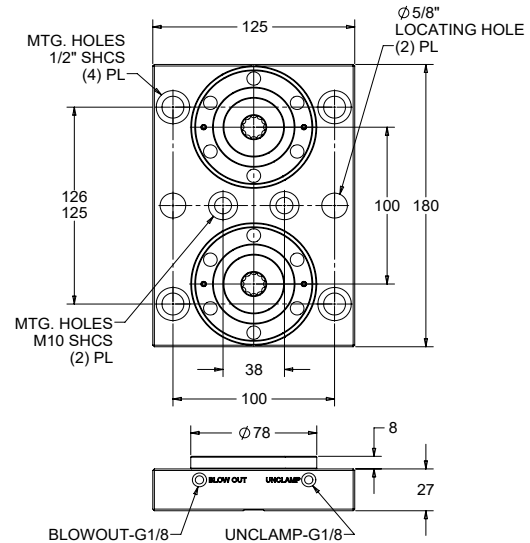


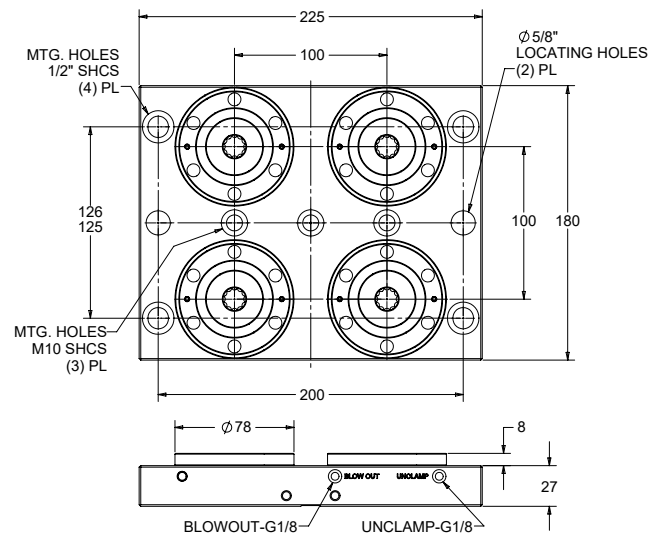
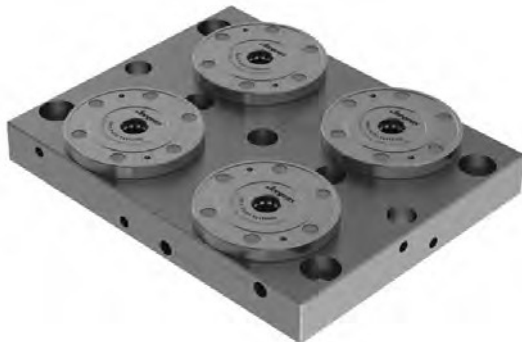
Zero Point Subplates – K5.3

- Includes K5.3 low pressure pneumatic clamping modules installed
- Plate material: Fremax 15 Steel or Equiv.
- Includes porting for Blowout function
- Includes quick connect fittings
- Repeatability < 0.005 mm (0.0002")
- Custom designs available on request

Part No.	Wt. (kg)
30110	4.6



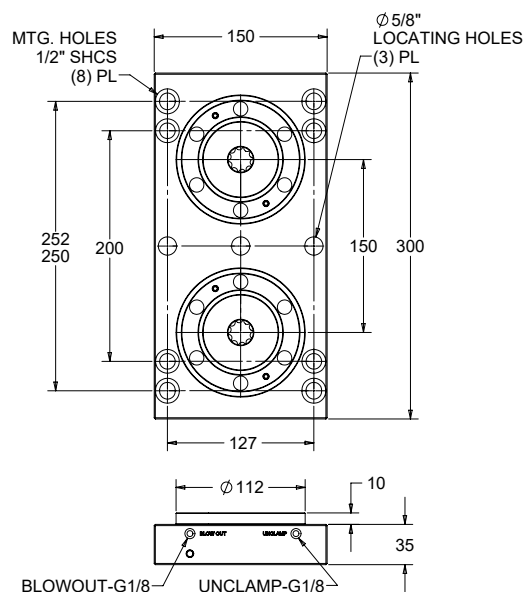
Part No.	Wt. (kg)
30111	8.4



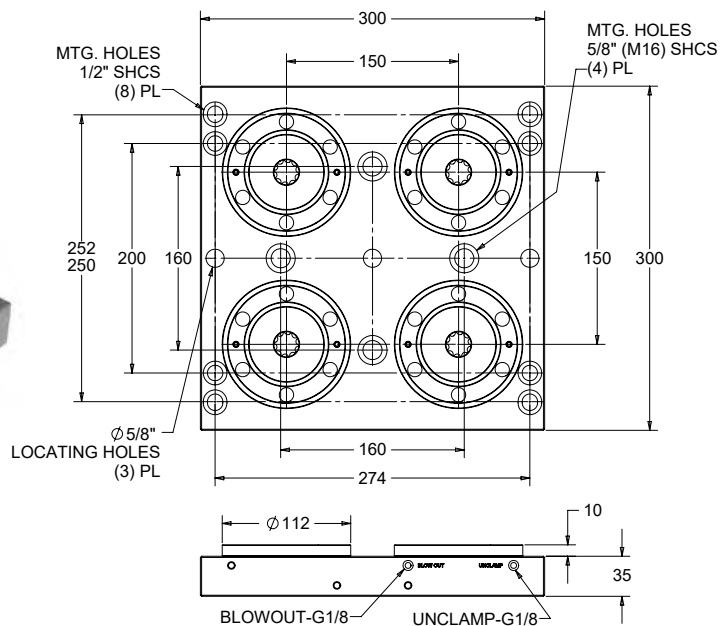
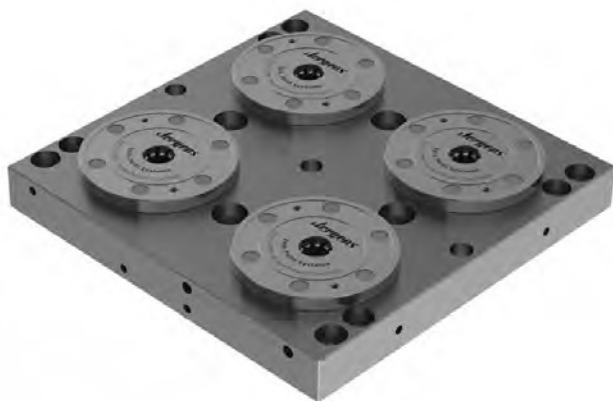
Zero Point Subplates – K10.3

- Includes K10.3 low pressure pneumatic clamping modules installed
- Plate material: Fremax 15 Steel or Equiv.
- Includes porting for Blowout function
- Includes quick connect fittings
- Repeatability < 0.005 mm (0.0002")
- Custom designs available on request

Part No.	Wt. (kg)
30120	13



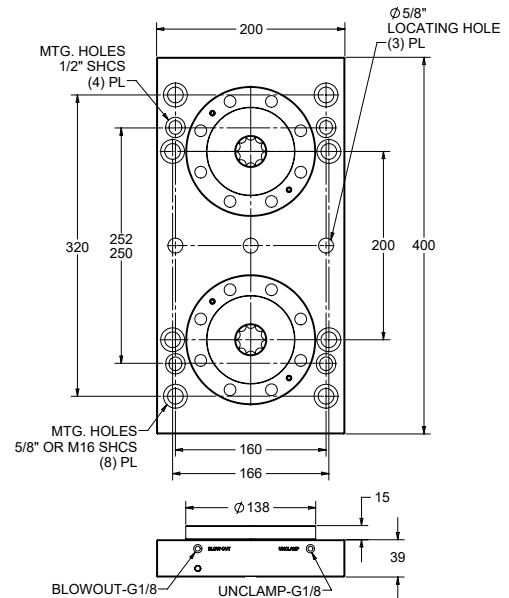
Part No.	Wt. (kg)
30121	25



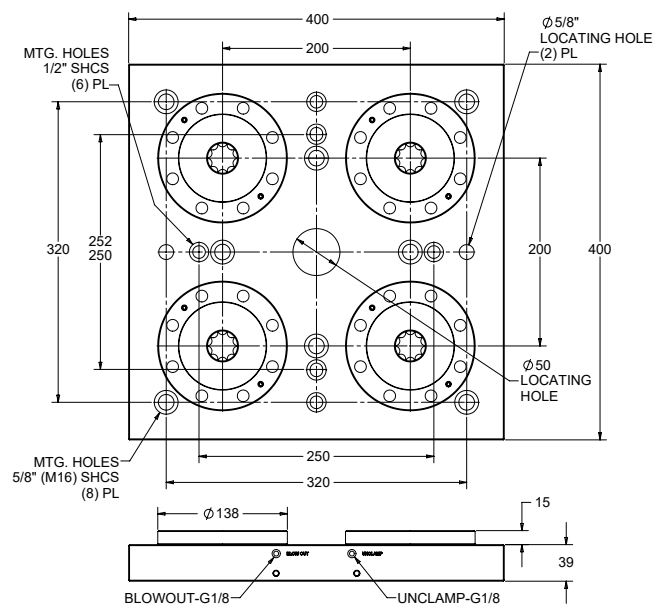
Zero Point Subplates – K20.3

- Includes K20.3 low pressure pneumatic clamping modules installed
- Plate material: Fremax 15 Steel or Equiv.
- Includes porting for Blowout function
- Includes quick connect fittings
- Repeatability < 0.005 mm (0.0002")
- Custom designs available on request

Part No.	Wt. (kg)
30130	24

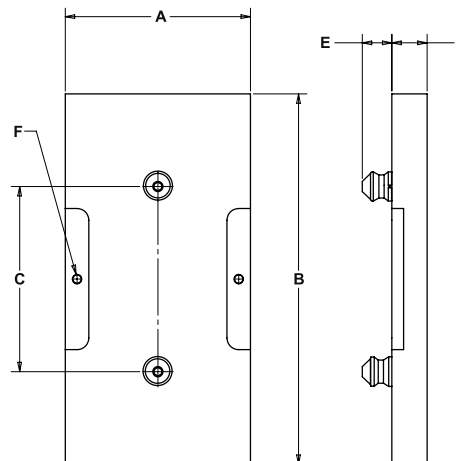


Part No.	Wt. (kg)
30131	48



Zero Point Fixture Plates – 2 Stud

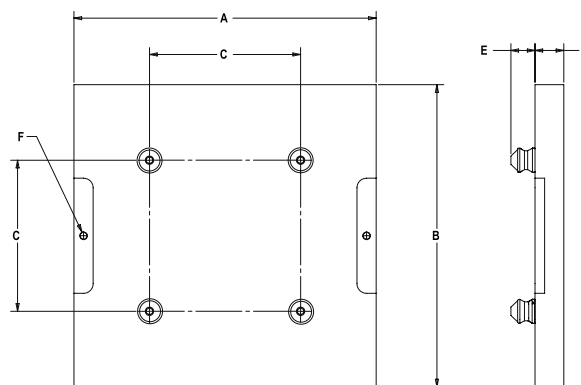
- 2 pull stud configuration suitable for 2 module subplates
- Includes pull studs installed: (1) Zero Point Stud & (1) Timing Stud
- Custom sizes available on request



Part No. Aluminum	Wt. (kg)	Part No. Steel	Wt. (kg)	Pull Stud Size	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (Lifting Holes)
30310-A	1.3	30310-S	3.4	K5	100	180	100	25.4	13.6	—
30320-A	3.1	30320-S	8.4	K10	150	300	150	25.4	22	M10 x 1.50
30330-A	8.2	30330-S	23.2	K20	200	400	200	38.1	32	M10 x 1.50

Zero Point Fixture Plates – 4 Stud

- 4 pull stud configuration suitable for 4 module subplates
- Includes pull studs installed: (1) Zero Point Stud, (1) Timing Stud, & (2) Clearance Studs
- Custom sizes available on request



Part No. Aluminum	Wt. (kg)	Part No. Steel	Wt. (kg)	Pull Stud Size	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (Lifting Holes)
30311-A	3.1	30311-S	8.2	K5	225	180	100	25.4	13.6	—
30321-A	6.4	30321-S	17.6	K10	300	300	150	25.4	22	M10 x 1.50
30331-A	16.6	30331-S	47.4	K20	400	400	200	38.1	32	M10 x 1.50

FIXTURE-PRO® MULTI-AXIS QUICK CHANGE FIXTURING

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Top Tooling

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Building Solutions From The Best Modular Quick-Change Workholding System

STEP 1:

Machine Table Knowledge

STEP 2:

Subplate Systems for Quick Change and Ease of Use

STEP 3:

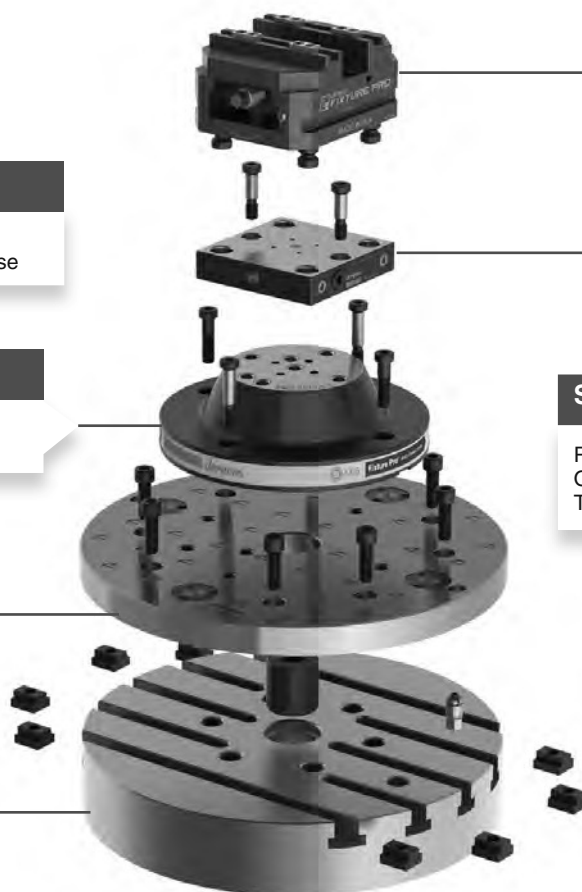
Risers for Height and Clearance

STEP 4:

Pallet Changers for Quick Change of Top Tooling

STEP 5:

CNC Vises and Top Tooling for Holding Power that Holds Up



Good news – you're not far from achieving the potential of all of your multi-axis machining applications.

With Jergens Fixture Pro quick change workholding, we have everything you need under the spindle, from subplates to vises and top tooling. Our full range of standard solutions are easily assembled to meet your specific 4 axis and 5 axis CNC machining needs, plus we have full custom design and build capabilities for your unique challenges.

It begins just by knowing your basic equipment, starting with your machine table. One of the many benefits of Jergens Fixture Pro is the flexibility to mount the system to any machine or rotary table.

From there, you can 'build' your own, and we're here to support you every step of the way. If you need help selecting the right components for your application, just contact Jergens customer service at 877-426-2504.



Jergens®

WORKHOLDING SOLUTIONS GROUP

FIXTURE-PRO® MULTI-AXIS QUICK CHANGE FIXTURING

How Fixture-Pro® Works

Unique, modular design offers maximum flexibility when choosing workholding for your job.

