

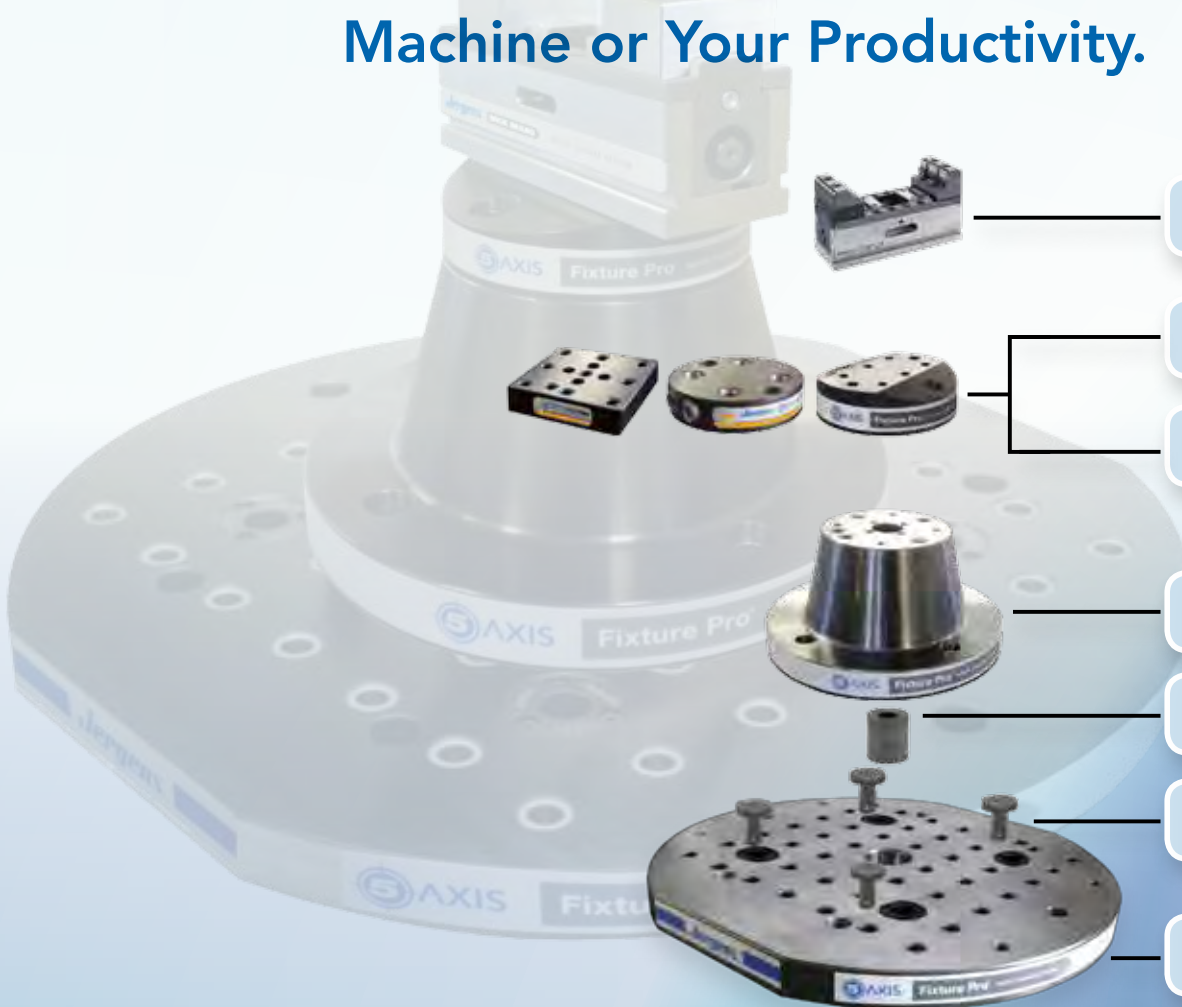
Jergens®

MANUFACTURING EFFICIENCY

FIXTURE PRO® 5-AXIS QUICK CHANGE FIXTURING



No Limits...On Your 5-Axis
Machine or Your Productivity.



Vises

Pallet Changers

Adapter Plates

Risers

Locating Pins

Ball Lock® Shanks

Subplates



Jergens Workolding Solutions Group... your Uptime Consultants

To compete in today's global industry you need to accommodate shorter lead times, smaller batch sizes and frequent set up changes.

Get more savings by changing what's UNDER the spindle, not ON it.

Shave 90% from your set up times by implementing a quick change fixturing system for a fraction of the cost of your cutting tool investment. Jergens' workholding efficiency improvement process helps:

- Increase spindle uptime
- Speed implementation of lean manufacturing
- Improve productivity
- Optimize workholding
- Reduce downtime
- Maximize cost savings
- Eliminate setup errors and inefficiencies
- Faster part-to-part changeover



"The applications of the Ball Lock® System are basically limitless - you're completely free from the design limitations of common tooling. We have increased utilization rates 75% - 90%."

Jergens Ball Lock® Customer

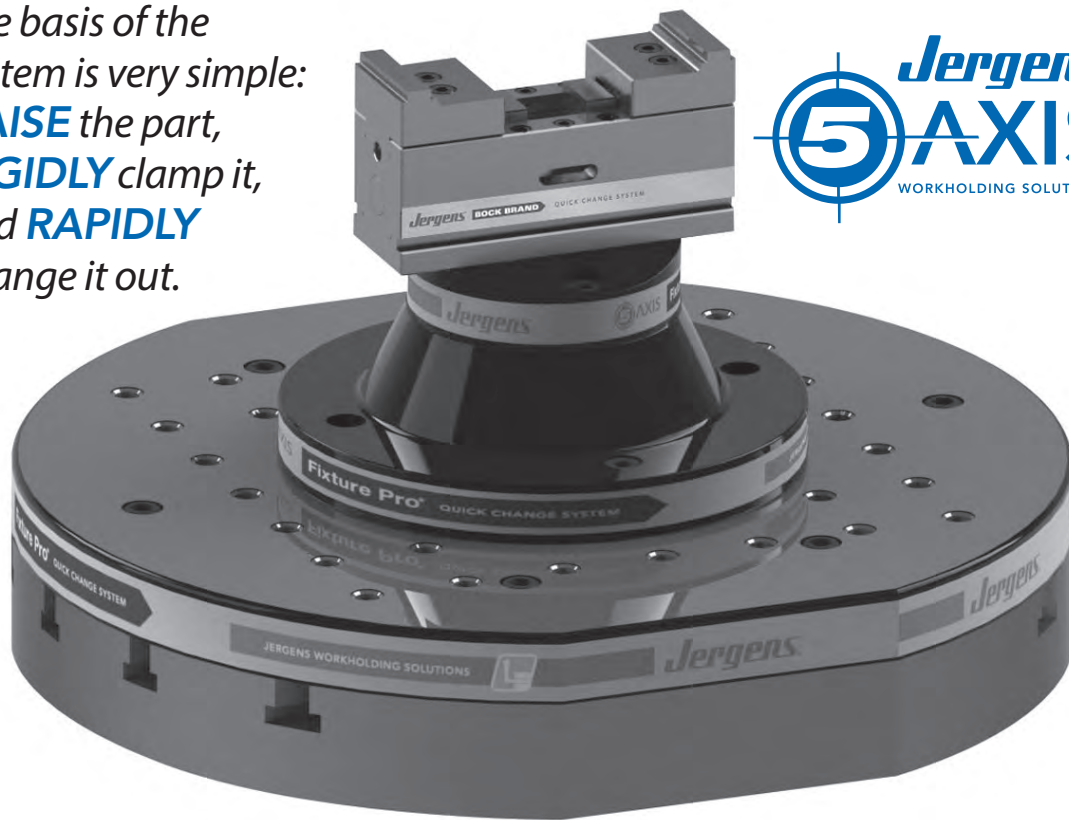


Maximize the Benefits of Your 5-Axis Machine

Getting your spindle and cutting tool close to the workpiece without running into obstructions is a challenge on a 5-axis machine. Jaws and other vise components, and even the machine table itself, can restrict your access and prevent you from machining multi-sided parts. Your only choice is stopping the machine and repositioning your part...

...until now.

The basis of the system is very simple: **RAISE** the part, **RIGIDLY** clamp it, and **RAPIDLY** change it out.



Jergens' unique modular system features a variety of riser sizes and styles to get your part off the table and allow unrestricted access. This system was built with rigidity in mind, from uniquely designed pull studs to 5-axis vises and dovetail clamps. This added rigidity helps maintain accuracy, even in your most aggressive roughing and finishing operations.

Best of all, you can integrate this system with our best-selling Ball Lock® Mounting System, for quick change capabilities even at the subplate level.



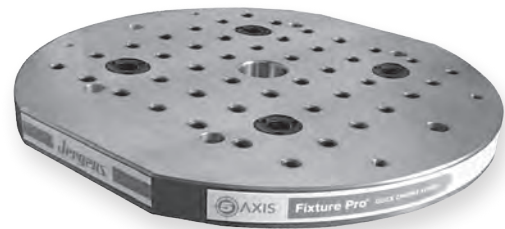
QUICK CHANGE FIXTURING » FIXTURE PRO® 5-AXIS QUICK CHANGE FIXTURING



SYSTEM FEATURES & BENEFITS

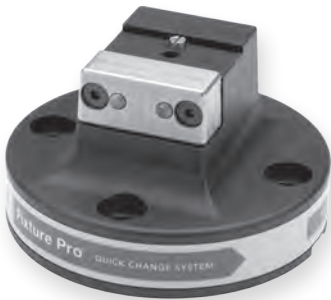
Modular approach designed for 5-axis machining

- Unrestricted access to the part
- Extremely customizable to your application



Uniquely designed pull studs and vises with high clamping forces

- Added rigidity for aggressive operations
- Higher cutting rates



Quality construction – Components made from high strength steel and aluminum

- Long life & durability



Integration of unique quick change elements at virtually every level of your setup

- Complete part to part changeover in under 60 seconds
- Maximizes your machine table
- Provides additional productivity gains

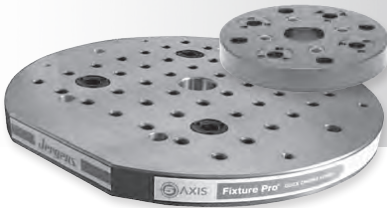




How Does It Work?

STEP 1: KNOW YOUR MACHINE TABLE

Jergens' 5-Axis Quick Change Fixturing System provides incredible flexibility. The Fixture Pro® System can mount to any machine or rotary table. Contact Jergens customer service at 877-426-2504 to help you select the components for your application.

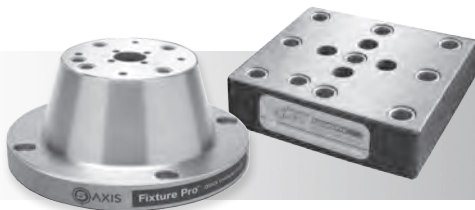
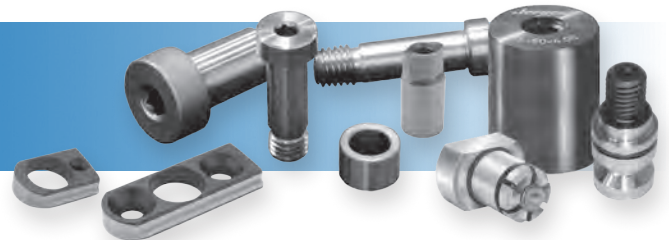


STEP 2: SELECT YOUR SUBPLATE

Subplates can be configured with either the Ball Lock® Mounting System or the QLS for quick fixture changeover at the subplate level.

