

GANASCE & PIASTRE GANASCE PER MORSE MULTITASKING Art.670

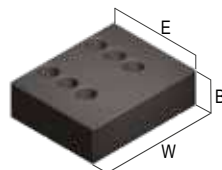
JAWS & JAW PLATES FOR MULTITASKING VISES Art.670

Tipo (grandezza) / Type (size)	2	3	4
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Art. 671A*

Ganascia mobile lavorabile
Soft movable jaw

Materiale temprabile 20MnCr5
Hardenable material 20MnCr5

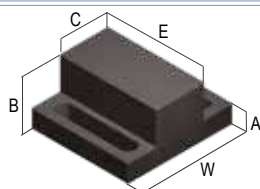


W	74	99	124
B	25	30	35
E	49	79	96
Cod.	7.67.1A200	7.67.1A300	7.67.1A400

Art. 671B*

Ganascia mobile lavorabile ridotta
Soft narrow movable jaw

Materiale temprabile 20MnCr5
Hardenable material 20MnCr5

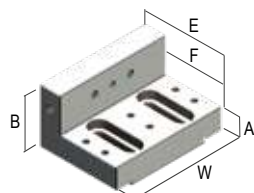


W	40	65	81
A	10	10	15
B	25	30	35
C	15	28	38
E	40	65	81
Cod.	7.67.1B200	7.67.1B300	7.67.1B400

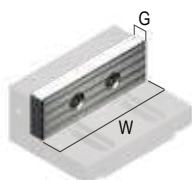
Art. 671C*

Ganascia mobile predisposta
per piastre ganasce standard ridotte
Movable jaw for narrow standard jaw plates

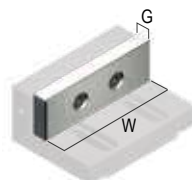
* Viti per fissaggio a richiesta
Fixing screws on request



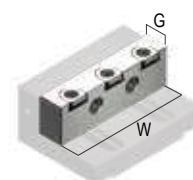
W	74	94	124
A	13,5	18	18
B	38	48	58
E	45	70	87
F	30	51	62
Cod.	7.67.1C200	7.67.1C300	7.67.1C400



Art. 243*



Art. 245*



Art. 247G*

Piastrine ganasce: Art. 243 piana rigata temprata, Art. 245 piana liscia temprata, Art. 247G con inserti GRIP.
Jaw Plates: Art. 243 Hardened flat grooved jaw plate, Art. 245 hardened flat smooth jaw plate, Art. 247G with GRIP inserts.

* Viti per fissaggio a richiesta - Fixing screws on request

Art. 670K

Parti di ricambio per Morse GripMatic
Grip Matic Jaws spare parts



Cod.	7.67.0K200	7.67.0K300	7.67.0K400
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Art. PN16

Valvola direzionale di non ritorno - 1/8" Gas
Unidirectional check valve - 1/8" Gas



Cod.	9.PN.16000
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Art. PN22

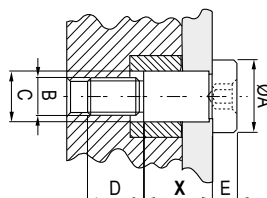
Raccordo a Y Ø6 - Ø8
Y adaptor Ø6 - Ø8



Cod.	9.PN.22006/8
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Art. 83

Vite Calibrata a colletto
Shoulder calibrated screw



A	16	18	24
B	M8	M10	M12
C	10h7	12h7	16h7
D	15	15	18
E	7	8	11
X	30	40	45
Cod.	8.83.10300	8.83.12400	8.83.16450

Art. 670IDL

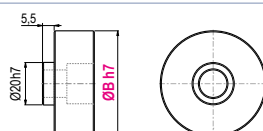
Adattatore per innesto diretto
Direct input adaptor



Cod.	7.67.0IDL20	7.67.0IDL30
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Art. 670P

Perno di centraggio
Straight pin



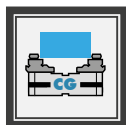
ØB	20 - 30 - 38,1 - 50 - 50,8
Cod.	7.67.0P3000

Specificare sempre quota B - Specify always B dimension

MORSE COMPACT GRIP

COMPACT GRIP VISES

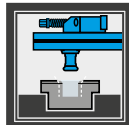
Esempi applicativi su centri a 5 assi - Application example on 5 axis machine



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, cosiddetto "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.

