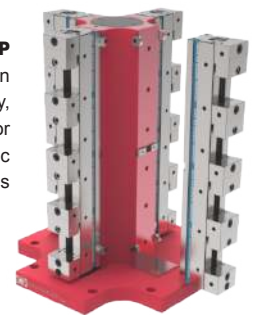
**CLAMPING WEDGE**  
Allows double clamping



**STEP FIXED & MOVABLE JAW**



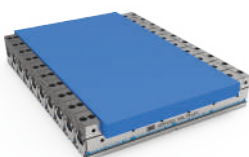
**VERTICAL SET-UP**  
Multiflex vises can be stacked vertically, connected together, or mounted on specific workholding structures



## CLAMPING APPLICATIONS

### PARALLEL MOUNTING

10 vises - 1 workpiece clamped

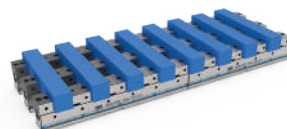


10 vises - 4 workpieces clamped

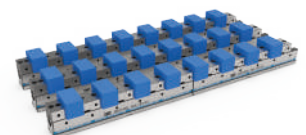


### IN LINE MOUNTING

6 vises - 8 workpieces clamped



6 vises - 24 workpieces clamped





# For multiple clamping from 1 to 16 workpieces of various sizes

## THE MOST VERSATILE VISE SERIES



DISCOVER HOW MANY WORKPIECE CAN BE CLAMPED ON EACH VISE TYPE



FIND OUT MORE

### MULTIFLEX VISES

Multiflex Vise with Fixed & Movable jaws

	Jaw Height	Base Height	Length	Jaw Width	SPREAD mm	Cod. Art. 600	SPREAD mm	Cod. Art. 606	SPREAD* mm	Cod. Art. 611
Type 1 (20kN)	32/25	50	300	49	4 x 8	6.60.01300	3 x 19	6.60.61300	4 x 21	6.61.11300
			400		4 x 33	6.60.01400	4 x 23	6.60.61400	4 x 46	6.61.11400
			500		4 x 58	6.60.01500	4 x 48	6.60.61500	4 x 71	6.61.11500
			600		4 x 83	6.60.01600	4 x 73	6.60.61600	4 x 94	6.61.11600
			700		4 x 108	6.60.01700	4 x 97	6.60.61700	4 x 121	6.61.11700
Type 2 (30kN)	40	75	400	74	4 x 12	6.60.02400	3 x 31	6.60.62400	4 x 34	6.61.12400
			500		4 x 37	6.60.02500	4 x 27	6.60.62500	4 x 59	6.61.12500
			600		4 x 62	6.60.02600	4 x 52	6.60.62600	4 x 84	6.61.12600
			700		4 x 87	6.60.02700	4 x 77	6.60.62700	4 x 109	6.61.12700
			800		4 x 112	6.60.02800	4 x 102	6.60.62800	4 x 134	6.61.12800
Type 3 (40kN)	60	100	900	99	4 x 137	6.60.02900	4 x 127	6.60.62900	4 x 159	6.61.12900
			700		4 x 59	6.60.03700	4 x 44	6.60.63700	4 x 77	6.61.13700
			800		4 x 84	6.60.03800	4 x 69	6.60.63800	4 x 102	6.61.13800
			900		4 x 109	6.60.03900	4 x 94	6.60.63900	4 x 127	6.61.13900
			1000		4 x 134	6.60.03100	4 x 119	6.60.63100	4 x 152	6.61.13100



**Art. 600:** Hard smooth or serrated jaw



**Art. 606:** Step jaws



**Art. 611:** Double clamping jaws

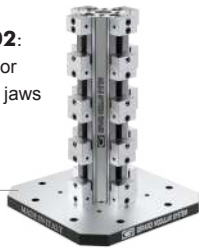
### MULTIFLEX TOWERS

Multiflex Tower With Fixed & Movable

	Jaw Height	Tower Base Section	Length/Height	Jaw Width	SPREAD mm	Cod. Art. 607	SPREAD mm	Cod. Art. 602
Type 1 (20kN)	32/25	100	300	49	3 x 19	6.60.71300	4 x 8	6.60.21300
			400		4 x 23	6.60.71400	4 x 33	6.60.21400
			500		4 x 48	6.60.71500	4 x 58	6.60.21500
			600		4 x 73	6.60.71600	4 x 83	6.60.21600
			700		4 x 97	6.60.71700	4 x 108	6.60.21700
Type 2 (30kN)	40	150	400	74	3 x 28	6.60.72400	4 x 12	6.60.22400
			500		4 x 24	6.60.72500	4 x 37	6.60.22500
			600		4 x 49	6.60.72600	4 x 62	6.60.22600
			700		4 x 74	6.60.72700	4 x 87	6.60.22700
			800		4 x 99	6.60.72800	4 x 112	6.60.22800
Type 3 (40kN)	60	240	700	99	4 x 39	6.60.73700	4 x 59	6.60.23700
			800		4 x 64	6.60.73800	4 x 84	6.60.23800
			900		4 x 89	6.60.73900	4 x 109	6.60.23900
			1000		4 x 114	6.60.73100	4 x 134	6.60.23100

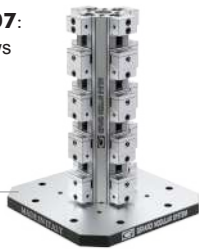
**Art. 602:** Smooth or serrated jaws

**Art. 828A extra**



**Art. 607:** Step jaws

**Art. 828A extra**



### JAW PLATES

	Fixed Serrated <b>ART.604</b>	Fixed Smooth <b>ART.604G</b>	Fixed Grip <b>ART.604T</b>	Fixed Step <b>ART.608</b>	Fixed Double Step <b>ART.614T</b>	Movable Smooth <b>ART.605</b>	Movable Serrated <b>ART.605S</b>
Vise Size 1 (49)	6.60.41000	6.60.4G100	6.60.4T100	6.60.81000	6.61.4T100	6.60.51000	6.60.5S100
Vise Size 2 (74)	6.60.42000	6.60.4G200	6.60.4T200	6.60.82000	6.61.4T200	6.60.52000	6.60.5S200
Vise Size 3 (99)	6.60.43000	6.60.4G300	6.60.4T300	6.60.83000	6.61.4T300	6.60.53000	6.60.5S300

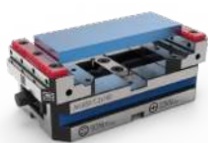
  

	Movable Step <b>ART.609</b>	Movable Grip <b>ART.609T</b>	Soft <b>ART.610B</b>	Smooth <b>ART.610C</b>	Serrated <b>ART.610D</b>	Parallel <b>ART.610E</b>	Prismatic <b>ART.610F</b>
Vise Size 1 (49)	6.60.91000	6.60.9T100	6.61.0B100	6.61.0C100	6.61.0D100	6.61.0E100	6.61.0F100
Vise Size 2 (74)	6.60.92000	6.60.9T200	6.61.0B200	6.61.0C200	6.61.0D200	6.61.0E200	6.61.0F200
Vise Size 3 (99)	6.60.93000	6.60.9T300	6.61.0B300	6.61.0C300	6.61.0D300	6.61.0E300	6.61.0F300

# MULTITASKING SERIES



## COMPACT, RIGID & ACCURATE



**TOP GRIP JAW INSERTS**  
Easy to replace and usable on both sides. A wide range available for any type of clamping

### HIGHEST CLAMPING FORCE

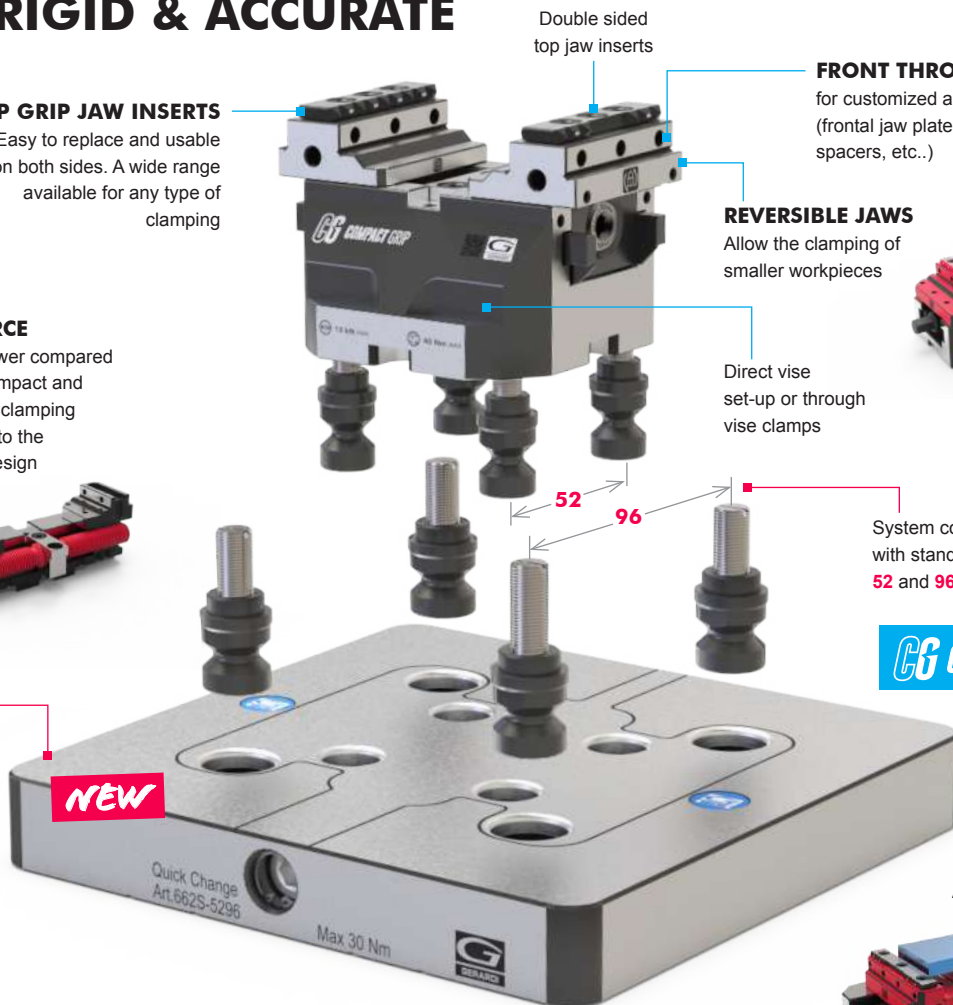
Significantly higher clamping power compared to existing vises, with a more compact and lighter design. This is due to the clamping screw design, positioned closer to the workpiece, and the integrated design of the slides and jaws



### QUICK CHANGE PLATE

A mechanical system for the quick positioning and clamping of fixtures for securing workpieces that stands out for its wide range of variations, offering a solution suitable for every type of machine tool