STEP 3: SELECT YOUR MOUNTING COMPONENTS

- Center locating pins
- Timing pins
- QLS bolts
- Locating Keys



STEP 4: SELECT YOUR RISER, TOP PLATES AND MINI PALLET

Get your part off the table and allow tool clearance by selecting the right riser for your application. Rectangle, square, cone and mini risers are available in a variety of sizes. Adapter plates and the patent pending Drop & Lock™ Pallet Changer allow for lightning fast part to part changeover.



STEP 5: SELECT YOUR TOP TOOLING

Choose from a variety of incredibly strong clamping products, from dovetail vises to self-centering vises specially designed for 5-axis workholding applications.



5-Axis Vise or Dovetail Vise



Quick Change Element! Drop & Lock™ Pallet Changer

You can use a simple adapter plate instead of the Drop & Lock™ Pallet Changer



Choose from a range of risers



Accessories and hardware help you customize



Quick Change Element! Choose from a variety of standard subplates. Configure with Ball Lock® or QLS for quick change capabilities at the subplate level.

Feature Focus: The Drop & Lock™ Pallet Changer

Simply install 2 or 4 pull studs into the bottom of your fixture or vise and literally drop it into the pallet changer. In less than two quick turns of a hex wrench, you can switch out your workpiece without re-indicating.

Drop it, lock it, and go!

Install pull studs into your fixture or vise.

Drop your fixture or vise into the Vise Adapter.

Two quick turns of a hex wrench and you're ready to machine. No re-indicating!



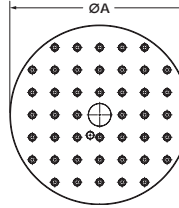


5-Axis Subplates

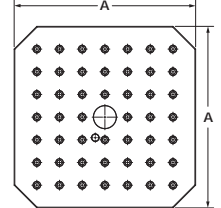
- Material: 1018 Steel
- Thickness Tolerance ± 0.005
- Flat & Parallel within .0005"/Ft. (.013mm)
- Subplates do not include mounting holes
- Includes Pre-Installed QLS Bushings



Round



Square



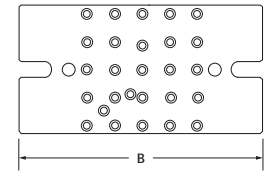
Part Number	Style	A (mm)	B (mm)	Thickness of Subplate (mm)	Locating	Mounting Type	Mounting Grid	Weight lbs (Kgs)
5SP130	Round	130	130	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	6.3 (2.86)
5SP160	Round	160	160	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	10.36 (4.7)
5SP210	Round	210	210	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	18.83 (8.54)
5SP250	Round	250	250	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	26.5 (12)
5SP310	Round	310	310	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	41.89 (19)
5SP400	Round	400	400	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	70.44 (31.95)
5SP500	Round	500	500	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	110.9 (50.3)
5SP630	Round	630	630	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	176.8 (80.2)
5SP800	Round	800	800	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	296.3 (134.4)

Part Number	Style	A (mm)	B (mm)	Thickness of Subplate (mm)	Locating	Mounting Type	Mounting Grid	Weight lbs (Kgs)
5SP400S	Square	400	400	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	88 (39.9)
5SP500S	Square	500	500	35	Center (50H7), Timing Pin	12mm SHCS	12mm x 50mm	139.3 (63.2)

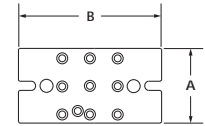
Part Number	Style	A (mm)	B (mm)	Thickness of Subplate (mm)	Locating	Mounting Type	Mounting Grid	Weight lbs (Kgs)
5QP130020	VMC	130	250	35	Center (12mm), Timing Pin	12mm SHCS	12mm x 50mm	19.86 (9.01)
5QP250020	VMC	250	340	35	Center (12mm), Timing Pin	12mm SHCS	12mm x 50mm	51.75 (23.47)



VMC 250mm



Used for mounting risers & other Fixture Pro® items to a Vertical Machining Center



VMC 130mm

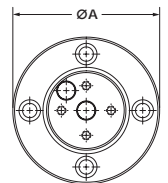
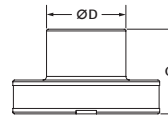
5-Axis Risers, Mini & Barbell Style – Steel or Aluminum

Fixture Pro® 5-Axis Risers raise, position and locate the part off the machine or rotary table so the part is accessible for machining all 5 sides. Mounts to tables with Sine Fixture Keys, Fixture Pro® Machine Keys, SHCS or QLS Grids.

- Material: 1018 Steel
- Thickness Tolerance ± 0.002 (.05mm)
- Flat & Parallel within: .0005"/Ft. (.013mm)
- Finish: Black Oxide or Aluminum



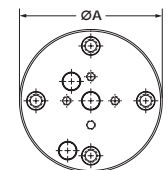
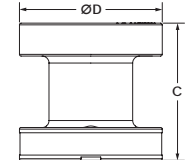
Aluminum Mini



Mini Risers – Designed for use with small pallet machine tools and the 75mm platform top tooling.



130mm Barbell



250mm Barbell

Part Number		Style	A (mm)	B (mm)	C (mm)	D (mm)	Locating Keyway, Timing Pin	Mounting Type	Mounting Grid	Weight lbs (Kgs)	
Steel	Aluminum									Steel	Aluminum
5RS130001	5RS130004	Mini	130	—	75	70.3	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	8.21 (3.72)	2.84 (1.29)
5RS130002	5RS130005	Barbell Low	130	—	75	130	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	12.82 (5.82)	4.44 (2.01)
5RS130003	5RS130006	Barbell Tail	130	—	125	130	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	16.8 (7.62)	5.82 (2.64)
5RS250001	5RS250005	Barbell Low	250	—	75	250	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	88.6 (40.2)	20.5 (9.3)
5RS250002	5RS250006	Barbell Tail	250	—	125	250	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	93.3 (42.3)	25.34 (11.5)

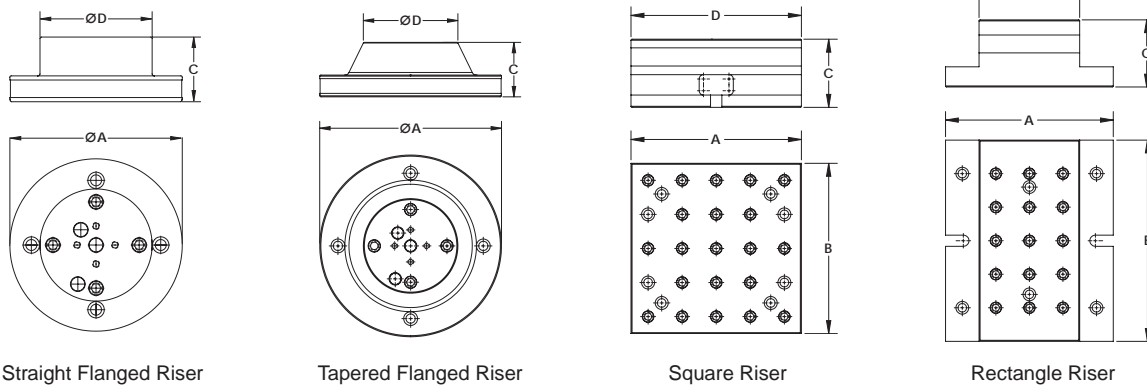
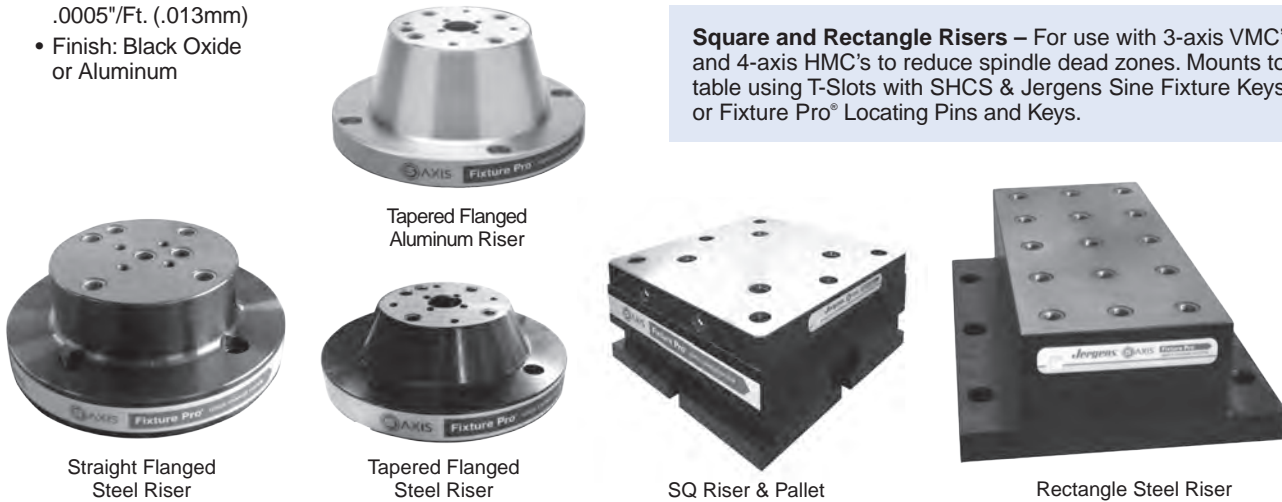


5-Axis Risers, Flanged, Rectangle or Square Style – Steel or Aluminum

Fixture Pro® 5-Axis Risers raise, position and locate the part off the machine or rotary table so the part is accessible for machining all 5 sides. Mounts to tables with Sine Fixture Keys, Fixture Pro® Machine Keys, SHCS or QLS Grids.

- Material: 1018 Steel
- Thickness Tolerance ± 0.002 (.05mm)
- Flat & Parallel within: .0005"/Ft. (.013mm)
- Finish: Black Oxide or Aluminum

Square and Rectangle Risers – For use with 3-axis VMC's and 4-axis HMC's to reduce spindle dead zones. Mounts to table using T-Slots with SHCS & Jergens Sine Fixture Keys, or Fixture Pro® Locating Pins and Keys.



Part Number		Style	A (mm)	B (mm)	C (mm)	D (mm)	Locating Keyway, Timing Pin	Mounting Type	Mounting Grid	Weight lbs (Kgs)	
Steel	Aluminum									Steel	Aluminum
5RS250003	5RS250007	Tapered Flanged	250	—	75	130	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	36.8 (16.7)	12.75 (5.78)
5RS250004	5RS250008	Tapered Flanged	250	—	125	130	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	53.2 (24.1)	18.42 (8.36)
5RS150001	5RS150002	Rectangle	250	300	100	150	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	87.0 (39.5)	30.67 (13.9)
5RS250009	5RS250010	Square	250	250	100	250	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	77.3 (35.1)	28.0 (12.7)

Rotary Table Risers

Part Number		Style	A (mm)	B (mm)	C (mm)	D (mm)	Locating Keyway, Timing Pin	Mounting Type	Mounting Grid	Weight lbs (Kgs)	
Steel	Aluminum									Steel	Aluminum
5RS200007*	5RS200010*	Straight Flanged	200	—	75	130	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	24.0 (10.9)	8.4 (3.8)
5RS200008*	5RS200011*	Straight Flanged	200	—	125	130	Center (50H7)	QLS, 12mm SHCS	12mm x 50mm	36.0 (16.4)	12.4 (5.6)

* 200mm risers are designed to work with rotary tables. If intended for use on Fixture Pro® subplates, 4 extra mounting holes are needed. Call 877-426-2504 for assistance.