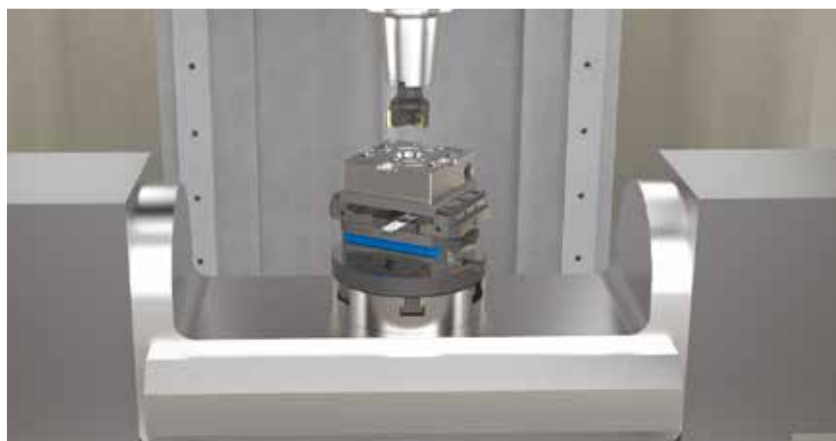
The absolute news for 5 axis machine centres and new multiclamping system are the self-centering Compact Grip vises. Their name identifies the main vise features which are the extreme compactness and easiest handling and the system of inserts which adopts, so called "GRIP". This system includes a range 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.

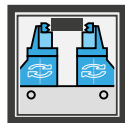


Tramite il gradino liscio della ganascia si rimuove il sovrametallo rimanente e si finisce il particolare.
Then through the smooth jaw step you can remove the remaining stock allowance from the workpiece and finish the workpiece.

MORSE FMS

FMS VISES

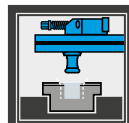
Esempi applicativi su centri a 5 assi - Application example on 5 axis machine



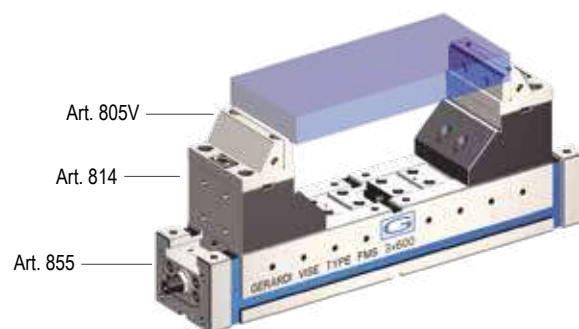
Ganasce alte e rialzate
High and raised jaws



lavorazioni a 5 assi
5 axis machining



Predisposizione
Zero Point
Zero Point ready



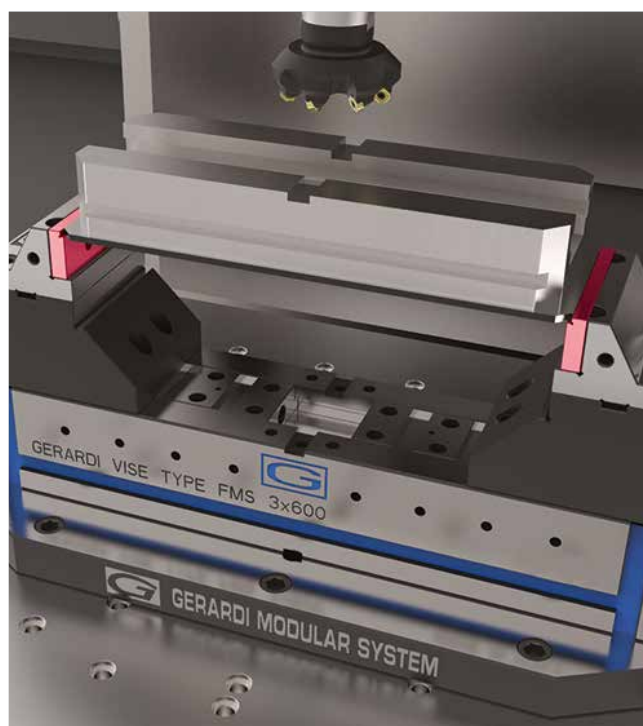
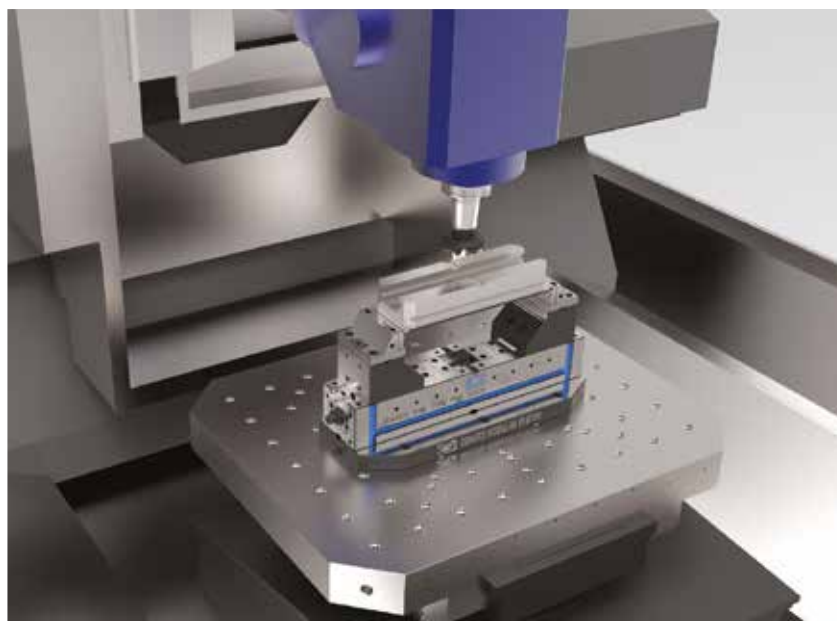
Art.868 FMS series