**NEW**



Double sided top jaw inserts

**FRONT THROUGH HOLES**  
for customized applications (frontal jaw plates, inserts, spacers, etc..)

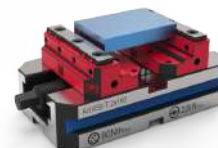
**REVERSIBLE JAWS**  
Allow the clamping of smaller workpieces

Direct vise set-up or through vise clamps

System compatible with standard pitch **52** and **96**



**SELF-CENTERING**  
Adjustment from the top by key-nuts



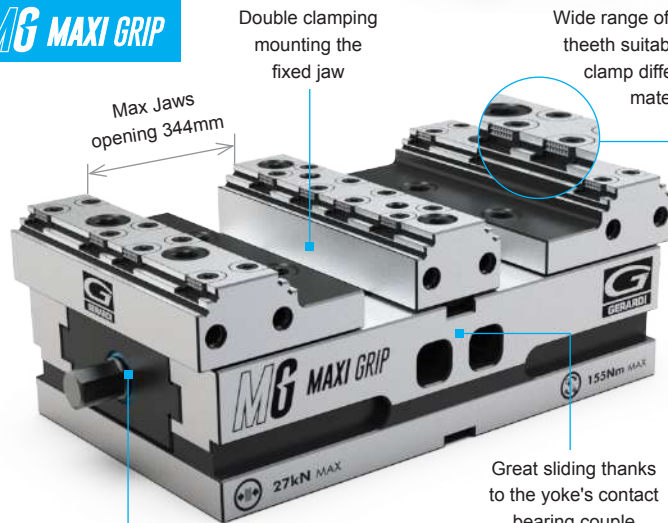
## MTK MULTITASKING



**VERSATILITY**  
Possibility of jaws positioning, addition or remove on whatever position on the vise base teeth



## MG MAXI GRIP



Double clamping mounting the fixed jaw

Wide range of grip teeth suitable to clamp different materials

Max Jaws opening 344mm

High chips protection by the internal seals

Great sliding thanks to the yoke's contact bearing couple



## Vises for advanced applications not only on 5 axis machining centres

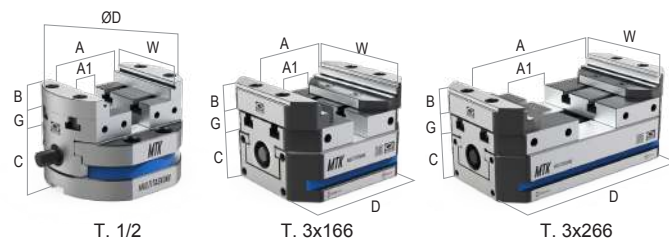
FOR MORE PRODUCT TYPES, SEE THE GENERAL CATALOGUE



FIND OUT MORE

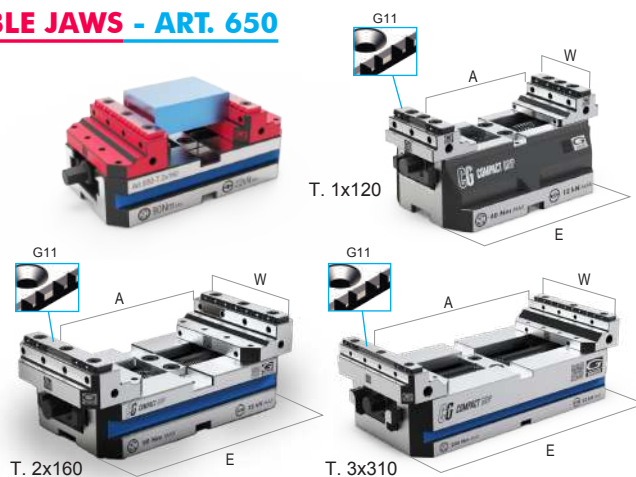
### SELF-CENTERING OR ECCENTRIC VISE. MANUAL OPERATION. MECHANICAL CLAMPING - ART. 640

Type	A	Stroke A1	W	B	C	D	G	Kg	Cod.
1 (16kN)	65	20	74	15	50	Ø120	20	4,9	6.64.01000
2 (20kN)	95	40	99	20	70	Ø160	25	11	6.64.02000
3 (30kN)	108	20	138	30	58	166	25	13	7.64.03166
	208	60	138	30	58	266			20



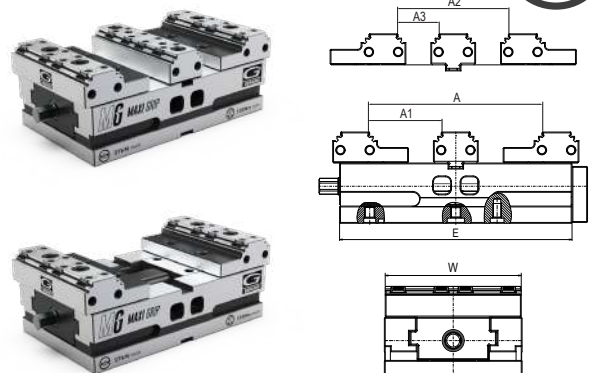
### SELF-CENTERING COMPACTGRIP VISE WITH REVERSIBLE JAWS - ART. 650

Type	A	W	E	Kg	Cod.
1 (12kN)	54	50	80	1,9	7.65.01080
	94		120	2,7	7.65.01120
	134		160	3,4	7.65.01160
2 (22kN)	96	88	120	3,6	7.65.02120
	136		160	4,4	7.65.02160
	176		200	5,2	7.65.02200
	216		240	5,8	7.65.02240
3 (32kN)	133	123	160	9,1	7.65.03160
	183		210	10,9	7.65.03210
	233		260	12,8	7.65.03260
	283		310	14,8	7.65.03310
	333		360	17	7.65.03360



### MAXIGRIP VISE - 3 CLAMPING IN 1 SELF-CENTERING, DOUBLE AND SINGLE - ART. 685

Type	A	A1	A2	A3	W	E	Kg	Cod.
4 x 270 (41kN)	200	83	104	35	158	270	28,5	76854270
4 x 420 (41kN)	344	155	248	107	420	420	40	76854420



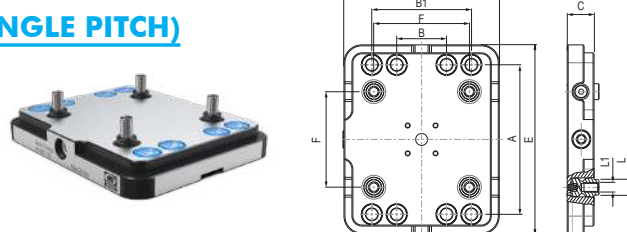
### MAXIGRIP VISE ONLY SELF-CENTERING - ART. 684

Type	A	A1	A2	A3	W	E	Kg	Cod.
4 x 270 (41kN)	200	-	104	-	158	270	25	76844270
4 x 420 (41kN)	344	-	248	-	420	420	36	76844420



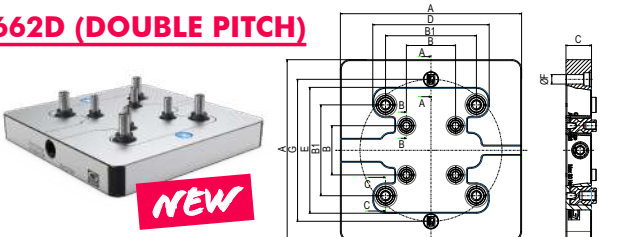
### (RECTANGULAR) QUICK CHANGE PLATE - ART. 660 (SINGLE PITCH)

Type	Pitch	A	B	B1	C	D	E	F	L	L1	Kg	Cod.
1-2	52	100	50	-	27	116	150	52	Ø12 H7	M8	3	9.66.05200
3	96	150	50	100	27	156	190	96	Ø16 H7	M10	5,2	9.66.09600



### (SQUARE) MACHINABLE QUICK CHANGE PLATE - ART. 662D (DOUBLE PITCH)

Type	Pitch	A	B	B1	C	D	E	F	G	Kg	Cod.
1-2-3	52/96	191,5	52	96	27	122	132	Ø10 H7	150	7,5	9662D5296



# RISERS AND PYRAMIDAL SUPPORT

FOR MORE PRODUCT TYPES,  
SEE THE GENERAL CATALOGUE



FIND OUT MORE

## PYRAMIDAL SUPPORT

Aluminum pyramidal support, it permits the simultaneous mounting of vises, plates or dove tail thus increasing the working space and allowing the contemporary machining of multiple workpieces.

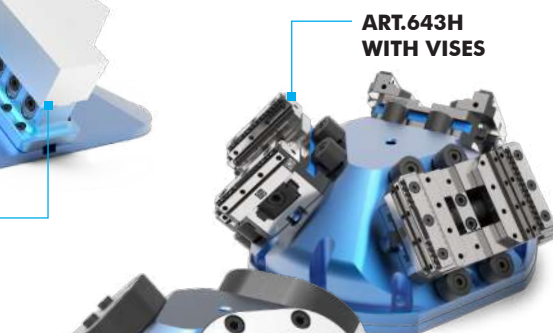
	Ø	Height	Cod.	
Type	1	235	170	7.64.3H100
	2	308	135,5	7.64.3H200
	3	360	190,5	7.64.3H300

### Standard equipment Art.643H:

- 12 x Vise holding clamps Art.298 CGR
- 1 x Eyebolt
- 1 x Centering pin
- Pair of keynuts Art.297



ART.643H  
WITH DOVE TAIL



ART.643H  
WITH VISES



ART.643H  
WITH PLATES



### KIT #1 Art. 643H + N°3 Art.650 T.1x120



60°

Cod.

6501120-G11-643H1-60

### KIT #2 Art. 643H + N°3 Art.650 T.2x200



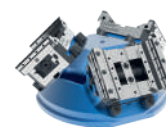
30° 45°

Cod.

6502200-G11-643H2-30/45

\* Check the machine spindle turning

### KIT #3 Art. 643H + N°3 Art.650 T.3x210



45°

Cod.

6503210-G11-643H3-45

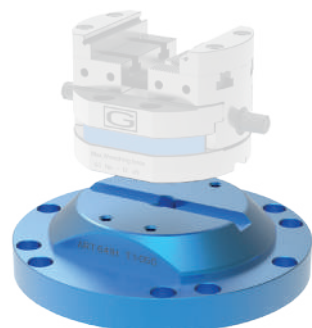
\* Check the machine spindle turning

## ALUMINUM RISERS

Through the elevations, by raising the vice relative to the machine base plane, it is possible to keep the force unchanged instead of raising the jaws and thus reducing the force and the accuracy. It also allows full use of the spindle strokes in the machine that might otherwise collide with the machine table. They can be used with both vises and plates.