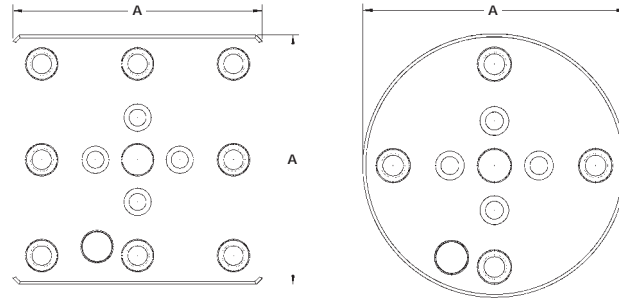
QUICK CHANGE FIXTURING » FIXTURE PRO® 5-AXIS QUICK CHANGE FIXTURING



5-Axis Riser Top Plates



Convert the riser into a QLS grid for precision mounting of any workholding fixture, including the entire family of Fixture Pro® Top Tooling. Available in square or round styles.

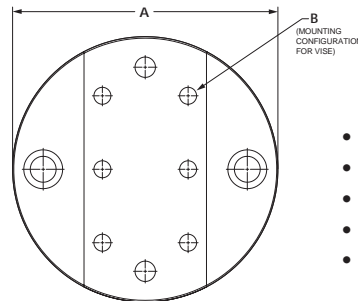


- Material: 1018 Steel
- Thickness Tolerance ± 0.005 (.13mm)
- Flat & Parallel within: .0005"/Ft. (.013mm)
- Includes: Hardened Bushings

Part Number	Style	A (mm)	Thickness of Plate (mm)	Locating	Mounting Type	Mounting Grid	Weight lbs (Kgs)
5TP130002	Round	130	35	Center, Timing Pin	8mm SHCS	12mm x 50mm	7.09 (3.22)
5TP250002	Round	250	35	Center, Timing Pin	8mm SHCS	12mm x 50mm	27.02 (12.26)
5TP130001	Square	130	35	Center, Timing Pin	8mm SHCS	12mm x 50mm	8.97 (4.07)
5TP250001	Square	250	35	Center, Timing Pin	8mm SHCS	12mm x 50mm	34.81 (15.79)

5-Axis Vise Adapter Plates

Convert the Jergens 5-axis vise into a QLS grid for precision mounting of any Fixture Pro® modular system part that requires a match with the QLS grid.



- Material: 1018 Steel
- Thickness Tolerance ± 0.005 (.13mm)
- Flat & Parallel within: .0005"/Ft. (.013mm)
- Includes: Hardened Bushings
- Vise Adapter Pin Required 5LP25M10

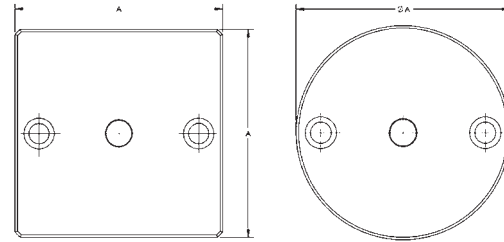
Part Number	Style	A (mm)	B (Vise Part. No.)	Thickness of Plate (mm)	Locating	Mounting Type	Mounting Grid	Weight lbs (Kgs)
5VA130001	Round	130	80000, 80400	35	QLS, Dowel Pin	12mm SHCS	12mm x 50mm	6.9 (3.1)
5VA250001	Round	250	80100	35	Center, Timing, QLS	12mm SHCS	12mm x 50mm	27 (12.2)
5VA130002	Round	130	80000, 80400	35	Quick Change Stud	20mm QCS	60mm x 60mm	7.4 (3.4)
5VA250002	Round	250	80100	35	Quick Change Stud	20mm QCS	120mm x 120mm	27.5 (12.5)

Vise Locator Adapter Pin 5LP25M10 Available. Please call 877-426-2504 for more information.

5-Axis Blank Fixture Plates



Mount fixtures that already have mounting holes that do not match the QLS grid. Available in round and square styles.



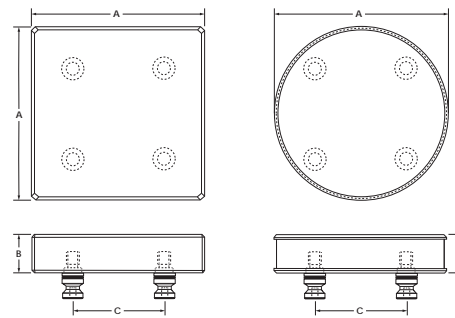
- Material: 1018 Steel
- Thickness Tolerance ± 0.005 (.13mm)
- Flat & Parallel within: .0005"/Ft. (.013mm)
- Includes: Hardened Bushings

Part Number	Style	A (mm)	Thickness of Plate (mm)	Locating	Mounting Type	Weight lbs (Kgs)
5FP130002	Round	130	35	Center, Timing Pin	12mm SHCS	7.41 (3.36)
5FP250002	Round	250	35	Center, Timing Pin	12mm SHCS	28.65 (13)
5FP130001	Square	130	35	Center, Timing Pin	12mm SHCS	9.62 (4.36)
5FP250001	Square	250	35	Center, Timing Pin	12mm SHCS	36.78 (16.68)

5-Axis Machinable Blanks



Designed for 2nd operation machining. Blanks can be machined to accept parts and clamping systems.



- Material: 1018 Steel/6061 Aluminum
- Thickness: ± 0.005 (.13mm)
- Includes: Hardened Bushing
- Pull Studs Included

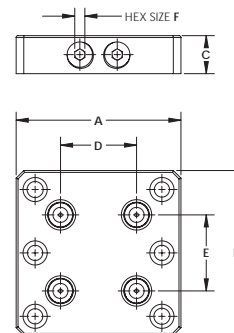
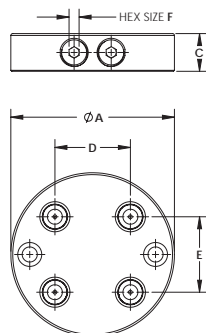
Steel Part Number	Aluminum Part Number	Style	A (mm)	B (mm)	C (mm)	Locating	Mounting Type	Mounting Grid	Weight Steel (lbs/kg)	Weight Alum (lbs/kg)	Pull Stud Size	Pull Stud Part Number
5MB130002	5MB130004	Square	130	35	60	Quick Change Studs	20mm QCS	60mm x 60mm	9.9 (4.5)	3.4 (1.6)	20	5QP020
5MB130003	5MB130005	Round	130	35	60	Quick Change Studs	20mm QCS	60mm x 60mm	7.7 (3.5)	2.7 (1.2)	20	5QP020
5MB130006	-	Square	130	75	60	Quick Change Studs	20mm QCS	60mm x 60mm	21.6 (9.8)	-	20	5QP020
-	5MB130007	Square	130	130	60	Quick Change Studs	20mm QCS	60mm x 60mm	-	13.0 (5.9)	20	5QP020
5MB160002	5MB160004	Square	160	35	60	Quick Change Studs	20mm QCS	60mm x 60mm	15.2 (6.9)	5.2 (2.4)	20	5QP020
5MB160003	5MB160005	Round	160	35	60	Quick Change Studs	20mm QCS	60mm x 60mm	11.8 (5.4)	4.1 (1.8)	20	5QP020
5MB210002	5MB210004	Square	210	35	60	Quick Change Studs	20mm QCS	60mm x 60mm	26.3 (11.9)	9.1 (4.1)	20	5QP020
5MB210003	5MB210005	Round	210	35	60	Quick Change Studs	20mm QCS	60mm x 60mm	20.6 (9.3)	7.1 (3.2)	20	5QP020
5MB210006	5MB210008	Square	210	35	120	Quick Change Studs	20mm QCS	120mm x 120mm	26.3 (11.9)	9.1 (4.1)	20	5QP020
5MB210007	5MB210009	Round	210	35	120	Quick Change Studs	20mm QCS	120mm x 120mm	20.6 (9.3)	7.1 (3.2)	20	5QP020
5MB250002	5MB250004	Square	250	35	120	Quick Change Studs	20mm QCS	120mm x 120mm	37.4 (17.0)	12.9 (5.9)	20	5QP020
5MB250003	5MB250005	Round	250	35	120	Quick Change Studs	20mm QCS	120mm x 120mm	29.3 (13.3)	10.1 (4.6)	20	5QP020
5MB310002	5MB310004	Square	310	35	120	Quick Change Studs	20mm QCS	120mm x 120mm	57.7 (26.2)	19.9 (9.0)	20	5QP020
5MB310003	5MB310005	Round	310	35	120	Quick Change Studs	20mm QCS	120mm x 120mm	45.2 (20.5)	15.6 (7.1)	20	5QP020

QUICK CHANGE FIXTURING » FIXTURE PRO® 5-AXIS QUICK CHANGE FIXTURING



5-Axis Drop & Lock™ Pallet Changer

Mount parts or fixtures quickly to a machine. Available in Round and Square styles. Drop a Fixture or Vise into the Pallet Changer using the Fixture Pro® pull stud system. With two quick turns of a hex wrench it's ready to machine. Drop it, Lock it, and go!



- Material: A2 Steel
- Hardness: 58-62 Rc
- Flatness: Ground .0002"/Ft.
- Thickness Tolerance: ±0.002
- Finish: Black Oxide

Pull Studs

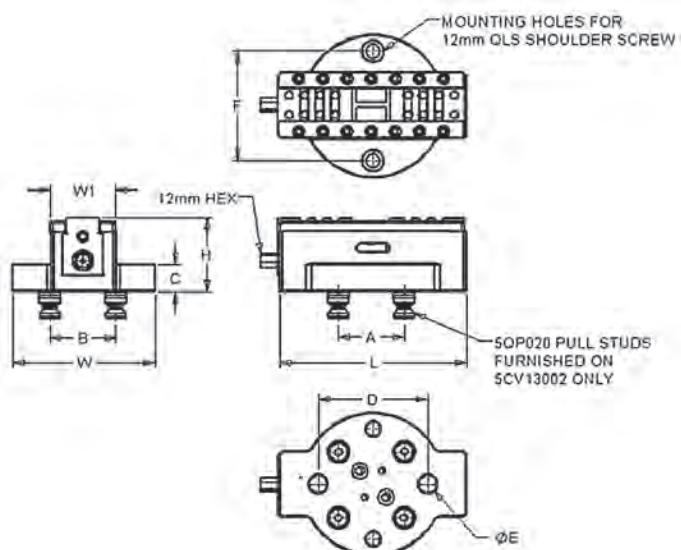
Adapt any machinable part or fixture directly to the part. Use with our quick change Drop & Lock™ Pallet Changer.



