PIASTRE CAMBIO RAPIDO TONDE
ROUNDED QUICK CHANGE PLATES

Per Morse Tipo - For Vises Type **INTERASSE** - PITCH		**1 - 2** **52**	**3** **96**
Art. 661 **INTERASSE SINGOLO** **SINGLE PITCH** Piastra cambio rapido tonda ad interasse 52 o 96 con chiavette e fori calibrati Round Quick Change plate with 52 or 96 interaxis with key-ways and calibrated holes	ØA	158	196
	ØB	120	175
	C	27	27
	F	52	96
	L	Ø12h7	Ø16h7
	L1	M8	M10
	kg	3,4	5,6
	Cod.	9.66.15200	9.66.19600



Per Morse Tipo - For Vises Type **INTERASSE** - PITCH		**1 - 2** **52**	**3** **96**		
Art. 661S **DOLCE LAVORABILE** **SOFT MACHINABLE** Piastra cambio rapido tonda lavorabile ad interasse 52 o 96 Round machinable Quick Change plate with 52 or 96 interaxis	A	158	196	250	300
	C	27	27	27	27
	F	52	96	96	96
	L	Ø12h7	Ø16h7	Ø16h7	Ø16h7
	L1	M8	M10	M10	M10
	kg	3,8	6,1	10	15
	Cod.	9.66.1S520	9.66.1S960	9.66.1S960-250	9.66.1S960-300



Personalizzazione esclusa - Customization not included

Per Morse Tipo - For Vises Type **INTERASSE** - PITCH		**1 - 2 - 3** **52 - 96**
Art. 661R **RIDUZIONE DA 96 A 52** **REDUCTION FROM 96 TO 52** Piastra cambio rapido tonda di riduzione da interasse 96 a 52 Round reduction Quick Change from 96 to 52 interaxis	ØA	158
	B	96
	C	27
	F	52
	L	Ø12h7
	L1	M8
	kg	3,75
	Cod.	9.66.1R210