### ART.641H

For Multitasking Grip Vises Art.640 and Art.640J



Type 1-2



Type 3x166



Type 3x266

### ART.651H

For Compact Grip Vises Art.650 and Art.950



Type 1



Type 2



Type 3

### ART.680H

For Maxi Grip Vises Art.684 and Art.685



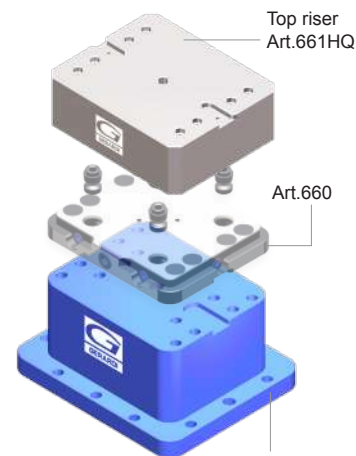
Type 4x270



Type 4x420

### ART.661H AND ART.661HQ

For Quick Change Table Art.660



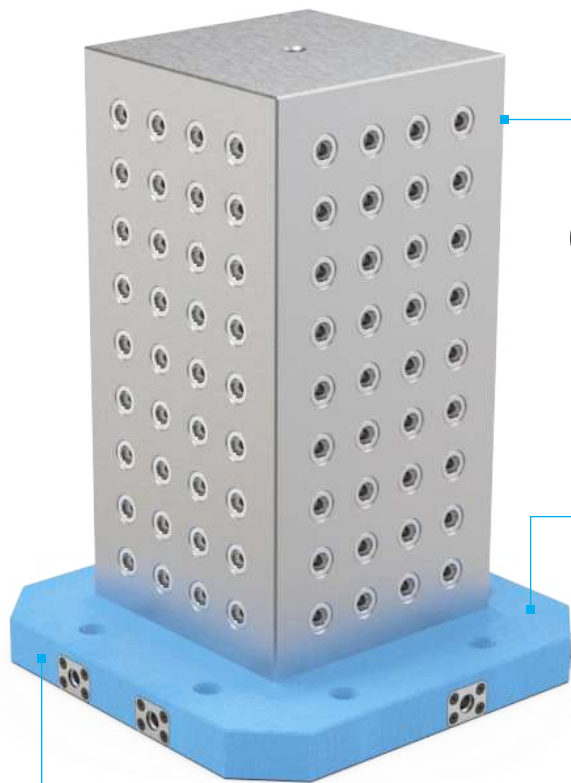
Top riser  
Art.661HQ

Art.660

Base riser  
Art.661H



# TOMBSTONE, PLATES & MACHINE PALLETS



### DIFFERENT SHAPES

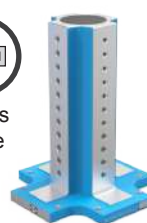
We offer cubes, two-side tombstones, angles, plates, subplates, shelves, and custom designs. These products are essential for horizontal machining centers and multipallet systems, which require sturdy structures for fixtures or workpieces



Grid Cube



Cross cube

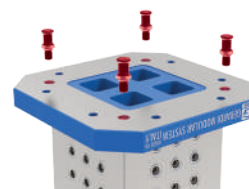


Grid angle with bushing



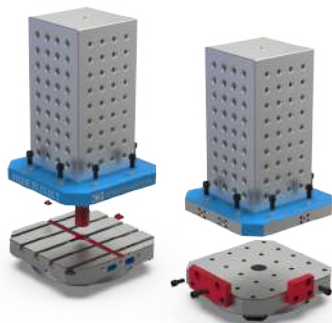
### ZERO POINT READY

Base with 4 precision Ø 20F7 holes and M16 bottom threads for Zero Point use or compatibility with other pallets/head plates



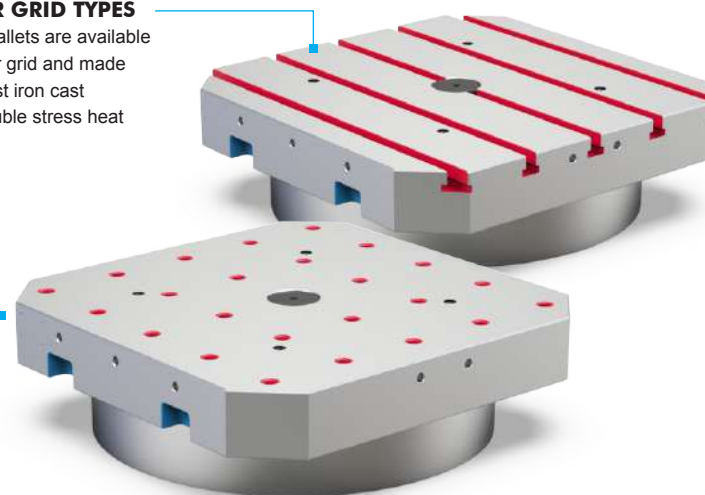
### EUROPEAN & JAPANESE

Rough casting with machined for pallets according to European or Japanese standards



### T-SLOT OR GRID TYPES

All Gerardi pallets are available with caves or grid and made with solid cast iron cast G30 with double stress heat treatment



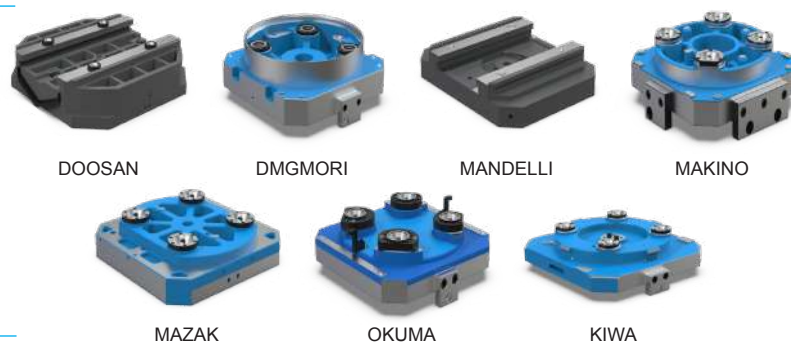
### SPECIAL TOMBSTONES

Tailor-made tombstones with clamping systems, designed and produced on request to optimize machine performance and capacity



### THE BEST PALLET FOR YOUR HORIZONTAL MACHINING CENTRE

Solid cast iron cast G30 with double stress relieving heat treatment. Highest accuracy



# For horizontal machining centre

FOR MORE PRODUCT TYPES, SEE THE GENERAL CATALOGUE



FIND OUT MORE

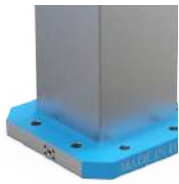
## CUBES AVAILABLE IN 5 DIFFERENT FINISHING



### TYPE A CAST IRON CASTING

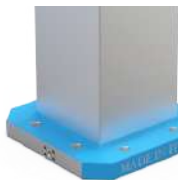
One integral G30 cast iron casting rough milled with doubles stress relieving heat treatment. Wall thickness 43-45 mm (10 mm stock)

\*Few highlighted items are not rough milled



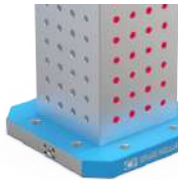
### TYPE B BASE FINISHED

Rough milled casting with base face machined and hand scraped for direct clamping on European or Japanese standard pallet.



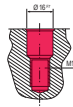
### TYPE C COMPLETELY FINISHED

Cube completely finished with wall thickness roughly 38-40 mm. Tolerance  $\pm 0,02$  mm



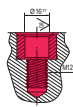
### TYPE E GRID CUBE

Integral cube with calibrated holes and solid threads in the casting itself. Tolerance  $\pm 0,02$  mm



### TYPE F GRID CUBE WITH BUSHINGS

Integral cube with centering bushings in special hardened alloy steel 100Cr6 - DIN 179C. Inserted threads are in 18/8 stainless steel. Tolerance  $\pm 0,02$  mm

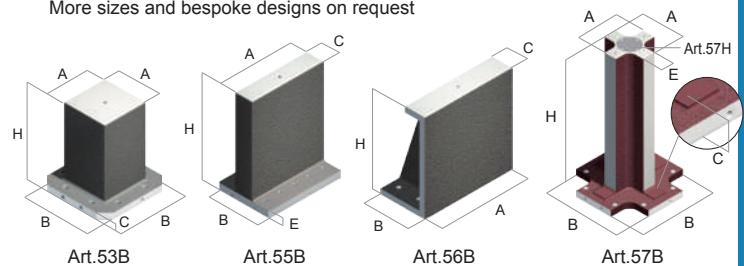


For illustrative purposes, are shown dimensions and codes of four cubes of different shapes but with the same type of finishing (B):

General tolerance  $+12 / -5$  mm   = light version

Art.	A	B	C	E	H	Kg	Cod.
53B Cubes	210	400	45	25	750	167	8.53.B10055
	260	400	45	25	850	229	8.53.B10085
	280	400	45	-	510	198	8.53.B00110
	260	500	45	25	750	234	8.53.B10105
	360	500	45	-	700	356	8.53.B00171
	360	630	45	30	950	468	8.53.B10185
	460	630	45	-	550	409	8.53.B00190
	460	630	45	-	650	463	8.53.B00200
	460	630	45	35	950	634	8.53.B10205
	410	400	160	55	500	199	8.55.B00051
55B 2 Sides Tombstones	410	400	160	50	660	244	8.55.B00052
	410	400	160	55	850	239	8.55.B10050
	510	500	160	50	700	331	8.55.B00053
	510	500	210	55	600	316	8.55.B00054
	510	500	210	55	900	402	8.55.B10085
	560	450	160	55	820	406	8.55.B00160
	640	450	160	55	820	460	8.55.B00170
	640	450	260	65	900	564	8.55.B00171
	640	630	210	55	850	545	8.55.B00172
	640	630	210	55	950	553	8.55.B10172
56B Angle	640	630	260	55	700	485	8.55.B00173
	360	450	160	65	650	232	8.55.B00180
	810	450	160	65	850	604	8.55.B00190
	350	160	45	-	250	46	8.56.B00008
	300	230	105	-	300	61	8.56.B00009
	350	240	105	-	360	80	8.56.B00010
	400	290	105	-	400	106	8.56.B00011
	200	350	35	-	700	104	8.56.B00012
	400	340	155	-	510	148	8.56.B00030
	500	350	155	-	500	176	8.56.B00031
57B Cross Cube	450	340	155	-	460	150	8.56.B00040
	450	340	155	-	610	185	8.56.B00050
	210	500	50	80	750	157	8.57.B00100
	210	500	50	80	650	142	8.57.B00105
	260	500	50	80	750	197	8.57.B00106
	280	500	50	80	850	242	8.57.B00110
	240	500	50	110	850	218	8.57.B00120
	310	500	50	150	850	269	8.57.B00130
	310	630	50	150	950	327	8.57.B00140
	380	500	50	200	950	400	8.57.B00145
410	500	55	100	855	241	8.57.B00150	