- Easily set up new or prototype jobs
- Move jobs from one machine to another
- Portability - Risers, adaptors, pallet changers and top tooling can be used on any machine
- Fixture-Pro grows with your machine tool investment

Machine Mounting Options

Option 1 QLS Mounting System

Jergens Quick Locating System or QLS allows for rapid and accurate location of QLS components on a QLS subplate.



Two precision ground shoulder bolts pass through precision ground liners to accurately locate and mount to the QLS grid.

Option 2 Centering Pin to QLS Grid

Utilizes center pin and standard SHCS to mount to the QLS Subplate. Diamond pin for radial location.



Central bore pin location standard on QLS subplates. Multiple center pin locations available on request.

Option 3 Direct to Table

Mount direct to table with center pin, keyways, SHCS and t-slot nuts.



Quickly direct mount for prototype work, long runs or to maximize Z travel.

Rotary Adaptors for QLS and ZPS

The Fixture-Pro adaptor permits the easy mounting of Fixture-Pro system QLS based vises, dovetail vises, collet holders and the Quick-Loc™ pallet changers for quick, flexible multi axis workholding on popular rotary indexers and trunions.

Quickly add the QLS mounting Grid to most popular table configurations and utilize Fixture-Pro top tooling and Quick-Loc™ pallet changers.

ZPS systems from Jergens provide a single step to fix, position and clamp parts, reducing setup time by as much as 90%. At the same time, repeatability within 0.0002" can be achieved.

See page 76 for more rotary adapter products, including risers and top plates.





Jergens
QUICK-LOC
MADE IN USA

A Solution for EVERY Platform



HORIZONTAL



VERTICAL



ROTARY



AVAILABLE IN BOTH
52mm & 96mm PATTERNS



REPEATABILITY
0.0003" (0.008mm)



SOLUTIONS FOR
HORIZONTAL, VERTICAL
AND ROTARY APPLICATIONS

QUICK-LOC™ PALLETS

Jergens new Quick-Loc™ pallets provide fast and repeatable fixture changes for small tooling platforms. They feature a single drive screw for fast operation. The comprehensive selection of base pallets, risers, and accessories allow this system to be configured for multiple applications. They are also compatible with other industry standard 52mm and 96mm pallet systems.



Jergens®

WORKHOLDING SOLUTIONS GROUP

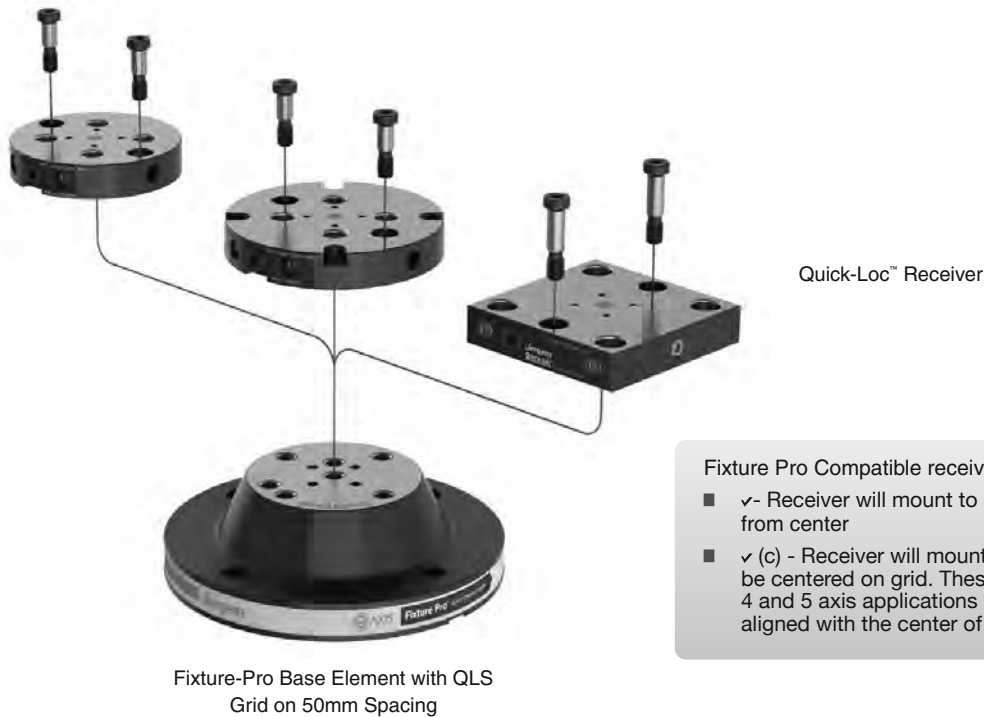
FIXTURE-PRO® MULTI-AXIS QUICK CHANGE FIXTURING

Jergens
QUICK-LOC™

Versatile Top Tooling and Receiver Mounting Options



Fixture-Pro™ Compatible - QLS Mounting



Fixture Pro Compatible receivers are denoted by ✓ or ✓ (c):

- ✓ - Receiver will mount to 50mm QLS grid offset from center
- ✓ (c) - Receiver will mount to 50mm QLS grid and be centered on grid. These receivers are ideal for 4 and 5 axis applications where the pallet must be aligned with the center of rotation

Top Tooling Solutions

The Industry's Most Complete Range of Standard Vises, Collets and Adapters



Rigid, high-strength multi-axis vises

- Self-centering
- 75mm and 130mm widths
- Wide range of standard jaws available



Dovetail Vises

- Light and heavy duty standard dovetails
- 10 Degree dovetail angle permits high clamping force
- Heavy Duty Block Style dovetails for large parts and extreme cutting conditions



ER Style Collet Holders

- Excellent option for solid round and cylindrical parts
- Available for standard ER40 collets



Vise Adapters

- For QLS and Quick-Loc™ mounting of 5 Axis vises



Quick-Loc™ Support Pallets

- Quickly design custom fixtures
- Utilize low profile clamping components

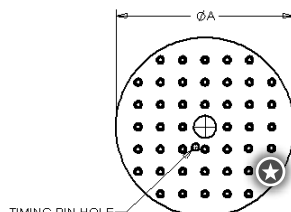
5-Axis Subplates

Standard subplates mount to machine table with center bore and do not include mounting holes.

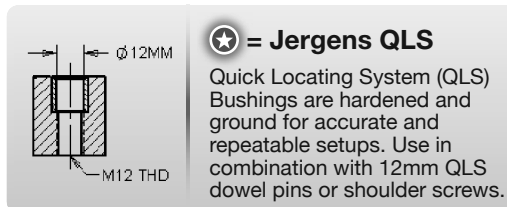
- Material: 1018 Steel
- Thickness Tolerance ± 0.005
- Flat & Parallel within .0005"/Ft. (.013mm)
- Includes Pre-Installed QLS Bushings



Round



5-Axis Subplate



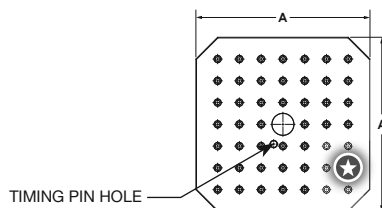
★ = Jergens QLS

Quick Locating System (QLS) Bushings are hardened and ground for accurate and repeatable setups. Use in combination with 12mm QLS dowel pins or shoulder screws.

Part Number	Style	A (mm)	Thickness of Plate (mm)	Locating Method	Timing Pin	Mounting Type	Grid	Weight lbs (Kgs)
5SP130	Round	130	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	6.3 (2.86)
5SP160	Round	160	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	10.36 (4.7)
5SP210	Round	210	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	18.83 (8.54)
5SP250	Round	250	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	26.5 (12)
5SP310	Round	310	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	41.89 (19)
5SP400	Round	400	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	70.44 (31.95)
5SP500	Round	500	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	110.9 (50.3)
5SP630	Round	630	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	176.8 (80.2)
5SP800	Round	800	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	100mm x 100mm	296.3 (134.4)



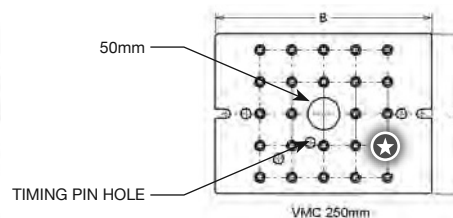
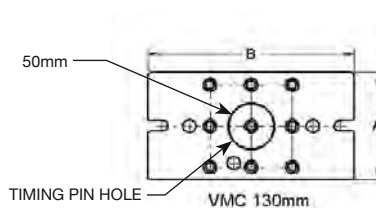
Square



Part Number	Style	A (mm)	Thickness of Plate (mm)	Locating Method	Timing Pin	Mounting Type	Grid	Weight lbs (Kgs)
5SP400S	Square	400	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	88 (39.9)
5SP500S	Square	500	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	139.3 (63.2)



VMC



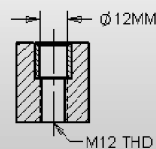
Part Number	Style	A (mm)	B (mm)	Thickness of Plate (mm)	Locating Method	Timing Pin	Mounting Type	Grid	Weight lbs (Kgs)
5QP130020	VMC	130	250	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	19.86 (9.01)
5QP250020	VMC	250	340	35	Center (50H7), Timing Pin	5LP1225001	12mm SHCS	50mm x 50mm	51.75 (23.47)



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 direct to QLS grid or tables with Fixture-Pro® Locating Keys and LHCS. Mounts to Fixture-Pro® subplate with center bore, timing pin and LHCS or QLS shoulder screws.

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

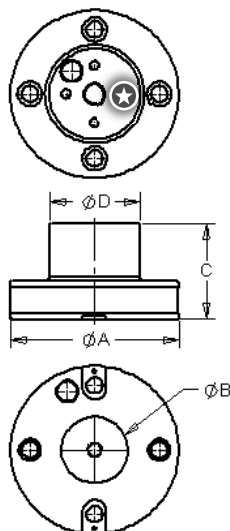


★ = Jergens QLS

Quick Locating System (QLS) Bushings are hardened and ground for accurate and repeatable setups. Use in combination with 12mm QLS dowel pins or shoulder screws.



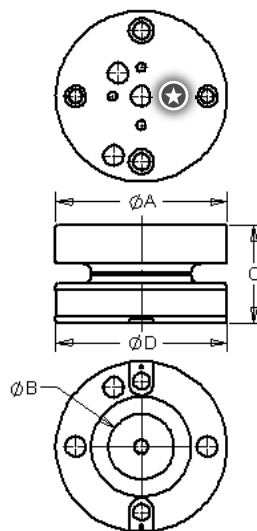
Mini Riser



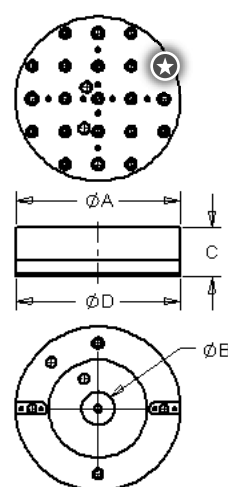
Mini Risers – Designed for use with small pallet machine tools and the 75mm platform top tooling.



130mm Barbell



250mm Barbell

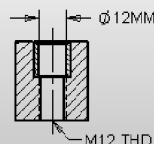


Part Number		Style	A (mm)	B (mm)	C (mm)	D (mm)	Bottom Center Bore	Mounting Type	Grid	Weight lbs (Kgs)	
Steel	Aluminum									Steel	Aluminum
5RS130001	5RS130004	Mini	130	50	75	70.3	50H7	QLS, 12mm LHCS	50mm x 50mm	8.21 (3.72)	2.84 (1.29)
5RS130002	5RS130005	Barbell Low	130	50	75	130	50H7	QLS, 12mm LHCS	50mm x 50mm	12.82 (5.82)	4.44 (2.01)
5RS130003	5RS130006	Barbell Tall	130	50	125	130	50H7	QLS, 12mm LHCS	50mm x 50mm	16.8 (7.62)	5.82 (2.64)
5RS250001	5RS250005	Barbell Low	250	50	75	250	50H7	QLS, 12mm LHCS	50mm x 50mm	88.6 (40.2)	20.5 (9.3)
5RS250002	5RS250006	Barbell Tall	250	50	125	250	50H7	QLS, 12mm LHCS	50mm 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 direct to QLS grid or tables with Fixture-Pro® Locating Keys and LHCS. Mounts to Fixture-Pro® subplate with center bore, timing pin and LHCS or QLS shoulder screws.

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



★ = Jergens QLS

Quick Locating System (QLS) Bushings are hardened and ground for accurate and repeatable setups. Use in combination with 12mm QLS dowel pins or shoulder screws.

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.

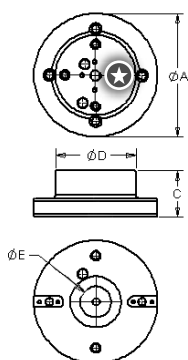


Straight Flanged Steel Riser

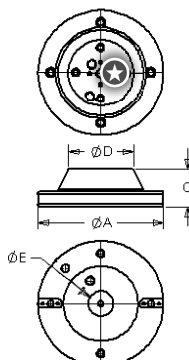
Tapered Flanged Steel Riser

SQ Riser & Pallet

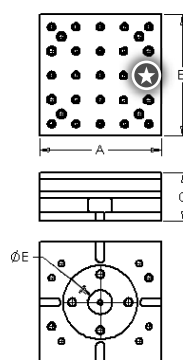
Rectangle Steel Riser



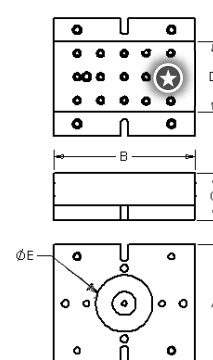
Straight Flanged Riser



Tapered Flanged Riser



Square Riser



Rectangle Riser

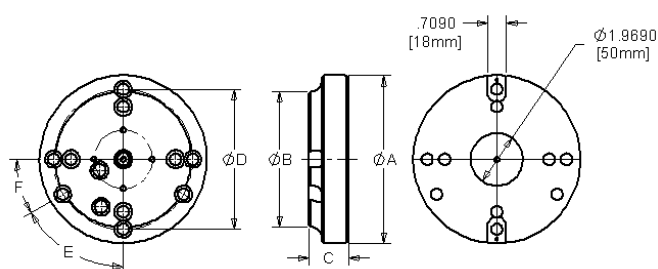
Part Number		Style	A (mm)	B (mm)	C (mm)	D (mm)	E Bottom Center Bore	Mounting Type	Grid	Weight lbs (Kgs)	
Steel	Aluminum									Steel	Aluminum
5RS250003	5RS250007	Tapered Flanged	250	—	75	130	50H7	QLS, 12mm SHCS	50mm x 50mm	36.8 (16.7)	12.75 (5.78)
5RS250004	5RS250008	Tapered Flanged	250	—	125	130	50H7	QLS, 12mm SHCS	50mm x 50mm	53.2 (24.1)	18.42 (8.36)
5RS150001	5RS150002	Rectangle	250	300	100	150	50H7	QLS, 12mm SHCS	50mm x 50mm	87.0 (39.5)	30.67 (13.9)
5RS250009	5RS250010	Square	250	250	100	250	50H7	QLS, 12mm SHCS	50mm x 50mm	77.3 (35.1)	28.0 (12.7)
5RS200007*	5RS200010*	Straight Flanged	200	—	75	130	50H7	QLS, 12mm SHCS	12mm x 50mm	24.0 (10.9)	8.4 (3.8)
5RS200008*	5RS200011*	Straight Flanged	200	—	125	130	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.