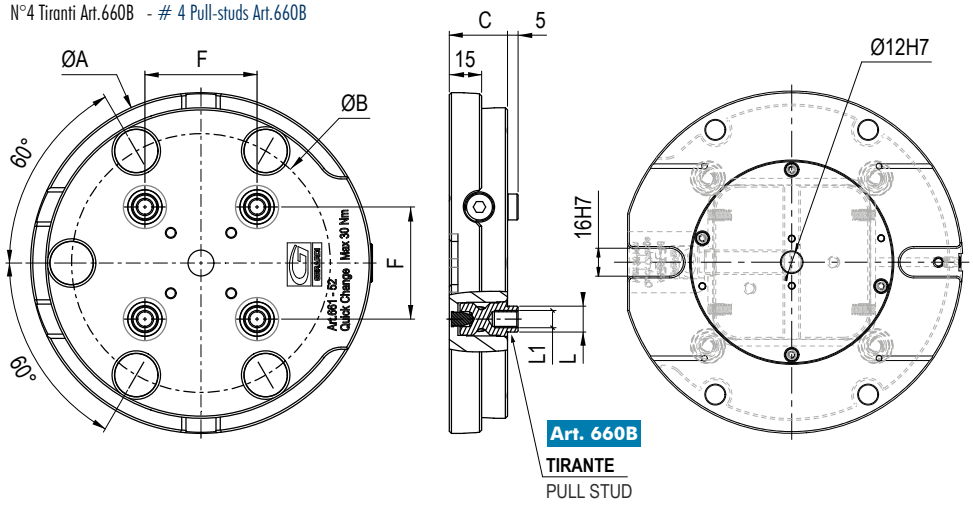


*** Non disponibili per il mercato Tedesco e Austriaco -** * Not available for German and Austrian market

PIASTRE CAMBIO RAPIDO TONDE
ROUNDED QUICK CHANGE PLATES

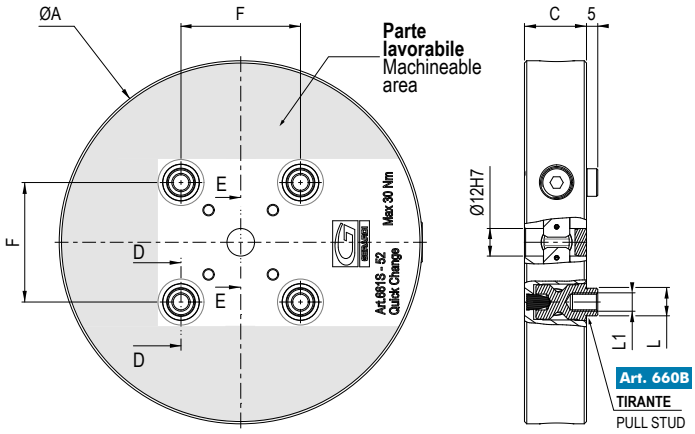
Art. 661

Dotazione standard - Standard equipment:
N°4 Tiranti Art.660B - # 4 Pull-studs Art.660B



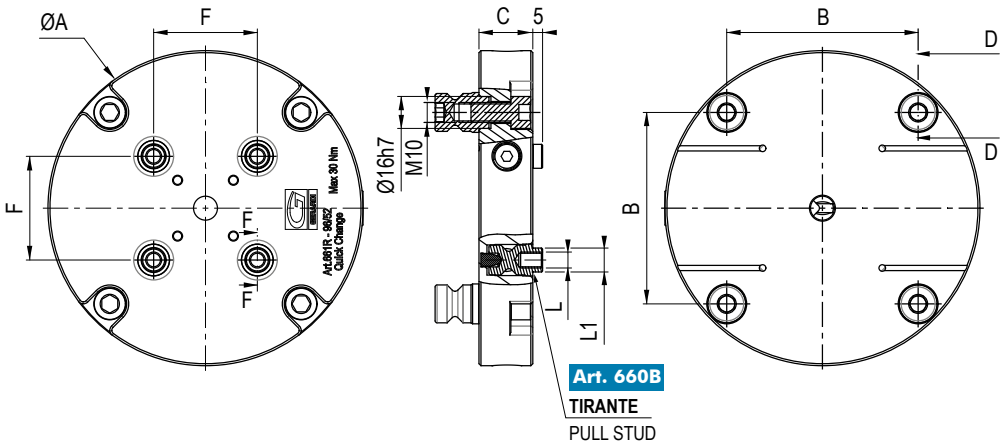
Art. 661S

Dotazione standard - Standard equipment:
N°4 Tiranti Art.660B - # 4 Pull-studs Art.660B



Art. 661R

Dotazione standard - Standard equipment:
N°4 Tiranti Art.660B - # 4 Pull-studs Art.660B

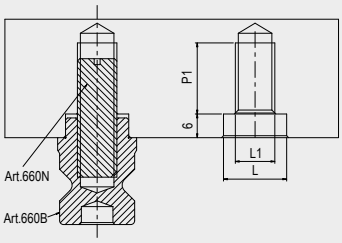


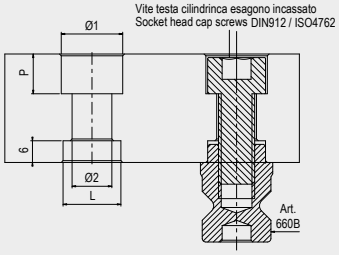
Art. 660B

Tiranti per piastra cambio rapido
Quick change table pull studs



Tipo - Type 1 Tipo - Type 2





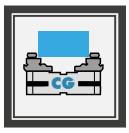
Type	1	2
L	Ø12 h7	Ø16 h7
L1	M8	M10
Ø1	14	17
Ø2	9	11
P	9	11
P1	12	18
Code	9.66.0B100	9.66.0B200



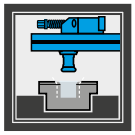
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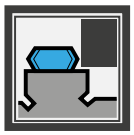
MORSE COMPACT GRIP
COMPACT GRIP VISES

