

Vario•Tec





Vario•Tec
jaws
Page 128



Vario•Tec
accessories
Page 129



Super•Vario
vice
Page 132

Vario•Tec – A system for all common vices

How does it work?



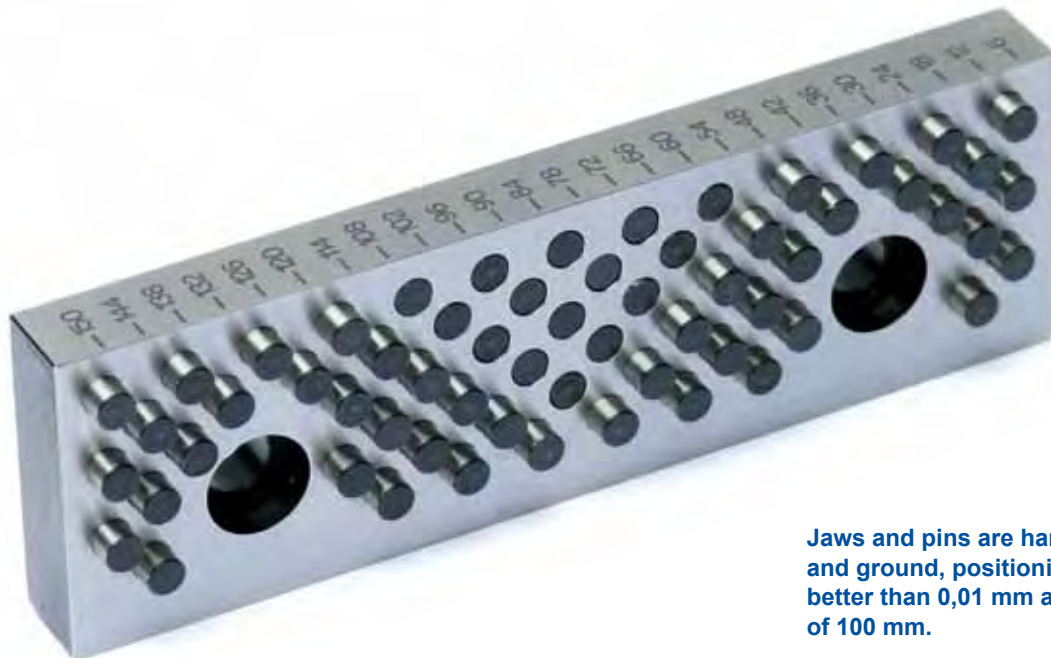
The pins are blown out with compressed air row by row at high accuracy ($\pm 0,01$ mm). Push back the pins not needed easily by hand.

Lasermarkings facilitate accurate reproduction of fixture for repeating work pieces.



Also 45° angles can be achieved within seconds just by pushing in the pins accordingly. With accessories, e.g. angle-plates you are able to fit on all defined angles you need easily. Your advantage: safe milling, better quality and higher repeatability.

Movable pins make expensive devices and all existing parallels obsolete



Jaws and pins are hardened and ground, positioning accuracy better than 0,01 mm at a length of 100 mm.

In order to maintain best function of pins it is recommended to move all pins once a week and to leave them in raised position while not using the vice (this avoids crusting of coolant).

All common vices can be retrofitted.

