



MACHINE AND BENCH VISES





BISON VISES

**MACHINE VISES
CAST IRON BODY**



**PRECISION VISES
STEEL BODY**



**BENCH VISES
CAST IRON BODY**



**TOOLMAKERS,
GRINDING VISES**



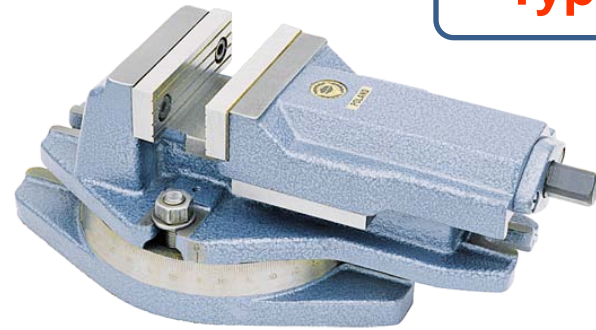


Machine Vises with Cast Iron Body

Type 6512



Type 6537



With swivel base

- Cast iron body, jaws and lead screw
- Lead screw protected against chips and dirt
- Designed for all typical milling operations

Standard accessories:

- ☐ Handcrank
- ☐ Slot nuts



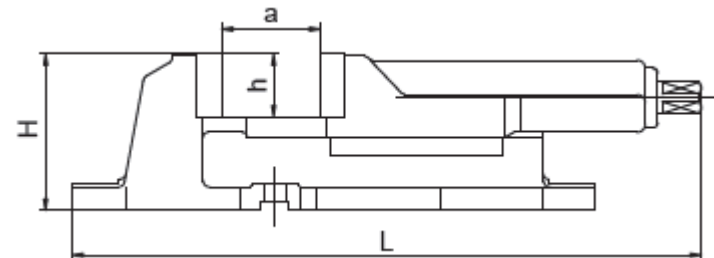
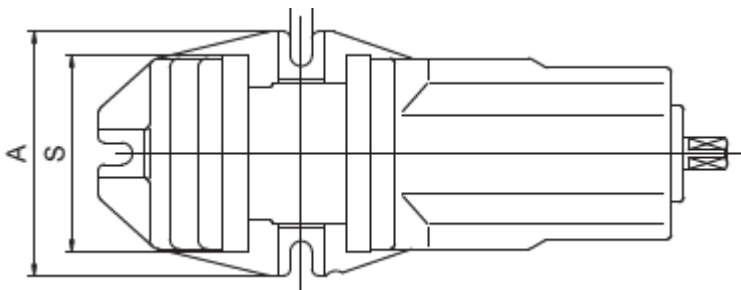
Machine Vises with Cast Iron Body

Type 6512

Type 6537



Jaw Width [S]	Length [L]	Opening [a]
100	294	80
125	347	95
160	423	125
200	515	160
250	615	200





Machine Vises with Cast Iron Body and Hydraulic Spindle

Type 6516



Type 6515



With swivel base

- Hydraulic spindle enables high clamping force with little effort of operator
- Heavy-duty body and jaws
- Body and jaws are made of high-quality castings
- For all typical milling operations

Standard accessories:

- ☐ Handcrank
- ☐ Slot nuts

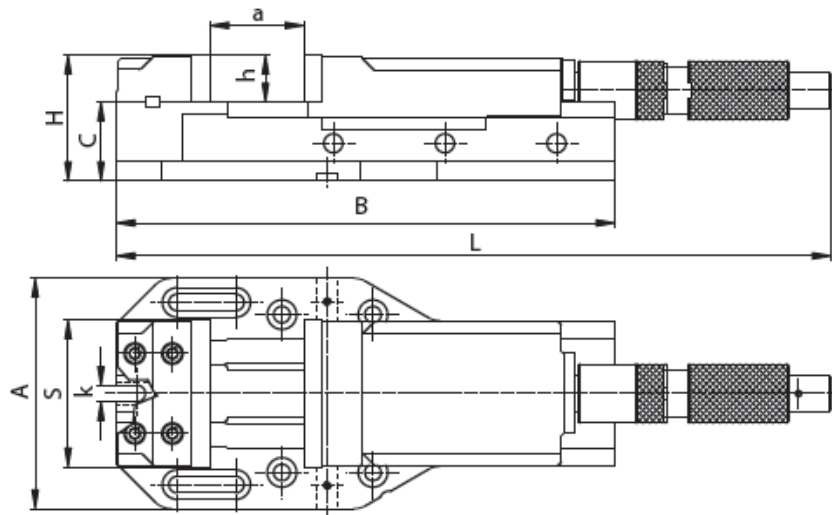
Machine Vises with Cast Iron Body and Hydraulic Spindle

Type 6516



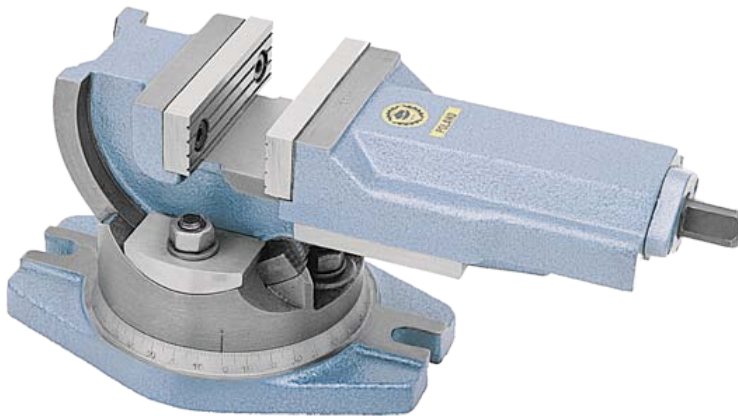
Jaw Width [S]	Length [L max]	Opening [a]
125	530	205
160	615	280
200	795	375

Type 6515



Two angle swivel machine vises

Type 6530



Jaw Width [S]	Opening [a]
100	80
125	100
160	125

- 90 degrees tilt in vertical plane
- 360 degrees swivel base
- Fully covered lead screw
- For milling operations in two planes

Standard accessories:

- ☐ Handcrank
- ☐ Slot nuts

Self-Centering Machine Vises

Type 6531



Jaw Width [S]	Opening [a]
125	100
160	125
200	160

- Centering clamping
- For milling symmetric grooves and slots
- Fully covered lead screw

Standard accessories:

- ☐ Handcrank
- ☐ Slot nuts



Type 6546

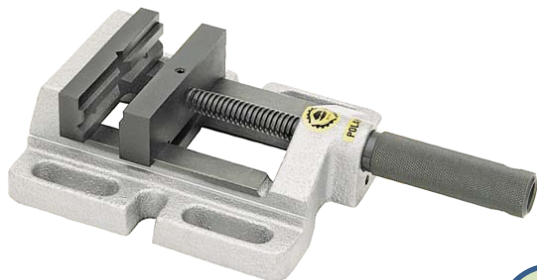


Shaft holding machine vise

- Designed for clamping round parts
- Horizontal and vertical work positions

Jaw Width [S]	Diameter [d]
100	10-63
125	15-100
160	50-160

Type 6543



Drilling vise

- Designed for most drilling operations and light milling
- Vertical and horizontal grooves in jaw inserts enables clamping round parts



Jaw Width [S]	Opening [a]
80	70
100	85
120	120
150	150

Type 6543



Two-piece vise

Jaw Width
160
200

- For clamping very long parts
- Machined part is placed directly on machine table ensuring better rigidity

Type 6910



Prismatic vise

Jaw Width	Opening
105	75
155	165
210	205



- Prismatic guides provide adjusting option in case of wear during exploitation period

Type 6911



With swivel base

Bench Vises

Type 1250



- Cast iron body and movable jaw
- Steel jaw inserts with file cut for good grip
- Rugged design
- For all typical workshop works

Type 1255



With swivel base

Standard accessories:

- ☐ Handcrank
- ☐ Slot nuts



Bench Vises

Type 1250

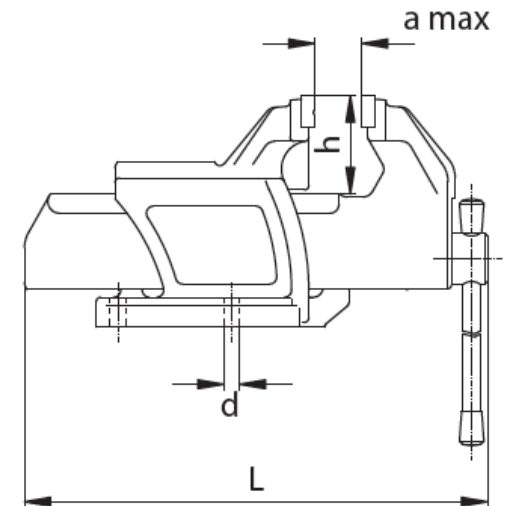
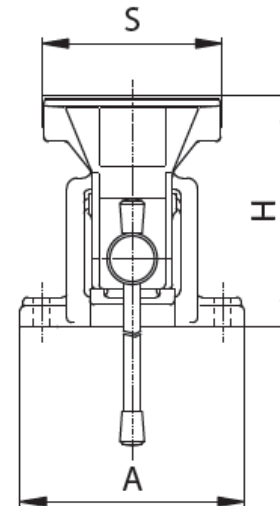


Type 1255



With swivel base

Jaw Width [S]	Opening [a max]
63	63
80	80
100	80
125	100
150	125
175	150

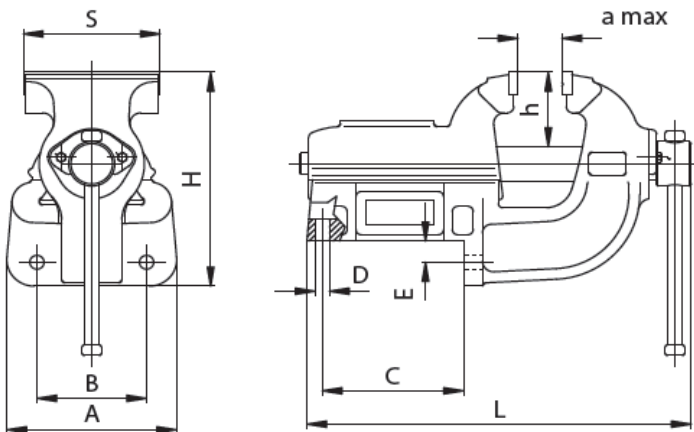
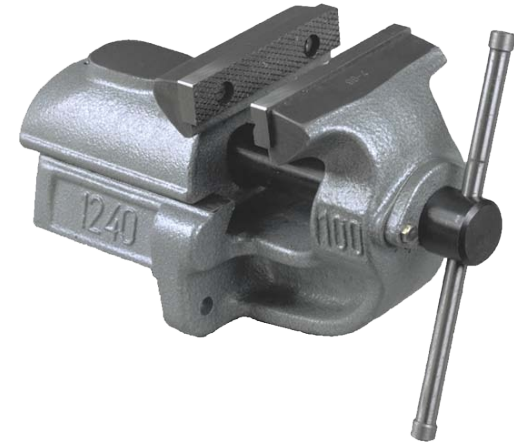




Heavy Duty Bench Vises

TABLE VISE Type 1240

- High quality finish
- Cast iron body and jaws
- Steel jaw inserts with prismatic groove for clamping round parts
- Rugged design
- Dovetail guide for movable jaws
- Excellent for extra heavy work



Jaw Width [S]	Opening [a]
80	100
100	100
125	140
150	175
175	175
200	250
250	250

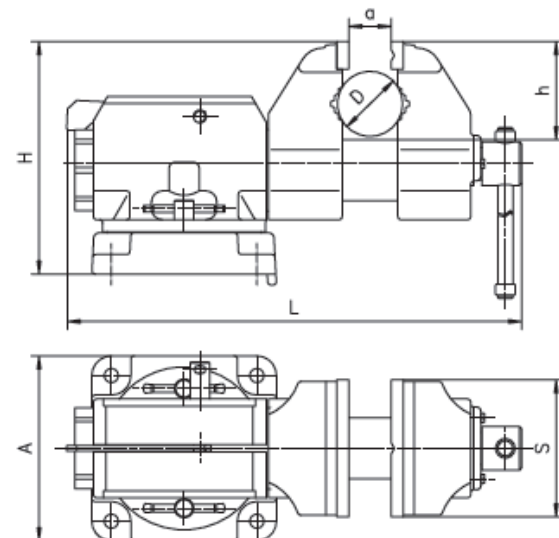
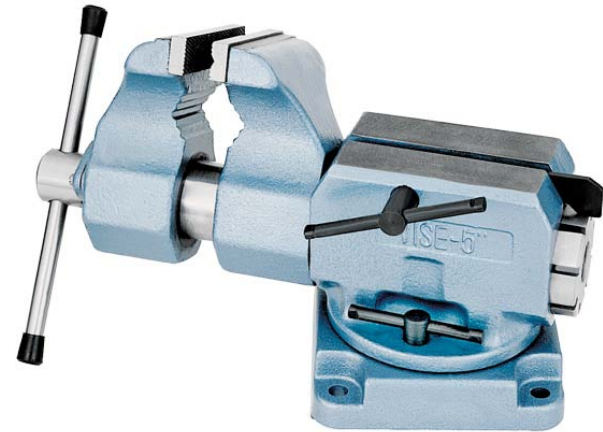