Esempi applicativi su centri a 5 assi - Application example on 5 axis machine


Morse Compact Grip
Compact Grip vises


lavorazioni a 5 assi
5 axis machining


Predisposizione
Zero Point
Zero Point ready


Inserti GRIP
GRIP inserts



Art.650 Compact Grip

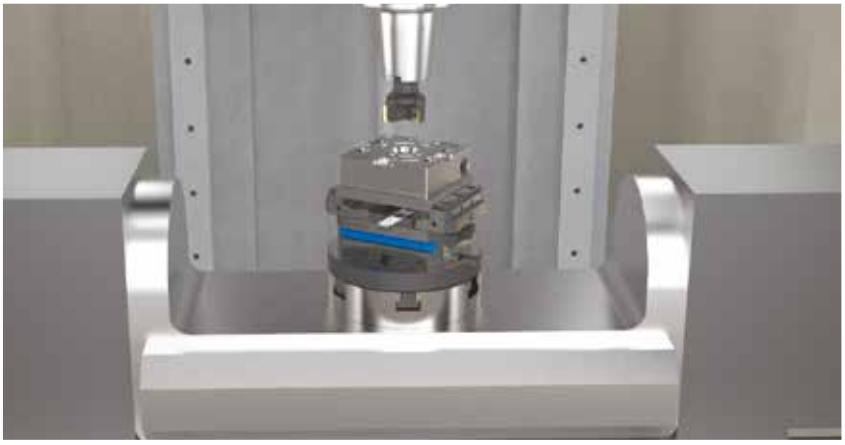
La novità assoluta per centri a 5 assi e sistemi multipli sono le morse autocentranti Compact Grip. Il loro nome accosta le principali peculiarità della morsa date dall'estrema compattezza e maneggevolezza al nome del sistema di inserti che adotta, cosidetto "GRIP". Questo sistema consiste in una gamma di inserti ganascia modulari montati sopra al corpo ganascia principale con la funzione di serrare il particolare da lavorare tramite dei dentini affilati o conformati a seconda del tipo di materiale e di durezza.

The absolute news for 5 axis machine centres and new multiclamping system are the self-centering Compact Grip vises. Their name indentifies the main vise features which are the extreme compactness and easiest handling and the system of inserts which adopts,
so called "GRIP". This system includes a range of jaw plates assembled on the top of the main jaw with the function of clamping the workpiece through sharp or duly shaped teeth according to the material type and hardness to clamp.

Aperture Morse / Opening vise range

Scansiona il QR code e scarica la tabella con tutte le aperture delle morse CompactGrip

Scan the QR code to download the chart with all vise jaws opening





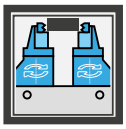
Tramite l'inserto Grip si esegue la sgrossatura e la finitura del pezzo sui cinque lati.
Through the Grip insert you can rough mill and finish the workpiece on five sides.


Dettaglio Inserto Grip.
Insert Grip detail.


Tramite il gradino liscio della ganascia si rimuove il sovrametallo rimanente e si finisce il particolare
Then through the smooth jaw step you can remove the remaining stock allowance from th e workpiece and finish the workpiece

MORSE FMS
FMS VISES

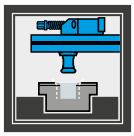
Esempi applicativi su centri a 5 assi - Application example on 5 axis machine



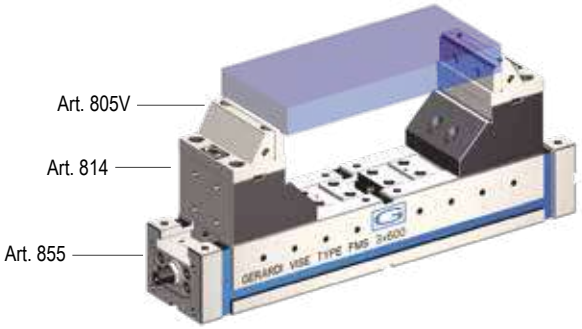
Ganasce alte e rialzate
High and raised jaws