Grazie all'estrema versatilità del sistema modulare Gerardi anche le morse FMS, adeguatamente riconfigurate, possono rientrare nella cosiddetta 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

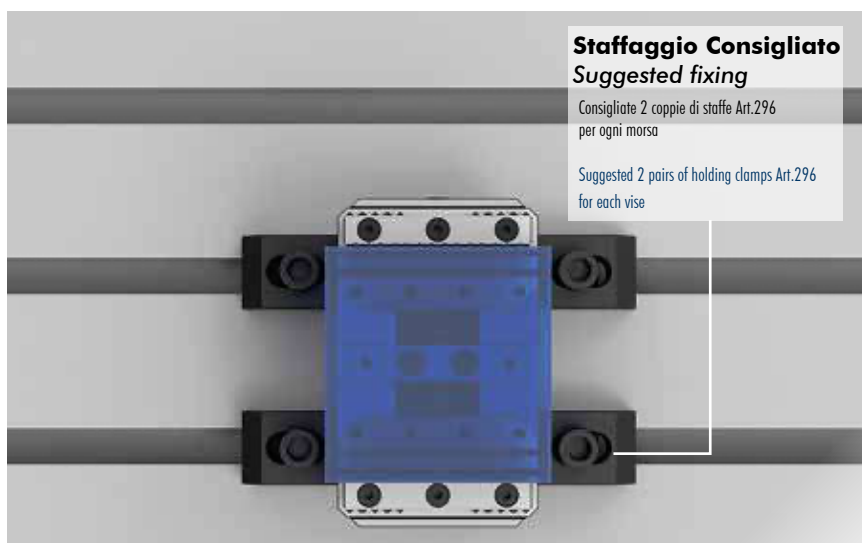


Esempio d'ordine per morsa tipo 3 su macchina con cave a T da 18mm: Art.296 T.3 X=18mm

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

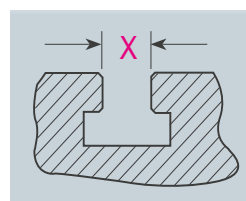
Also with code: 2.29.6100 X=18mm



Staffaggio Consigliato Suggested fixing

Consigliate 2 coppie di staffe Art.296
per ogni morsa

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

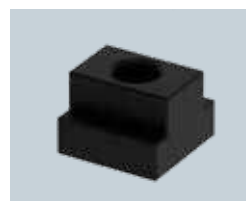


Cava a T

T Slot

Specificare sempre la cava
della vostra macchina

Always specify the
machine T-slot dimension

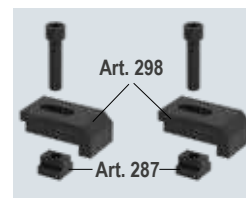


Art.287 (Pag.4.34)

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)

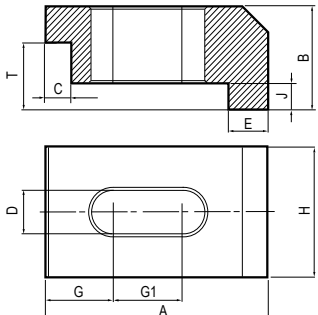
Consigliate 2 coppie di staffe Art.296
per ogni morsa