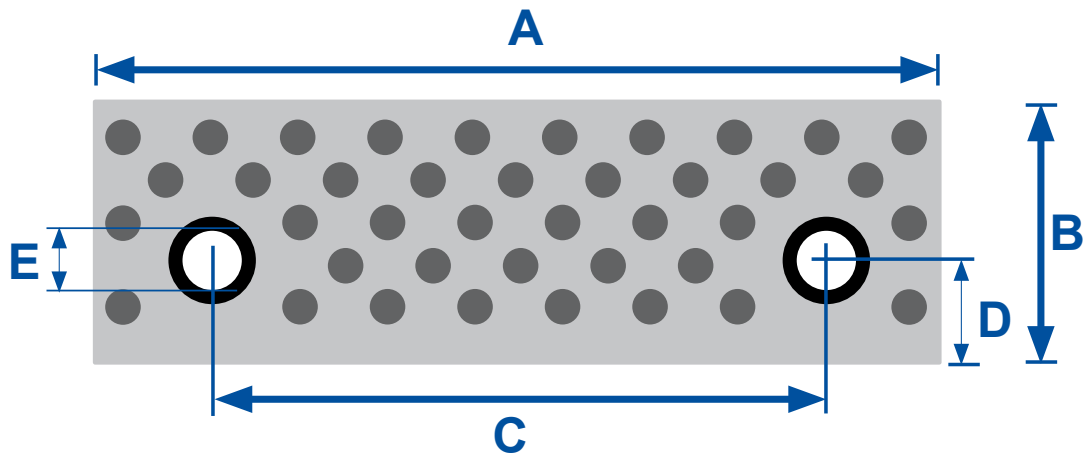


Even small and flat work pieces can be fixed and clamped easily, quickly and safely in Vario•Tec jaws. No more damaging of parallels while drilling near to the jaw.

With restrung strips you achieve different clamping heights in steps of 2 mm quickly

Choose the suitable size for your vice!

Thickness of all jaws 15 mm generally



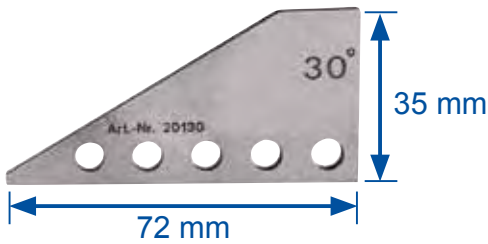
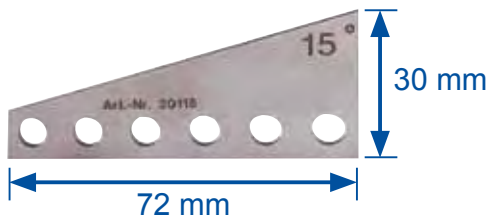
| Type | Jaw width | Fixed jaw Order No. | Movable jaw Order No. | Price per jaw in € | Dimensions | | | | |
|-------------------------|-----------|---------------------|-----------------------|--------------------|------------|----|-----|------|-----|
| | | | | | A | B | C | D | E |
| Standard* | 125 | 22551 | 22552 | | 125 | 40 | 80 | 15 | M8 |
| Standard** | 160 | 26041 | 26042 | | 160 | 50 | 100 | 20 | M 8 |
| Allmatic NC Allmatic | 125 | 22528 | 22529 | | 125 | 40 | 88 | 12,3 | M6 |
| | 125 | 22521 | 22522 | | 125 | 40 | - | 18 | M10 |
| Hilma | 100 | 20011 | 20012 | | 100 | 34 | 65 | 11 | M6 |
| Hilma | 125 | 22511 | 22512 | | 125 | 45 | 80 | 14 | M8 |
| Hilma | 160 | 26011 | 26012 | | 160 | 54 | 100 | 17 | M10 |
| Röhme | 125 | 22581 | 22582 | | 125 | 40 | 80 | 15,6 | M8 |

* suitable for Arnold, Gressel and Kesel

** suitable for Arnold, Kesel and Röhme

Please check jaw dimensions of your vice to match Vario•Tec!





Hint: When turning the angle plate 180 degrees you receive a clamping depth of 1 mm - ideal for minimum clamping

| Angle plates for clamping in sloping position, 3 mm thick, hardened | | | |
|---|-----------|--------|-------|
| Type | Order No. | Amount | Price |
| 5°, hardened | 20105 | 1 pair | |
| 10°, hardened | 20110 | | |
| 15°, hardened | 20115 | | |
| 20°, hardened | 20120 | | |
| 25°, hardened | 20125 | | |
| 30°, hardened | 20130 | | |
| 35°, hardened | 20135 | | |
| 40°, hardened | 20140 | | |
| 45°, hardened | 20145 | | |



- Higher accuracy of the angles
- Secure repeatability
- Higher milling feeds possible