lavorazioni a 5 assi
5 axis machining



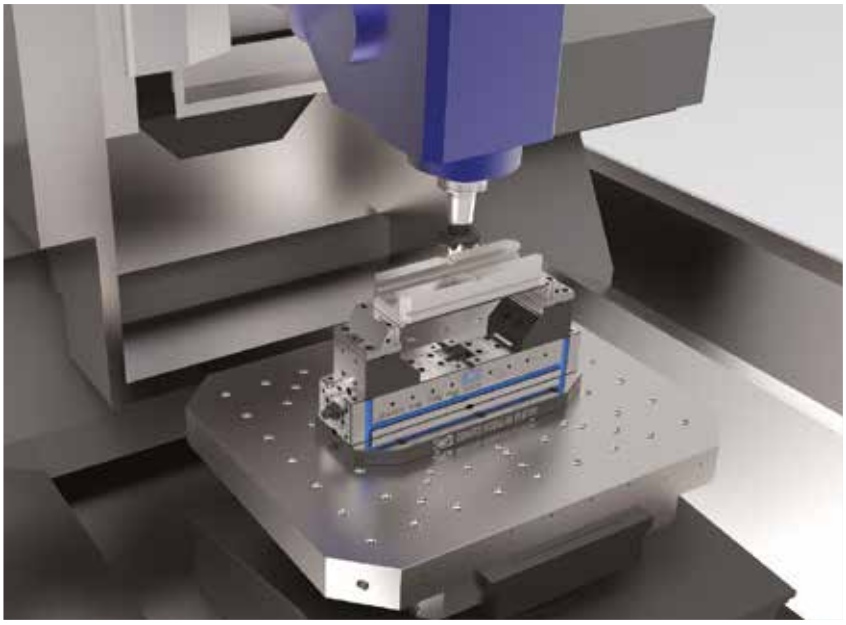
Predisposizione
Zero Point
Zero Point ready

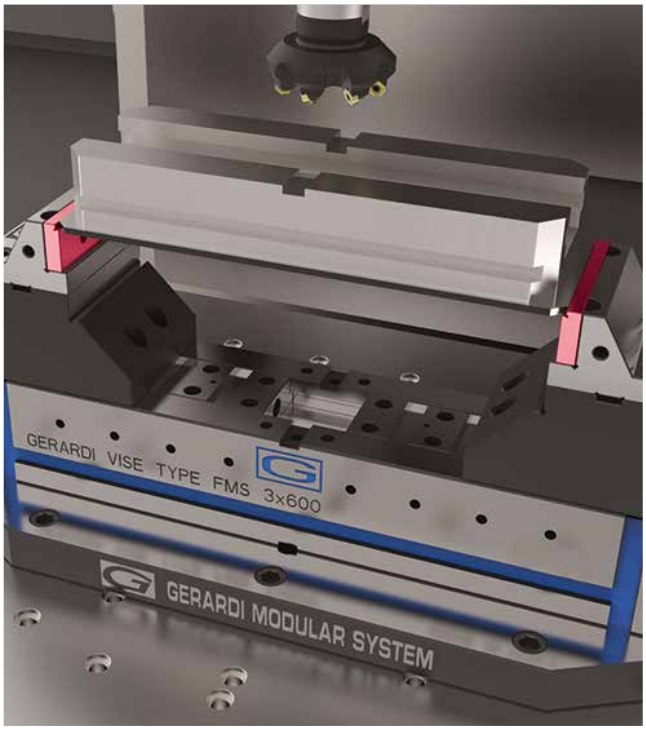


Art.868 FMS series

Grazie all'estrema versatilità del sistema modulare Gerardi anche le morse FMS, adeguatamente riconfigurate, possono rientrare nella cosidetta categoria di morse Multitasking per centri di lavoro a 5 assi.
Basterà quindi montare la base mobile Art.814 con le relative ganasce Art.805V sul modulo base universale Art.855.