- Material: A2 Steel
- Hardness: 50-54 Rc

Part Number	Style	Configuration of Pins	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	Hex Size F (mm)	Locating	Mounting Type	Weight lbs (Kgs)	Pull Stud	
												Size (mm)	Part Number
5QP130002	Round	4	130	—	30	60	60	8	Center, Timing Pin, QLS	QLS, 12mm SHCS	5.8/2.6	20	5QP020
5QP250002	Round	4	250	—	30	120	120	8	Center, Timing Pin, QLS	QLS, 12mm SHCS	23.9/10.8	20	5QP020
5QP130001	Square	4	130	130	30	60	60	8	Center, Timing Pin, QLS	QLS, 12mm SHCS	7.2/3.3	20	5QP020
5QP250001	Square	4	250	250	30	120	120	8	Center, Timing Pin, QLS	QLS, 12mm SHCS	30.4/13.8	20	5QP020
5QP130003	Round	2	130	—	30	60	60	8	Center, Timing Pin, QLS	QLS, 12mm SHCS	6.0/2.7	20	5QP020
5QP130004	Square	2	130	130	30	60	60	8	Center, Timing Pin, QLS	QLS, 12mm SHCS	7.6/3.5	20	5QP020

Self Centering 60mm Vise



Part Number	Pull Studs	Size	Clamping Force (kN/Torque Nm)	Weight (Kg)	L (mm)	W (mm)	H (mm)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)
5CV13001	—	60mm	15/50	5.6	170	130	67.6	60	60	25	100	16	100
5CV13002	4 Included	60mm	15/50	5.6	170	130	67.6	60	60	25	100	16	100



5-Axis Top Tooling – 130mm Dovetail Vises



Light Duty



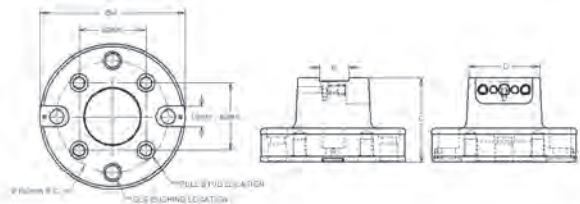
Heavy Duty

Mounts directly to a rotary table, Fixture Pro® Riser or any QLS Grid. Reduces distortion of parts. Requires 0.060" or less material to clamp.

Cutting a 10° angle cut in the bottom surface of a machinable part allows for extremely high clamping forces while leaving all 5 sides accessible. The heavy duty 130mm version has higher torque and tilting moments than the standard 130mm Fixture Pro® Dovetail Vise.

Dovetail cutter (part number 5DC3) available.

- Material: 1018 Steel
- Flat & Parallel within: .002"/Ft. (.05mm)
- Includes: Hardened Bushings
- Includes Center Locator Pin



Part Number	Pull Studs	Description	A (mm)	B (mm)	C (mm)	D (mm)	Locating	Mounting Type	Mounting Grid	Weight lbs (Kgs)	Dovetail Cutter P/N
5DV130002	—	130mm L.D. Dovetail Vise, Steel	130	25	75	50	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	7.36 (3.34)	5DC3
5DV130003	—	130mm H.D. Dovetail Vise, Steel	130	25	75	65	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	7.21 (3.27)	5DC3
5DV130004	4 Included	130mm H.D. Dovetail Vise, Steel	130	25	75	65	Center, Timing Pin, QLS (& Quick Change Stud)	12mm SHCS (& 20mm QCS)	12mm X 50mm (60mm X 60mm)	6.2 (2.8)	5DC3

5-Axis Top Tooling – Block Dovetail Vises



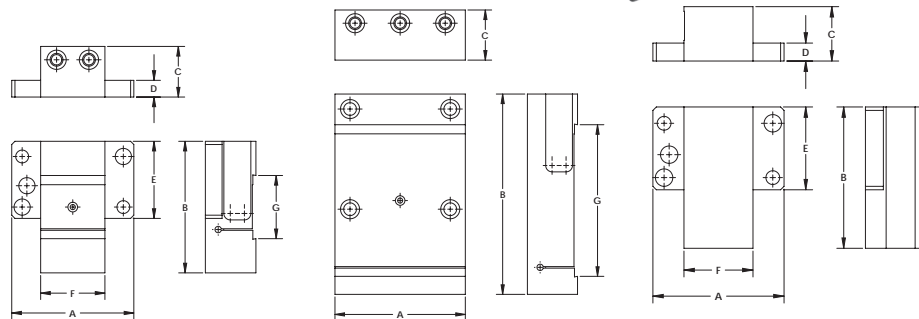
Mounts directly to a rotary table, Fixture Pro® Riser or any QLS Grid. Reduces distortion of parts. Requires 0.060" or less material to clamp.

By cutting a 10° angle cut in the bottom surface of a machinable part it allows for extremely high clamping forces while leaving all 5 sides accessible.

Dovetail cutter (part number 5DC3) available.



- Material: 1018 Steel
- Flatness: .002"/Ft.
- Flat & Parallel within: .002"/Ft. (.05mm)
- Includes: Hardened Bushings



See additional 5-Axis top tooling on pages 122–133

Part Number	Description	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	Locating	Mounting Type	Mounting Grid	Weight lbs (Kgs)	Dovetail Cutter P/N
5DV200	Dovetail Pre-Cut Vise, Steel	120.7	130	50	16.5	76.2	63.5	62.5	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	7.4 (3.3)	5DC3
5DV400	Dovetail Pre-Cut Vise, Steel	120.7	130	50	16.5	76.2	63.5	100.6	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	7.2 (3.3)	5DC3
5DV600	Dovetail Pre-Cut Vise Steel	130	200	50	15.4	—	—	15.4	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	19.7 (8.9)	5DC3
5MB250	Machinable Blank Steel	120.7	130	50	16.5	76.2	63.5	—	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	8.0 (3.6)	5DC3

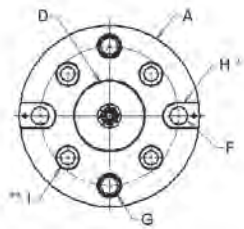
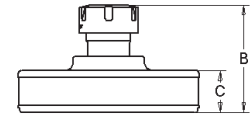


5-Axis ER Collet Fixtures

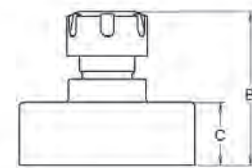
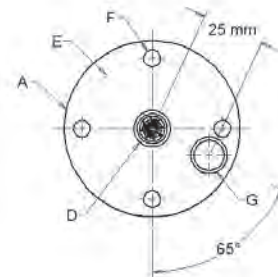


- Hardened alloy steel
- Excellent workholder for cylindrical parts
- Use with your existing ER Collets
- Direct interface with other Jergens Fixture-Pro® products
- Optional mounting styles available

ER130 Series



ER70 Series



Part Number	Collet Size	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	Wt. lbs. (kg)	Tightening (ft/lbs) over/under 1/16" (2 mm) Collets ID
5ER07001	16	70	61.0	25	12	56	M6	12	N/A	N/A	1.9 (0.9)	42/30
5ER07002	20	70	61.9	25	12	56	M6	12	N/A	N/A	1.9 (0.9)	59/24
5ER07003	25	70	62.4	25	12	56	M6	12	N/A	N/A	2.1 (0.9)	77/77
5ER13001	25	130	77.0	30	50	100	M12	12	18	20	6.3 (2.9)	77/77
5ER13002	32	130	78.0	30	50	100	M12	12	18	20	6.7 (3.0)	100/100
5ER13003	40	130	80.0	30	50	100	M12	12	18	20	7.3 (3.3)	130/130



Please call 877-426-2504 for special order of Multi-Platform Fixture



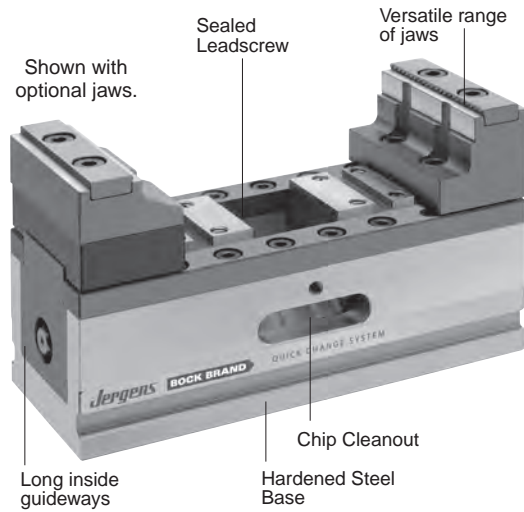
5-Axis Self Centering Vises

This series is suitable for many clamping tasks on 5-Axis machining centers and pallet systems. Whether the workpieces are angular or round, the concentric clamping system provides the same zero position.

The compact design, high stability and versatile selection of jaws (grip jaws, plain jaws, soft jaws, pendulum jaws, V-Type jaws) are additional features tailored for 5-Axis machining.

The 40, 60, 100 and 125 clamping systems are suitable for I.D. to O.D. clamping.

- Designed for 5-Axis machining
- Free access to the workpiece, allowing the use of short standard tools
- Simple, robust construction, smooth surfaces for easy cleaning
- Also suitable as a module for standard devices
- Comprehensive jaw selection



Customized design for positioning and fastening in the base on request.

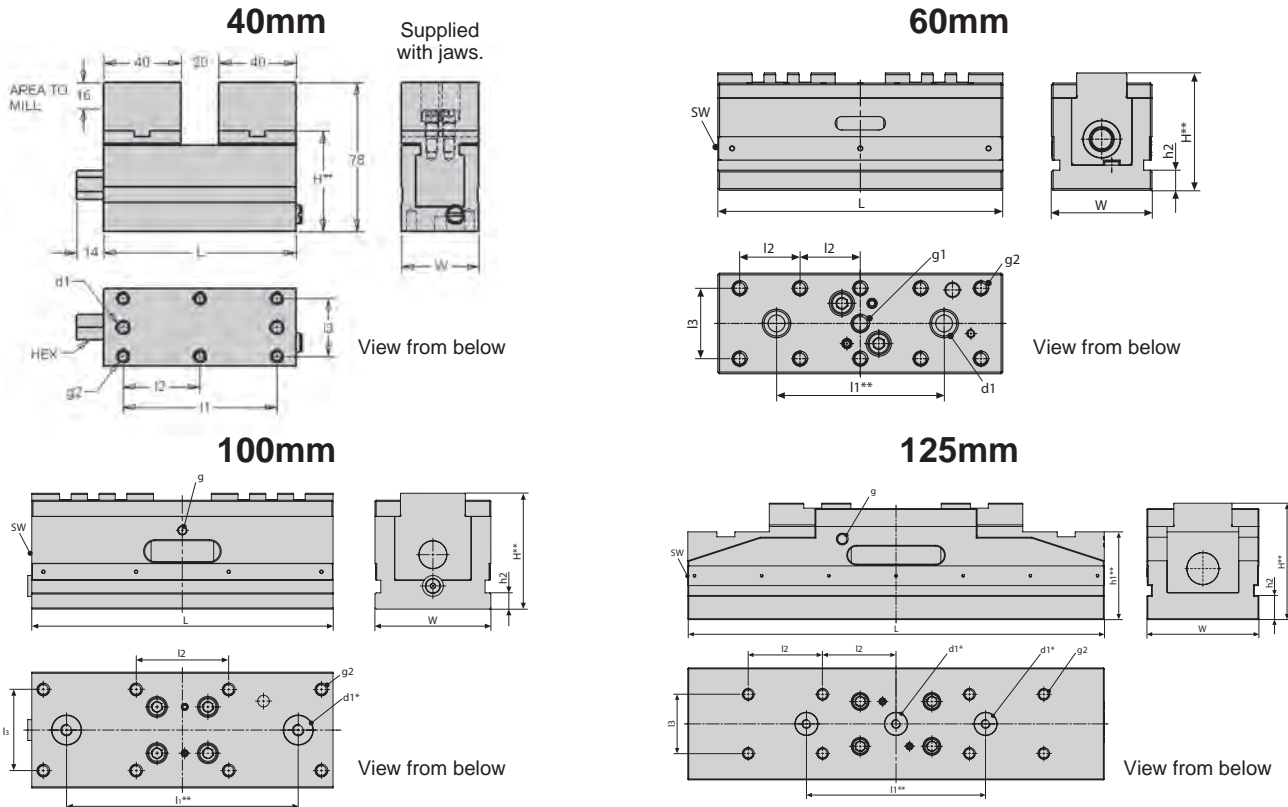
Part Number	Size	Clamping Force* (kN/Torque Nm)	Weight (Kg)	Dimensions (mm)											Hex (mm)		
				L	W	H**	d1*	g	g1	g2	h1**	h2	l1*	l2		l3	
81600	40mm	7.5 / 23	2.0	100	40	53	6H7 x8	-	-	M6 x 8	-	-	80	40.0	30	13	Male
80000	60mm	15 / 50	3.8	170	60	70	10F7	-	M10 x 11	M8 x 12	-	12	100	36.0	42	12	Male
80100	100mm	25 / 80	18.0	260	100	100	25 x 5/ M10 x 14	M8 x 11	-	M10 x 14	-	14	200	80.0	70	14	Male
80200	125mm	35 / 200	49.0	465	125	130	25 x 5/ M10 x 14	M12 x 16	-	M12 x 16	98	27	200	82.5	66	19	Male