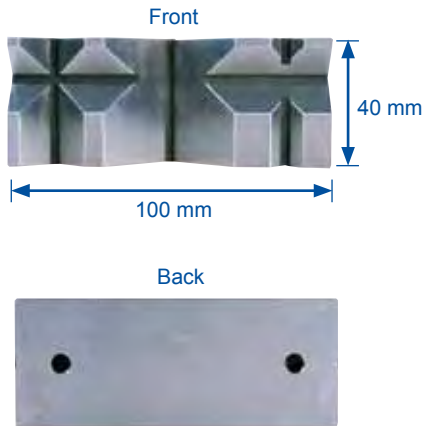
| Parallels, 12 mm height, 3 mm thick, hardened | | | |
|---|-----------|--------|-------|
| Version | Order No. | Amount | Price |
| Length X in mm | | | |
| Parallels 125 | 20401 | 1 pair | |

Parallels achieve 2 different clamping heights of 2 + 4 mm just by using them either top or bottom up. So small work pieces can be fixed safely.



Easy cleaning of resting strip, repeated positioning at high accuracy.

Prism for secure holding of round work pieces



Prism Standard

| Type | Order No. | Amount | Price |
|----------------|-----------|--------|-------|
| Prism Standard | 20501 | 1 | |

No damaging of the cylinder's surface due to low clamping forces. Fixation at Vario•Tec jaw simply by fitting on two particular pins in one row and by tightening the lateral fixing screw. For fixation of round material with a diameter from 5 to 55 mm.



For batch production: Highest repeatability by fixing the prism at the jaw.

Mounting base, ground - For simple adjustment of the jaws.



Mounting base

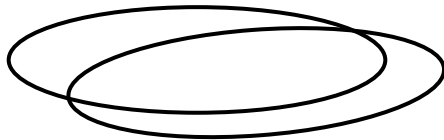
| Order No. | Amount | Price |
|-----------|--------|-------|
| 20003 | 1 | |

For simple adjustment of the jaws

Accessories for all Vario•Tec system with pin diameter 6 mm



| Spare pins, Ø6 mm | | |
|---|--------|-------|
| Order No. | Amount | Price |
| 20001 | 5 | |
| Pins which are damaged by collision should be replaced. | | |



| Sealing for jaws | | |
|---|--------|-------|
| Order No. | Amount | Price |
| 20002 | 1 pair | |
| Please specify the width of your jaws when ordering! e.g. 125 mm, 160 mm, ... | | |



| Air pressure pistol | | |
|--|--------|-------|
| Order No. | Amount | Price |
| 20004 | 1 | |
| <ul style="list-style-type: none"> • Ideal handling • Perfect for Vario•Tec • Best supply of air pressure | | |



| Sealing for pins, new version | | | |
|--|-----------|--------|-------|
| Type | Order No. | Amount | Price |
| New since approx. 2002 | 200010 | 100 | |
| Worn out sealings should be exchanged. | | | |