Heavy Duty Bench Vises

TWO - AXIS VISE Type 1271

- Excellent for extra heavy work
- Cast iron body and jaws
- Steel jaw inserts with prismatic groove
- Clamped part may be rotated in horizontal axis with 45° pitch
- Rotation in vertical axis within 360° with swivel base
- V-shaped jaws for clamping round parts

Jaw Width [S]	Opening [a]	D [mm]
125	150	32-60





Portable Bench Vise for Home Applications

PORTABLE VISE WITH SWIVEL BASE **Type 1256**

Jaw Width [S]	Opening [a]
63	63

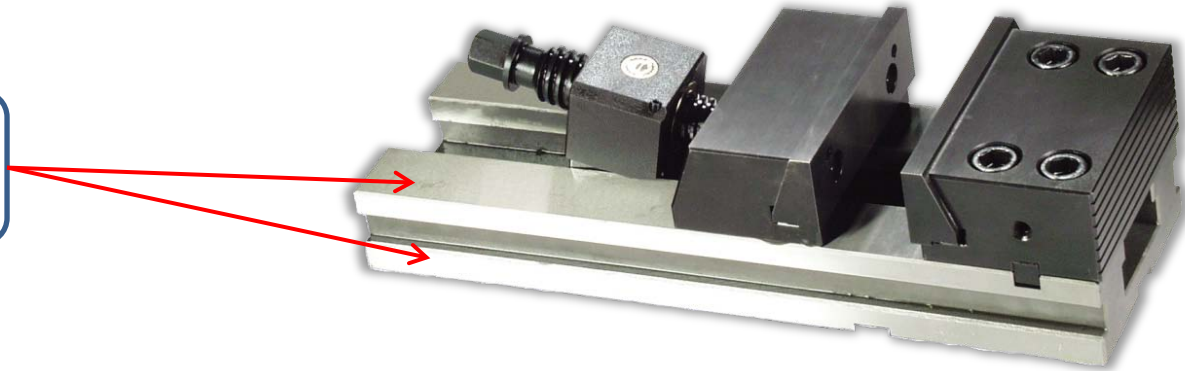


- High quality cast iron body and jaws
- Ideal for non-professional home use

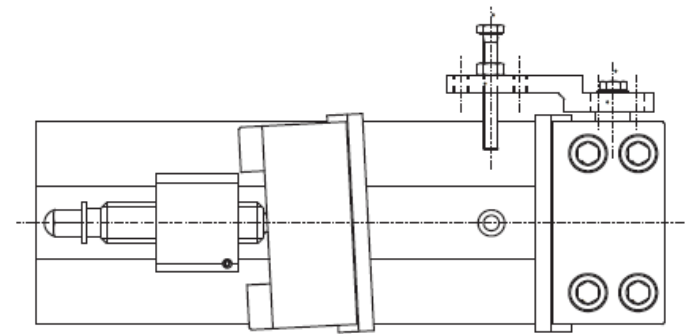


Precision Vise – Type 6620 (old type 6577)

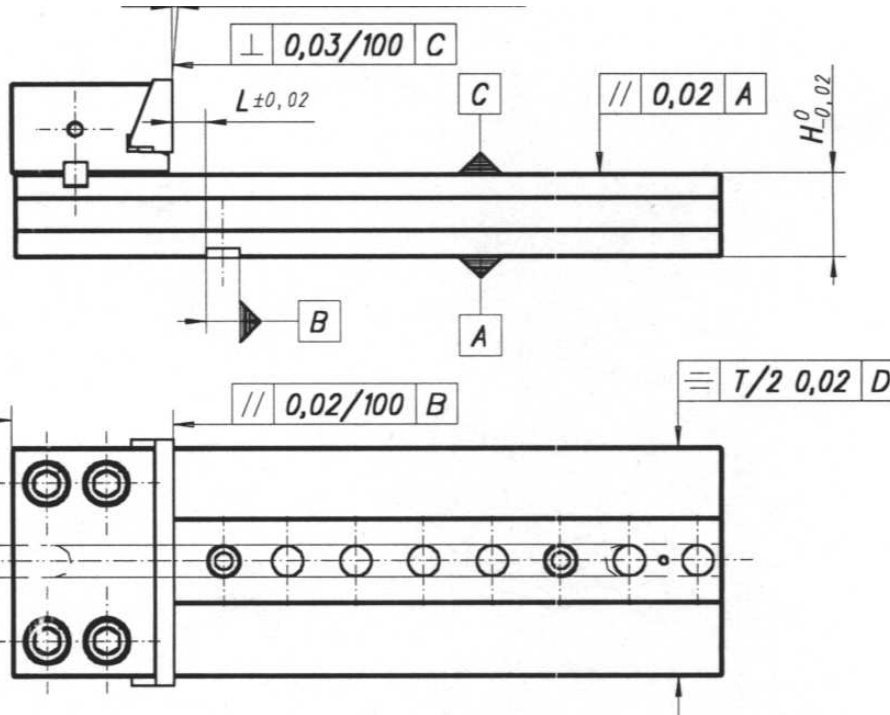
**Ground
surfaces**



- All parts made of steel
- High clamping repeatability
- Self-adjusting movable jaw within $\pm 3^\circ$ angle (with tilting plate re-mounted)