Note: Vise handles included with each Jergens 5-Axis Vise

* kN x 224.8=pound - force Nm x 8.85=in. lbs Kg x 2.205=lbs Bar x 14.5=psi

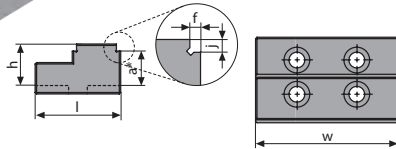
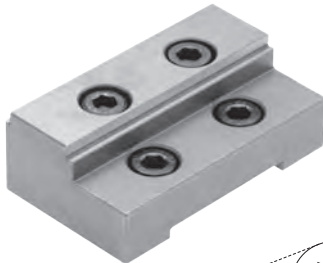
* Tolerance ±0.01mm

** Tolerance ±0.02mm



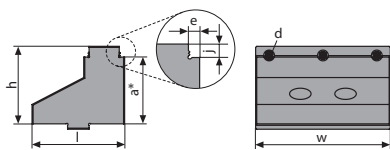


5-Axis Self Centering Jaws



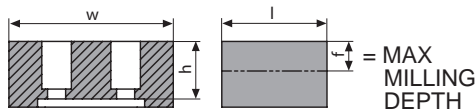
Reversible step jaw, 2 steps, hardened

Part Number	Vise(s)	Dimensions (mm)						Clamping Range min./max. (mm)
		l	w	h	a*	f	j	
80010	80000	49	60	23	18	3	5	6 – 150
80110	80100	60	100	30	25	3	5	6 – 204



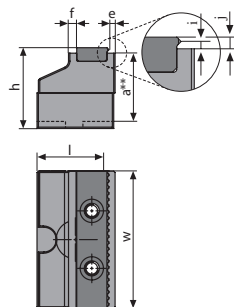
Reversible step jaw with interchangeable grip insert

Part Number	Vise	Dimensions (mm)							Clamping Range min./max. (mm)
		l	w	h	a*	d	e	j	
80210	80200	86	125	72	62	6x d10	5	10	10 – 400



Soft jaw for milling workpiece contours

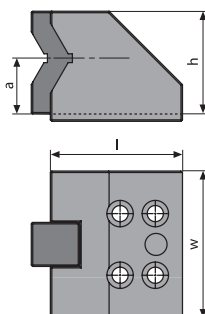
Part Number	Vise(s)	Dimensions (mm)				Material
		l	w	h	f	
80015	80000	42	60	25	8	Steel
80115	80100	64	100	35	18	Steel
80215	80200	88	125	55	32	Steel
80013	80000	53	60	22	8	Aluminum



Pendulum jaw with interchangeable insert, hardened

For safe clamping of one workpiece with non-parallel clamping surfaces or two workpieces with different tolerances.

Part Number	Vise(s)	Dimensions (mm)								Clamping Range min./max. (mm)
		l	w	h	a**	e	f	i	j	
80120	80100	56	100	54	50	4.5	6	2.5	4	12 – 204
80220	80200	88	125	66	62	4.5	6	2.5	4	12 – 400



V-Type jaw with clamping inserts

Part Number	Vise(s)	Dimensions (mm)				Clamping Range min./max. (mm)
		l	w	h	a	
80030	80000	60	60	70	40	D10-76 (1)
80130	80100	64	100	70	38	D12-80 (2)

(1) = D10 – 20, D20 – 58, D58 – 76

(2) = D12 – 26, D25 – 54, D53 – 80

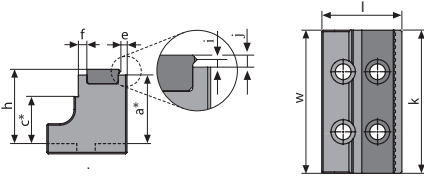
* Tolerance ±0.01mm

** Tolerance ±0.02mm



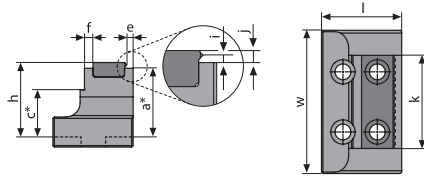
5-Axis Self Centering Step Jaws

Step Jaw with Hardened Jaw Insert (Wide)



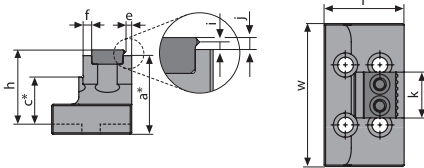
Part Number	Vise(s)	Dimensions (mm)										Clamping Range min./max.
		l	w	h	a*	c*	e	f	i	j	k	
80035	80000	56	60	34	30		4.5	6	2.5	4	60	12 - 126
80135	80100 / 80900	56	100	54	50	35	4.5	6	2.5	4	100	12 - 204
80235	80200	88	125	66	62	42	4.5	6	2.5	4	125	12 - 400

Step Jaw with Hardened Jaw Insert (Medium)



Part Number	Vise(s)	Dimensions (mm)										Clamping Range min./max.
		l	w	h	a*	c*	e	f	i	j	k	
80040	80000	56	60	34	30		4.5	6	2.5	4	35	12 - 126
80140	80100 / 80900	56	100	54	50	35	4.5	6	2.5	4	65	12 - 204
80240	80200	88	125	66	62	42	4.5	6	2.5	4	80	12 - 400

Step Jaw with Hardened Jaw Insert (Narrow)



Part Number	Vise(s)	Dimensions (mm)										Clamping Range min./max.
		l	w	h	a*	c*	e	f	i	j	k	
80145	80100 / 80900	56	100	54	50	35	4.5	6	2.5	4	32	12 - 204

* Tolerance ±0.01mm

5-Axis Self Centering Accessories

Positioning Pins, Various Diameters, for Grid Plate, set of 2



Part Number	Vise(s)	Ø (mm)
80060	80000	10/12
80160	80100 / 80200	25/12
80165	80100 / 80200	25/16

Positioning Pins, Various Diameters, for Table with T-Slots, Set of 2



Part Number	Vise(s)	Ø (mm)
80065	80000	10/14
80260	80100 / 80200	25/14
80265	80100 / 80200	25/18

Torque wrench

Part Number	Vise(s)	Torque (Nm)
80070	80000	5 - 60
80170	80100	20 - 120
80270	80200	40 - 200

Socket

Part Number	Vise(s)	Torque (Nm)
80071	80000	12
80171	80100	14
80271	80200	19

Clamping Claws, Set of 4, Including Screws

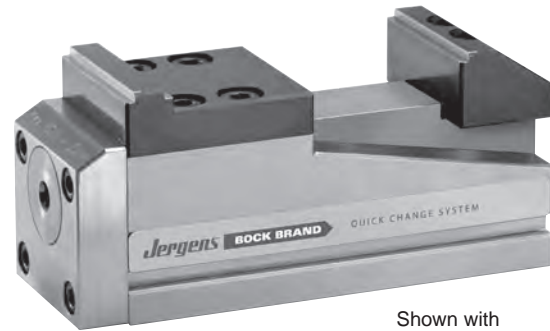
Part Number	Vise(s)	Torque (Nm)
80050	80000	M10
80053	80000	M12
80150	80100	M12
80250	80200	M12
80253	80200	M16



Jergens 5-Axis Fixed Jaw Vise

Designed especially for multi-face machining with a single clamping operation. Ideal for machining complicated workpieces in a single clamping operation, such as in mold making. These vises are small, but have a large holding capacity. A variety of jaw options increase the range of applications. Grip jaws and V-type jaws enhance the retention force of the workpiece. The hydraulic version provides automatic power clamping with exact force.

- Designed for 5-Axis machining
- Free access to the workpiece, allowing the use of short standard tools
- Simple and robust construction, smooth surfaces, easy cleaning
- Also suitable as a module for standard devices
- Comprehensive jaw selection



Shown with optional jaws.