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

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



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

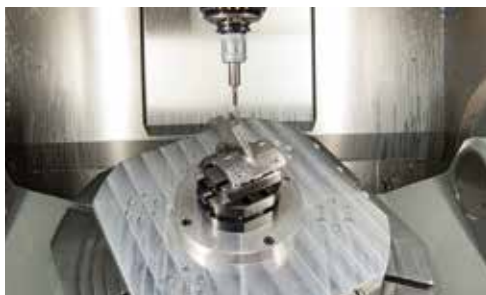
* Scelta NON consigliata - NO Suggested choice

Soluzioni personalizzate / Customized solutions

4th & 5th Axis

Soluzioni personalizzate a tutti i vostri problemi di serraggio

Customized solutions for all your clamping problems

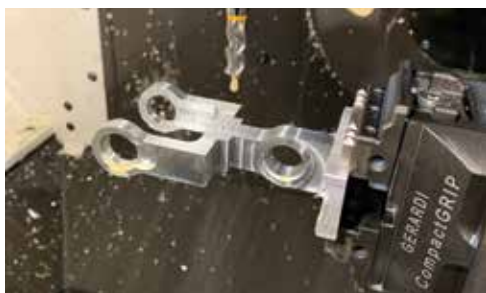


Morsa Multitasking su centro a 5 assi

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 morsa CompactGrip Art.650

Milling machining operations on a five axis machining center with CompactGrip vises Art.650



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 morsa 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

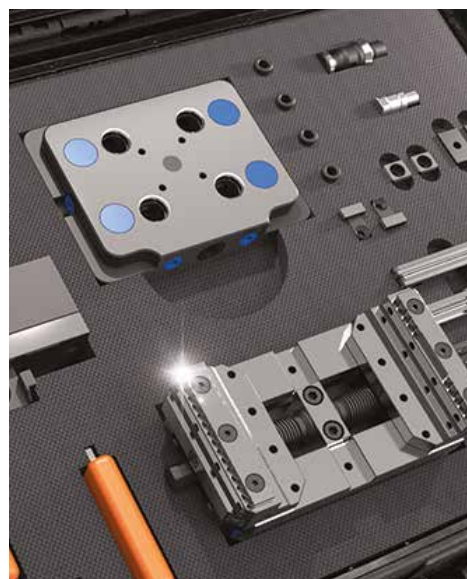
Art. 986



Morsa / Vise Art. 650

Cod. 0.98.60000

Art. 650 - All'Interno - Inside:



SIMBOLOGIA DATI TECNICI

TECHNICAL DATA ICONS

GANASCE JAWS						POSSIBILITÀ POSSIBILITY						
	Morse Multitasking vises	Morse Compact Grip vises	Morse Compact Grip Art. 950 vises	Morse Grip Matic vises	Sistema a coda di rondine Dove Tail fixtures					Montaggio con centralina Mounting with power unit	Lavorazioni a 5 assi 5 axis machining	Predisposizione Zero Point Zero Point Ready
PIASTRE GANASCE JAW PLATES						PAGINE PAGES						
		Liscio + Ruvido Smooth + Rough	Coda di Rondine Dove Tail	GRIP GRIP	Frontali Frontal		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.	Lavorazione extra Extra machining	Cod.
AGGIUNTA di un foro calibrato ADDITION of a calibrated hole	MAN-010-FMS	MONTAGGIO SEMPLICE SIMPLE ASSEMBLY	MAN-060-FMS
AGGIUNTA di una chiave calibrata ADDITION of a calibrated key-way	MAN-020-FMS	MONTAGGIO ed ALLINEAMENTO (Standard) (Standard) ASSEMBLY and ALIGNMENT	MAN-070-FMS
PREDISPOSIZIONE SEMPLICE SIMPLE SET UP	MAN-030-FMS	MONTAGGIO VERTICALE COMPLETE VERTICAL ASSEMBLY	MAN-080-FMS
PREDISPOSIZIONE & MONTAGGIO COMPLETO COMPLETE SET UP & MOUNTING	MAN-040-FMS	ALLINEAMENTO e CONTROLLO tramite DEA ALIGNMENT and CONTROL by DEA \ CMM	MAN-090-FMS
MONTAGGIO PARZIALE PARTIAL ASSEMBLY	MAN-050-FMS	TABULATO controllo DEA PRINTOUT DEA control	MAN-100-FMS

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