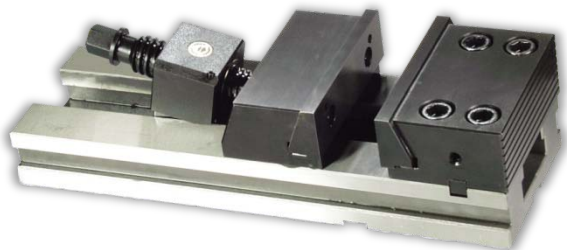
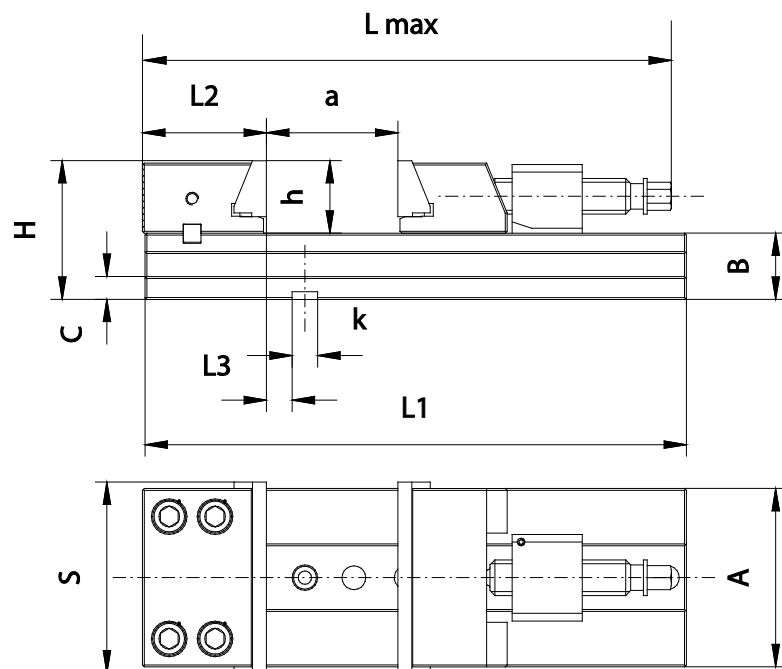


Accuracy of precision vises



➤ Vises may work in sets for clamping large-sized parts

Available sizes

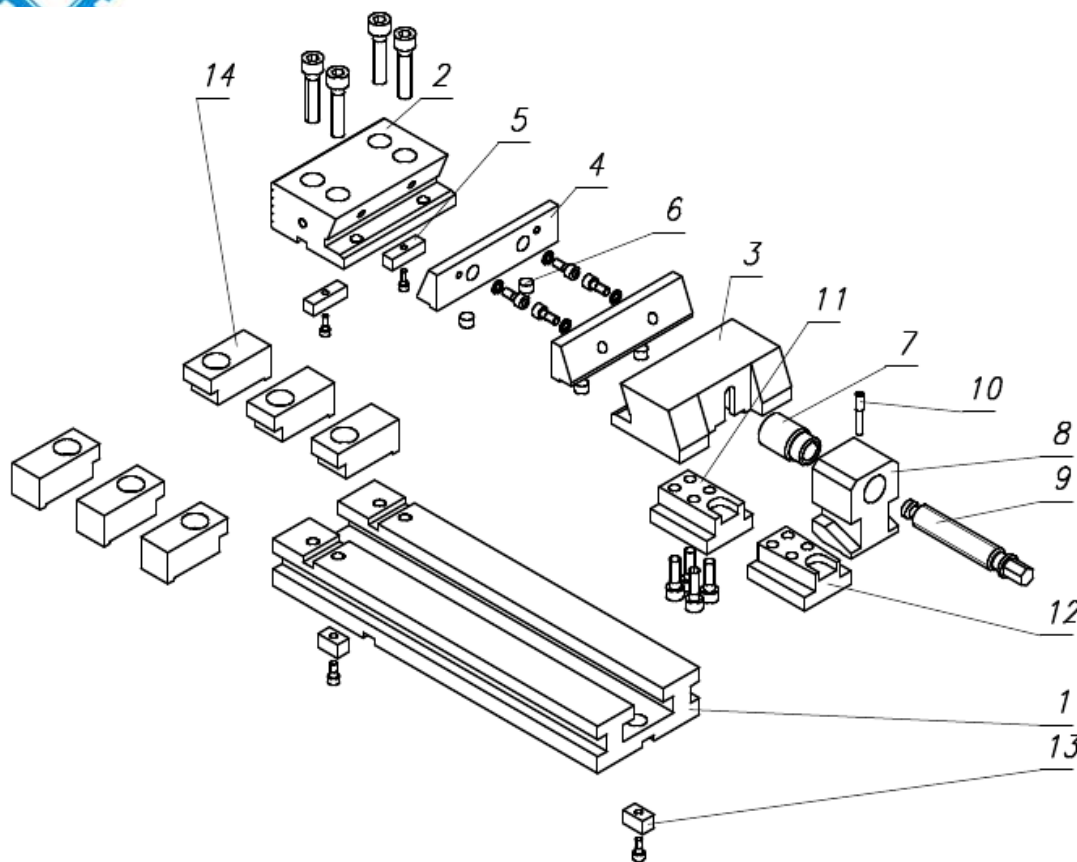


Jaw Width [S]	Length [L1]	Opening [a]
100	320	160
125	335	160
150	425	200
	475	250
	520	295
200	535	260
	585	310
	635	360

Type 6620-150-475/250



Precision vise Parts



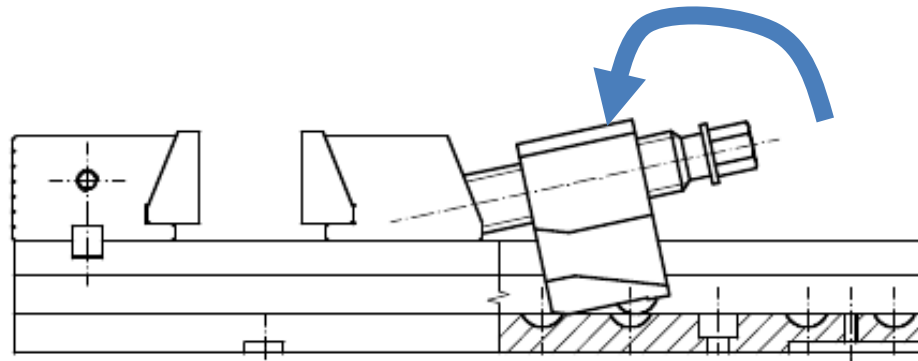
Standard accessories:

- ✓ Handcrank
- ✓ Slot nuts
- ✓ Clamps
- ✓ Tilting lead plate

1 – body
2 – fixed jaw
3 – movable jaw
4 – jaw inserts
5 – key
6 – rubber pad
7 – threaded bush

8 – block
9 – lead screw
10 – screw
11 – lead plate
12 – tilting lead plate
13 – key way block
14 – clamp

Changing the clamping range



1. Tilt the lead screw block up to disengage the ball from base groove
2. Pull the screw block to desired location
3. Engage the ball with another base groove



Precision Vise with Hydraulic spindle Type 6621 (old 6578)



Standard accessories:

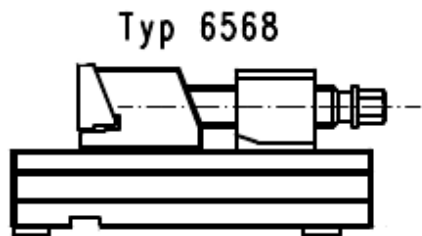
- ✓ Handcrank
- ✓ Slot nuts
- ✓ Vise clamps
- ✓ Tilting lead plate