More sizes and bespoke designs on request



## BASES AVAILABLE IN 5 DIFFERENT FINISHING



**TYPE C**  
Smooth pallet base plate.  
Two faces ground



**TYPE E**  
Grid type with solid calibrated holes and threads



**TYPE F**  
Grid type with hardened bushings 100Cr6 and inox steel elicoils

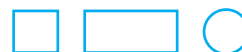


**TYPE G**  
With H7 T-slots



**TYPE H**  
With parallel slots

Available in different shapes: square base plates, rectangular base plates, rounded base plates





# Innovative solutions to optimize and speed up production



FOR MORE PRODUCT TYPES,  
SEE THE GENERAL CATALOGUE



FIND OUT MORE

## ZERO POINT SYSTEM

	Type	Art.	Description	kN	BAR	Kg	Cod.	
<b>NEW</b>	Built-in mounting standard optional	2	9665P	Ermetic	from 10 to 17kN	7	7,6	9.66.5P2000
<b>NEW</b>	Built-in mounting standard optional (automation ready)	2	9665PS	Ermetic	from 10 to 17kN	7	7,6	9.66.5PS200
<b>Built-in mounting for multiple applications</b>	1	665	Ermetic	up to 12,5 kN	6	1,5	9.66.51000	
	2		Classic	up to 15 kN	7 ÷ 14	2,7	9.66.52000	
	3		Ermetic	up to 42 kN	7	5,8	9.66.53000	
<b>Flange mounting for multiple applications</b>	1	664	Ermetic	up to 12,5 kN	6	3,2	9.66.41000	
	2		Classic	up to 15 kN	7 ÷ 14	5,7	9.66.42000	
	3		Ermetic	up to 42 kN	7	11,2	9.66.43000	
<b>Built-in mounting for single applications</b>	1	665S	Ermetic	up to 12,5 kN	6	1,5	9.66.5S100	
	2			up to 26 kN	6	2,5	9.66.5S200	
	3			up to 42 kN	7	5,8	9.66.5S300	
<b>Flange mounting for single applications</b>	1	664S	Ermetic	up to 12,5 kN	6	3,2	9.66.4S100	
	2			up to 26 kN	6	6,5	9.66.4S200	
	3			up to 42 kN	7	6,5	9.66.4S300	



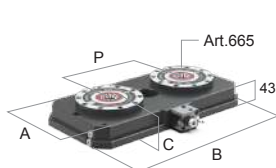
## ZERO POINT BASE PLATES



### ART.80P

Square Plates , Built-In Mounting

Type	kN	Material	A	C	P
1	up to 12,5 kN	Steel	400, 500, 630, 800	50	200, 250, 300, 350, 400, 450, 500, 550, 600
		Aluminum			
2	up to 15 kN	Steel	400, 500, 630, 800	58	250, 250, 300, 400
		Aluminum			
3	up to 42 kN	Steel	500, 630, 800	70	200, 250, 300, 350, 400, 450, 500, 550
		Aluminum			



### ART.81P

Rectangular Plates , Built-In Mounting

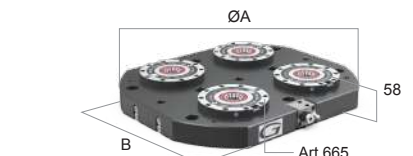
Type	kN	Material	A	B	C	P
1	up to 12,5 kN	Steel	160	350, 400, 450	55	200, 250, 300
		Aluminum				
2	up to 15 kN	Steel	200	400, 500, 600	58	200, 250, 300
		Aluminum				
3	up to 42 kN	Steel	250	500, 600, 700	70	250, 300, 400
		Aluminum				

Available  
for 2, 4  
or 6 Zero  
Points



### ART.72P

Rounded Plates , Flange Mounting



### ART.82P

Rounded Plates , Built-In Mounting

Type	kN	Material	ØA	B	N°ZP
2	up to 15 kN	Steel or Aluminum	280, 500, 420, 630, 700, 790, 1000, 900	380, 400, 500, 560, 630	1, 4, 6, 8

## DOUBLE ZERO POINT

Type	Art.	kN	Material	Kg	Cod.
1	665T	up to 12,5 kN	Steel	5,2	9.66.5T100
2		up to 15 kN		9,7	9.66.5T200
3		up to 42 kN		18,8	9.66.5T300





# MAGNETIC CHUCKS

**NEW**



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## ELECTRO-PERMANENT SYSTEM FOR MILLING OPERATIONS

### MAGNETIC CHUCK

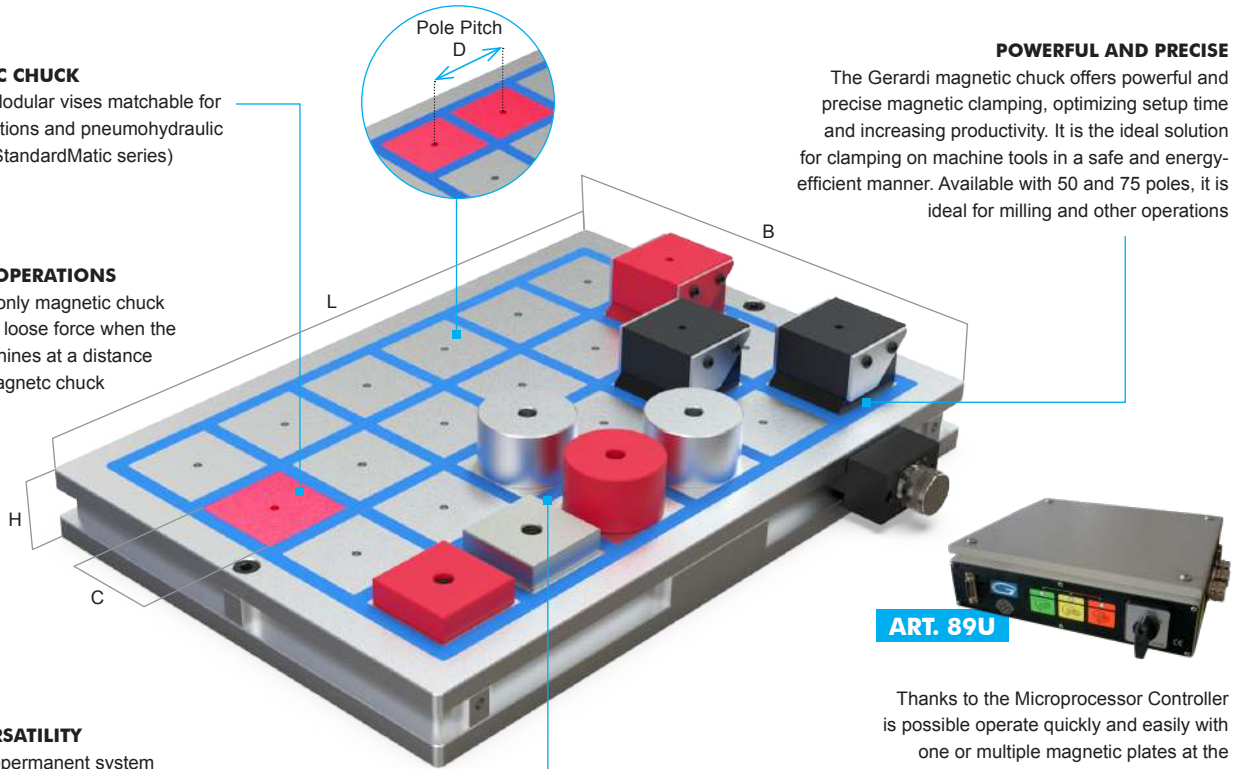
Precision Modular vises matchable for gang operations and pneumohydraulic clamping (StandardMatic series)

### MILLING OPERATIONS

This is the only magnetic chuck that will not loose force when the part is machines at a distance from the magnet chuck

### MORE VERSATILITY

The Electropermanent system easily adapts to pieces of various geometries and complexities



### POWERFUL AND PRECISE

The Gerardi magnetic chuck offers powerful and precise magnetic clamping, optimizing setup time and increasing productivity. It is the ideal solution for clamping on machine tools in a safe and energy-efficient manner. Available with 50 and 75 poles, it is ideal for milling and other operations

**ART. 89U**

Thanks to the Microprocessor Controller is possible operate quickly and easily with one or multiple magnetic plates at the same time

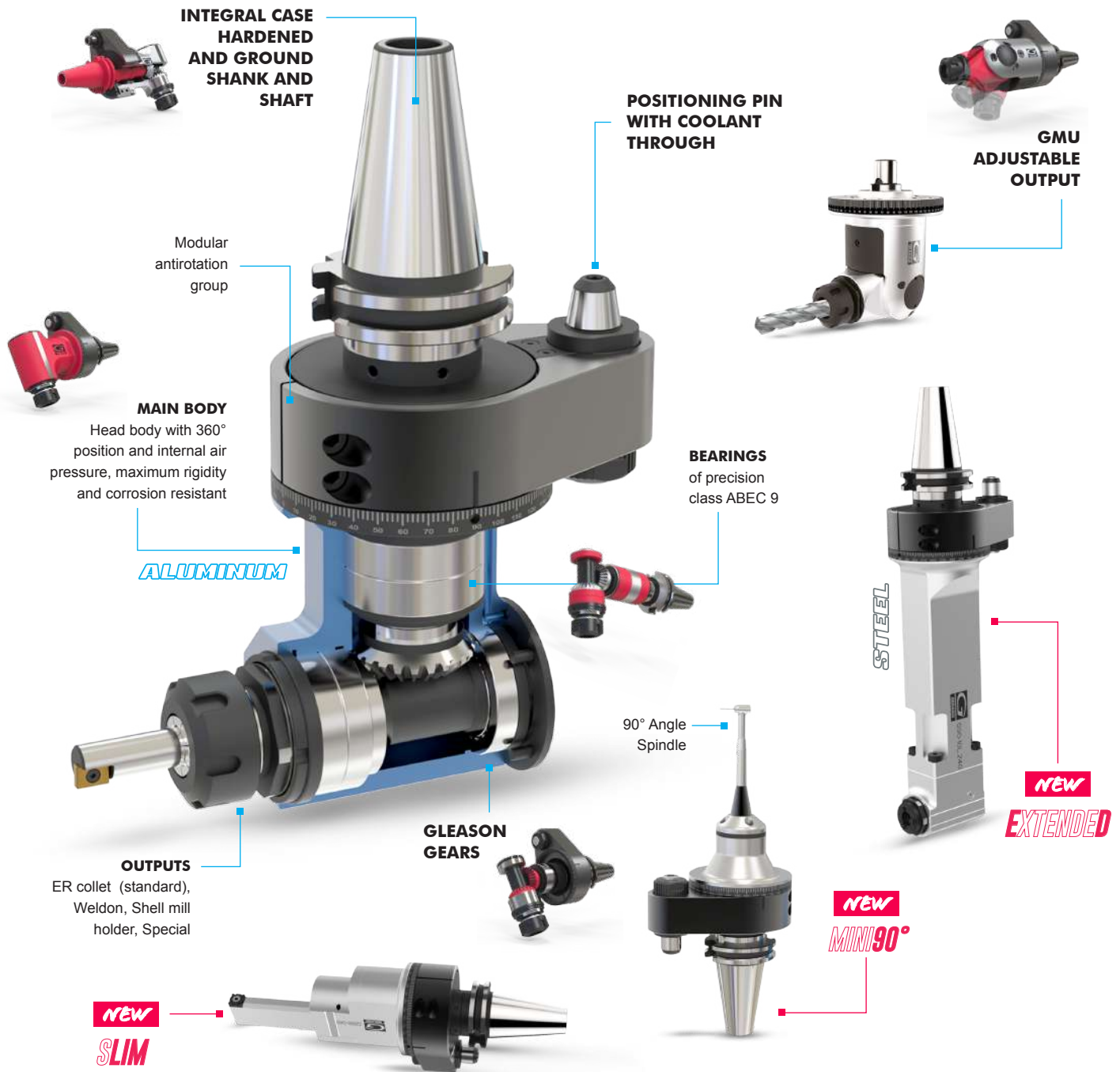
### ELECTRO-PERMANENT CHUCK POLE 50 (MAX PERFORMANCE AT 16MM HEIGHT) - ART.89P-50