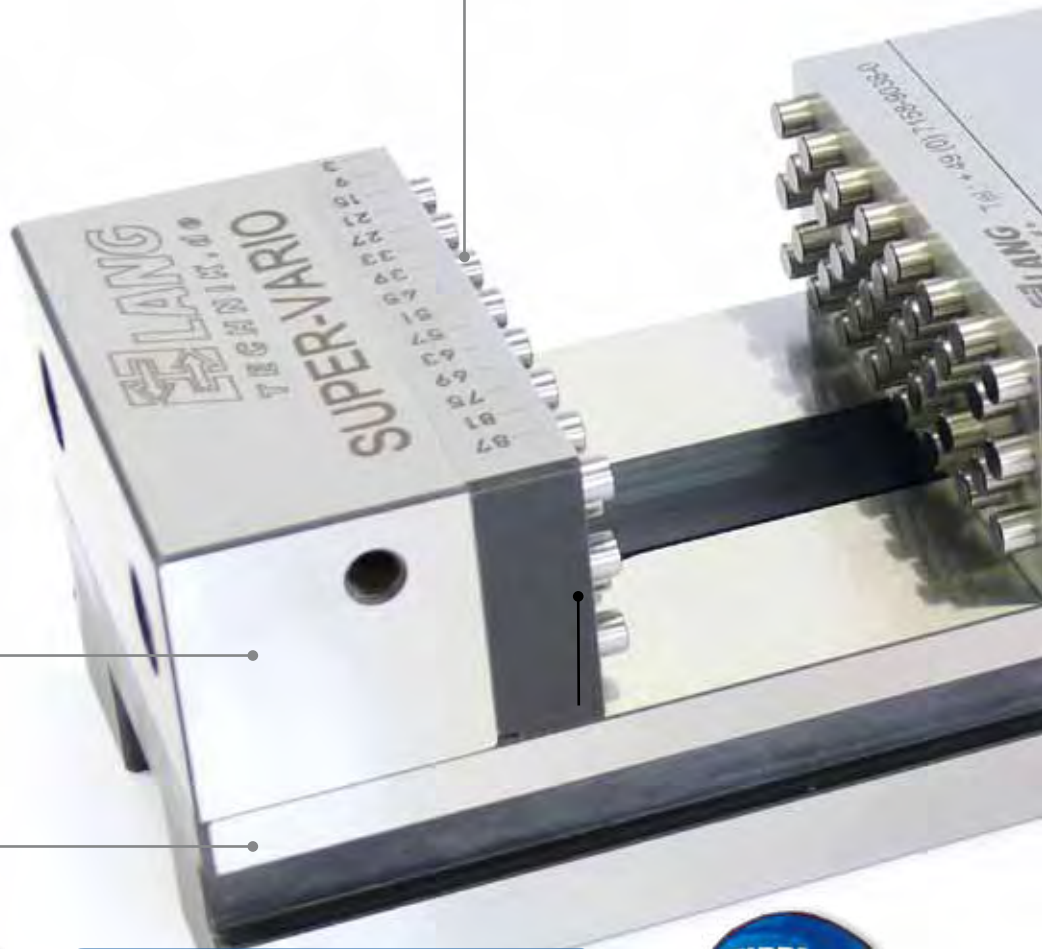


| Sealing for pins, old version | | | |
|--|-----------|--------|-------|
| Type | Order No. | Amount | Price |
| Older pins before 2002 | 200011 | 100 | |
| Worn out sealings should be exchanged. | | | |

Super•Vario 96 precision vice

the only precision vice with integrated Vario•Tec adaptive support system. Jaws are mounted from behind and therefore no swarf accumulation on the clamping surface

easy disassembly of spindle by pulling pin with internal thread



low weight, only about 10 kg

case-hardened steel, sturdy construction for the tough use in the work shop



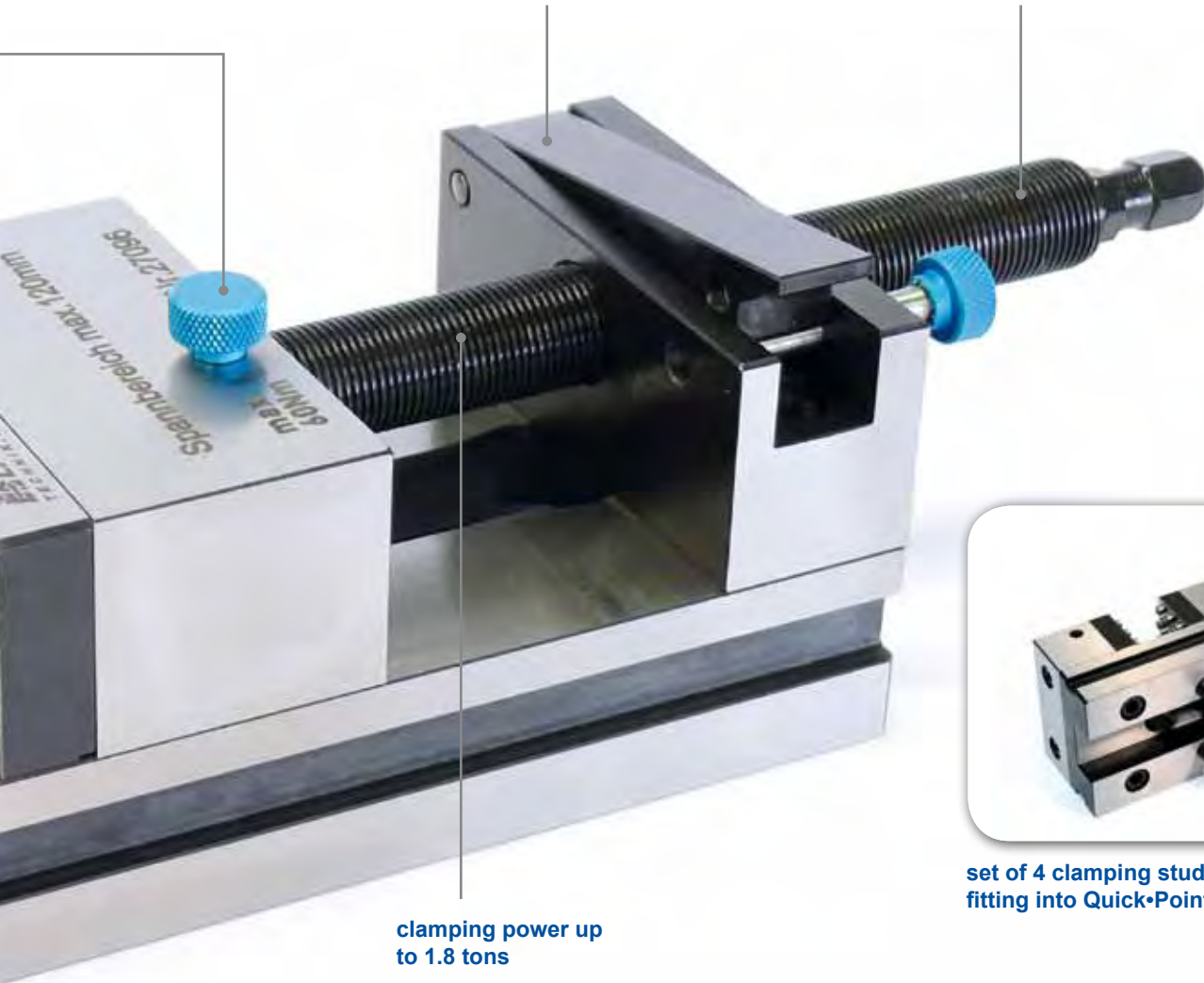
Highest repeat accuracy of your work piece clamping in the micron range, using a torque wrench.