Thanks to the extreme versatility of the Gerardi Modular System even the FMS vises, properly reconfigured, can be used as Multitasking vises for 5 axis machine centres.
It will be enough to assemble the movable base Art.814 with the Art.805V jaws on the universal vise base module Art.855





Particolare sollevato tramite base mobile Art.814
Workpiece raised by movable base Art.814



Dettaglio serraggio tramite piastrina GRIP Art.247T
Detail of clamping by GRIP jaw plate Art.247T

Staffe di ancoraggio / *Vise holding clamps*

NEW 2024

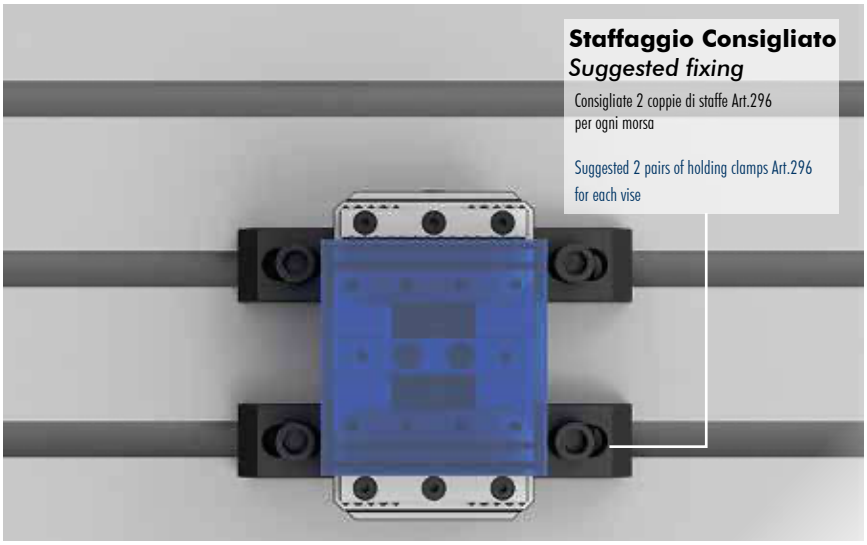
CompactGrip

Coppia staffe di fissaggio Art.296, complete di vite e dado a "T"

Pair of vise holding clamps Art.296 complete of screw and "T" nut

Esempio d'ordine per morsa tipo 3 su macchina con cave a T da 18mm: *Art.296 T.3 X=18mm*
Oppure con codice: *2.29.6100 X=18mm*

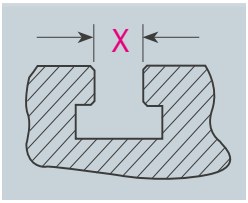
Order example for Type 3 vise on machine with 18mm T-slots: Art.296 T.3 X=18mm
Also with code: 2.29.6100 X=18mm



Art.298/CGR

Per lo staffaggio della morsa in spazi ristretti possibilità di usare staffe Art. 298 / CGR vedi pag. 7.29)
For clamping vise in narrow space it's possible to use the holding clamps Art 298 / CGR see pages 7.29



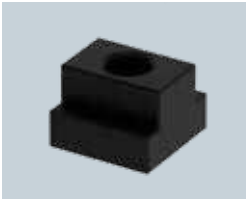


Cava a T

T Slot

Specificare sempre la cava della vostra macchina

Always specify the machine T-slot dimension

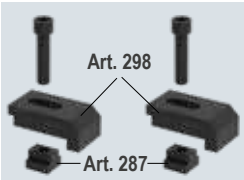


Art.287 (Pag.4.34)

Dadi a T - *T Nuts*

Per fissaggio morse alle cave a T della macchina

For vise clamping on the machine T-slots



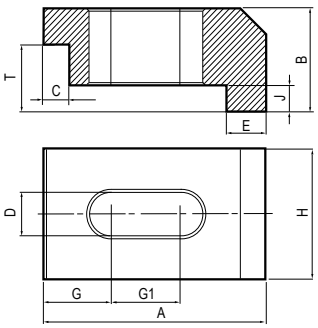
Art.296

(Art.298 + Art.287)