B	C	D	H	L	Kg	n° Poles	Prot Kg	Cod. Art. 89P (50) For CAST IRON/STEEL Fe370 or C40	Cod. Art. 89R (50) For ALLOY STEEL as 38NiCrMo5 or 16MnCr5
325				370	42	20	8000	89P5323720	89R5323720
360				360	57	25	10.000	89P5363625	89R5363625
370				635	90	40	16.000	89P5376340	89R5376340
360	50	60	55		108	50	20.000	89P5367950	89R5367950
445				790	150	60	24.000	89P5447960	89R5447960
					170	80	32.000	89P5587980	89R5587980
580				940	200	96	38.400	89P5589496	89R5589496

### ELECTRO-PERMANENT CHUCK POLE 75 (MAX PERFORMANCE AT 25MM HEIGHT) - ART.89P-75

B	C	D	H	L	Kg	n° Poles	Prot Kg	Cod. Art. 89P (75) For CAST IRON/STEEL Fe370 or C40	Cod. Art. 89R (75) For ALLOY STEEL as 38NiCrMo5 or 16MnCr5
				601	110	24	21.690	89P7416024	89R7416024
415				815	150	32	28.800	89P7418132	89R7418132
				1.029	188			89P7411040	89R7411040
				815	181	40	36.000	89P7508140	89R7508140
503	75	88	60	1.029	228	50	45.000	89P7501050	89R7501050
				601	157	36	32.400	89P7596036	89R7596036
591				815	212	48	43.200	89P7598148	89R7598148
				1.029	267	60	54.000	89P7591060	89R7591060

## CLASSIC LINE: INTEGRAL SYSTEM



### ATC SERIES (AUTOMATIC TOOL CHANGE)

This range of heads is designed to be used on machining centres and can be automatically transferred from the tool magazine to the machine spindle and back. The main input shaft is integral with the drive taper to ensure maximum rigidity.

### MTC SERIES (MANUAL TOOL CHANGE)

This is a range of heads for traditional machine tools with flange attachment. The modular system makes it possible to extend the length of the body by adding a spacer.

**ALL ATC ANGLE HEADS CAN BE SUPPLIED AS MTC**



# ANGLE HEADS



## EVOLUTION LINE: MODULAR ANGLE HEADS & SPINDLE SPEEDERS

**MODULAR SHANK**  
Case hardened and ground



**MODULARITY**  
One head for many machines



Slim Angle heads ideal for micromachining



**BEARINGS**  
Angular contact preloaded ball bearings of precision class ABEC 9



**POSITIONING PIN**



**ANGULAR HEAD BODY**  
Treated steel head body with 360° positions, maximum rigidity and corrosion resistant



**GLEASON SPIRAL BEVEL GEARS**  
Maximum performance and minimum vibration



**OUTPUTS**  
ER collet (standard), Weldon, Shell mill holder, Special



**FMU ADJUSTABLE**  
Fully adjustable output  $\pm 90^\circ$



**POSITIONING PIN**  
automatic release and internal coolant through the pin

**SPINDLE SPEEDERS BODY**  
Heat-treated steel body, speed increase up to 1+8 through two planetary gears with amazingly low noise levels





FIND OUT MORE

More than 1000 types available with  
the best price / quality ratio

INTERCHANGEABLE DRIVE TAPERS

SPINDLE SPEEDERS (AUTOMATIC TOOL CHANGE)

	Model	Coolant (options)	Type	Ratio	Output	Rpm	Nm
<b>GSP</b> For milling and drilling operations	<b>NEW</b> GSP 10.HS	☑	1	1:8	ER20	Output 36.000, Input 4.500	8
	GSP 13		1	1:8	ER20	Output 24.000, Input 3.000	8
	GSP 16		2	1:6	ER25	Output 20.000, Input 3.333	16
	GSP 20		2	1:6	ER32	Output 16.000, Input 2.666	23
	GSP 26		3	1:4,2	ER40	Output 16.000, Input 2.857	47
	GSP 34	☑	3	1:4	ER50	Output 10.000, Input 2.500	180

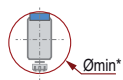


ATC SERIES (AUTOMATIC TOOL CHANGE)

	Model	Coolant (options)	Type	Rotation	Output	Body Length	L* Body Length	Ø min**	Rpm	Nm
<b>OFFSET</b> Offset output	FR90-10		1	↻	ER 16WP	110,5	-	73	6.000	25
	FR90-13	☑	1	↻	ER 20WP	126	-	88	4.500	45
	FR90-16		1	↻	ER 25WP	146,5	-	98	4.000	90
	FR90-20		2	↻	ER 32WP	153	-	105	3.500	95
<b>DOUBLE</b> Double Output	F90-7-2U		1		ER 11 MINI	116	176	96	10.000	11
	F90-10-2U		1		ER 16 MINI	106	176	131	10.000	14
	F9016 2U	-	2	↻↻	ER 25	100	200	174	5.000	55
	F90-20 2U		1		ER 32	108	-	198	3.500	90
	F90-30 2U		3		ER 40	115	-	234	2.500	165
<b>LIGHT</b> Weight reduction with same performances and rigidity	FL90-7		0		ER 11	52	-	77	8.000	5,6
	FL90-13		1	↻	ER 20	76	156	122	6.000	19
	FL90-16	☑	1	↻	ER 25	76	156	134	4.000	30
	FL90-16 2U		1	↻↻	ER 25	76	-	180	4.000	30
<b>SLIM</b> Micromachining	FLU-7		0		ER 11	37,5	-	95	8.000	5,6
	FS90-3		1	↻	6023E	142,5	170,5	35	8.000	3,5
	FS90-4	-	1	↻	600E	144,5	183	39	8.000	6
<b>STD 90°</b> 90° machining	FS90-6		1	↻	601E	144,5	183	47	8.000	8
	F90-7		1		ER 11	116	176	68	10.000	11
	F90-10		1		ER 16	106	176	94	10.000	14
	F90-13		1		ER 20	86	186	113	8.000	38
	F90-16		2	↻	ER 25	100	200	126	5.000	55
	F90-16S	-	1	↻	ER 25	86	-	132	8.000	38
	F90-20S		1		ER 32	98	-	150	5.000	55
	F90-20		2		ER 32	108	183	168	3.500	90
<b>FMU</b> Adjustable angle from 0° to 90°	F90-S40		3		ISO40/CAT/BT40	115	-	204	2.500	165
	FMU-10		1		ER 16	66	-	118	8.000	12
	FMU-16	-	1	↻	ER 25 MINI	76	-	152	6.000	
<b>COOLANT</b> Coolant by tool at 10bar	FMU-20		3		ER 32 MINI	96	-	203	4.000	60
	F90-7		1		ER11 WP	116	176	87	10.000	
	F90-10		1		ER16 WP	106	176	115	10.000	14
	F90-13		1		ER20 WP	86	186	134	8.000	
	F90-16	☑	2	↻	ER25 WP	100	200	144	5.000	55
	F90-16S		1		ER25 WP	86	-	155	8.000	38
	F90-20		2		ER32 WP	108	183	186	3.500	90
	F90-S40		3		ISO40/CAT/BT40	115	-	222	2.500	165



\* Also available "L" series with the longer body



\*\* Ø Min bore for internal machining. Excluding cutting tool

↻ Direction of rotation opposite to the machine spindle

↻ Direction of rotation same as machine spindle

☑ Internal coolant feed through the tool options:  
- 10bar through rotating distributor  
- From 30 to 70bar through machine spindle

## DRIVEN TOOLS FOR CNC LATHES & VDI TURRETS STATIC TOOLS FOR VDI & BMT TURRETS

### VDI TOOLHOLDERS

It consists of a serrated shaft that is inserted into an opening on the face of the turret. The driven tool is locked in position by a mating part with teeth located inside the turret. Tightening the locking screw with an Allen wrench secures the toolholder, preventing its rotation with a pin on the turret. Unlike BMT driven tools, VDI types can be mounted on either the outer circumference or the face of the turret, depending on the machine's configuration.


#### ANTI-CORROSION TREATMENT

Static toolholders are produced with certified top quality steel and are subjected to an anti-corrosion treatment



### THE BMT, OR "BASE MOUNTED TURRET"

The BMT toolholder is securely fastened to the turret face with 4 socket head cap screws and locked in place using locating keys on the turret face. Unlike VDI models, there is no need to align the motorized toolholder, and its simple design makes it the best choice for quick replacement.

 External Coolant standard

#### BORING BAR SLEEVES

Used on all types of lathe. They can be supplied with screw and slot, with collar, extended or reduced.



#### GLEASON SPIRAL BEVEL GEARS

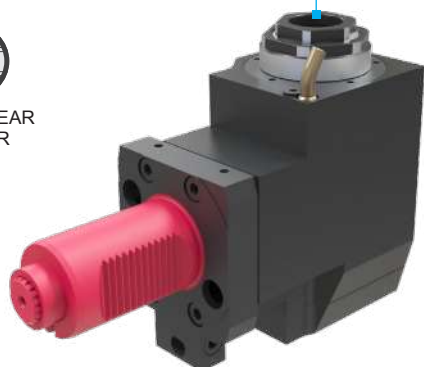
With completely ground involute form

#### BALL BEARINGS

Preloaded angular contact ball bearings precision and long life lubrication



#### AVAILABLE OUTPUTS



#### MAIN BODY TREATED

Corrosion resistant steel body



#### TAPPING

All driven tools can be equipped with axially compensated collets ET-1. They allow the tap an axial compensation from 7 to 13 mm in order to compensate any feed error and the inversion of the rotation of direction

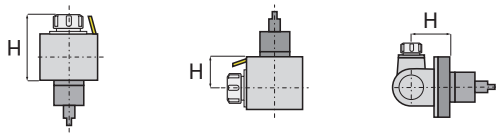
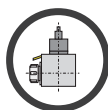
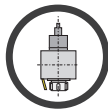




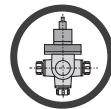
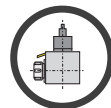
## UPGRADE YOUR LATHE AND BOOST PRODUCTIVITY!