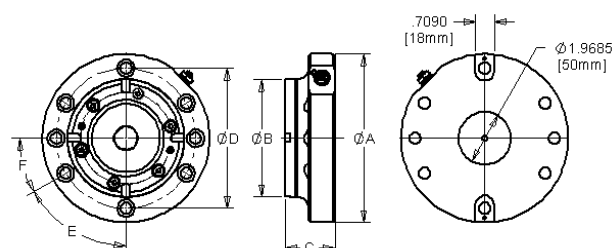
Universal Fixture-Pro® and ZPS Rotary Adapters

The Fixture-Pro® Adaptor permits the easy mounting of Fixture-Pro® system QLS based vises, dovetail vises, collet holders and the Quick-Loc™ pallet changers for quick, flexible multi axis workholding on popular rotary indexers and trunions. ZPS systems from Jergens provide a single step to fix, position and clamp parts, reducing setup time by as much as 90%. At the same time, repeatability within 0.0002" can be achieved.

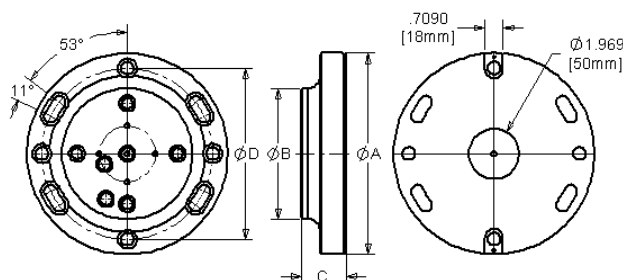
- Mounts to most rotary indexers face plates with 4 or 6 T-slots
- Fixture-Pro® model allows mounting of Jergens Fixture-Pro® top tooling
- ZPS model accepts air gun valve or standard fittings
- Material: Aluminum
- See page 48-50 for pull-studs and accessories.



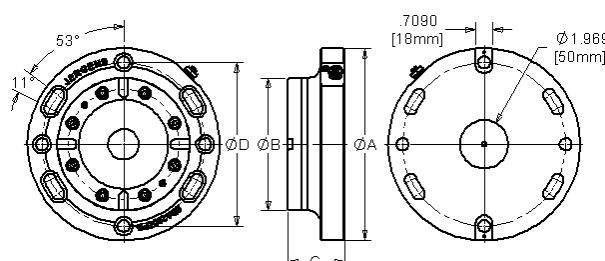
5RA160FP
ROTARY ADAPTER
Fixture-Pro



5RA160ZPS
ROTARY ADAPTER - ZPS



5RA200FP



5RA200ZPS

Part Number**	Type	A	B	C	D	E	F	Weight (LBS)
5RA160FP	Fixture Pro	160mm	130mm	38.1mm	133.4mm	60°	30°	3.62
5RA200FP	Fixture Pro	200mm	130mm	44.45	180mm	53°	11°	5.62

Part Number**	Type	A	B	C	D	E	F	Weight (LBS)
5RA160ZPS	ZPS	160mm	112mm	48.1mm	133.4m	60°	30°	5.9
5RA200ZPS	ZPS	200mm	138mm	59.45mm	170mm	53°	11°	10

**Center locator, timing key and mounting hardware sold separately



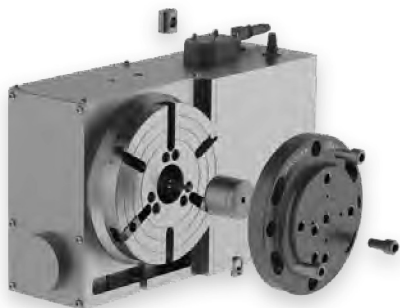
Jergens®

WORKHOLDING SOLUTIONS GROUP

FIXTURE-PRO® MULTI-AXIS QUICK CHANGE FIXTURING

Jergens-Haas Rotary Adapter Kits for 160mm and 210mm Platter Tables

- Adapters available in multi-axis Fixture Pro® and ZPS
- Fixture-Pro® adapters are ideally suited for Jergens Quick-Loc™ pallet changers, vises or collet fixtures
- ZPS Adapters include low pressure ZPS clamping modules 511139 / 511154



Kit Part Number*	Description	Haas Rotary Tables	Table Size
5RA160FP-HAAS	160MM Fixture-Pro Adapter Kit	TR; HRT	160mm
5RA160ZPS-HAAS	160MM ZPS Adapter Kit	TR; HRT	160mm
5RA200FP-HAAS	200MM Fixture-Pro Adapter Kit	TR; HRC; HRT	210mm
5RA200ZPS-HAAS	200MM ZPS Adapter Kit	TR; HRC; HRT	210mm

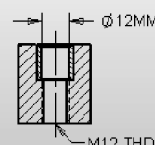
*All locating & mounting hardware for Haas kits included

5-Axis Riser Top Plates



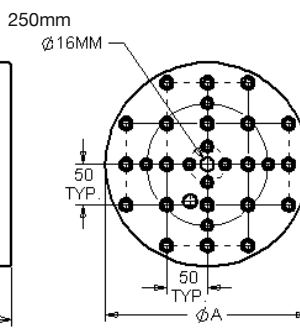
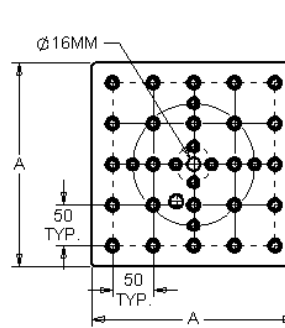
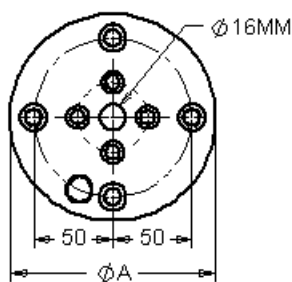
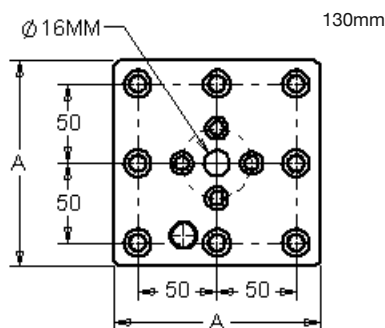
Convert the riser into a QLS grid for precision mounting of any workholding fixture, including the entire family of Fixture-Pro® Top Tooling. Available in square or round styles.

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



★ = Jergens QLS

Quick Locating System (QLS) Bushings are hardened and ground for accurate and repeatable setups. Use in combination with 12mm QLS dowel pins or shoulder screws.



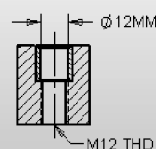
Part Number	Style	A (mm)	Thickness of Plate (mm)	Locating Method	Mounting Type	Mounting Grid	Weight lbs (Kgs)
5TP130002	Round	130	35	Center, Timing Pin	8mm SHCS	50mm x 50mm	7.09 (3.22)
5TP250002	Round	250	35	Center, Timing Pin	8mm SHCS	50mm x 50mm	27.02 (12.26)
5TP130001	Square	130	35	Center, Timing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



QLS Tooling Columns

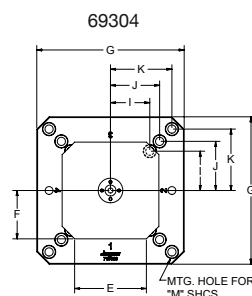
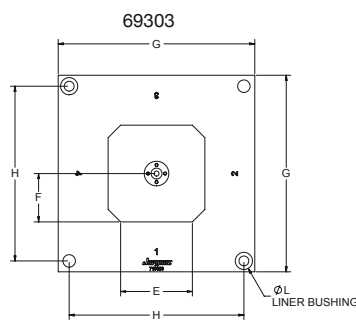
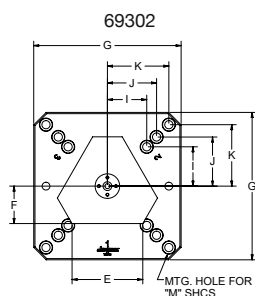
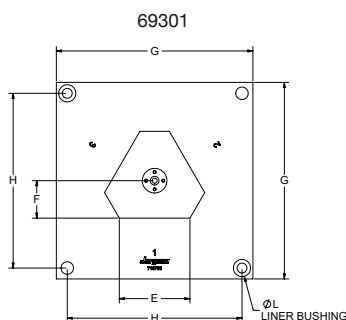
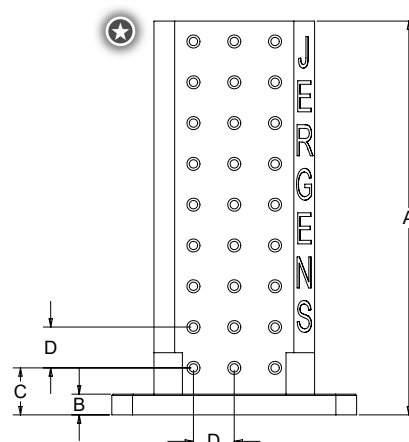
QLS Tooling Columns provide a base mounting platform for utilizing Fixture-Pro or OK Vise RM Rails on HMC's. They feature a lightweight 2-pc aluminum construction.

- **Material:** 6061-T651
- **Finish:** Black Hardcoat Anodize on Upright Faces
- **Includes Pre-Installed QLS Bushings**
- **Custom baseplates** are available upon request



★ = Jergens QLS

Quick Locating System (QLS) Bushings are hardened and ground for accurate and repeatable setups. Use in combination with 12mm QLS dowel pins or shoulder screws.



Part No.	No. of Sides	A (in)	B (in)	C (in)	D (mm)	E (in)	F (in)	G (mm)	H (in)	I (mm)	J (mm)	K (mm)	L (mm)	M	Weight lbs (kg)
69301	3	19	1	2.27	50	5.66	3	400	14	—	—	—	20	—	85 (39)
69302	3	19	1	2.27	50	5.66	3	300	—	80	100	125	—	5/8" or M16	80 (36)
69303	4	19	1	2.27	50	5.75	3.875	400	14	—	—	—	20	—	125 (57)
69304	4	19	1	2.27	50	5.75	3.875	300	—	80	100	125	—	5/8" or M16	113 (51)



Jergens®

WORKHOLDING SOLUTIONS GROUP

FIXTURE-PRO® MULTI-AXIS QUICK CHANGE FIXTURING

Fixture-Pro® Pyramid Risers

Jergens Pyramid Risers give users the ability to increase productivity of 5 axis machining centers. The angled faces permit multi part loads while still providing the increased part access needed in 5 axis machining centers. The flexible design ties together many of Jergens popular quick change and top tooling options.

Key Features & Benefits:

- Light weight aluminum design
- Versatile mounting options
- Topside center hole for optional tooling ball (29071)
- Direct to table mounting is compatible with popular 5 axis t-slotted machine tables
- Angled faces are compatible with select pallets and top tooling from the following Jergens product lines:

Jergens
Quick-Loc™

Jergens
FIXTURE PRO®
QUICK-CHANGE FIXTURING



Versatile Mounting Options

Direct to Table



Mount direct to t-slotted machine table. Locate with center pin and timing key. Secure to table with t-nuts & SHCS

QLS Mounting System



Mount to Fixture-Pro® base elements such as subplates via Jergens QLS Mounting System. A combination of (2) 12mm QLS shoulder screws and (2) M12 SHCS will accurately locate and securely clamp the pyramid to a base element.

Quick-Loc™ Pallet System

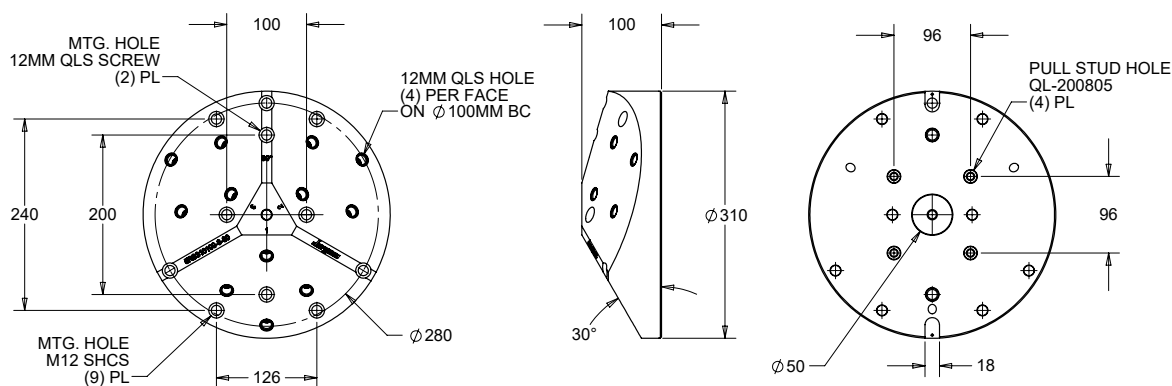


Mount to Jergens Quick-Loc™ Pallet System with (4) QL-200805 pull studs spaced at 96mm. Locate and clamp in a single step.

3-Sided Fixture-Pro® Pyramid Riser

- 6061-T651 Aluminum
- Hardcoat Anodized
- QLS Bushings Installed
- Custom sizes & configurations available upon request

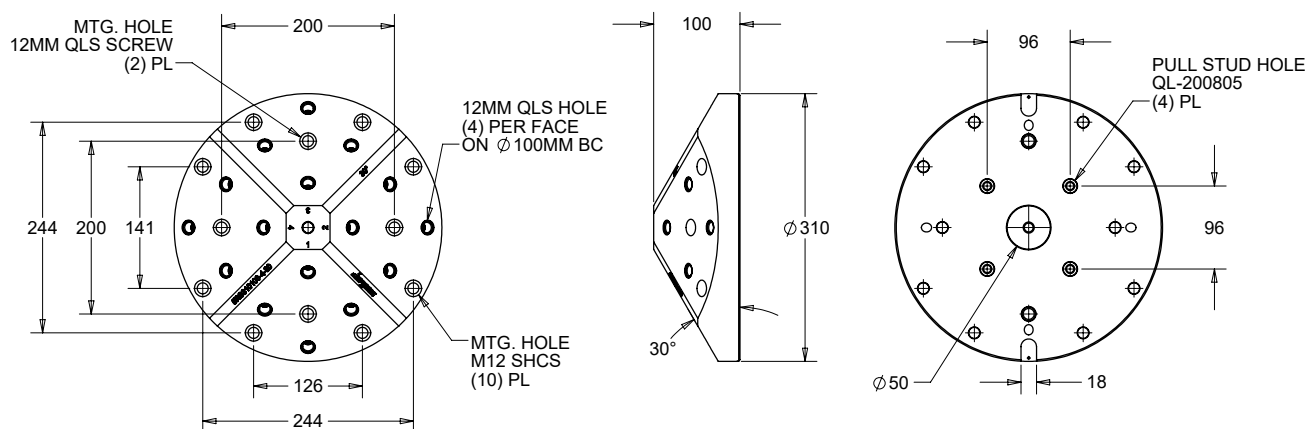
Part Number	Wt. lbs(kg)
5RS310100-3-30	28 (12.7)



4-Sided Fixture-Pro® Pyramid Riser

- 6061-T651 Aluminum
- Hardcoat Anodized
- QLS Bushings Installed
- Custom sizes & configurations available upon request

Part Number	Wt. lbs(kg)
5RS310100-4-30	26 (11.8)



3-Sided Pyramid Configuration Examples

52mm Quick-Loc™ Pallets



Part Number	Quantity
5RS310100-3-30	1 pc
QL-100306	3 pcs
5SH1220	6 pcs

75mm Vises Quick-Loc™ Mount



Part Number	Quantity
5RS310100-3-30	1 pc
QL-100306	3 pcs
5SH1220	6 pcs
5CV13050-IN	3 pcs