Consigliate 2 coppie di staffe Art.296 per ogni morsa

Suggested 2 pairs of holding clamps Art.296 for each vise

Tipo (grandezza) morsa / Vise type (size)		1			2			3		
Art. 296 Coppia di staffe / Holding clamps pair	Cava a T- slot **X**	12*	14	16	16	18	20	18*	20	22
	T-nuts Ref. N°	12	13	14	20	21	22	32	33	34
	Filetto vite / Screw thread	M10			M12 *			M16		
	A	50			50			50		
	B	24			24			24		
	C	6			6			6		
	Ø D	11			13			17		
	E	10			10			10		
	G	16			17,5			19		
	G1	15			13			9		
	H	34			34			34		
	J	4			4			4		
	T ± 0,1	15			15			15		
	Cod.	2.29.61000 / M10			2.29.61000 / M12			2.29.61000 / M16		



* *Scelta consigliata - Suggested choice*

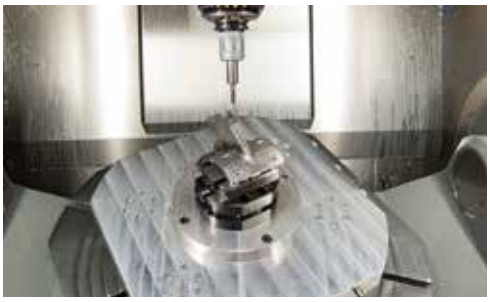
* *Scelta NON consigliata - NO Suggested choice*

Soluzioni personalizzate / *Customized solutions*

4th & 5th Axis

Soluzioni personalizzate a tutti i vostri problemi di serraggio

Customized solutions for all your clamping problems

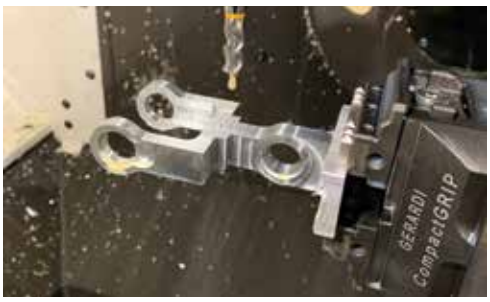


Morsa Multitasking su centro a 5 assi

Multitasking vise on 5th axis machining center

Applicazione aeronautica, morsa Art.640 tipo 2 montata su macchina a 5 assi

Typical Multitasking vise Art.640 type 2 application on a 5 axis machine for aerospace workpiece



Morsa CompactGrip su centro a 5 assi

CompactGrip vise on 5th axis machining center

Lavorazioni di fresatura effettuate su di un centro di lavoro a cinque assi con morse CompactGrip Art.650

Milling machining operations on a five axis machining center with CompactGrip vises Art650



Morsa CompactGrip su rialzo semplice

Compact Grip vise on simple riser

Morsa CompactGrip montata su Kitamura Mytrunnion 4G per la lavorazione di uno stampo nel settore plastica.

Compact Grip vise on Kitamura Mytrunnion-4G for machining a die mould used in the plastic industry



Morse CompactGrip su piastra Zero Point

CompactGrip vises on Zero Point plate

Piastra base con 6 Zero Point singoli per morse CompactGrip Art.650 T2 per lavorazioni di piccoli particolari

Zero Point plate with 6 single Zero Point units for CompactGrip vises Art.650 T2 for small workpieces machining.



Un sistema completamente automatico

Fully automatic system

Morsa automatica GripMatic Art.670PN montata tramite robot su tavola Zero Point.