The tables above show some models from the BMT Standard range for example purposes

BMT		COMPATIBLE WITH DOOSAN / HARDINGE / SAMSUNG / HWACHEON / HYUNDAI WIA / VICTOR / HAAS / SPINNER. BMT 65 ALSO COMPATIBLE WITH HAAS LATHES !						
Type	BMT	Cod.	ER	H Max	Nm*	Rpm		
Axial	45	99.DS.A03	25	57,2	35	8000		
Axial	45	99.DS.A04	25	57,2	35	8000		
Axial	55	99.DS.A01	25	57,2	40	8000		
Axial	55	99.DS.A02	25	57,2	40	8000		
Axial	65 HAAS READY!	99.DS.A41	32	72,5	70	6000		
Axial	65 HAAS READY!	99.DS.A42	32	72,5	70	6000		
Axial	75	99.DS.A34	40	90,2	100	6000		
Axial	75	99.DS.A35	40	90,2	100	6000		
Radial	45	99.DS.A07C	25	65	35	8000		
Radial	45	99.DS.A08C	25	65	35	8000		
Radial	55	99.DS.A11C	25	70	40	8000		



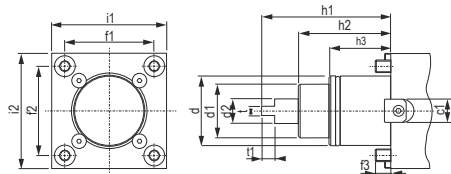
BMT		COMPATIBLE WITH DOOSAN / HARDINGE / SAMSUNG / HWACHEON / HYUNDAI WIA / VICTOR / HAAS / SPINNER. BMT 65 ALSO COMPATIBLE WITH HAAS LATHES !						
Type	BMT	Cod.	ER	H Max	Nm*	Rpm		
Radial	55	99.DS.A12C	25	70	40	8000		
Radial	65 HAAS READY!	99.DS.A51C	32	72	70	6000		
Radial	65 HAAS READY!	99.DS.A52C	32	72	70	6000		
Radial	65 HAAS READY!	99.DS.A73C	32	100	70	6000		
Radial	65 HAAS READY!	99.DS.A74C	32	100	70	6000		
Radial	75	99.DS.A38C	40	60	100	6000		
Radial	75	99.DS.A39C	40	60	100	6000		
Adj ±90°	45	99.DS.A16	20	65	15	8000		
Adj ±90°	45	99.DS.A17	20	65	15	8000		
Adj ±90°	55	99.DS.A23	20	65	15	8000		
Adj ±90°	55	99.DS.A66	20	65	15	8000		
Adj ±90°	65 HAAS READY!	99.DS.A64	25	75	25	6000		
Adj ±90°	65 HAAS READY!	99.DS.A65	25	75	25	6000		
Adj ±90°	75	99.DS.A47	25	75	25	6000		
Adj ±90°	75	99.DS.A48	25	75	25	6000		



\* The torque value, expressed in Nm, is the maximum allowed. Prolonged use at this value can damage the driven tool; for longer life and less wear, it is recommended to keep it below this limit.

Both direction of rotation to machine spindle available   
 Int. Coolant  
 Direction of rotation same as machine spindle  
 Direction of rotation opposite to machine spindle

## BMT ATTACHMENT WITH STANDARD TENON



BMT	c1	Ød	Ød1	Ød2	f1	f2	f3	h1	h2	h3	i1	i2	t	t2	h4	N	ØM
45	15	45	35	14	58	58	10	84	60	40	75	75	6	8,5	-	-	-
55	15	55	40	16	64	64	14	104	75	30	85	85	8	8,5	9,5	8	29
65	18	65	45	18	70	73	15	112	83	32	94	94	10	14	15	10	29
75	25	75	55	23	90	90	15	110	80	43	112	112	14	15	-	-	-
85	25	85	65	33,5	100	100	18	140	100	43	125	125	16	20	-	-	-

Driven tools with bigger tenon available on request

Code example with Bigger Tenon: 99.DS.A03T

## ESTORE GERARDI

WHICH IS YOUR MACHINE MODEL? WE BET IT IS ON OUR ESTORE!



- 1 What brand and model of lathe are you looking for ?  
DOOSAN / HARDINGE / GOODWAY / DMG MORI / MIYANO ecc...
- 2 Which kind of turret has your lathe?  
VDI / BMT55 / BMT65 ecc...

Check out our estore, with two simple questions you will find all the Driven Tools suitable for the lathe you have !







# WE DESIGN, MANUFACTURE & DISTRIBUTE WORLDWIDE

## DESIGNING

We design and develop innovative solutions for clamping, workholding and fixture such as precision vises, angle heads and driven tools

## MANUFACTURING

Machines, tools, CAD/CAM and a great Team contribute to the realization of even very complex components and ensure excellent machining results

## WORLDWIDE DISTRIBUTION

The distribution of our products is supported by an extensive network of wholesalers and agents that promote and service our range of products worldwide

## CUSTOMER CARE

An extraordinary point of our strength is our huge spare parts stock, maintenance and repair service with free phone assistance of our technical Team before & after sales



ANGLE HEADS  
CLASSIC LINE

PRECISION  
MODULAR  
VISES

TOMBSTONES



## GERARDI SPA

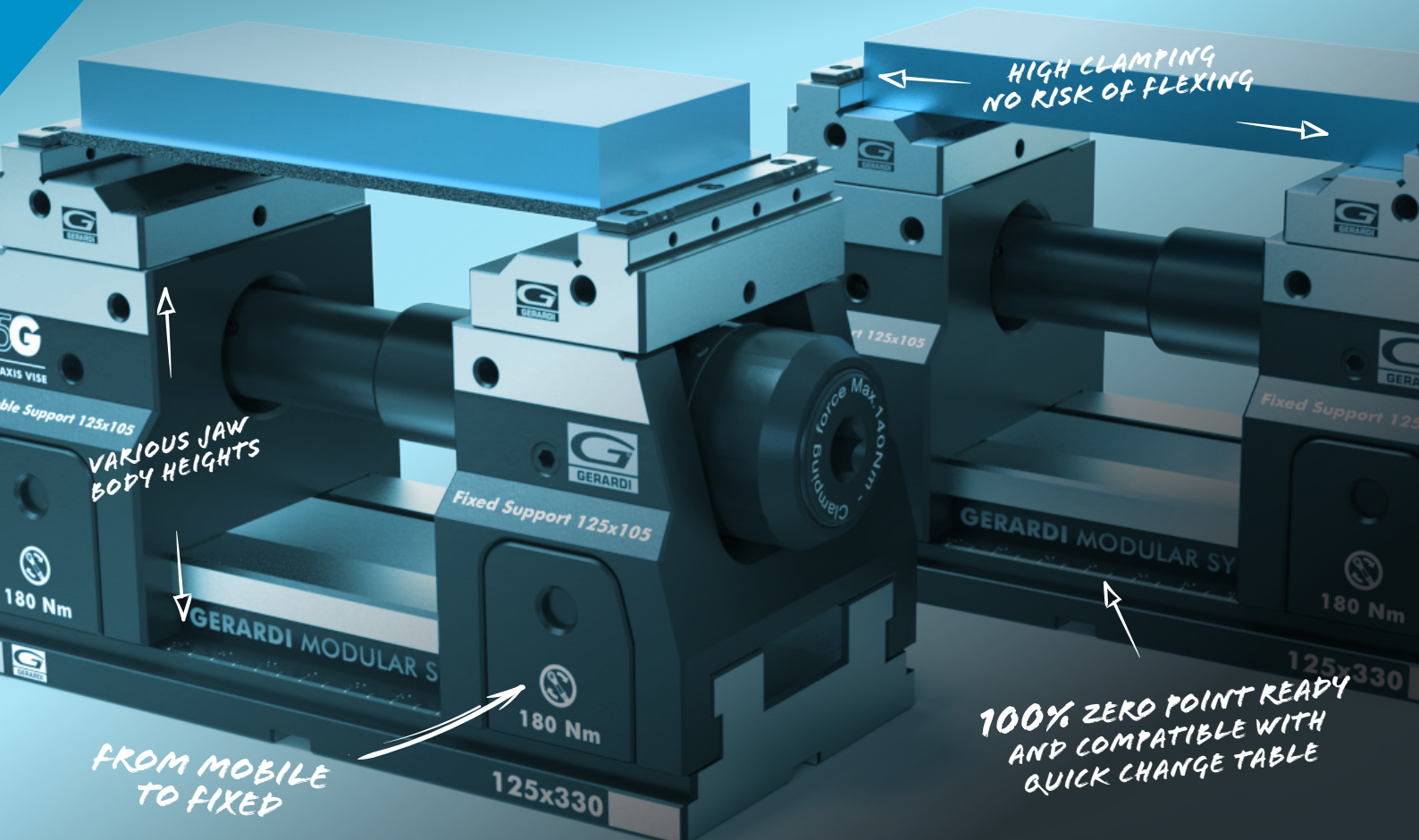
via Giovanni XXIII, 101 - 21015 LONATE POZZOLO  
(VA) Italia - Tel. +39.0331.303911 - Fax +39.0331.301534

[gerardi@gerardispa.com](mailto:gerardi@gerardispa.com) - [www.gerardi.it](http://www.gerardi.it)



# 5G Vises

UNA TECNOLOGIA AVANZATA PER CENTRI A 5 ASSI  
ADVANCED TECHNOLOGY FOR 5 AXIS MACHINE



BRING YOUR MACHINING TO NEW PEAKS

## Eleva il tuo Processo di Lavorazione ad un Livello Superiore



Grazie alla sua versatilità e stabilità, la morsa 5G riesce a garantire una elevata precisione e ripetibilità di serraggio su tutte le facce del particolare. Attraverso delle staffe di ancoraggio si possono rendere fissi entrambi i supporti ganascia, in modo da irrigidire la struttura e minimizzare le flessioni normalmente sviluppate nei serraggi ad altezze elevate, una volta stabilita l'apertura che si desidera utilizzare. Inoltre grazie al sistema vite, che agisce in prossimità della superficie di serraggio, siamo riusciti ad alzare notevolmente l'altezza della presa pezzo, senza avere riduzioni di forza nel serraggio.