96mm Quick-Loc™ Pallets



Part Number	Quantity
5RS310100-3-30	1 pc
QL-100126	3 pcs
5SH1225	6 pcs

130mm Vises Quick-Loc™ Mount



Part Number	Quantity
5RS310100-3-30	1 pc
QL-100126	3 pcs
5SH1225	6 pcs
5CV13042-IN	3 pcs

75mm Vises QLS Mount



Part Number	Quantity
5RS310100-3-30	1 pc
5VA13075	3 pcs
5SH1230	6 pcs
5CV13049-IN	3 pcs

130mm Vises QLS Mount



Part Number	Quantity
5RS310100-3-30	1 pc
5CV13041-IN	3 pcs
5SH1250	6 pcs



4-Sided Pyramid Configuration Examples

52mm Quick-Loc™ Pallets



Part Number	Quantity
5RS310100-4-30	1 pc
QL-100306	4 pcs
5SH1220	8 pcs

75mm Vises Quick-Loc™ Mount



Part Number	Quantity
5RS310100-4-30	1 pc
QL-100306	4 pcs
5SH1220	8 pcs
5CV13050-IN	4 pcs

96mm Quick-Loc™ Pallets



Part Number	Quantity
5RS310100-4-30	1 pc
QL-100126	2 pcs
5SH1225	4 pcs

130mm Vises Quick-Loc™ Mount



Part Number	Quantity
5RS310100-4-30	1 pc
QL-100126	2 pcs
5SH1225	4 pcs
5CV13042-IN	2 pcs

75mm Vises QLS Mount



Part Number	Quantity
5RS310100-4-30	1 pc
5VA13075	4 pcs
5SH1230	8 pcs
5CV13049-IN	4 pcs

130mm Vises QLS Mount



Part Number	Quantity
5RS310100-4-30	1 pc
5CV13041-IN	2 pcs
5SH1250	4 pcs



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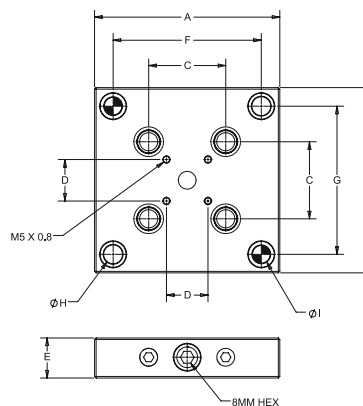
FIXTURE-PRO® MULTI-AXIS QUICK CHANGE FIXTURING

Quick-Loc™ Receivers

Quick-Loc™ Receivers provide a platform for fast and accurate mounting of fixtures and workpieces. Square, rectangular, and round styles are available. Custom mounting configurations available upon request.

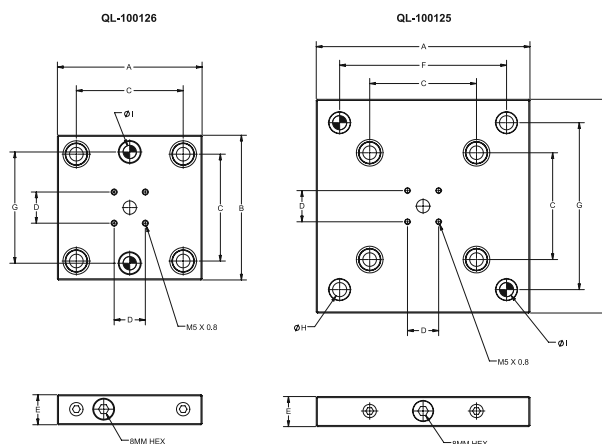
- Material: Alloy Steel
- Heat Treat: Case Hardened, Rc 58-62
- Thickness Tolerance: $\pm 0.01\text{mm}$

52mm Square Receivers



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100105	104	104	52	28	27	82	82	12.7	12H7	3.97 (1.80)	22 (30)	QL-200800	—
QL-100115	125	125	52	28	27	100	100	12.7	12H7	6.12 (2.78)	22 (30)	QL-200800	✓ (c)

96mm Square Receivers

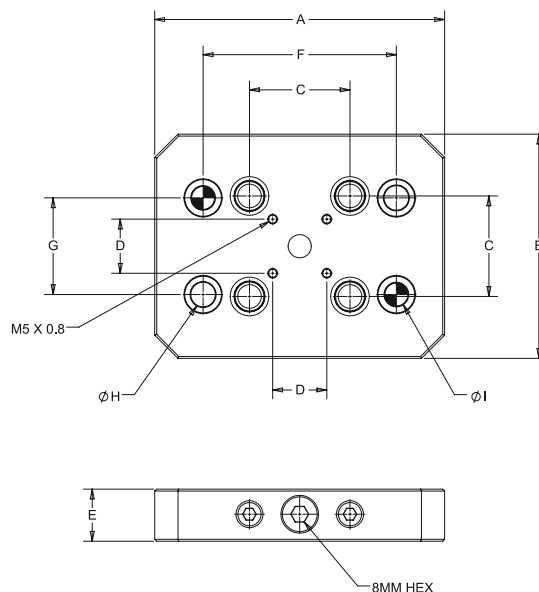


Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100125	192	192	96	28	27	150	150	12.7	12H7	15.44 (7.00)	22 (30)	QL-200805	✓
QL-100126	130	130	96	28	27	—	100	—	12H7	6.95 (3.15)	22 (30)	QL-200805	✓ (c)

✓ - Receiver will mount to 50mm QLS grid offset from center | ✓ (c) - Receiver will mount to 50mm QLS grid and be centered on grid.

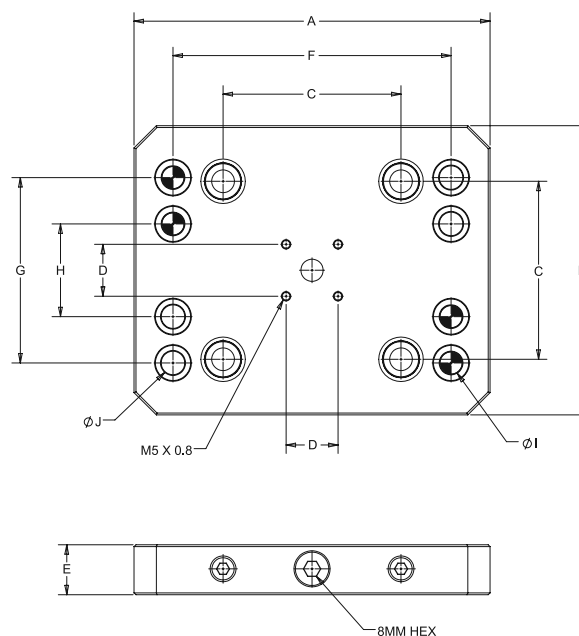


52mm Rectangular Receiver



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100205	150	126	52	28	27	100	50	12.7	12H7	6.82 (3.09)	22 (30)	QL-200800	✓

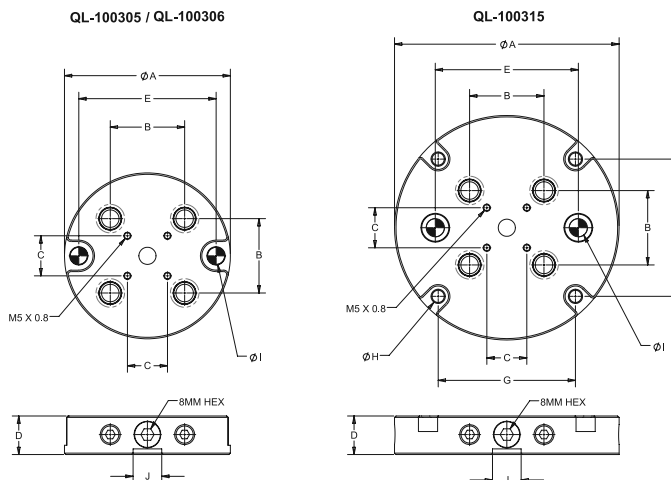
96mm Rectangular Receivers



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	J (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100215	192	156	96	28	27	150	100	50	12H7	12.7	11.77 (5.34)	22 (30)	QL-200805	✓
QL-100216	229	156	96	28	27	200	100	—	12H7	12.7	15.06 (6.83)	22 (30)	QL-200805	✓ (c)

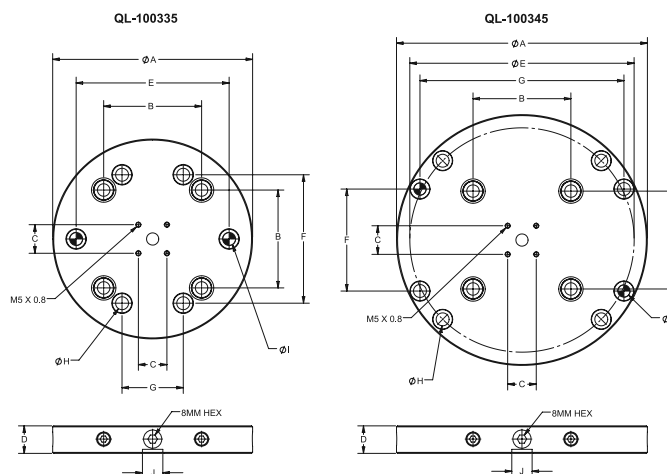
✓ - Receiver will mount to 50mm QLS grid offset from center | ✓ (c) - Receiver will mount to 50mm QLS grid and be centered on grid.

52mm Round Receivers



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	J (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100305	116	52	28	27	96	—	—	—	12H7	20	3.61 (1.64)	22 (30)	QL-200800	—
QL-100306	130	52	28	27	100	—	—	—	12H7	20	5.14 (2.33)	22 (30)	QL-200800	✓ (c)
QL-100315	157	52	28	27	100	96	96	9	12H7	20	7.47 (3.39)	22 (30)	QL-200800	✓ (c)

96mm Round Receivers

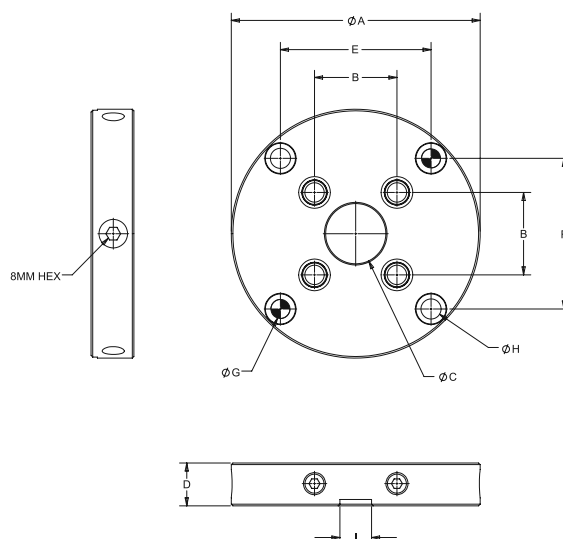


Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	J (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100335	196	96	28	27	150	126	60	12.7	12H7	20	12.45 (5.65)	22 (30)	QL-200805	✓
QL-100345	246	96	28	27	220	100	200	12.7	12H7	20	20.17 (9.15)	22 (30)	QL-200805	✓ (c)

✓ - Receiver will mount to 50mm QLS grid offset from center | ✓ (c) - Receiver will mount to 50mm QLS grid and be centered on grid.



52mm Round Receiver with Bore

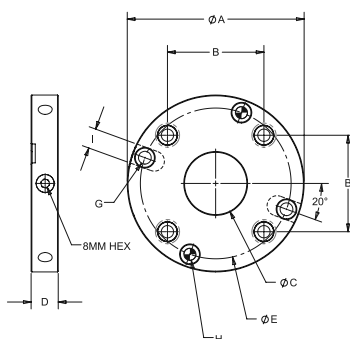


Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100375	157	52	38	27	95	95	12H7	12.7	20	7.19 (3.26)	22 (30)	QL-200800	—

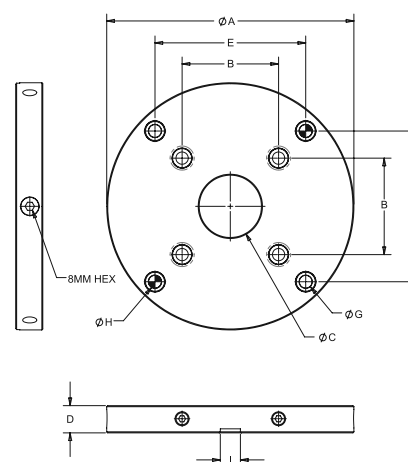
96mm Round Receivers with Bore



QL-100385 / QL-100395



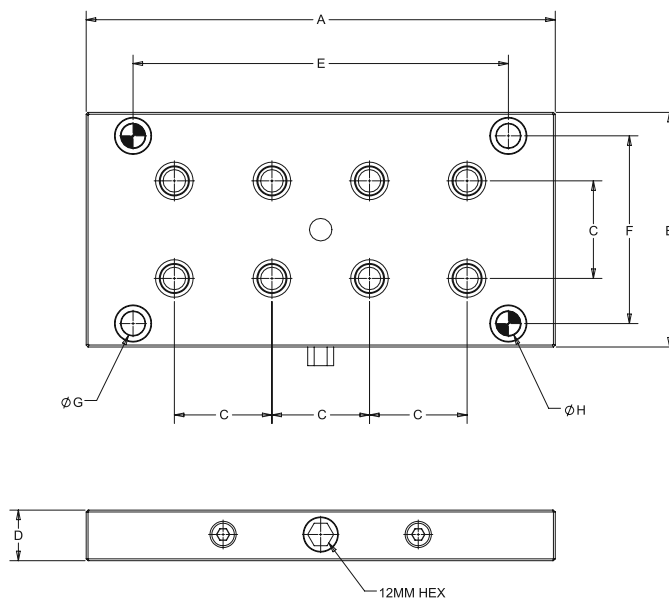
QL-100405



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100385	176	96	62	27	150	—	12.7	12H7	20	8.54 (3.87)	22 (30)	QL-200805	—
QL-100395	196	96	62	27	150	—	12.7	12H7	20	11.22 (5.09)	22 (30)	QL-200805	✓
QL-100405	246	96	62	27	150	150	12.7	12H7	20	18.95 (8.60)	22 (30)	QL-200805	✓

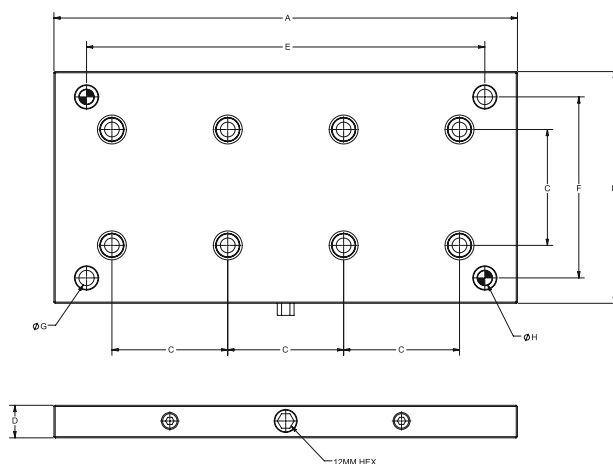
✓ - Receiver will mount to 50mm QLS grid offset from center | ✓ (c) - Receiver will mount to 50mm QLS grid and be centered on grid.