Part Number	Size	Clamping Force* (kN/Torque Nm)	Weight (Kg)	Dimensions (mm)														Hex (mm)
				Stroke	L	W	H**	d1	g	g1	g2	h2	l1**	l2	l3	l4*		
80300	40mm	8.0 / 15 Nm	1.3	—	117	40	44	6H7	M5 x 6	—	M6 x 7	—	80	40	30	10	6 Female	
80400	60mm	15.0 / 25 Nm	3.3	—	168	60	57	10F7	M6 x 10	M10 x 11	M8 x 12	12	100	36	42	17	8 Female	
80500	60mm Hyd	15.0 / 260 bar	3.8	4	185	60	57	10F7	M6 x 10	M10 x 11	M8 x 12	12	100	36	42	17	8 Female	

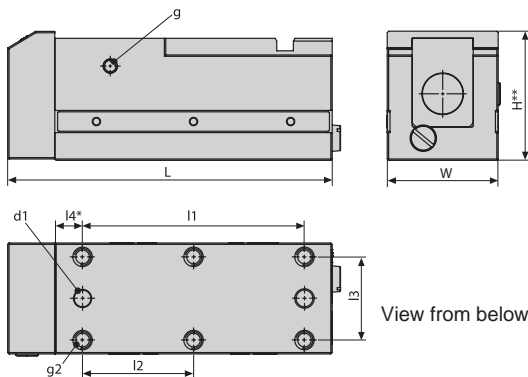
Note: Vise handles included with each Jergens 5-Axis Vise

* kN x 224.8=pound - force Nm x 8.85=in. lbs Kg x 2.205=lbs Bar x 14.5=psi

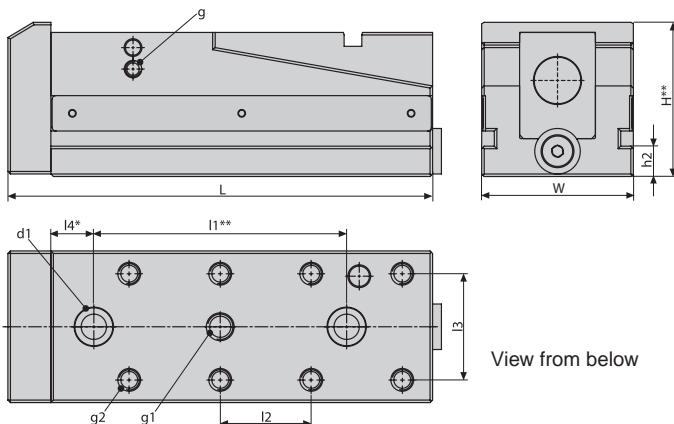
* Tolerance ±0.01mm

** Tolerance ±0.02mm

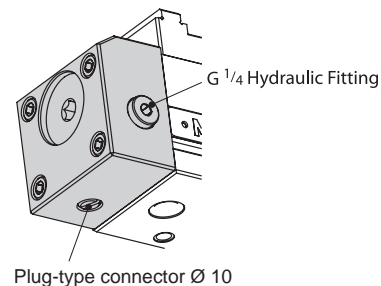
40mm



60mm / 60mm Hyd

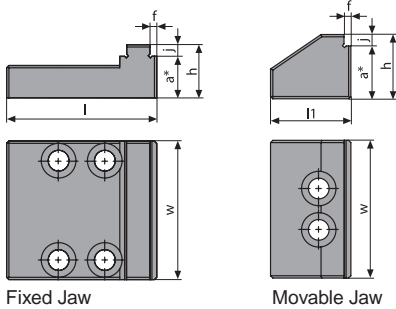


Hydraulic Drive Unit
60 HVD





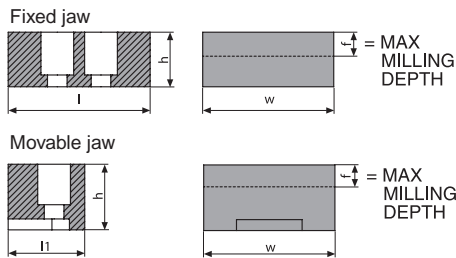
5-Axis Jaws for Fixed Jaw Vises



Step Jaw, Reversible

Part Number Fixed jaw	Part Number Movable jaw	Vise(s)	Dimensions (mm)							Clamping Range min./max.
			l	l1	w	h	a*	f	j	
80310	80315	80300	40	34	40	15	12	3	3	6 – 70
80410	80415	80400	65	35	60	23	18	3	5	6 – 106

l1 only for movable jaw



Block Jaw, Soft for Milling Workpiece Contours

Part Number Fixed jaw	Part Number Movable jaw	Vise	Dimensions (mm)				
			l	l1	w	h	f
80420	80425	80400	65	35	60	25	11

l1 only for movable jaw

* Tolerance ±0.01mm

5-Axis Fixed Jaw Accessories



Positioning Pins, Various Diameters, for Grid Plate, set of 2

Part Number	Vise(s)	Ø (mm)
80060	80400/80500	10/12



Positioning Pins, Various Diameters, for Table with T-Slots, Set of 2

Part Number	Vise(s)	Ø (mm)
80065	80400/80500	10/14

Torque Wrench

Part Number	Vise(s)	Torque (Nm)
80070	80300/80400	5 – 60

Socket

Part Number	Vise(s)	SW
80380	80300	6
80430	80400	8

Socket Wrench

Part Number	Vise	SW
80531	80500	8

Clamping Claws, set of 4, Including Screws

Part Number	Vise(s)	Thread
80050	80400/80500	M10
80053	80400/80500	M12

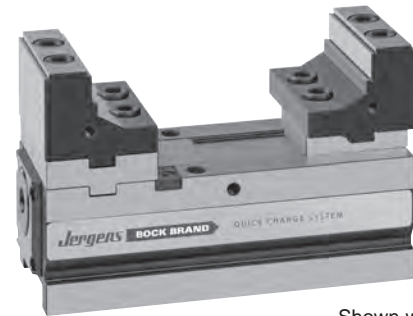


5-Axis Compact Vises

New machining technologies and manufacturing methods call for the development of new solutions in clamping technology. The Jergens 5-Axis Compact Vise, with its short base and easy movement of the fixed jaw, is ideal for 5-sided machining.

The well balanced design of the guide between the base and the moveable jaw allows the use of high clamping jaws, for performing machining operations close to the workpiece.

The base is made from cast steel for rigidity and dimensional stability. All sides are hardened and ground.



Shown with optional jaws.

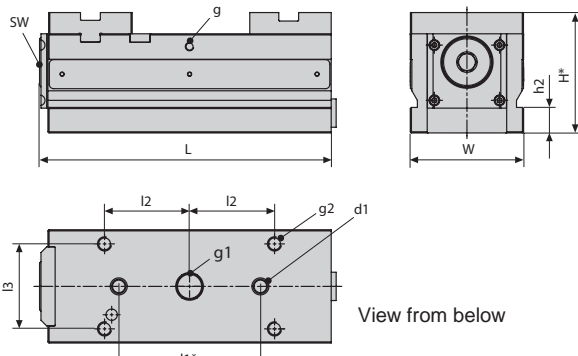
Part Number	Size	Clamping Force* (kN/Torque Nm)	Weight (Kg)	Dimensions (mm)											Hex (mm)	
				Stroke	L	W	H*	d1*	g	g1	g2	h2	l1*	l2		l3
81000	80mm Man	25/ 60 Nm	8.8	–	206	80	85	10F7	M6 x 10	M10 x 11	M10 x 16	18	100	60	60	12 Female
81100	120mm Man	40/100 Nm	18.4	–	260	120	100	25 x 5/ M10 x 14	M8 x 15		M12 x 18	18	200	100	80	14 Female
81200	80mm Hyd	20/310 bar	9.0	4	227	80	85	10F7	M6 x 10	M10 x 11	M10 x 16	18	100	60	60	12 Female
81300	120mm Hyd	40/270 bar	20.4	4	282	120	100	25 x 5/ M10 x 14	M8 x 15		M12 x 18	18	200	100	80	14 Female

Note: Vise handles included with each Jergens 5-Axis Vise

* Tolerance ±0.01mm

* kN x 224.8=pound - force Nm x 8.85=in. lbs Kg x 2.205=lbs Bar x 14.5=psi

80mm / 80mm Hyd



- High degree of freedom for spindle and tools; low risk of collision
- Well suited for short standard tools
- Repeatable and controllable clamping forces of up to 25 kN Compact 80 and 40 kN Compact 120
- Jaw with a special grip for maximum holding force (factor 3 as compared with standard jaw)

120mm / 120mm Hyd

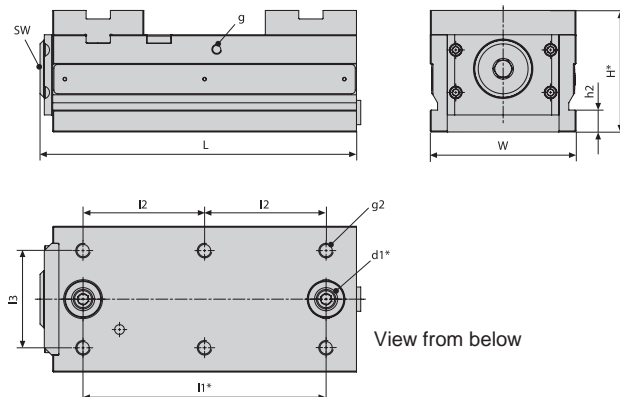
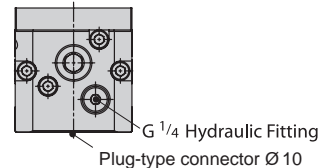
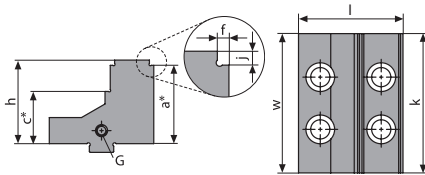


Figure: Hydraulic drive unit C80, C120



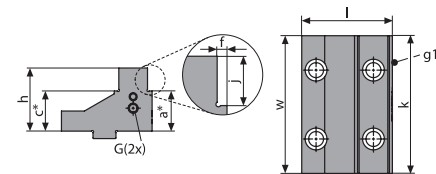


5-Axis Compact Vise Jaws



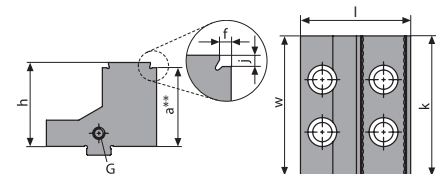
Precision Step Reversible Jaw for 81000 / 81200

Part Number	Dimensions mm									Clamping Range min./max.
	l	w	h	a*	c*	f	G	j	k	
81010	60	50	48	45	30	2.5	M6 x 10	3	25	5 – 155
81015	60	50	48	45	30	2.5	M6 x 10	3	50	5 – 155
81020	60	80	48	45	30	2.5	M6 x 10	3	80	5 – 155



Precision Step Reversible Jaw for 81100 / 81300

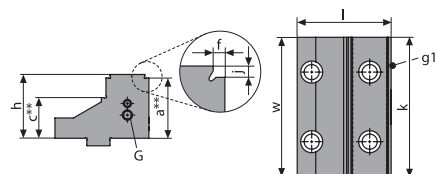
Part Number	Dimensions (mm)										Clamping Range min./max.
	l	w	h	a*	c*	f	G	g1	j	k	
81110	79	84	55	35	35	4	M8 x 14	M4 x 7	20	40	8 – 200
81120	79	84	55	35	35	4	M8 x 14	M4 x 7	20	84	8 – 200
81125	79	120	55	35	35	4	M8 x 14	M4 x 7	20	120	8 – 200



Special Grip Jaw for 81000 / 81200

Provides maximum retaining force

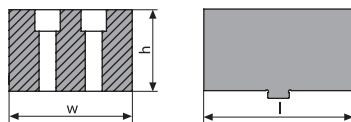
Part Number	Dimensions (mm)									Clamping Range min./max.
	l	w	h	a**	f	G	j	k		
81025	63	50	48	45	3.5	M6 x 10	3	25	7 – 151	
81030	63	50	48	45	3.5	M6 x 10	3	50	7 – 151	
81040	63	80	48	45	3.5	M6 x 10	3	80	7 – 151	



Special Grip Jaw for 81100 / 81300

Provides maximum retaining force

Part Number	Dimensions (mm)										Clamping Range min./max.
	l	w	h	a**	c**	f	G	g1	j	k	
81130	81	84	55	52	35	3.5	M8 x 14	M4 x 7	3	40	7 – 195
81135	81	84	55	52	35	3.5	M8 x 14	M4 x 7	3	84	7 – 195
81140	81	120	55	52	35	3.5	M8 x 14	M4 x 7	3	120	7 – 195