Thanks to its versatility and stability, the 5G vise can ensure high precision and repeatability of clamping on all faces of the workpiece. Anchoring brackets can be used to fix both jaw supports in place, stiffening the structure and minimising the deflection that normally occurs when clamping at a high height, once the desired opening has been established. Furthermore, thanks to the screw system, which works in close proximity to the clamping surface, we have been able to significantly increase the height of the workpiece clamping without reducing the clamping force.

**NEW**

[www.gerardi.it](http://www.gerardi.it)





## SISTEMA VITE ALTO - HIGH SCREW SYSTEM

Il gruppo vite posizionato vicino alla superficie di serraggio, consente di ottenere un serraggio alto, senza avere riduzioni nella forza di serraggio

The screw assembly positioned close to the clamping surface allows for high clamping without having reductions in clamping force



## DA MOBILI A FISSE - FROM MOBILE TO FIXED

Le staffe di ancoraggio trasformano le due slitte mobili in supporti fissi, in modo da irrigidire la struttura e minimizzare le flessioni in fase di serraggio

The vise holding clamps transform the two mobile slides into fixed supports, in order to strengthen the structure and minimize flexion during the clamping



## LA LUNGHEZZA CONTA - LENGTH MATTERS

Possibilità di scegliere diverse lunghezze della base a seconda della dimensione dei particolari da serrare. La base della morsa 5G è integrale e ad alta rigidità, compatibile con tutti i sistemi di posizionamento e cambio rapido come zero point e tavolette

You can choose different base lengths depending on the size of the parts to be clamped. The base of the 5G vise is integral and highly rigid, compatible with all positioning and quick-change systems such as zero point and tablets



## SOLLEVA IL PARTICOLARE - LIFT THE WORKPIECE

Svariate altezze di corpi ganasce per poter effettuare lavorazioni a qualunque livello. I corpi ganasce sono realizzati in acciaio integrale ad alta rigidità

Various jaw body heights for machining at any level, made of high-strength hardened steel

## INSERTI TEMPRATI - HARDENED INSERTS

Inserti temprati facilmente intercambiabili per il serraggio del pezzo da lavorare

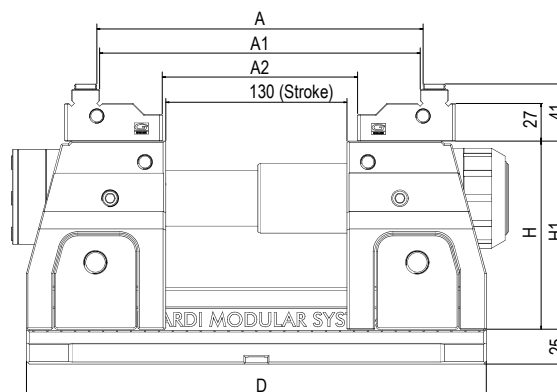
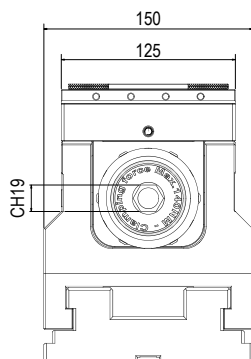
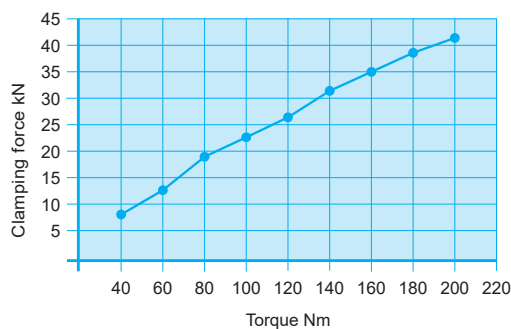
Easily interchangeable hardened inserts for grip clamping of the workpiece



Dimensione della ganascia Jaw Size	H	H1	D	A	A1	A2	Cod.
125 x 105	105	135	330	234	230	140	5G-125-330
125 x 105	105	135	430	334	330	240	5G-125-430
125 x 105	105	135	500	404	400	310	5G-125-500
125 x 150	150	185	430	334	330	240	5G-125H-430
125 x 150	150	185	500	404	400	310	5G-125H-500
125 x 150	150	185	630	534	530	440	5G-125H-630

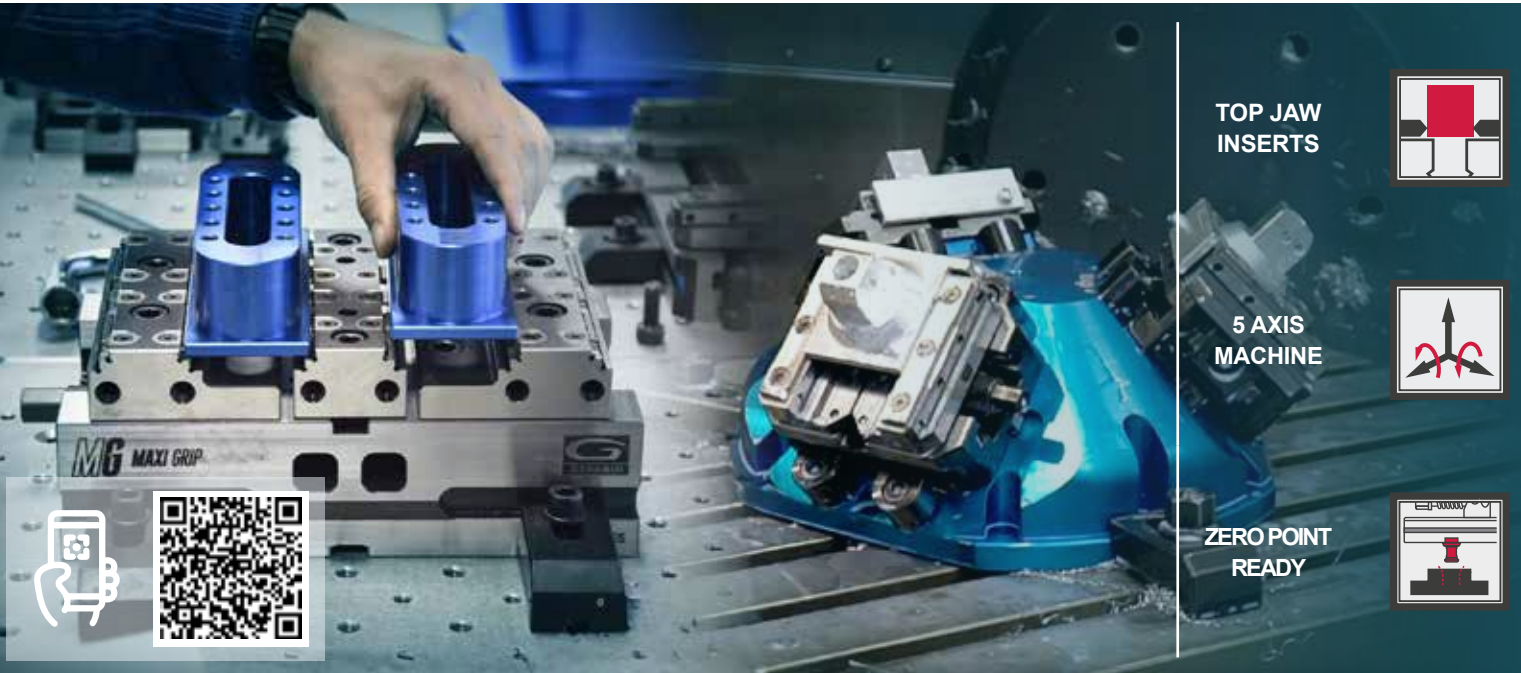
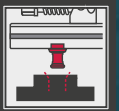
<b>Coppia massima</b> Max Torque	200 Nm
<b>Forza di serraggio massima</b> Max Clamping Force	40 kN

<b>Coppia consigliata</b> Recommended Torque	120 Nm
<b>Forza consigliata</b> Recommended Force	26,5 kN

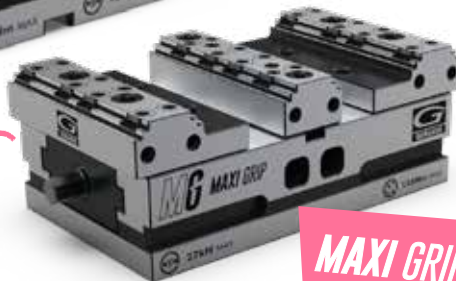


PER CENTRI DI LAVORO A 5 ASSI / FOR 5TH AXIS MACHINING CENTRES

# MULTITASKING

TOP JAW  
INSERTS5 AXIS  
MACHINEZERO POINT  
READY
**COMPACT GRIP**

Art. 650

12  
MODELLI4  
MODELLI
**MAXI GRIP**

Art. 685

**COMPATTE, RIGIDE  
E PRECISE**  
COMPACT, RIGID  
& ACCURATE

**3 MORSE IN 1 SERRAGGIO  
SINGOLO DOPPIO E  
AUTOCENTRANTE**

**3 VISES IN 1 SINGLE  
DOUBLE AND SELF-CENTERING  
CLAMPING**

### COMPACT GRIP

Nata espressamente per i centri a 5 assi, la gamma **CompactGRIP** permette di intervenire sulle 5 facce del particolare in lavorazione con riferimenti precisi in spazi contenuti garantendo usure inesistenti e grande rigidità.

Designed for 5 axis machines, **CompactGRIP** 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.

### MAXI GRIP

La possibilità di passare dal serraggio di un pezzo singolo a quello doppio, o alla modalità autocentrante in modo immediato e intuitivo, unito all'elevata compattezza, ne fanno il prodotto ideale per l'utilizzo su qualsiasi tipo di macchina, dal 3 al 5 assi.

The possibility of shifting from the workholding of a single part to the double one, or to the self-centring modality immediately and intuitively, combined with the high compactness, make it the ideal product for the use on any machine kind, from 3 to 5 axes.

# CG COMPACT GRIP

Per attrezzare macchine di piccole dimensioni

To set up small machines

**MORSA AUTOCENTRANTE CON GANASCE REVERSIBILI**

SELF-CENTERING VISE WITH REVERSIBLE JAWS



**Rapidità nei serraggi**  
Quick clamping operation

**Tolleranze entro ±0,02 mm**  
Highest accuracies ± 0,02 mm

**Fori frontali passanti per applicazioni personalizzate (piastrine, puntali)**  
Front through holes for customized applications (plates, points, etc..)