52mm Double Grid Receiver



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100250	250	125	52	27	200	100	12.7	12H7	12.29 (5.57)	22 (30)	QL-200800	✓ (c)

96mm Double Grid Receiver

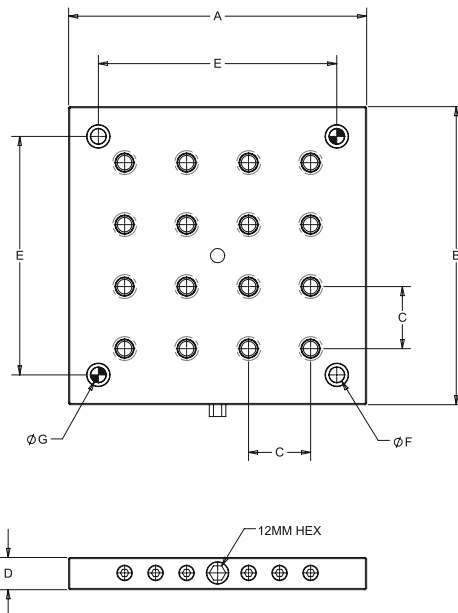


Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-100260	384	192	96	27	350	150	12.7	12H7	30.75 (13.95)	22 (30)	QL-200805	✓

✓ - Receiver will mount to 50mm QLS grid offset from center | ✓ (c) - Receiver will mount to 50mm QLS grid and be centered on grid.

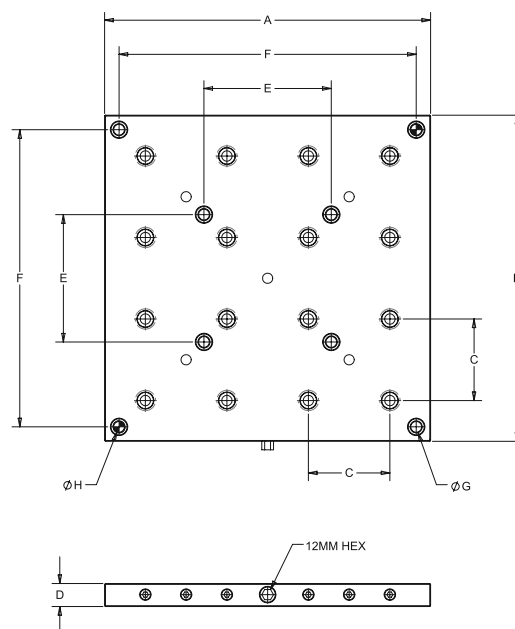


52mm Multi-Grid Receiver



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-300320	250	250	52	27	200	12.7	12H7	23.7 (10.8)	22 (30)	QL-200800	✓ (c)

96mm Multi-Grid Receiver



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud	Fixture-Pro Compatible
QL-300330	384	384	96	27	150	350	12.7	12H7	60.1 (27.3)	22 (30)	QL-200805	✓

✓ - Receiver will mount to 50mm QLS grid offset from center | ✓ (c) - Receiver will mount to 50mm QLS grid and be centered on grid.



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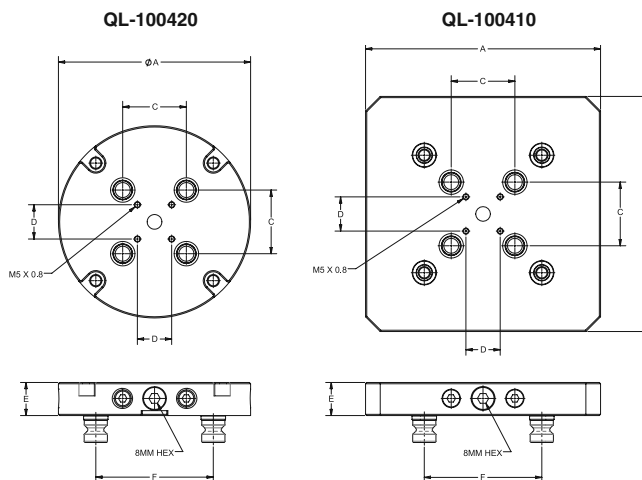
FIXTURE-PRO® MULTI-AXIS QUICK CHANGE FIXTURING

Reduction Receivers

Reduction Receivers function as adapters to allow tooling utilizing the smaller 52mm pattern to be mounted on 96mm pattern receivers.

- Material: Alloy Steel
- Heat Treat: Case Hardened, Rc 58-62
- Thickness Tolerance: ± 0.01 mm
- Pull Studs Included

96-52mm Reduction Receivers



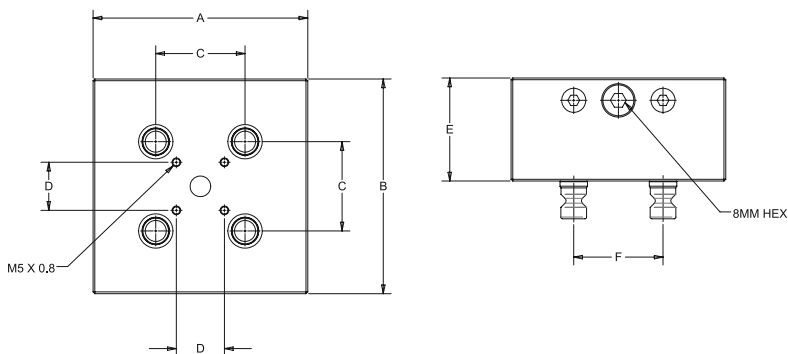
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud
QL-100410	192	192	52	28	27	96	15.71 (7.13)	22 (30)	QL-200800 / QL-200805
QL-100420	157	—	52	28	27	96	7.90 (3.58)	22 (30)	QL-200800 / QL-200805

Integrated Risers

Quick-Loc™ Integrated Risers provide a means of raising tooling up from the machine table to gain greater part access. Square and round styles are available. These risers feature a Quick-Loc™ Receiver built directly into the top of the riser body.

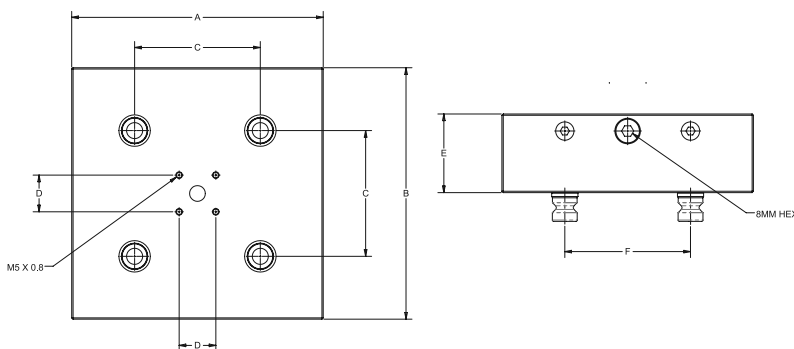
- Material: Alloy Steel
- Heat Treat: Case Hardened, Rc 58-62
- Thickness Tolerance: ± 0.01 mm
- Pull Studs Included

52mm Square Integrated Risers



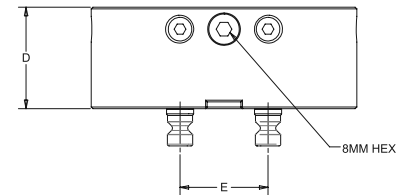
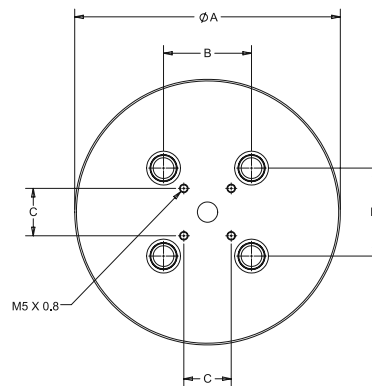
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	Weight lbs (kg)	Max.Torque ft*lbs (Nm)	Pull Stud
QL-200210	125	125	52	28	60	52	15.35 (6.96)	22 (30)	QL-200800
QL-200215	125	125	52	28	100	52	26.01 (11.80)	22 (30)	QL-200800

96mm Square Integrated Risers



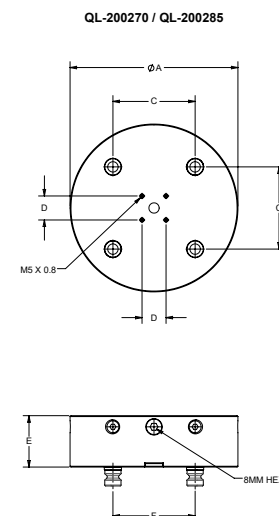
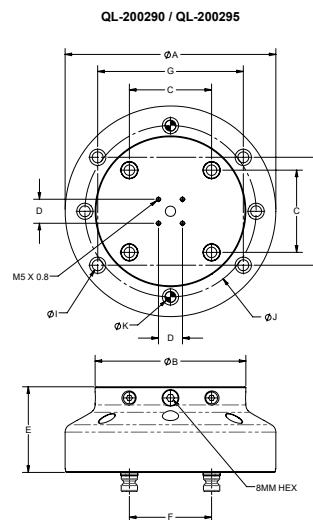
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	Weight lbs (kg)	Max.Torque ft*lbs (Nm)	Pull Stud
QL-200220	192	192	96	28	60	96	36.96 (16.76)	22 (30)	QL-200805
QL-200225	192	192	96	28	100	96	61.88 (28.07)	22 (30)	QL-200805

52mm Round Integrated Risers



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud
QL-200260	157	52	28	60	52	19.03 (8.63)	22 (30)	QL-200800
QL-200265	157	52	28	100	52	32.27 (14.64)	22 (30)	QL-200800

96mm Round Integrated Risers



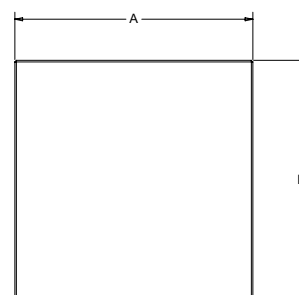
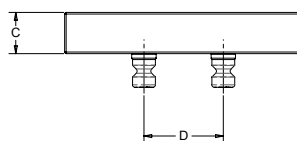
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	J (mm)	K (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud
QL-200270	176	—	96	28	60	96	—	—	—	—	—	23.91 (10.85)	22 (30)	QL-200805
QL-200285	196	—	96	28	100	96	—	—	—	—	—	50.85 (23.07)	22 (30)	QL-200805
QL-200290	246	176	96	28	60	96	170	126	12.7	200	12H7	31.78 (14.42)	22 (30)	QL-200805
QL-200295	246	176	96	28	100	96	170	126	12.7	200	12H7	60.91 (27.63)	22 (30)	QL-200805

Support Pallets

Support Pallets function as machinable blanks. These are intended to be modified to accept various tooling components and clamping devices. They provide an ideal base for building fixtures that will be mounted with the Quick-Loc™ system. Square and round styles are available.

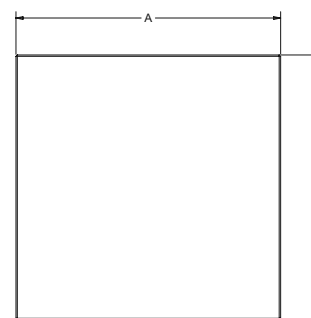
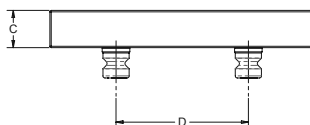
- Material: Low Carbon Steel
- Thickness Tolerance: ± 0.13 mm
- Pull Studs Included

52mm Square Support Pallets



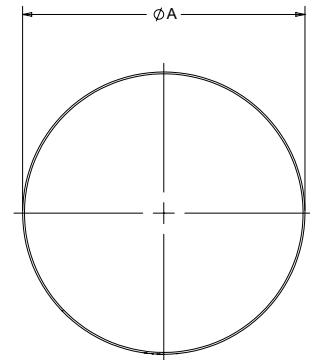
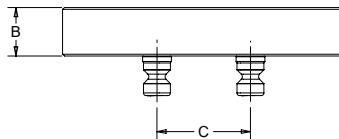
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	Weight lbs (kg)	Pull Stud
QL-200300	96	96	27	52	4.40 (2.00)	QL-200800
QL-200320	156	156	27	52	11.42 (5.18)	QL-200800

96mm Square Support Pallets



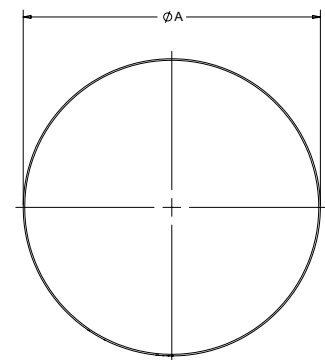
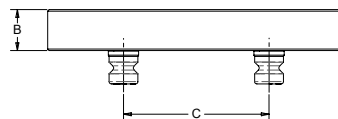
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	Weight lbs (kg)	Pull Stud
QL-200500	156	156	27	96	11.42 (5.18)	QL-200805
QL-200510	192	192	27	96	18.05 (8.19)	QL-200805

52mm Round Support Pallet



Part Number	A (mm)	B (mm)	C (mm)	Weight lbs (kg)	Pull Stud
QL-200410	157	27	52	9.11 (4.13)	QL-200800

96mm Round Support Pallet

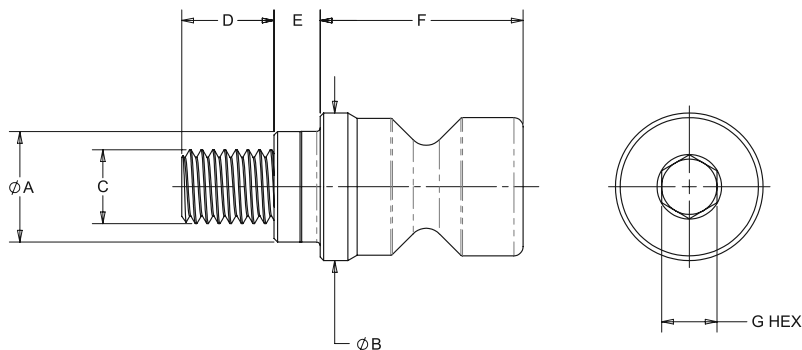


Part Number	A (mm)	B (mm)	C (mm)	Weight lbs (kg)	Pull Stud
QL-200610	196	27	96	17.65 (8.01)	QL-200805



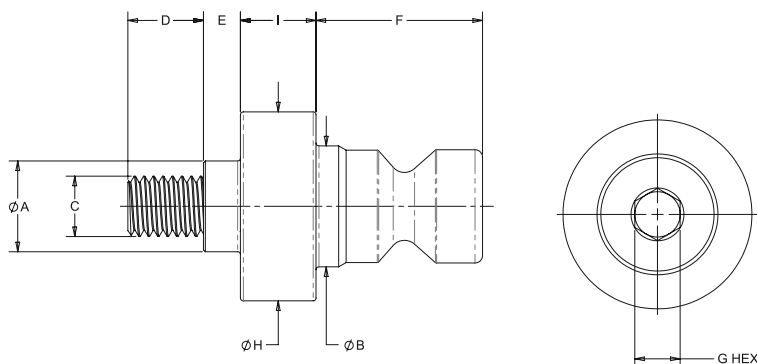
Pull Studs

- Material: A2 Tool Steel
- Heat Treat: Thru Hardened, Rc 50-54
- Finish: Black Oxide



Part Number	A (mm)	B (mm)	C	D (mm)	E (mm)	F (mm)	G (mm)	Weight lbs (kg)
QL-200800	12	16	M8 x 1.25	10	5	22	6	.06 (.03)
QL-200805	16	20	M10 x 1.5	14	5	22	8	.10 (.05)