Soft Jaws

Part Number	Vise(s)	Dimensions (mm)			Material
		l	w	h	
81045	81000 / 81200	97	80	53	Steel C 45
81050	81000 / 81200	97	80	53	Aluminium
81145	81100 / 81300	97	120	53	Steel C 45
81150	81100 / 81300	97	120	53	Aluminium

* Tolerance ±0.01mm

** Tolerance ±0.02mm

PRODUCTION VISES » JERGENS 5-AXIS



5-Axis Compact Vise Accessories



Positioning Pins, Various Diameters, for Grid Plate, set of 2

Part Number	Vise(s)	Ø (mm)
80060	81000 / 81200	10/12
80160	81100 / 81300	25/12
80165	81100 / 81300	25/16



Positioning Pins, Various Diameters, for Table with T-Slots, set of 2

Part Number	Vise(s)	Ø (mm)
80065	81000 / 81200	10/14
80260	81100 / 81300	25/14
80265	81100 / 81300	25/18

Clamping Claws, set with M10 Fastening Screws

Part Number	Vise(s)	Qty.
81075	81000 / 81200	4
81180	81100 / 81300	6

Double Clamping Claws, set with M10 Fastening Screws

Part Number	Vise(s)	Qty.
81080	81000 / 81200	4
81185	81100 / 81300	6

Torque Wrench

Part Number	Vise(s)	Clamping Force (Nm)
80070	81000	5 – 60
80170	81100	20 – 120

Socket for Torque Wrench

Part Number	Vise(s)	SW
81060	81000	12, 3/8"
81160	81100	14, 1/2"



C80



C120

Workstops

Part Number	Vise(s)
81090	81000 / 81200
81195	81100 / 81300



Jergens 5-Axis Fixed Jaw Vise with Reversible and Interchangeable Inserts

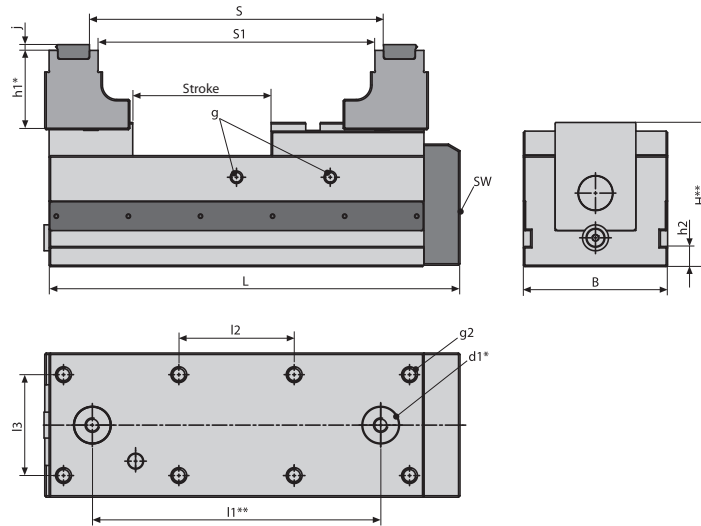


With reversible (1 face flat, 1 face with grip) and interchangeable inserts, as well as round inserts (with grip), this vise allows machining of both machined and un-machined parts. Insert design minimizes change over time and an all-steel construction guarantees a long service life and high stability. With pre-drilled holes in the base for positioning and fastening, the vise is ideal for use with Jergens' Zero Point System and Ball Lock® Quick Change System.

- Suitable for clamping both un-machined and machined parts
- Interchangeable inserts allow machining of the 6th face with minimal set up
- Free access to the workpiece, allowing the use of standard tools
- Minimal clamping edge reduces material losses

Part Number	Size	Clamping Force* (kN/Nm)	Weight (Kg)	Stroke (mm)	S	S1	L	B	H	d1	g	g2	h1	h2	l1	l2	l3	j	SW
80900	100mm	25/60	19.6	96	18-204	6-192	285	100	100	25 x 5/M10 x 14	M8 x 15	M10 x 15	50	14	200	80	70	4	12

* kN x 224.8=pound - force Nm x 8.85=in. lbs Kg x 2.205=lbs Bar x 14.5=psi



Jergens 5-Axis Fixed Jaw Vise Accessories

Clamping Claws

Set of 4 pieces, with nuts

Part Number	Vise	Thread
80150	80900	M12

Torque Wrench

Part Number	Vise	Torque (Nm)
80070	80900	5-60

Socket for Torque Wrench

Part Number	Vise	Width Across Flats
81060	80900	12

Workpiece Stop

Part Number	Vise
81195	80900



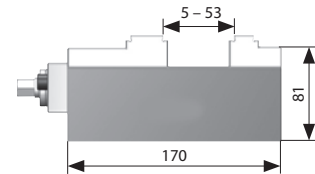
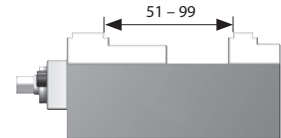
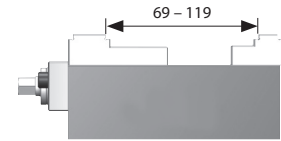
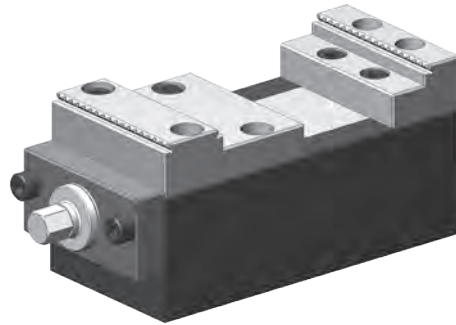
Jergens 5-Axis Pallet Clamps

Jergens pallet clamps (comprised of clamping jaws with a grip structure) can be used either for concentric clamping or for clamping to the fixed jaw. These pallet clamps are an effective, affordable clamping solution.

- 2 designs available: concentric clamping or clamping to a fixed jaw
- Highest quality, compact, all-steel construction
- Precise clamping
- Easy to dismantle and clean

Fixed Pallet Clamp

Clamping to the fixed jaw
Clamping jaws with a grip structure

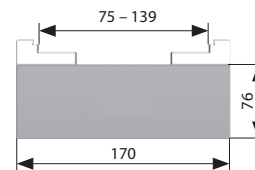
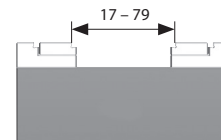
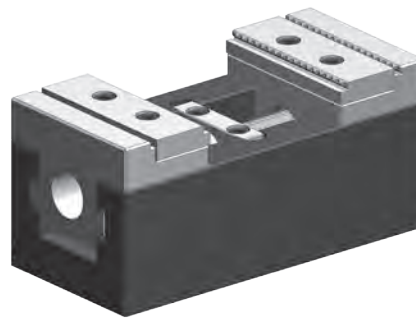


Part Number	Clamping Principle	Jaw Width (mm)	Clamping Force* (kN)	Clamping Width (mm)	Clamping Step (mm)	Weight (Kg)
81400	Against the fixed jaw	80	20 at 60 Nm	5 - 119	4 x 4	6.9

* kN x 224.8=pound - force Nm x 8.85=in. lbs Kg x 2.205=lbs Bar x 14.5=psi

Concentric Pallet Clamp

Concentric clamping
Clamping jaws with a grip structure



Part Number	Clamping Principle	Jaw Width (mm)	Clamping Force (kN)	Clamping Width (mm)	Clamping Step (mm)	Weight (Kg)
81500	Concentric clamping	80	20 at 60 Nm	15 - 139	4 x 4	6.4



5-Axis Locating Pins

Locates subplates to machine rotary tables, risers to subplates, and mounts Fixture Pro® Top Tooling directly to a rotary table.

- Material: 1018 Steel
- Tolerance: ±0.0002 (.005mm)

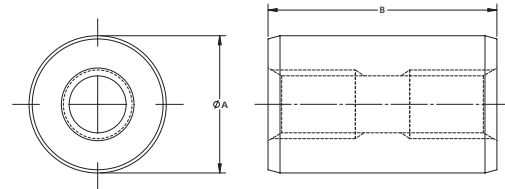
Center Locating Pins - Metric

Part Number	A (mm)	B (mm)	Thread	Weight lbs (Kgs)
5LP1220	12	20	M6	0.03 (.014)
5LP1225	12	25	M6	0.04 (.018)
5LP1230	12	30	M6	0.05 (.023)



Center Locating Pins - Inch

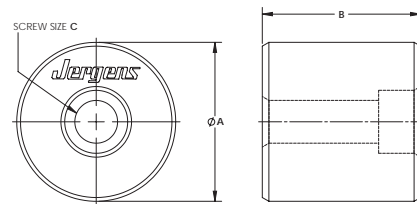
Part Number	A (mm)	B (mm)	Thread	Weight lbs (Kgs)	Extraction Tool
5LP50075	0.5	0.75	1/4-20	0.03 (.014)	5HW004
5LP500100	0.5	1	1/4-20	0.04 (.018)	5HW004
5LP500125	0.5	1.25	1/4-20	0.05 (.023)	5HW004



Center Locator Pins

Center Locator Pins, Long

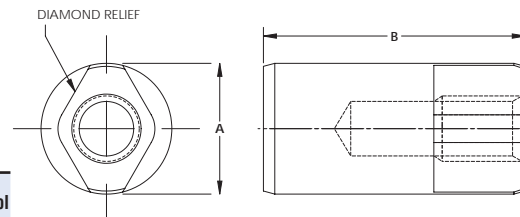
Part Number	A (mm)	B (mm)	C Screw Size	Weight lbs (Kgs)
5LP5050	50	50	M12, 1/2 SHCS	1.49 (.68)
5LP5070	50	70	M12, 1/2 SHCS	2.11 (.96)
5LP5090	50	90	M12, 1/2 SHCS	2.73 (1.24)
5LP50110	50	110	M12, 1/2 SHCS	3.35 (1.52)



Center Locator Pins, Long

Diamond Timing Pins - Metric

Part Number	A (mm)	B (mm)	Thread	Weight lbs (Kgs)
5LP1220001	12	20	M6	0.03 (.014)
5LP1225001	12	25	M6	0.04 (.018)
5LP1230001	12	30	M6	0.05 (.023)



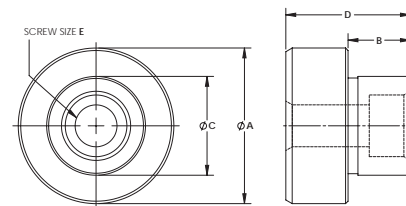
Diamond Timing Pins

Diamond Timing Pins - Inch

Part Number	A (mm)	B (mm)	Thread	Weight lbs (Kgs)	Extraction Tool
5LP50075001	0.5	0.75	1/4-20	0.03 (.014)	5HW004
5LP500100001	0.5	1	1/4-20	0.04 (.018)	5HW004
5LP500125001	0.5	1.25	1/4-20	0.05 (.023)	5HW004

Center Step Locator

Part Number	A (mm)	B (mm)	C in. (mm)	D (mm)	E Screw Size	Weight lbs (kg)
5LP1255020	50	20	1.25 (31.75)	40	M12, 1/2 SHCS	0.8 (.36)
5LP12512	1.25" (31.8 mm)	12	.472 (12)	27	N/A	0.2 (0.10)
5LP5050001	50	22	2.00 (50.8)	50	M12, 1/2 SHCS	1.5 (0.7)
5LP5050002	50	26	1.5 (38.1)	50	M12, 1/2 SHCS	1.2 (0.52)