Hydraulic spindle enables application
of high clamping force and safe clamping with
little effort from the operator

Module vises

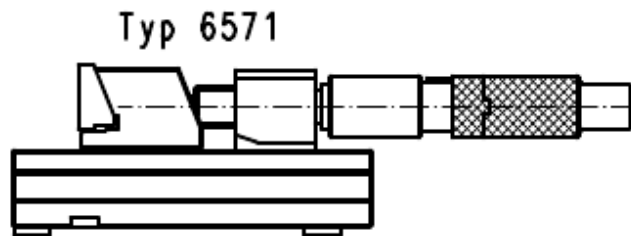


Type 6622

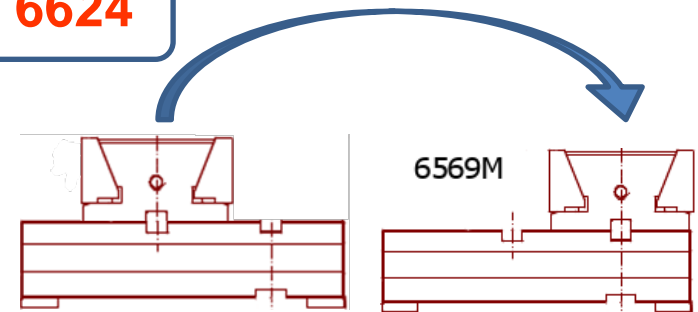


Mobile elements

Type 6623

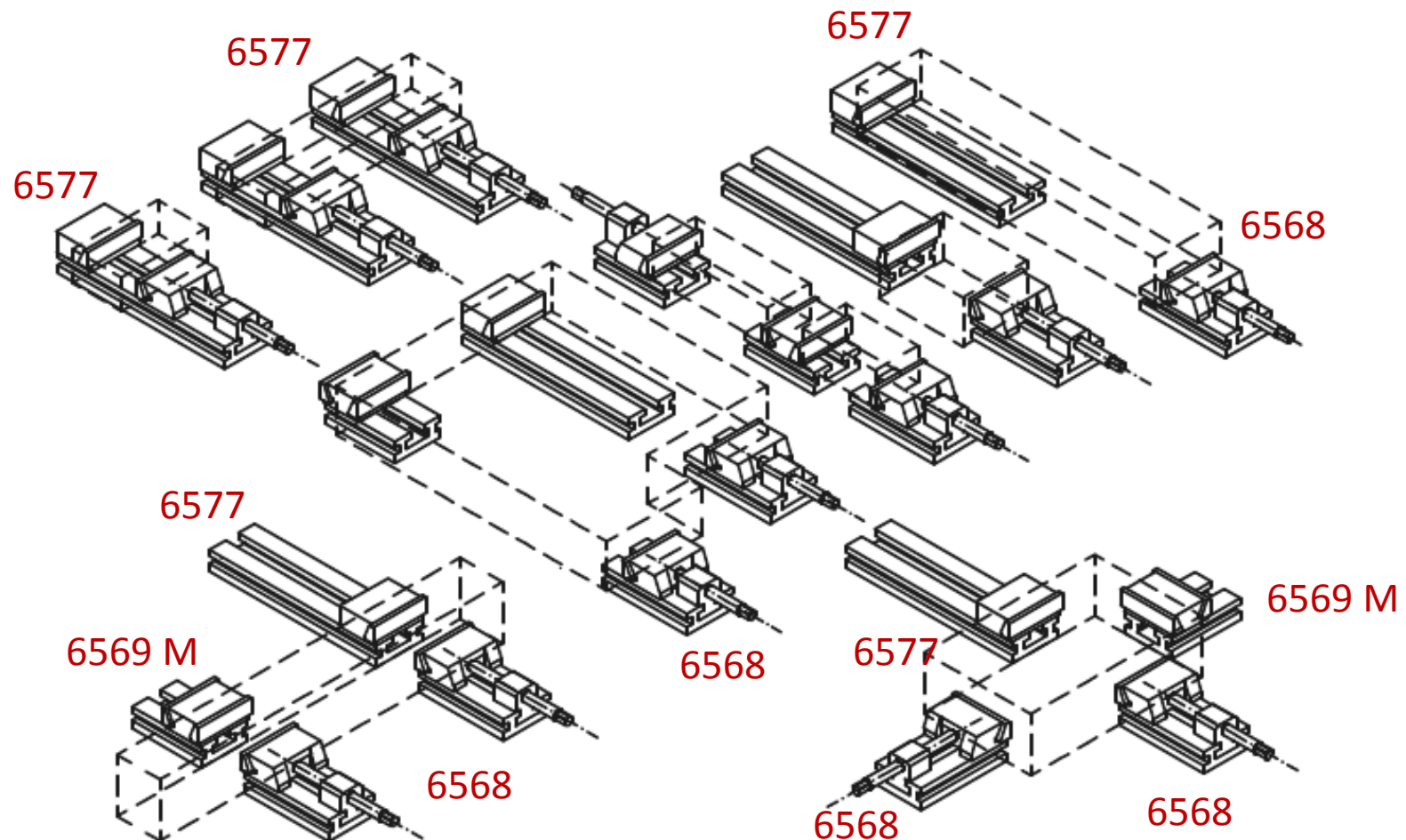


Type 6624



Double back jaw fixed element

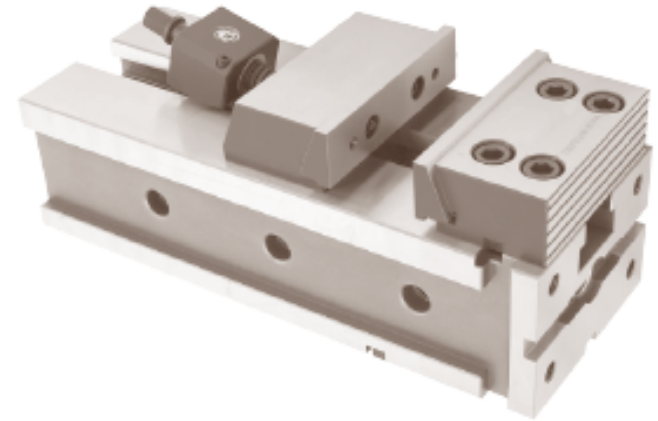
Examples of applications