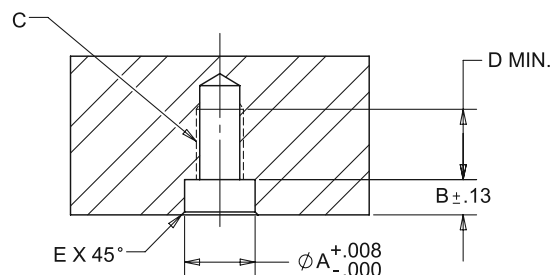
Spacer Studs



Part Number	A (mm)	B (mm)	C	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (mm)	Weight lbs (kg)
QL-200810	12	16	M8 x 1.25	10	5	22	6	25	10	.14 (.06)
QL-200815	16	20	M10 x 1.5	14	5	22	8	29	10	.21 (.10)

Pull Stud Installation Dimensions

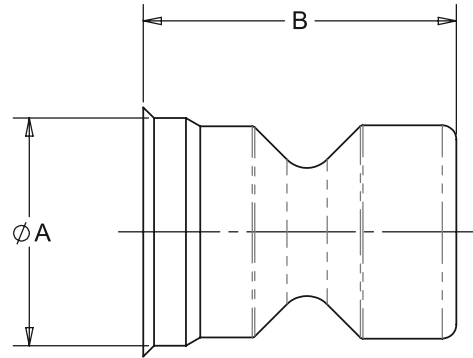
Part Number	A (mm)	B (mm)	C	D (mm)	E (mm)
QL-200800 / QL-200810	12	6	M8 x 1.25	12	0.8
QL-200805 / QL-200815	16	6	M10 x 1.5	16	0.8



*tolerances in millimeters

Plugs

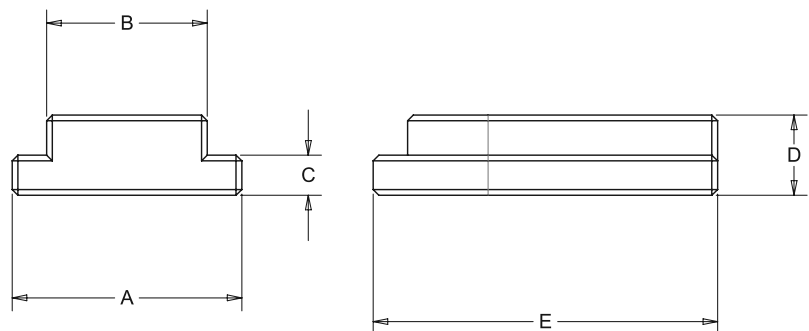
- Protects unused and exposed pull stud holes from filling with contaminants
- Material: Delrin or 6061 Aluminum



Part Number	A (mm)	B (mm)	Material	Weight lbs (kg)
QL-200820	16	22	Plastic	.01 (.005)
QL-200825	20	22	Plastic	.02 (.01)
QL-200830	16	22	Aluminum	.02 (.01)
QL-200835	20	22	Aluminum	.03 (.014)

Keys

- Used for aligning any of the Quick-Loc™ elements with bottom keyways to the t-slots of a machine table or rotary face.
- Material: Low Carbon Steel
- Heat Treat: Case Hardened, Rc 58-62



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	Weight lbs (kg)
QL-200840	20	14	3.5	7	31	.02 (.01)
QL-200845	20	16	3.5	7	31	.03 (.014)
QL-200850	20	18	3.5	7	31	.03 (.014)
QL-200855	20	20	—	7	31	.04 (.02)

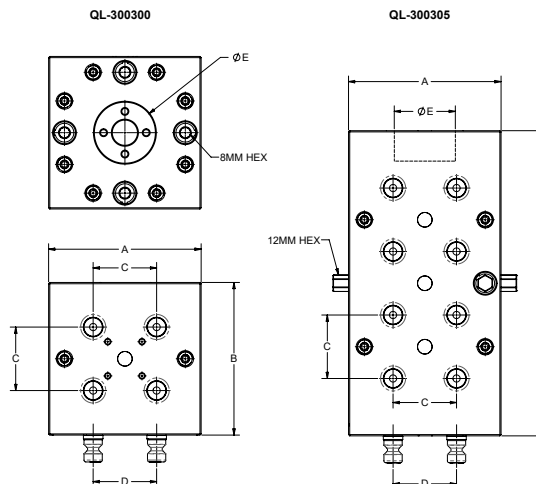


Cubes & Twin Bases

Quick-Loc™ Cubes and Twin Bases function like miniature quick change tooling columns. They are well suited for multiple fixture setups as well as 4th axis applications in VMC's. The upright faces feature Quick-Loc™ Receivers built directly into the body of the cube/base. Available with 2, 3, or 4 sides.

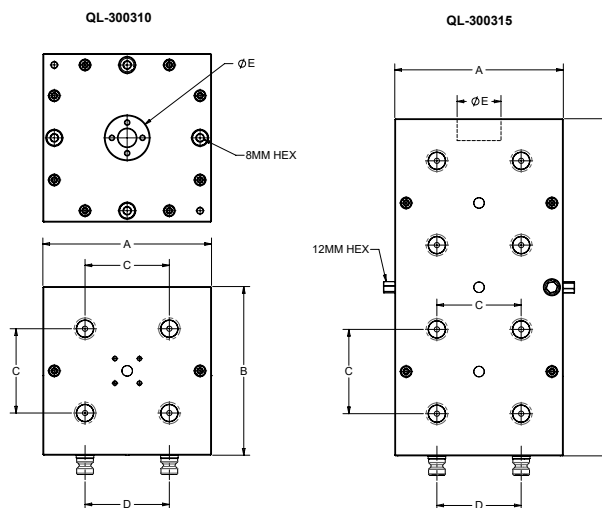
- Material: Alloy Steel
- Heat Treat: Case Hardened, Rc 58-62
- Pull Studs Included

52mm Cubes



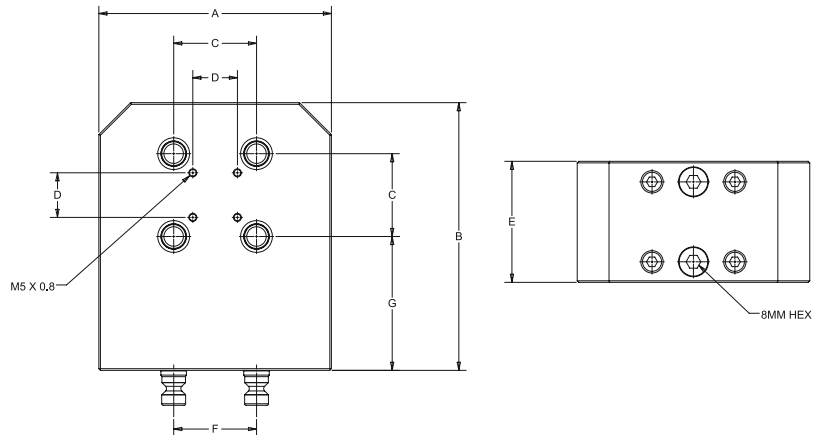
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud
QL-300300	125	125	52	52	50H7	25.29 (11.47)	22 (30)	QL-200800
QL-300305	125	250	52	52	50H7	50.55 (22.93)	44 (60)	QL-200800

96mm Cubes



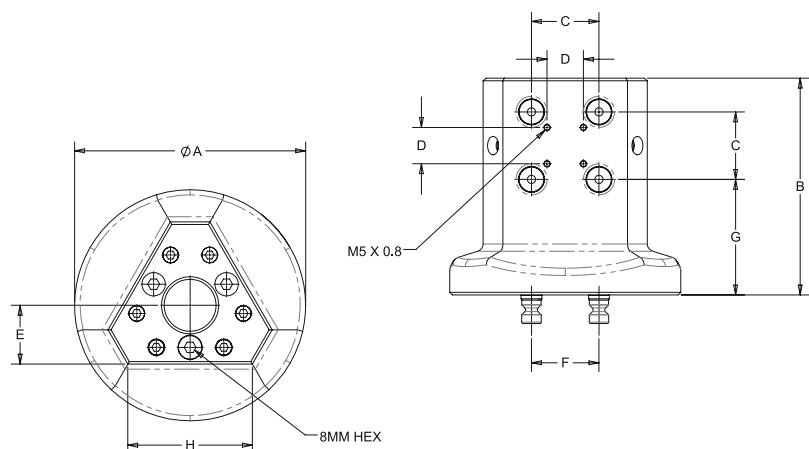
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud
QL-300310	192	192	96	96	50H7	106.8 (48.4)	22 (30)	QL-200805
QL-300315	192	384	96	96	50H7	216.8 (98.3)	44 (60)	QL-200805

Twin Base



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud
QL-400200	144	168	52	28	76	52	84	29.62 (13.44)	22 (30)	QL-200800
QL-400205	190	247	96	28	116	96	110	91.63 (41.56)	22 (30)	QL-200805

Tri Cube



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud
QL-400300	178	167	52	28	45	52	89	96	27.58 (12.51)	22 (30)	QL-200800
QL-400305	247	247	96	28	77	96	110	157	99.32 (45.05)	22 (30)	QL-200805

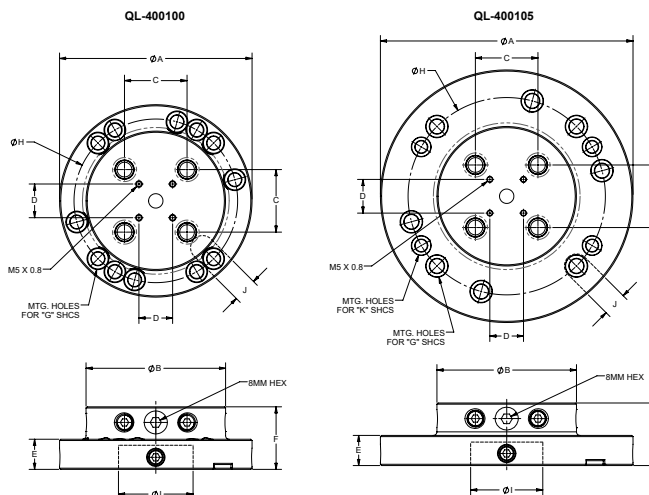


Rotary Receivers

Quick-Loc™ Rotary Receivers provide a quick change platform specifically suited for rotary indexers and 5-axis machines.

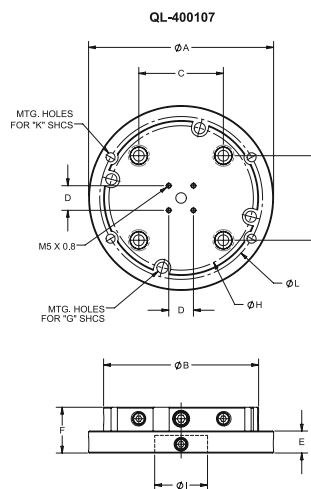
- Material: Alloy Steel
- Heat Treat: Case Hardened

52mm Rotary



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G	H (mm)	I (mm)	J (mm)	K	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud
QL-400100	160	116	52	28	25	52	M10 or 3/8"	136	60	20	—	11.15 (5.06)	22 (30)	QL-200800
QL-400105	210	116	52	28	25	52	M12	164	60	20	3/8"	16.72 (7.58)	22 (30)	QL-200800

96mm Rotary

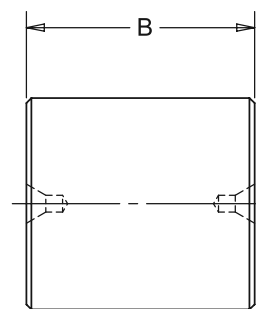
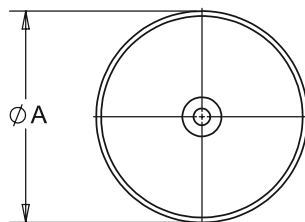


Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G	H (mm)	I (mm)	K	L (mm)	Weight lbs (kg)	Max. Torque ft*lbs (Nm)	Pull Stud
QL-400107	210	176	96	28	25	52	M12	164	60	3/8"	185	22.32 (10.58)	22 (30)	QL-200805

Center Locating Pins for Rotary Receivers

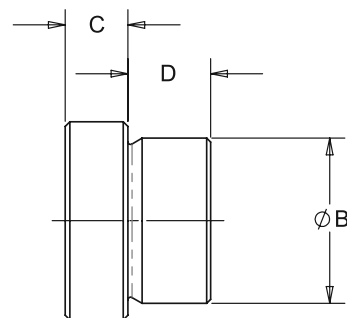
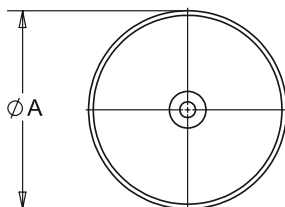
- Material: Stressproof®
- Finish: Black Oxide
- Diameter Tolerance
 - Nominal Metric sizes: g5
 - Nominal Inch sizes: -.0004/-.0009"

Straight Pin



Part Number	A (mm)	B (mm)	Weight lbs (kg)
QL-488500	60	65	3.14 (1.42)

Step Pin

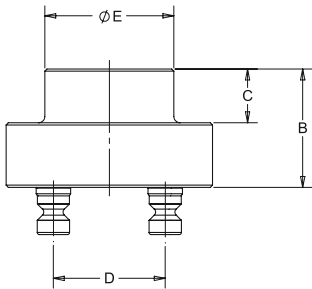
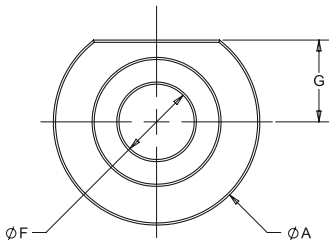


Part Number	A (mm)	B in (mm)	C (mm)	D (mm)	Weight lbs (kg)
QL-488520	60	1.9685 (50)	19	25	1.74 (.79)
QL-488600	60	1.50 (38.1)	19	25	1.39 (.63)
QL-488610	60	2.00 (50.8)	19	25	1.77 (.80)

Alignment Tool

The alignment tool provide accurate datum surfaces for measuring Quick-Loc™ system setups. These can be used to check critical aspects of a setup such as position or runout.

- Material: Alloy Steel
- Heat Treat: Case Hardened
- Pull Studs Included



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	Weight lbs (kg)	Pull Stud
QL-400530	96	55	25	52	60	35	38	6.02 (2.73)	QL-200800
QL-400535	160	55	25	96	60	35	64	11.38 (5.16)	QL-200805

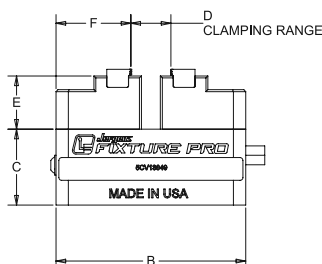
QUICK CHANGE FIXTURING » FIXTURE PRO® MULTI-AXIS QUICK CHANGE FIXTURING

75mm Self-Centering Vise

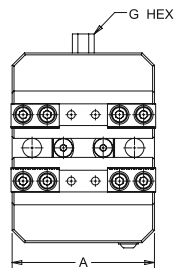
Clamping Force: 3,500 lbs. at 50 foot lbs.