**Rigidità & Sicurezza grazie alle ganasce integrali**  
Rigidity & safety thanks to the solid jaws

**Costruzione solida e compatta a massima apertura rispetto agli ingombri**  
Solid and rigid construction and maximum clamping ratio to the total length

**Ancoraggio diretto o tramite staffe**  
Direct vise set-up or through vise clamps

**Da autocentrante a bloccaggio singolo grazie alla flangia per bloccaggio slitta**  
From self centering to single clamping thanks to the slide clamping flange

**Usura inesistente HRC 58 ±2**  
No Wear HRC 58 ±2

**Compatibile con sistema Zero Point**  
Zero Point Ready

**Inseri reversibili completamente dentati da un lato e scaricati al centro dall'altro**  
Double sided top jaw inserts with full work piece contact on one side and partial on the other



## Art. 650

Type	A	A1	W	B	C	C1	C2	D	E	F	L	L1	Kg	Code
<b>1</b> 12kN	54							80					1,8	7.65.01080
	94	6	50	65	45	53	61	80	120	52	12	M8	2,6	7.65.01120
	134								160				3,4	7.65.01160
<b>2</b> 22kN	96								120				3,6	7.65.02120
	136	10	88	65	38	51	61	90	160	52	12	M8	4,4	7.65.02160
	176								200				5,2	7.65.02200
	216								240				5,8	7.65.02240
<b>3</b> 32kN	133								160				9,1	7.65.03160
	183								210				10,9	7.65.03210
	233	10	123	89	57	75	85	125	260	96	16	M10	12,8	7.65.03260
	283								310				14,8	7.65.03310
	333								360				17	7.65.03360

### Art. 650S

**LISCI + RUVIDI - SMOOTH + ROUGH**  
Materiali teneri e lavorazioni finali  
Soft material clamping and final machining

### Art. 650T G01

**GRIP (Passo - Pitch 1,5mm)**  
Materiali teneri e lavorazioni finali  
Soft material clamping and final machining

### Art. 650R

**CODA DI RONDINE - DOVE TAIL**  
Miglior presa pezzo  
Best workpiece clamping

### Art. 650T G02

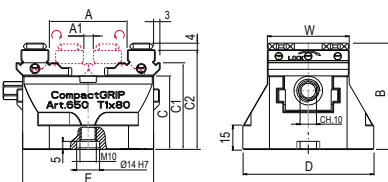
**GRIP (Passo - Pitch 2mm)**  
Miglior presa pezzo  
Best workpiece clamping



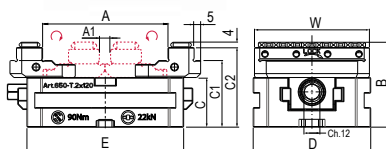
### Art. 650T G11

**GRIP (Passo - Pitch 11mm)**  
Per materiali di durezza normale  
For standard workpieces hardness clamping

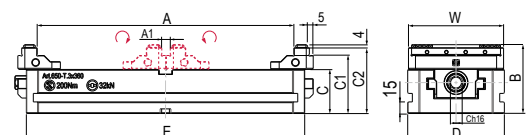
Tipo / Type 1



Tipo / Type 2



Tipo / Type 3



# MG MAXI GRIP

Per lavorare particolari di grandi dimensioni

To machine large parts

**MORSA MODULARE DI PRECISIONE**

PRECISION MODULAR VISE



**Morsa di massima qualità in acciaio cementato e rettificato**

Maxi quality vise made by case hardened and ground steel

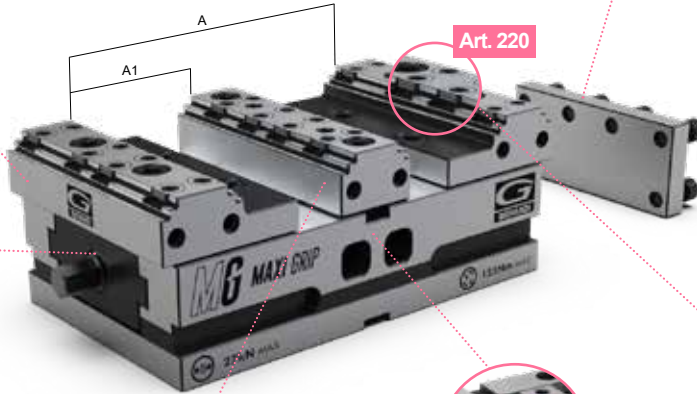
**Compatibile con sistema Zero Point**  
Zero Point Ready

**Da autocentrante a bloccaggio singolo grazie alla flangia per bloccaggio slitta**

From self centering to single clamping thanks to the slide clamping flange

**Apertura Massima Ganasce 200mm**  
Max Jaws opening 200mm

**Elevata protezione dai trucioli grazie alle guarnizioni interne**  
High chips protection by the internal seals



**Massima stabilità di serraggio**  
The highest clamping stability

**Inserti grip: ampia gamma di grip adatti a bloccare diversi materiali**  
Inserts grip: wide range of grip teeth suitable to clamp different materials

**Grande scorrevolezza grazie alla coppia di cuscinetti a contatto della forcella**  
Great sliding thanks to the yoke's contact bearing couple

**Doppio bloccaggio montando una ganascia fissa anche di due pezzi di dimensioni diverse**  
Double clamping mounting the fixed jaw even of two pieces of different sizes

## Art. 685

1 Piastra Laterale - 1 Lateral Plate  
**Art. 680U**

- 1 Ganascia Fissa - Fixed Jaw  
**Art. 683K/G01**
- 2 Ganasce Mobili - Movable Jaws  
**Art. 682K/G01**



## Art. 684

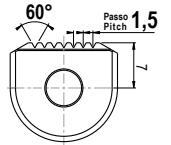
**Serraggio autocentrante**  
Self-centering clamping

- 2 Ganasce Mobili - Movable Jaws  
**Art. 682K/G01**



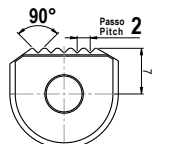
## Art. 220 G01

Per materiali di durezza normale  
For standard workpieces hardness clamping



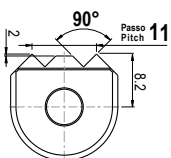
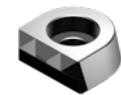
## Art. 220 G02

Per materiali di notevole durezza  
For hardened workpieces clamping



## Art. 220 G11

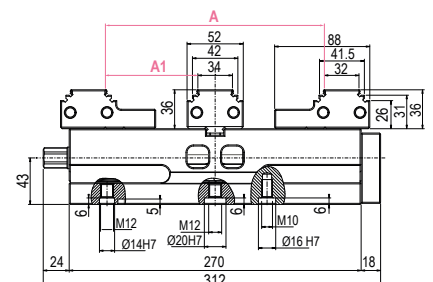
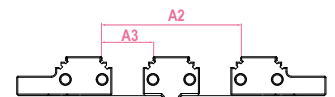
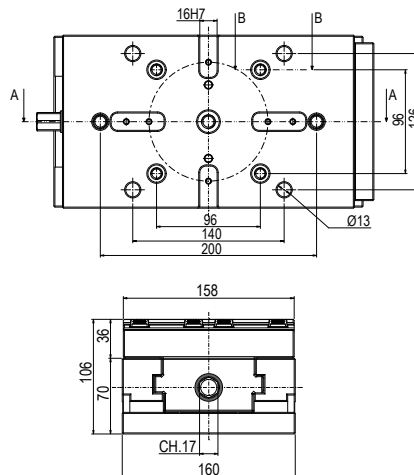
Per materiali teneri  
For soft material clamping



Type	Art. 685		Art. 684	
	A	A1	Code	Code
<b>4x270</b> 39 kN	* Min 19 / Max 200	* Min 19 / Max 200	7.68.54270	7.68.44270
<b>4x420</b> 39 kN	* Min 19 / Max 344	* Min 19 / Max 155	7.68.54420	7.68.44420

\* Apertura minima con ganasce ruotate di 180° / \* Minimum opening with 180° rotated jaws

## Art. 685 4x270



# QC QUICK CHANGE

**Il tempo è denaro - Save Time, Save Money**

## PIASTRA A CAMBIO RAPIDO

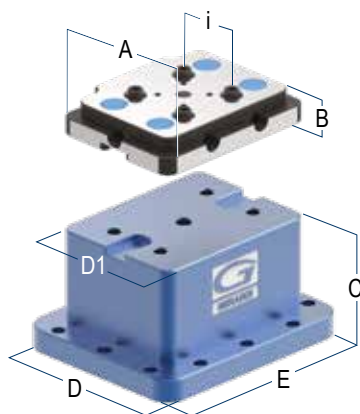
QUICK CHANGE PLATE

La nuova Piastra a Cambio Rapido meccanico Art.660 (disponibile anche tonda Art.661) permette la rapida rapida sostituzione di morse o attrezzature su tutte le più diffuse tavole girevoli, la versione lavorabile può essere personalizzata direttamente dal cliente in base alla sua tavola macchina.

The new mechanical Quick Change Plate Art.660 (available also as round Art.661) allows the quick vises or fixtures replacing on the most famous rotary table. The machineable version can be tailor made by the customer himself according to his machine table.

### Art. 660/661H

Type	i	A	B	C	D	D1	E	Art. 660		Art. 661H	
								Kg	Code	Kg	Code
1&2	52	116	27	100	156	116	190	3	9.66.05200	5	9.66.1H100
3	96	156	27	100	176	136	210	5,2	9.66.09600	6,5	9.66.1H200

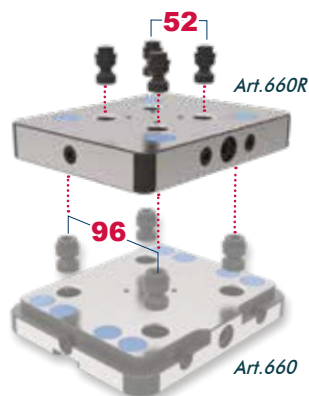


#### Art. 660

Piastra a cambio rapido  
Quick change plate

#### Art. 661H

Rialzo in alluminio per piastra cambio rapido  
Simple aluminum riser for quick change plate



#### Art. 660R

Piastra di adattamento  
Adapting plate

Consente di ridurre la distanza tra i tiranti da 96 mm a 52 mm

*It allows to reduce the pull studs distance from 96 mm to 52 mm*



#### Compatibilità Compatibility

Compatibilità con i sistemi di cambio pallet già esistenti sul mercato, incluso i nostri sistemi Zero Point e Cambio Rapido meccanico.

Compatibility with the most popular pallet change systems, including our Zero Point and mechanical Quick Change system.



#### Inserti Grip Grip Inserts

Inserti GRIP intercambiabili con diverse tipologie di dentini GRIP adatti al serraggio di differenti materiali.

Interchangeable GRIP inserts with different types of GRIP teeth suitable for clamping different materials.



#### Serraggio Doppio Double Clamping

Le morse Maxi Grip possono serrare contemporaneamente 2 pezzi anche di differenti dimensioni tra loro.

The Maxi Grip vises can clamp 2 workpieces at the same time with different sizes.



#### 5 Anni di Garanzia 5 Years Warranty

Sicuri dell'affidabilità e dell'elevata qualità riconosciamo 5 anni di garanzia sull'intera gamma.

Sure of the reliability and high quality of all MaxiGrip vises, we recognize 5 years warranty on the whole range.