Compact Precision Vises – Type 6820

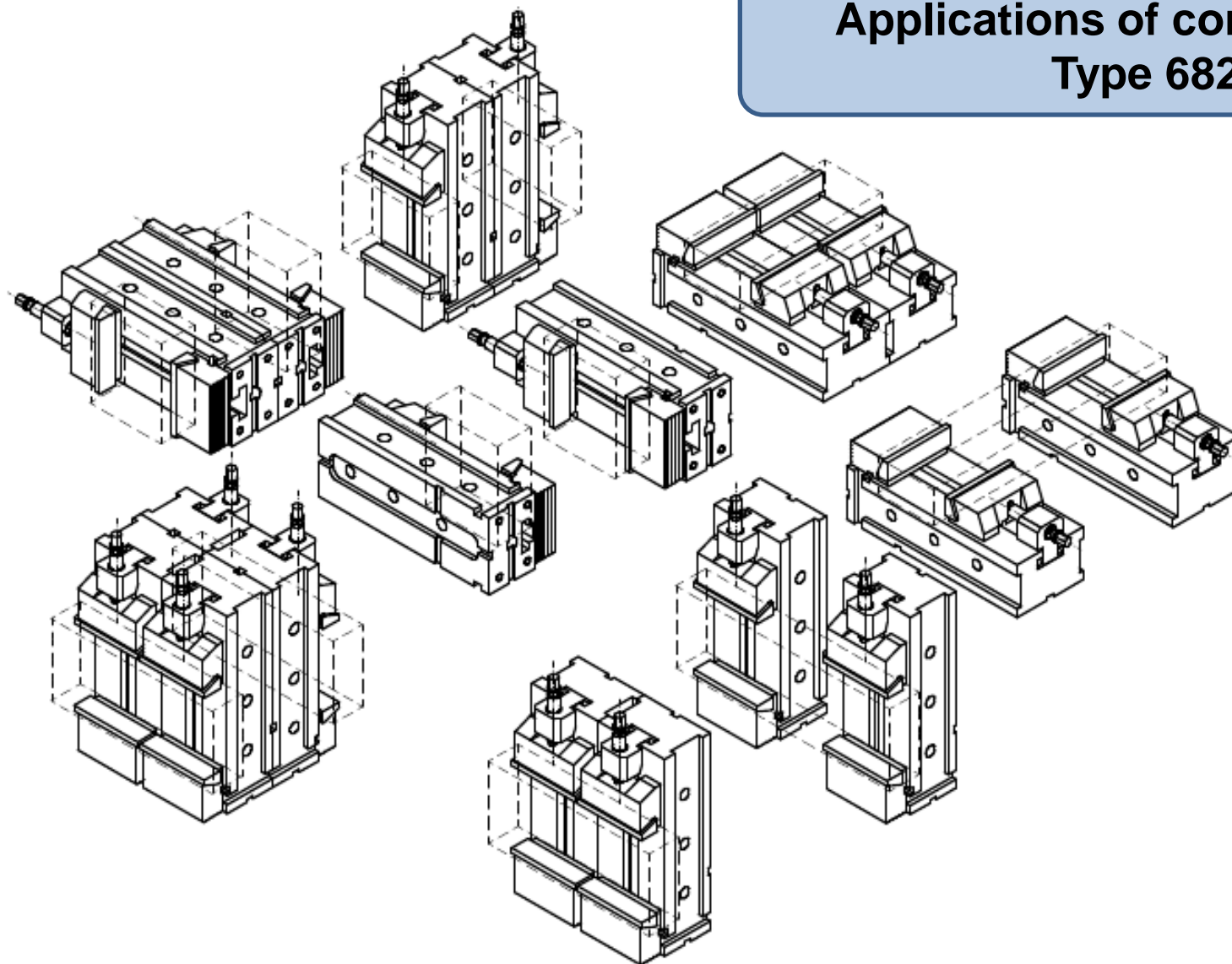
- **Rigid and sturdy body preventing from any deflections during clamping and machining**
- **All parts made of steel**
- **All surfaces ground**
- **High clamping repeatability**
- **Reversible fixed jaw**
- **Horizontal, vertical or side positioning**



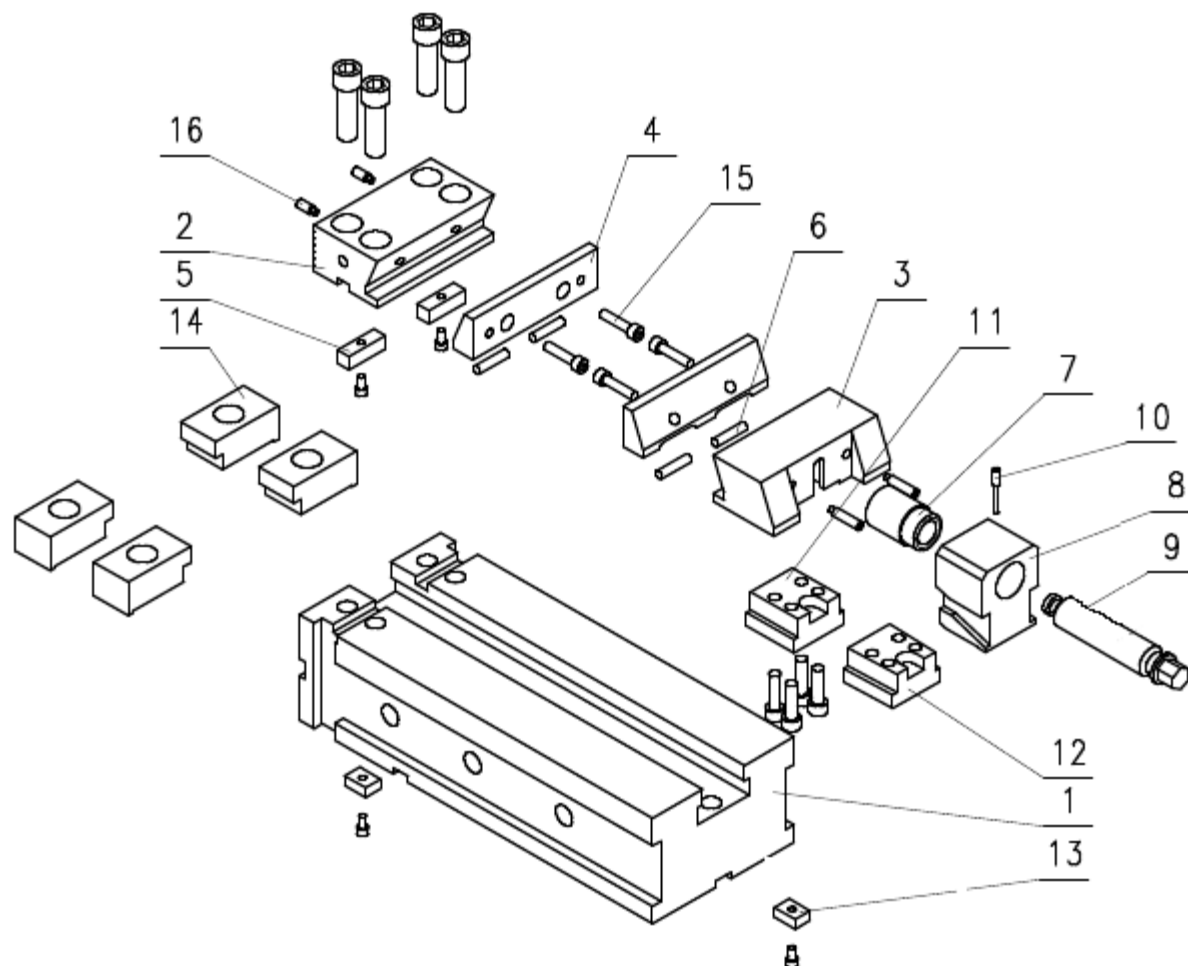
Standard accessories:

- ✓ **Handcrank**
- ✓ **Slot nuts**
- ✓ **Vise clamps**
- ✓ **Tilting lead plate**

Applications of compact vises Type 6820



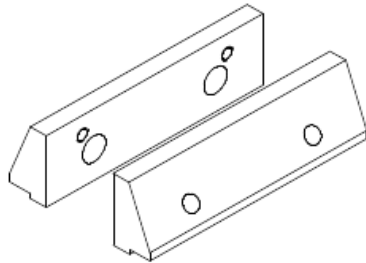
Compact Precision Vises – Type 6820



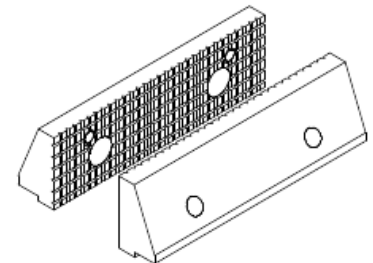
- 1 - body
- 2 - fixed jaw
- 3 - movable jaw
- 4 - jaw inserts
- 5 - key
- 6 - rubber pad
- 7 - threaded bush plate
- 8 - block
- 9 - lead screw
- 10 - screw
- 11 - lead
- 12 - swinging lead plate
- 13 - key way block
- 14 - clamp
- 15 - Screw
- 16- screw



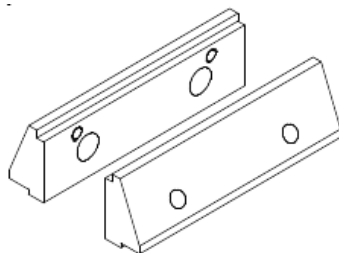
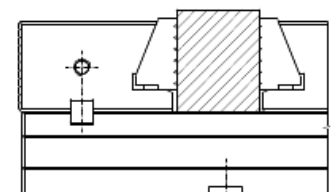
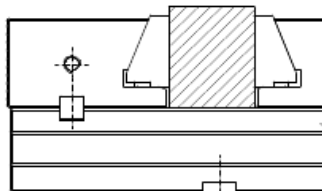
Optional accessories for precision and module vices



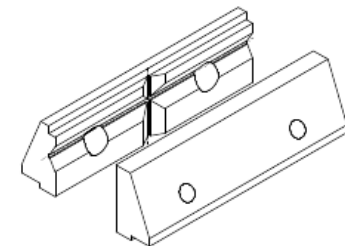
Plain jaw insert
Type 6572



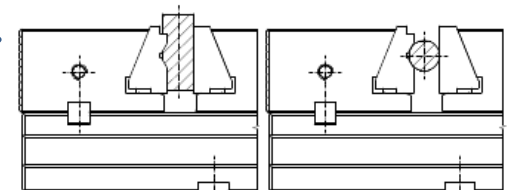
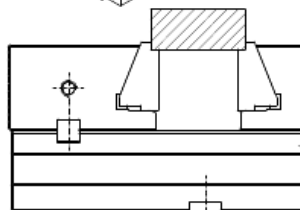
Grooved jaw insert
Type 6573



Plain jaw insert with step
Type 6574

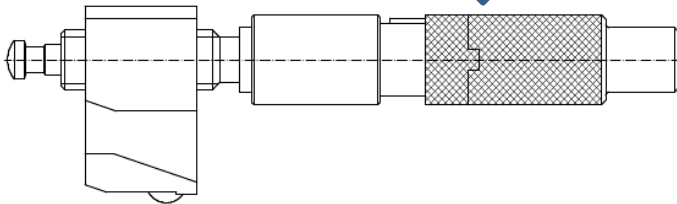


Prismatic jaw insert
Type 6575

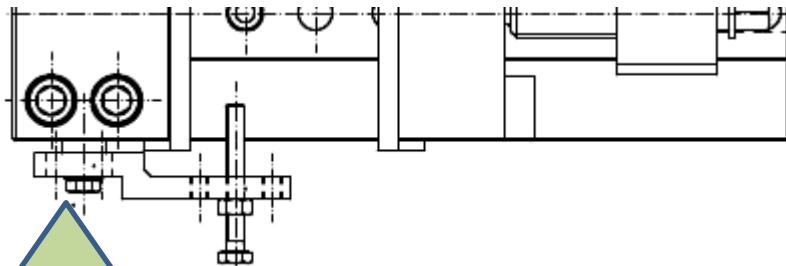
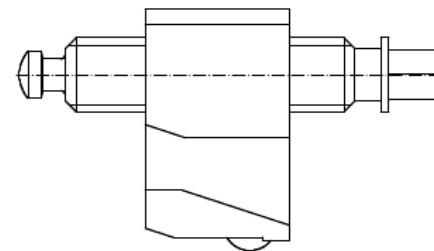