Vises can be ordered with alternate jaw types by adding one of the following suffixes to a base part number:

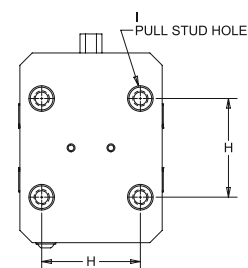
- **A** for aluminum soft jaws
- **H** for hardened step jaws
- **S** for steel soft jaws
- **IN** for insert jaws



TOP VIEW



BOTTOM VIEW



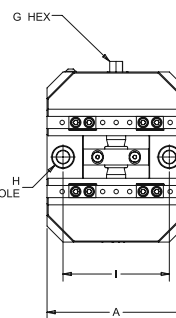
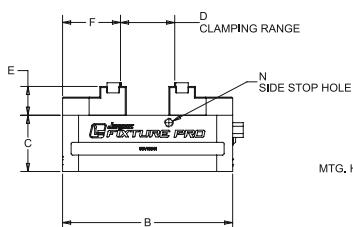
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	I (part no.)	Pull Studs Included	Weight (kg)
5CV13049-IN	75	100	40	12-85	28	39.5	10	52	QL-200800	No	3.1
5CV13050-IN	75	100	40	12-85	28	39.5	10	52	QL-200800	Yes	3.3
5CV13051-IN	75	160	40	12-145	28	39.5	10	52	QL-200800	No	4.0
5CV13052-IN	75	160	40	12-145	28	39.5	10	52	QL-200800	Yes	4.2

130mm Self-Centering Vise

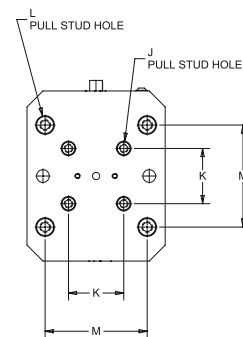
Clamping Force: 3,600 lbs. at 50 foot lbs.

Vises can be ordered with alternate jaw types by adding one of the following suffixes to a base part number:

- **A** for aluminum soft jaws
- **H** for hardened step jaws
- **S** for steel soft jaws
- **IN** for insert jaws



TOP VIEW



BOTTOM VIEW

Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H	I (mm)	J (Part No.)	K (mm)	L (Part No.)	M (mm)	Pull Studs Included	N	Weight (kg)
5CV13041-IN	130	160	53	12-150	27	54	12	12mm QLS	100	QL-200800	52	QL-200805	96	No	M8 X 1.25	7.4
5CV13042-IN	130	160	53	12-150	27	54	12	12mm QLS	100	QL-200800	52	QL-200805	96	Yes (QL-200805)	M8 X 1.25	7.7
5CV13045-IN	130	250	53	12-240	27	54	12	12mm QLS	100	QL-200800	52	QL-200805	96	No	M8 X 1.25	10.2
5CV13046-IN	130	250	53	12-240	27	54	12	12mm QLS	100	QL-200800	52	QL-200805	96	Yes (QL-200805)	M8 X 1.25	10.5

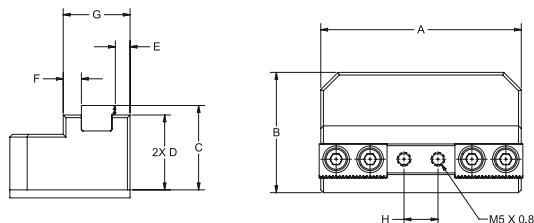


Vise Jaws & Accessories

Insert Jaw Sets for 75mm Vise



- Includes Serrated Inserts
- Alloy Steel Jaw, Thru Hardened
- Alternate Insert Styles Available
- Set Includes 2 Jaws

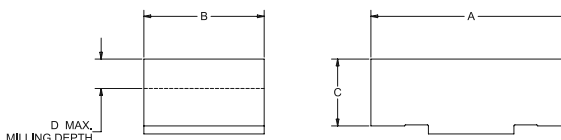


Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)
5CV13049-INSJ	75	45	31.6	28	5.5	6.7	25	12.7
5CV13049-INSJ-L	75	45	25.6	22	5.5	6.7	25	12.7

Soft Jaw Sets for 75mm Vise



- High Strength Aluminum with Blue Anodize Finish or Low Carbon Steel with Black Oxide Finish
- Set Includes 2 Jaws w

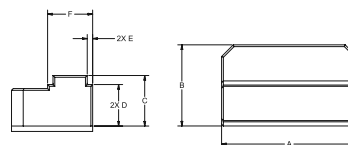


Part Number	A (mm)	B (mm)	C (mm)	D (mm)	Material
5CV13049-ASJ	75	45	25	11	Aluminum
5CV13049-ASJ-50	75	45	50	36	Aluminum
5CV13049-SSJ	75	45	25	11	Steel
5CV13049-SSJ-50	75	45	50	36	Steel

Step Jaw Set for 75mm Vise



- Alloy Steel, Thru Hardened, Black Oxide Finish
- Set Includes 2 Jaws



Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)
5CV13049-HSJ	75	45	28	23	3	25

Insert Options



Serrated

Part Number	Lg. (mm)
5JISER.5	12.7
5JISER1.0	25.4
5JISER1.5	38.1



Peak

Part Number	Lg.(mm)
5JIDPK.5	12.7
5JIDPK1.0	25.4
5JIDPK1.5	38.1



Scalloped

Part Number	Lg. (mm)
5JISCA.5	12.7
5JISCA1.0	25.4
5JISCA1.5	38.1



Dovetail

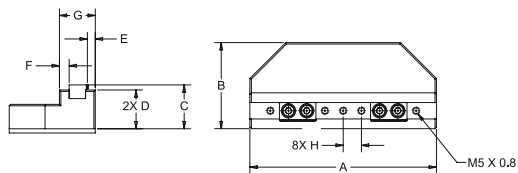
Part Number	Lg.(mm)	Angle
5JIDOV.5	12.7	10°
5JIDOV1.0	25.4	10°
5JIDOV1.5	38.1	10°
5JIDOV30.5	12.7	30°
5JIDOV301.0	25.4	30°
5JIDOV301.5	38.1	30°

Vise Jaws & Accessories

Insert Jaw Sets for 130mm Vise



- Includes Serrated Inserts
- Alloy Steel Jaw, Thru Hardened
- Alternate Insert Styles Available, see page 102
- Set Includes 2 Jaws

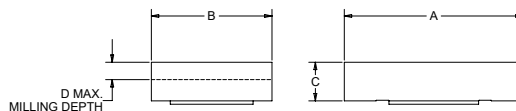


Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)
5CV13041-INSJ	130	60	30	27	5.5	6.7	25	12.7
5CV13041-INSJ-L	130	60	36	33	5.5	6.7	25	12.7

Soft Jaw Sets for 130mm Vise



- High Strength Aluminum with Blue Anodize Finish or Low Carbon Steel with Black Oxide Finish
- Set Includes 2 Jaws

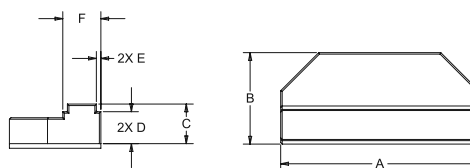


Part Number	A (mm)	B (mm)	C (mm)	D (mm)	Material
5CV13041-ASJ	130	74	26	12	Aluminum
5CV13041-ASJ-50	130	74	50	36	Aluminum
5CV13041-SSJ	130	74	26	12	Steel
5CV13041-SSJ-50	130	74	50	36	Steel

Step Jaw Set for 130mm Vise



- Alloy Steel, Thru Hardened, Black Oxide Finish
- Set Includes 2 Jaws



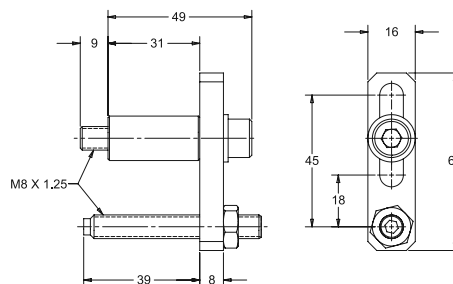
Part Number	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)
5CV13041-HSJ	130	60	26	21	3	25

Workstop for 130mm Vise



Part Number

5CV13041-WST



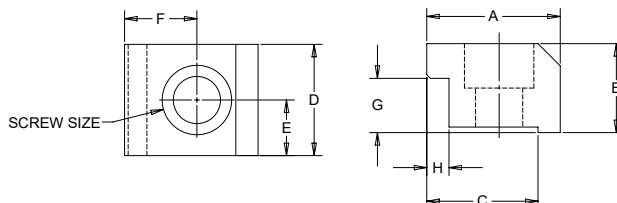


Vise Accessories

Toe Clamp Sets



- Clamp vises directly to machine tables or fixture plates
- Low Carbon Steel
- Case Hardened
- Black Oxide Finish
- 1 set includes 2 clamps



Part Number	Vise Size (mm)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	H (mm)	Screw Size
5CV13041-TC	130	38.1	25.4	31.8	31.8	15.9	20.7	15.5	6.4	1/2" or M12
5CV13049-TC	75	31.8	22.2	25.4	25.4	12.7	15.9	13	5.1	3/8" or M10

Lead Screw Chip Protectors



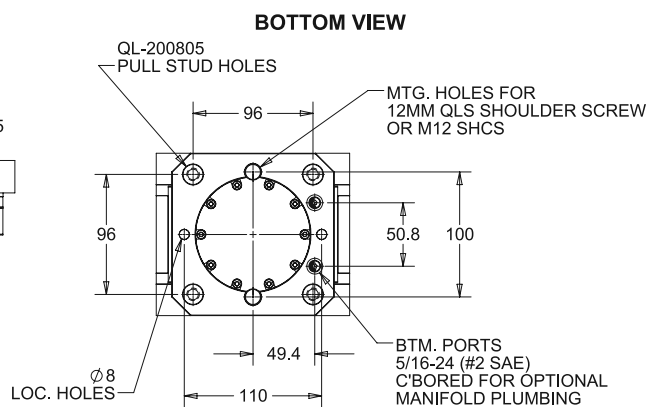
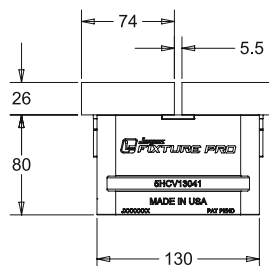
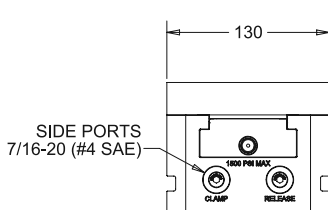
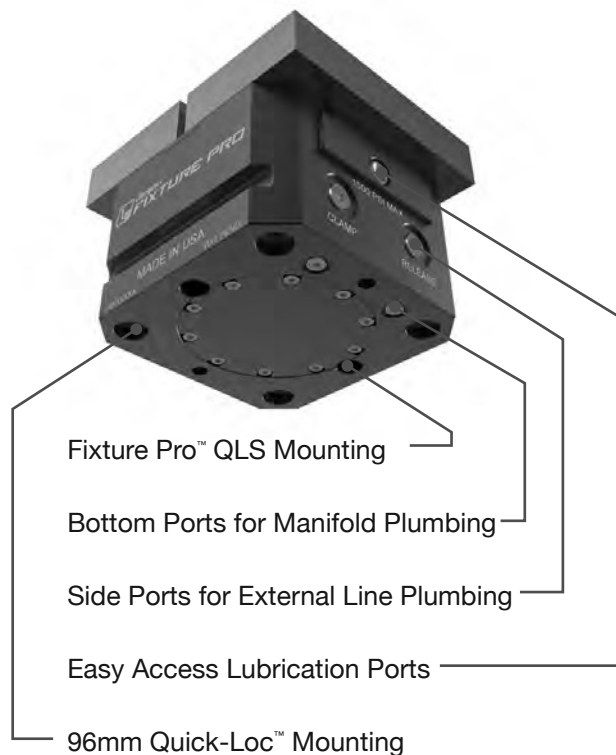
- Compressible foam inserts fill in the space around lead screw to protect it from chips
- Pieces can be stacked in succession to account for any jaw opening
- Easy installation and removal, no disassembly of vise required
- Flame retardant foam
- 1/2" thick
- 1 set includes 2 pieces

Part Number	Vise Size (mm)
5CV13041-CP	130
5CV13049-CP	75

130mm Self-Centering Hydraulic Vise



- Double-acting
- Highly-repeatable clamping forces
- Quick-change jaws
- Includes aluminum (A) or steel (S) soft jaws
- Versatile mounting options
- High clamping forces
- Low operating pressures permit running directly off of machine hydraulics
- Steel body and internal components treated with hardened low-friction process for enhanced performance and durability



Specifications

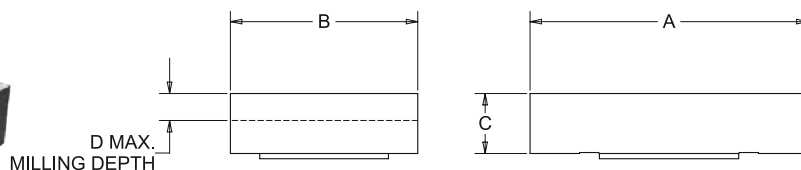
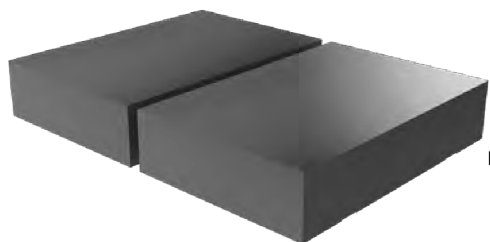
Part Number	5HCV13041-A	5HCV13041-S
Clamping Stroke - in (mm)	.22 (5.5)	.22 (5.5)
Operating Volume Clamp - in ³ (cm ³)	1.73 (28.3)	1.73 (28.3)
Operating Volume Unclamp - in ³ (cm ³)	1.95 (32)	1.95 (32)
Max. Input Pressure - psi (bar)	1,500 (104)	1,500 (104)
Min. Input Pressure - psi (bar)	500 (35)	500 (35)
Jaw Type	Alum. Soft Jaws	Steel Soft Jaws
Weight - lbs (kg)	23 (10.4)	28 (12.7)

Input Pressure		Clamping Force	
PSI	Bars	Lbs	Kgf
500	35	2,060	934
750	52	2,640	1,198
1,000	70	3,680	1,669
1,250	86	4,160	1,887
1,500	104	5,140	2,331