GripMatic automatic vises Art.670PN mounted by robot on Zero Point Plate

VALIGETTA DI CAMPIONATURA COMPACT GRIP
SAMPLE KIT CASE COMPACT GRIP

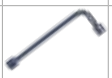
Art. 986

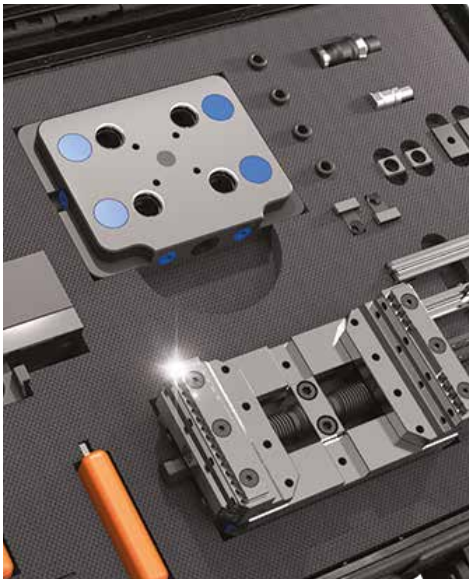


Morsa / Vise Art. 650

Cod.	0.98.60000

Art. 650 - All'Interno - Inside:

 Art.11A	 Art.650X	 Art.950D	 Art.950B
 Art.660B	 Art.79	 Art.650G11	 Art.650G02
 Art.650G01	 Art.650R	 Art.650S	 Art.298/CGR
 Art.297	 Art.370/EM	 Art.375	 Art.376
 Art.650G	 Art.650GZ		



SIMBOLOGIA DATI TECNICI
TECHNICAL DATA ICONS

GANASCE
JAWS


Morse Multitasking
Multitasking vises


Morse Compact Grip
Compact Grip vises


Morse Compact Grip Art.950
Art.950 Compact Grip vises


Morse Grip Matic
Grip Matic vises


Sistema a coda di rondine
Dove Tail fixtures

POSSIBILITÀ
POSSIBILITY


Montaggio con centralina
Mounting with power unit


Lavorazioni a 5 assi
5 axis machining


Predisposizione Zero Point
Zero Point Ready

PIASTRE GANASCE
JAW PLATES


Liscio + Ruvido
Smooth + Rough


Coda di Rondine
Dove Tail


GRIP
GRIP


Frontali
Frontal

PAGINE
PAGES


Rialzi
Risers


Sistema Pneumatico
Pneumatic system


Sistema Idraulico
Hydraulic system


Accessori & Ricambi
Accessories & Spare Parts


Istruzioni corretto utilizzo
Instruction for a proper use


Diagrammi forze di serraggio
Clamping force diagrams

OPZIONI LAVORAZIONI EXTRA
OPTIONS FOR EXTRA MACHINING

Nei codici, **FMS** si riferisce agli articoli dei gruppi 5, 6 e 7.
In codes, **FMS** refers to articles in groups 5, 6 and 7.

Lavorazione extra Extra machining	Cod.
AGGIUNTA di un foro calibrato ADDITION of a calibrated hole	MAN-010-FMS
AGGIUNTA di una chiavetta calibrata ADDITION of a calibrated key-way	MAN-020-FMS
PREDISPOZIONE SEMPLICE SIMPLE SET UP	MAN-030-FMS
PREDISPOSIZIONE & MONTAGGIO COMPLETO COMPLETE SET UP & MOUNTING	MAN-040-FMS
MONTAGGIO PARZIALE PARTIAL ASSEMBLY	MAN-050-FMS

Lavorazione extra Extra machining	Cod.
MONTAGGIO SEMPLICE SIMPLE ASSEMBLY	MAN-060-FMS
MONTAGGIO ed ALLINEAMENTO (Standard) (Standard) ASSEMBLY and ALIGNMENT	MAN-070-FMS
MONTAGGIO VERTICALE COMPLETE VERTICAL ASSEMBLY	MAN-080-FMS
ALLINEAMENTO e CONTROLLO tramite DEA ALIGNMENT and CONTROL by DEA \ CMM	MAN-090-FMS
TABULATO controllo DEA PRINTOUT DEA control	MAN-100-FMS

Vedi pagina 7.64 per esempi applicativi - See page 7.64 for application examples