The solution for efficient milling, grinding, drilling or measuring

quick adjustment of complete clamping range by pulling pin and lifting hatch with thread

alternatively, short spindle for narrow spaces on the machine table. Exchangeable within a minute!



set of 4 clamping studs included for fitting into Quick•Point® system

clamping power up to 1.8 tons



Integrated Vario•Tec jaws are completely sealed and allow clean and fast working. The tiresome removal of chips in holes and spaces is not necessary anymore.

Super•Vario 96 mm jaw width

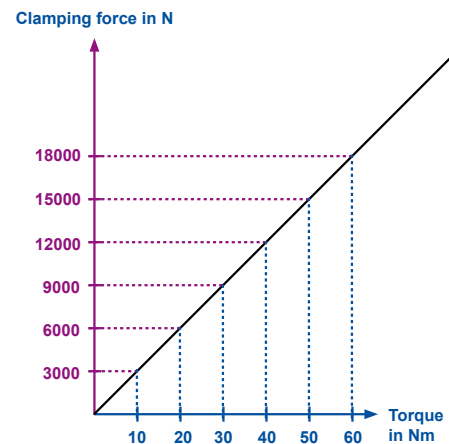
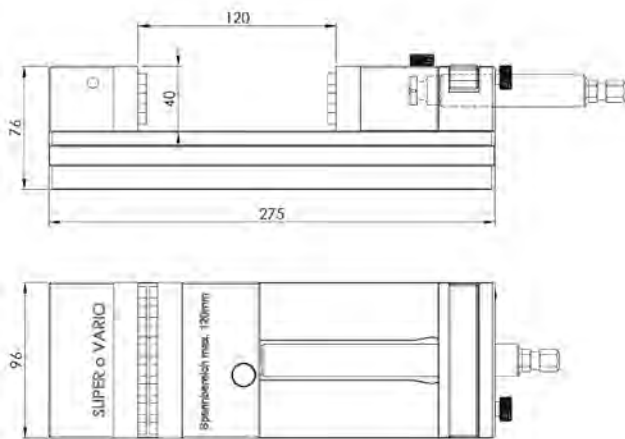


Super•Vario 96 mm, clamping range 0-120 mm

| Typ | Order No. | Price |
|---|-----------|-------|
| Super•Vario vice – jaw width 96 mm complete | 27096 | |