Center Step Locator

QUICK CHANGE FIXTURING » FIXTURE PRO® 5-AXIS QUICK CHANGE FIXTURING



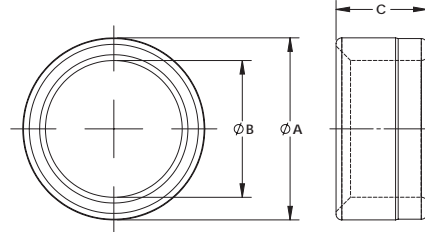
5-Axis Quick Locating System (QLS) Bushings



Part Number	A (mm)	B (mm)	C (mm)	Weight lbs (Kgs)
5BS1210	16	12	10	.01 (.005)
5BS1212	16	12	12	.02 (.009)
5BS1216	16	12	16	.02 (.009)
5BS1232	16	12	32	.05 (.023)

Part Number	A (in)	B (in)	C (in)	Weight lbs (Kgs)
5BS500375	0.75	0.5	0.375	.01 (.005)
5BS500500	0.75	0.5	0.5	.02 (.009)
5BS500625	0.75	0.5	0.625	.02 (.009)
5BS5001375	0.75	0.5	1.375	.05 (.023)

- Hardened and Ground
- Concentric within 0.0002" (0.005mm)



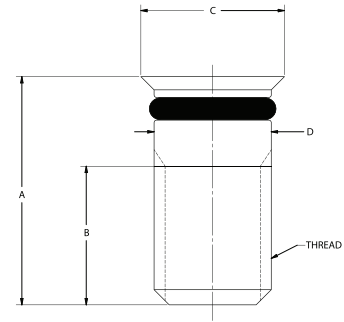
5-Axis Quick Locating System (QLS) Chip Plug*



* O-ring included.

Part Number	A (mm)	B (mm)	C (mm)	D (mm)	Thread Size (mm)	Weight lbs (Kgs)
5PL12002	12	7	14.5	11.8	M12 X 1.75	.02 (.01)
5PL23002	23	14	14.5	11.8	M12 X 1.75	.04 (.02)
5PL30002	30	16	14.5	11.8	M12 X 1.75	.05 (.023)

Part Number	A (in)	B (in)	C (in)	D (in)	Thread Size (in)	Weight lbs (Kgs)
5PL500001	0.5	0.3	0.57	0.50	1/2-13	.03 (.014)
5PL500002	1.0	0.6	0.57	0.50	1/2-13	.05 (.023)



Aluminum Chip Plug



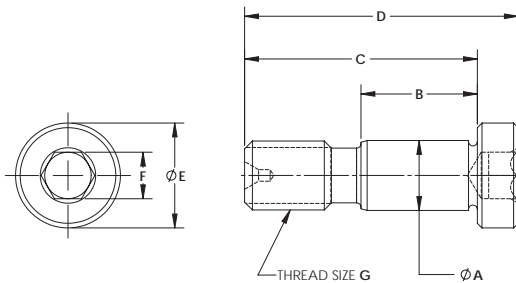
Part Number	C' Bore Hole Size (mm)	C (mm)	D (mm)	Weight (lbs/kgs)	Chip Plug Extractor Part Number
5PL12001	12	12.98	11.96	0.004 (0.002)	HW004
5PL15001	15	15.98	14.96	0.007 (0.003)	HW004
5PL16001	16	16.97	15.95	0.008 (0.004)	HW004
5PL17001	17	18.01	16.99	0.009 (0.004)	HW004
5PL18001	18	19.02	18.01	0.011 (0.005)	HW004
5PL19001	19	20.02	19	0.012 (0.005)	HW004
5PL20001	20	20.98	19.96	0.013 (0.006)	HW004
5PL25001	25	25.98	25.97	0.021 (0.010)	HW004



5-Axis Quick Locating System (QLS) Shoulder Screws



- Hardened and Ground
- "A" Diameter ±0.0003" (0.008mm)



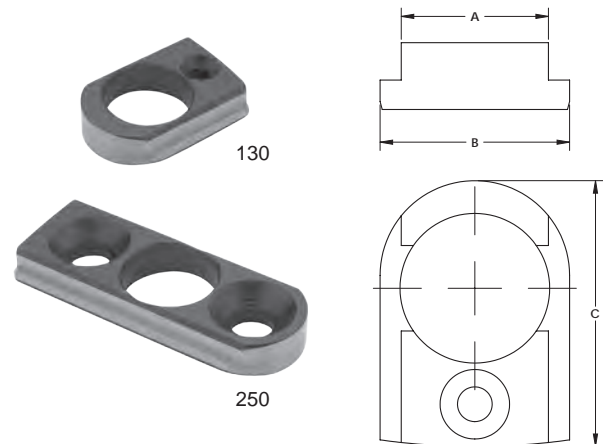
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	Hex Size F (mm)	Thread Size G (mm)	Weight lbs (Kgs)
5SH1220	12	20	40	47	18	8	M12 X 1.75	.09 (.04)
5SH1225	12	25	45	52	18	8	M12 X 1.75	.1 (.045)
5SH1230	12	30	50	57	18	8	M12 X 1.75	.11 (.05)
5SH1235	12	35	55	62	18	8	M12 X 1.75	.12 (.054)
5SH1240	12	40	60	67	18	8	M12 X 1.75	.13 (.06)
5SH1245	12	45	65	72	18	8	M12 X 1.75	.14 (.064)
5SH1250	12	50	70	77	18	8	M12 X 1.75	.15 (.07)

Part Number	A (in)	B (in)	C (in)	D (in)	E (in)	Hex Size F (in)	Thread Size G (in)	Weight lbs (Kgs)
5SH50075	0.5	0.75	1.375	1.625	0.74	0.313	1/2-13	.09 (.04)
5SH50100	0.5	1	1.625	1.875	0.74	0.313	1/2-13	.1 (.045)
5SH50125	0.5	1.25	1.875	2.125	0.74	0.313	1/2-13	.11 (.05)
5SH50150	0.5	1.5	2.125	2.375	0.74	0.313	1/2-13	.13 (.06)
5SH50175	0.5	1.75	2.375	2.625	0.74	0.313	1/2-13	.14 (.064)
5SH50200	0.5	2	2.625	2.875	0.74	0.313	1/2-13	.15 (.07)

5-Axis Locating Keys

Part Number	Mounts to Riser Size (mm)	A in (mm)	B in (mm)	C (mm)	Weight lbs (kgs)
5LK1301812	130	.472 (12)	.709 (18)	25.26	.02 (.009)
5LK1301814	130	.551 (14)	.709 (18)	25.26	.02 (.009)
5LK1301816	130	.630 (16)	.709 (18)	25.26	.02 (.009)
5LK1301818	130	.709 (18)	.709 (18)	25.26	.03 (.014)
5LK13018500	130	.500 (12.7)	.709 (18)	25.26	.02 (.009)
5LK13018562	130	.562 (14.3)	.709 (18)	25.26	.02 (.009)
5LK13018625	130	.625 (15.9)	.709 (18)	25.26	.02 (.009)
5LK13018687	130	.687 (17.4)	.709 (18)	25.26	.03 (.014)
5LK2501812	250	.472 (12)	.709 (18)	48	.04 (.018)
5LK2501814	250	.551 (14)	.709 (18)	48	.05 (.023)
5LK2501816	250	.630 (16)	.709 (18)	48	.05 (.023)
5LK2501818	250	.709 (18)	.709 (18)	48	.06 (.027)
5LK25018500	250	.500 (12.7)	.709 (18)	48	.05 (.023)
5LK25018562	250	.562 (14.3)	.709 (18)	48	.05 (.023)
5LK25018625	250	.625 (15.9)	.709 (18)	48	.05 (.023)
5LK25018687	250	.687 (17.4)	.709 (18)	48	.06 (.027)

Used to adapt any of the Fixture Pro® elements with bottom keyway slots for alignment to your machine table slots. Unique design accommodates socket head cap screws, which will tighten a T-nut to the T-slot in your machine.



- Case Hardened: 60 Rc
- Thickness Tolerance: +0, -.0005
- Finish: Black Oxide

Fixture Pro® components allow you to mount directly to a T-slot with our special through-hole machine keys, QLS bushings, and QLS shoulder screws. All hardware mounting methods can quickly be converted over and mounted to a different machine tool the next time you use the components.



Jergens: Leaders in Quick Change Fixturing Solutions

Our new 5-Axis System is the latest addition to a full line of quick change fixturing solutions, each designed to optimize your machining operation and maximize productivity. No matter how simple or complex the job, we've got a solution that can help you achieve lightning fast part setups and changeovers.

Jergens Bock Brand Quick Change System



The Jergens Bock Brand Quick Change System is one of the industry's easiest to implement, so you'll be maximizing productivity and saving money in no time.

- Alpha-numeric locator plate system for quick and accurate mounting
- Repeatability within +/- .0005" or better
- Machinable quick change jaws snap off in seconds

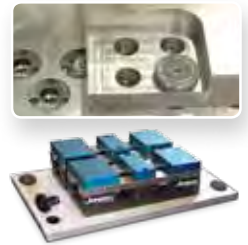


Jergens Ball Lock® Mounting System



The Jergens Ball Lock® Mounting System makes it easy and economical to establish lean manufacturing cells that really pay off. You can easily configure Ball Lock® for your specific application and start exchanging fixtures in mere seconds. Increase your profits, take on smaller runs, improve throughput...it's all possible with Ball Lock®.

- FAST setups and changeover
- STRONG holding forces
- COMBINES locking and locating
- ELIMINATES the need for indicating
- REPEATABILITY of +/-0.0005" (+/-0.013mm) or better



Jergens Zero Point System



Jergens Zero Point Mounting System: experience accuracy, speed and repeatability within <0.005mm (0.0002"). This revolutionary technology allows you to fix, position and clamp in a single step, cutting set up times by up to 90%. Available with either pneumatic or hydraulic release, these positive locking locating modules allow operators to quickly change out large and small fixtures with extreme accuracy and minimal effort. It's simply the lowest cost, fully automatic solution for quick pallet changing.



Jergens Production Vises, Columns & Accessories

Precision Part Clamping and Quick Change Features:

- Quick-change, machinable jaws speed part to part changeover.
- Dual stations permit more parts per machine cycle
- Strong, lightweight bodies improve handling
- Integrate with Ball Lock® and Bock Dexloc™ for further set up time reductions
- Hydraulic units available for precise clamping force
- Columns available in 6-8-12 and 16 stations



QUICK CHANGE FIXTURING SOLUTIONS

Jergens®

MANUFACTURING EFFICIENCY

WORLD HEADQUARTERS

15700 S. Waterloo Road, Cleveland, OH 44110-3898

☎ 877.426.2504 📠 216.481.6193

✉ workholding@jergensinc.com

🌐 www.jergensinc.com



Workholding Solutions Group



ALSO AVAILABLE:
Workholding Solutions Catalog

Request a copy or download at www.jergensinc.com



AD0613

© Copyright Jergens, Inc. 2013



ISO9001:2008
QUALITY SYSTEM CERTIFIED