Optional accessories precision and module vises

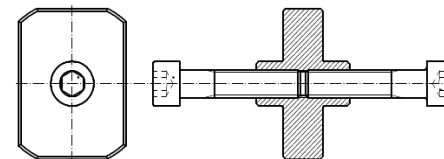
Hydraulic spindle with block
Type 3691



Lead screw with block
Type 6576



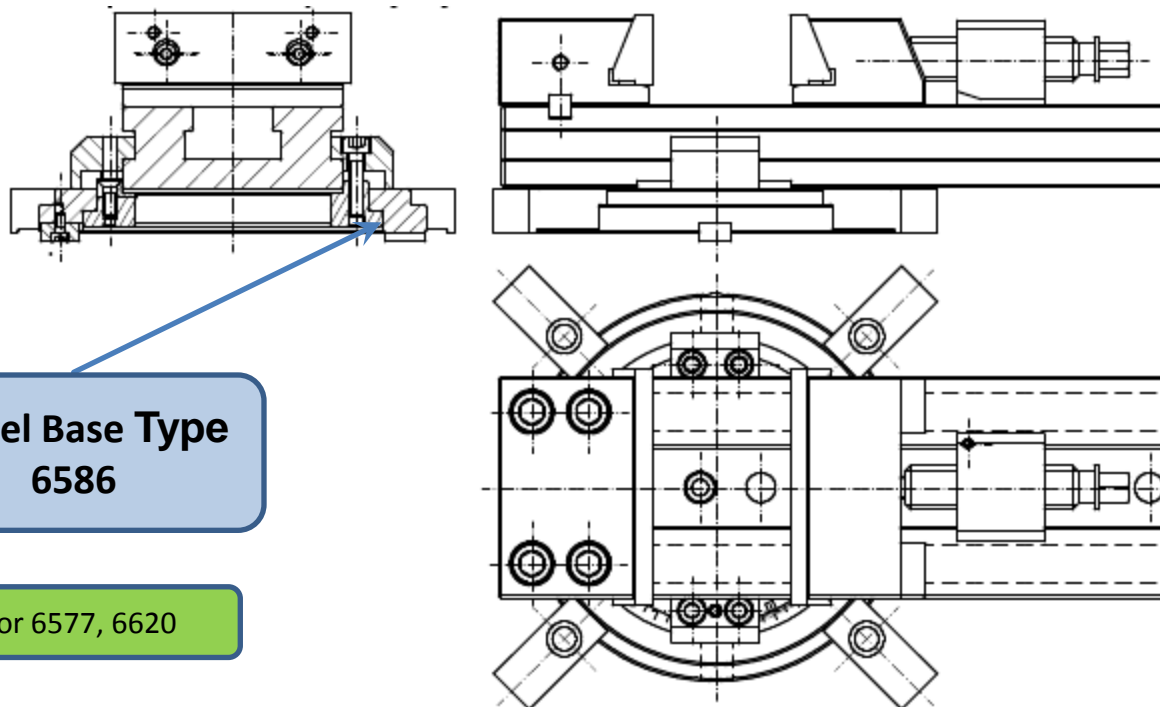
Side stop 6597



Couplers for compact
vises type 6820



Optional accessories precision and module vises



**Swivel Base Type
6586**

For 6577, 6620

Not intended for compact vises – type 6800



Toolmakers & Inspection vises

Type 6552

PLAIN

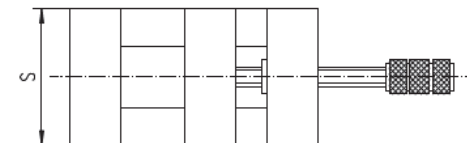
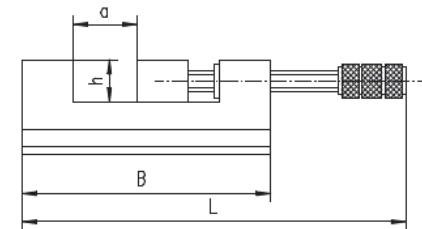


Used for precision grinding, milling and measuring work.

Made of alloy steel, hardened and precision ground

Type 6553

PLAIN WITH
VERTICAL PRISM

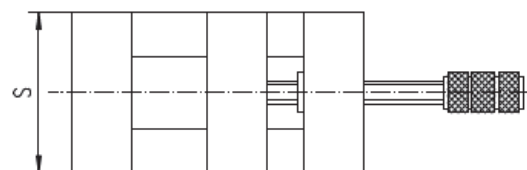
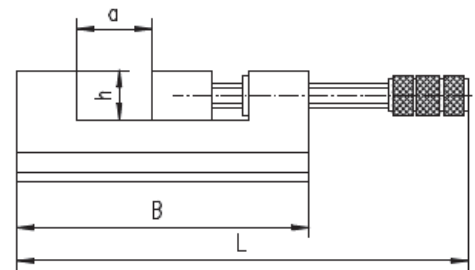




Type 6552

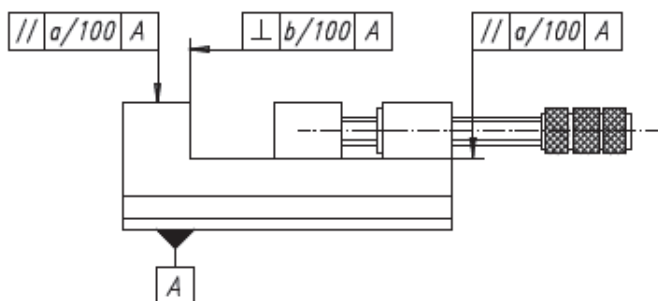


Type 6553



Size - S	B	H	L	a max.
63	120	47	182	50
80	146	56	215	63
100	174	71	243	80

Accuracy of 6552 and 6553 vises



Size - S	a	b	c
63	0,005	0,003	0,005
80	0,005	0,003	0,0105
100	0,007	0,005	0,005



Toolmakers & Inspection vises

Type 6554



Sine with front swivelling axis

Type 6555



Sine with side swivelling axis

- Privots hardened and ground with an accuracy of 0,001mm
- Accurate angle setting by means of gauge blocks
- Vises can be positively locked in any desired angular position



Type 6554

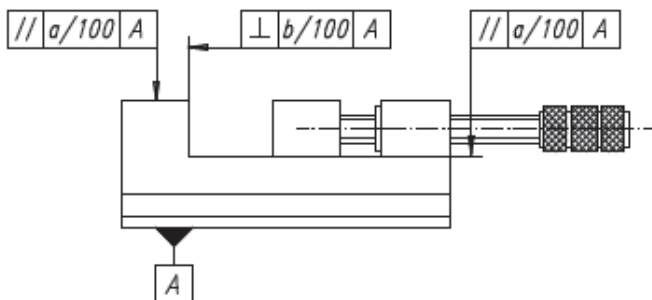
Jaw Width [S]	Opening [a]
63	50
80	63
100	80

Type 6555



Jaw Width [S]	Opening [a]
80	63

Accuracy of 6554 and 6555 vises



Size - S	a	b	c
63, 80	0,005	0,003	0,005
100	0,007	0,005	0,005