Included in delivery:

- 1 x Vice complete (Weight 10,5 kg)
- 1 x Short spindle 135 mm
- 4 x Studs Ø16 mm for Quick•Point® 52 mm
- 4 x Clamping jaws
- 1 x Hexagon wrench 90° angled
- 1 x Handle



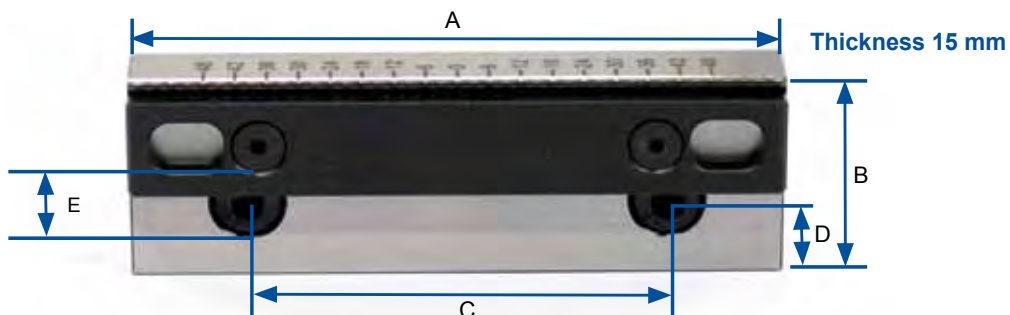
Universal stopper

| Description/Type | Order No. | Price |
|-------------------|-----------|-------|
| Universal stopper | 27095 | |

- Ideal for positioning work pieces correctly
- Screw-on thread M8 – can be easily operated without wrench

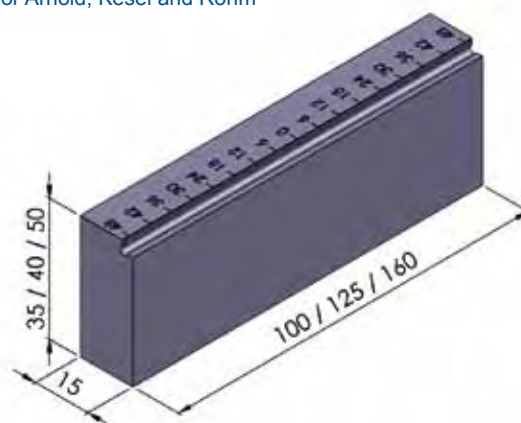
Grip•Fix jaws

Attach jaws to your existing vice - Parallels with clamping depth of 3 mm included.



| Type | Jaw width | Order No. | Price per pair | Dimensions | | | | |
|-------------|-----------|-----------|----------------|------------|----|-----|------|-----|
| | | | | A | B | C | D | E |
| Standard* | 125 | 421250 | | 125 | 40 | 80 | 15 | M8 |
| Standard** | 160 | 421600 | | 160 | 50 | 100 | 20 | M 8 |
| Allmatic NC | 125 | 422527 | | 125 | 40 | 88 | 12,3 | M6 |
| Allmatic | 125 | 422520 | | 125 | 40 | | 18 | M10 |
| Hilma | 100 | 420010 | | 100 | 34 | 65 | 11 | M6 |
| Hilma | 125 | 422510 | | 125 | 45 | 80 | 14 | M8 |
| Hilma | 160 | 426010 | | 160 | 54 | 100 | 17 | M10 |
| Röhms | 125 | 422580 | | 125 | 40 | 80 | 15,6 | M8 |

* suitable for Arnold, Gressel and Kesel ** suitable for Arnold, Kesel and Röhms



Universal gripping jaws

Customize these jaws individually to your vice. Jaws case-hardened 57 HRc, 0.7 mm deep. Material: 16MnCr5

| Type | Order No. | Price per pair | Dimensions | | | | |
|----------------------------|-----------|----------------|------------|----|--------------|---|---|
| | | | A | B | C | D | E |
| Universal Grip•Fix jaw 100 | 421035 | | 100 | 35 | individually | | |
| Universal Grip•Fix jaw 125 | 421240 | | 125 | 40 | individually | | |
| Universal Grip•Fix jaw 160 | 421650 | | 160 | 50 | individually | | |