130mm Self-Centering Hydraulic Vise Jaws and Accessories

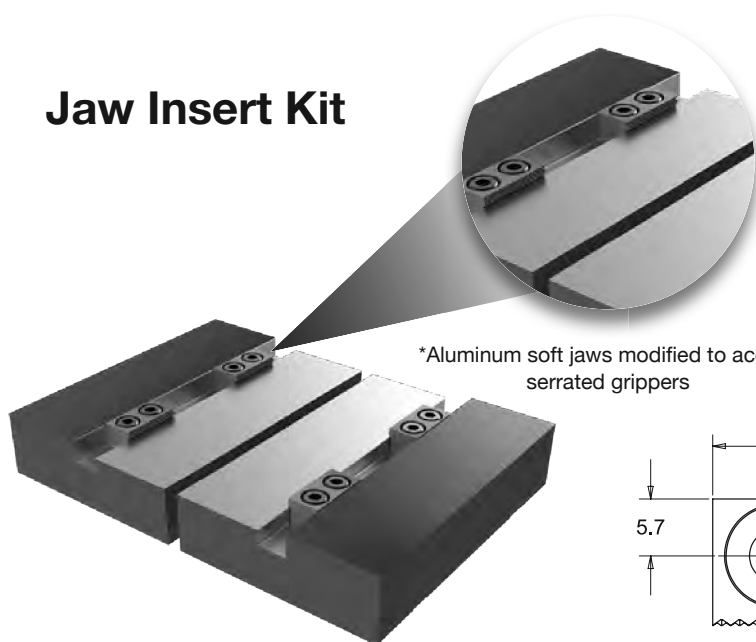
Soft Jaw Sets



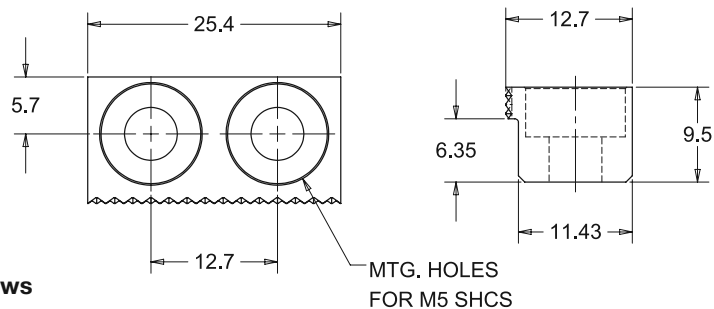
- High strength aluminum with blue anodize finish or low carbon steel with black oxide finish
- Set includes 2 jaws

Part Number	A (mm)	B (mm)	C (mm)	D (mm)	Material
5CV13041-ASJ	130	74	26	12	Aluminum
5CV13041-SSJ	130	74	26	12	Steel

Jaw Insert Kit



*Aluminum soft jaws modified to accept serrated grippers



- Gripping inserts easily install in modified soft jaws
- Extra secure holding for raw material and first operations
- Set includes 4 serrated inserts and mounting screws (does not include soft jaws)
- Case-hardened steel

Part Number

5JISER1.0-KIT

130mm Self-Centering Hydraulic Vise Pump Kits



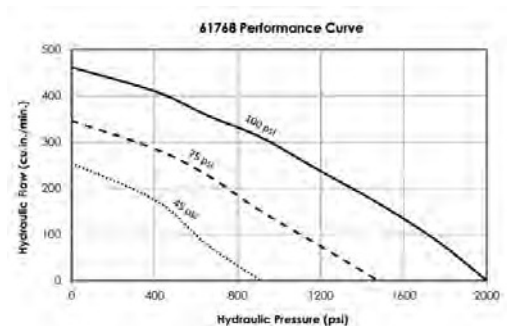
Manual Control Valve

Solenoid Control Valve

Jergens hydraulic pump kits serve as an ideal starter setup for powering 130mm self-centering hydraulic vises. They include everything needed to hookup and control a vise. The compact pumps can be mounted horizontally or vertically. Clamping action is controlled with a manual or solenoid zero leak valve. Clamping force can be adjusted with the included filter regulator. These kits are designed for powering single vise setups, for multiple vise applications please contact Jergens technical support.

Kits Include:

- 20:1 Air Powered Hydraulic Pump
- 4-Way Control Valve, Manual or Solenoid Actuated
- Hydraulic Hoses and Fittings
- Air Hose and Fittings
- Air Filter Regulator
- Hydraulic Oil



Pump Specifications	
Reservoir Capacity (in3)	115
Minimum Air Input (psi)	20
Maximum Air Input (psi)	100
Boost Ratio	20:1
Maximum Hyd. Output (psi)	2000
Maximum Flow (in3/min.)	460
Weight - lbs (kg)	40 (18)

Part Number	Control Valve Type
61768-1-MAN	Manual
61768-1-24VDC	Solenoid - 24V DC
61768-1-120VAC	Solenoid - 120V AC

THE NEW STANDARD FOR HYDRAULIC VISE QUALITY AND PRODUCTIVITY



ENGINEERED FOR IMPROVED PART QUALITY AND CONSISTENT PERFORMANCE

Our hydraulic workholding is a highly-repeatable technology with high clamping force capability and consistent holding pressure. These unique vises feature steel bodies and internal hardened (low-friction process) components for even greater performance and enhanced durability, for predictable performance even in harsh environments. Only low operating pressures are needed which means these vises perform perfectly directly off of machine hydraulics. For flexibility, both Fixture Pro™ Quick Locating System (QLS) and industry-standard 96mm Quick-Loc™ mounting patterns are included in every vise.

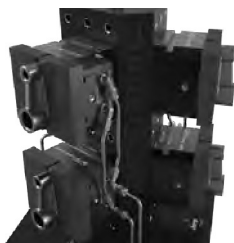


USING SPEED TO REDUCE SETUP TIME

Jergens 130mm hydraulic vises offer users the ability to position the jaws just outside of the dimension of the workpiece to minimize travel when clamping. This, in combination with the speed of hydraulic workholding, reduces clamping and unclamping operations to about one second. The ease of use of these double-acting vises allows operators to repeat these time-saving operations, adding up to measurable productivity increases. Quick-change jaws – aluminum or steel soft jaws – and jaw inserts extend the range of holding options. Plumbing and lubrication ports are easily accessed for fast connection and routine maintenance.

ONE VISE, MANY USES

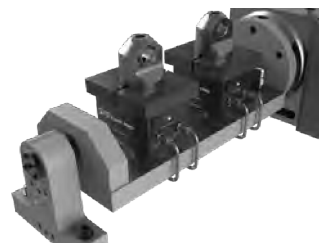
Jergens' hydraulic vise offers quick-change and secure part holding for multiple CNC machining applications including vertical, horizontal, rotary, 5-axis, and robotic setups.



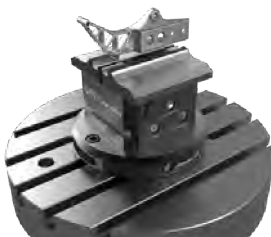
**Horizontal Machining
Center Applications**



**Vertical Machining Center
Applications**



**4th Axis Trunnion
Applications**



**5-Axis
Applications**



**Robotic / Automation
Applications**

5-Axis Top Tooling – 130mm Dovetail Vises



Light 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.

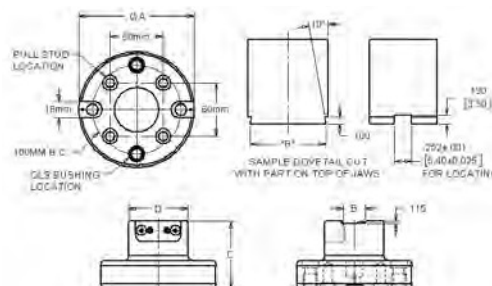
Cutting a 10° angle cut in the bottom surface of a machinable part allows for extremely high clamping forces while leaving all 5 sides accessible. The heavy duty 130mm version has higher torque and tilting moments than the standard 130mm Fixture-Pro® Dovetail Vise.



Heavy Duty

Dovetail cutter (part number 5DC3) available.

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



Part Number	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	28.6	75	65	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	7.21 (3.27)	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.

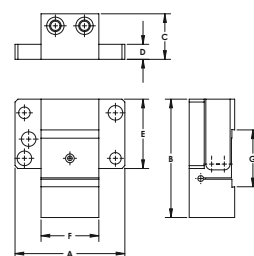
By cutting a 10° angle cut in the bottom surface of a machinable part it allows for extremely high clamping forces while leaving all 5 sides accessible.

Dovetail cutter (part number 5DC3) available.

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

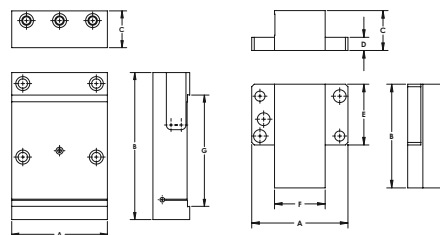


5DV200
5DV400



5DV600

5MB250

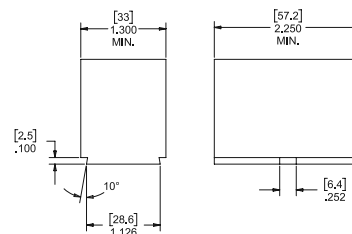


Part Number	Description	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G (mm)	Locating	Mounting Type	Mounting Grid	Weight lbs (Kgs)	Dovetail Cutter P/N
5DV200	Dovetail Pre-Cut Vise, Steel	120.7	130	50	16.5	76.2	63.5	62.5	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	7.4 (3.3)	5DC3
5DV400	Dovetail Pre-Cut 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	151.4	—	—	151.4	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	19.7 (8.9)	5DC3
5MB250	Dovetail Machinable Vise Blank	120.7	130	50	16.5	76.2	63.5	—	Center, Timing Pin, QLS	12mm SHCS	12mm X 50mm	8.0 (3.6)	5DC3



Modular Dovetail Vises

- Modular design can be configured to mount with Quick-Loc™ or QLS quick change platforms
- Secure clamping using minimal material
- Hardened steel dovetail jaws
- 10 degree dovetail angle
- Includes stop pin to prevent lateral movement of workpiece
- Dovetail cutter available (5DC3)

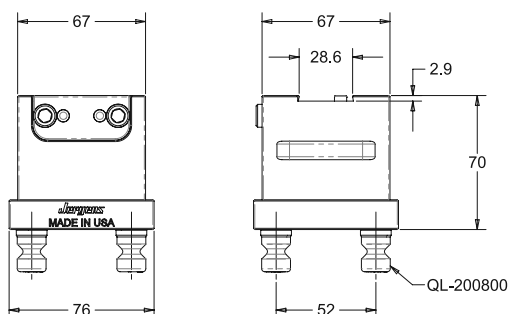


52mm Quick-Loc™ Mount



- Includes pull studs

Part Number	Wt. lb (kg)
QL-DV28.6-52	5.6 (2.54)

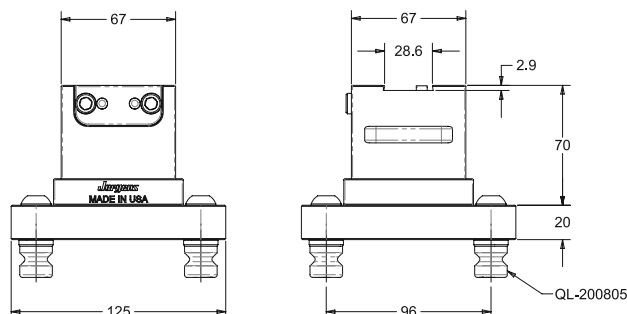


96mm Quick-Loc™ Mount



- Includes pull studs
- Aluminum adapter base

Part Number	Wt. lb (kg)
QL-DV28.6-96	7.6 (3.45)

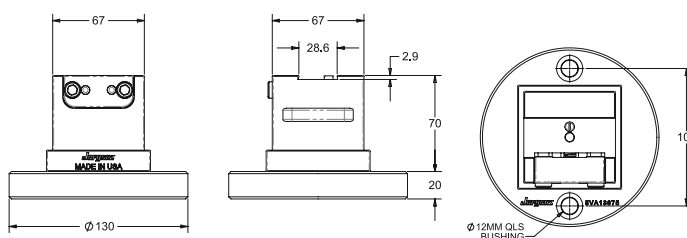


QLS Mount



- Includes 12mm QLS bushings
- Aluminum Adapter Base

Part Number	Wt. lb (kg)
QLS-DV28.6	6.90 (3.13)





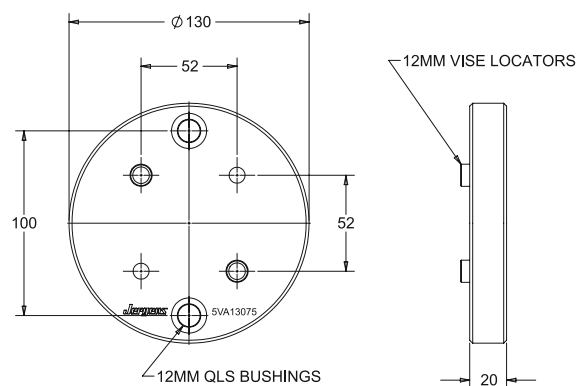
Vise Adapter Plates

QLS Vise Adapter Plate



Part Number	Wt. (kg)
5VA13075	0.7

- Allows select 52mm Quick-Loc™ top tooling to be mounted with QLS
- Aluminum, Blue Anodized
- Includes pre-installed QLS bushings and vise locators
- Includes vise mounting screws

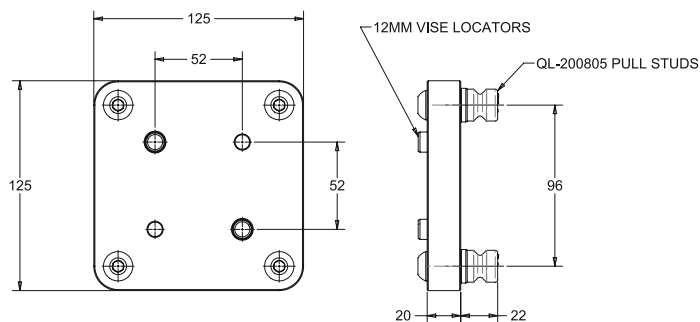


Quick-Loc™ Vise Adapter Plate



Part Number	Wt. (kg)
QL-VA52-96	1.04

- Allows select 52mm Quick-Loc™ top tooling to be mounted on 96mm Quick-Loc™ pattern
- Aluminum, Blue Anodized
- Includes pre-installed Quick-Loc™ pull studs and vise locators
- Includes vise mounting screws

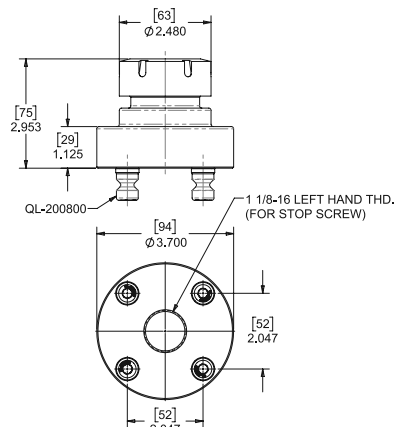


Quick-Loc™ ER Collet Fixtures

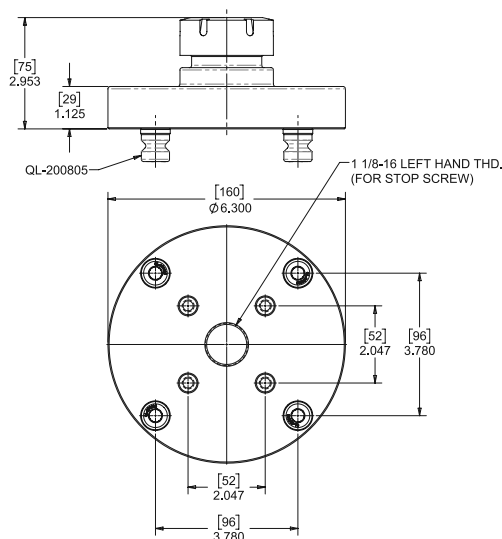
- ER Collet Fixtures provide a simple and low profile solution for clamping cylindrical workpieces
- Single piece, hardened alloy steel body
- Accepts standard ER40 collets (collets not included)
- Includes spanner style collet nut
- Includes (4) pull studs installed
- Optional stop screw (48837) permits repeatable part loading, left hand thread prevents back off when tightening collet nut



Part Number	Wt. lb (kg)
QL-ER40-52	4.9 (2.22)



Part Number	Wt. lbs (kg)
QL-ER40-52-96	11.4 (5.17)



Stop Screw



Part Number	Wt. lb (kg)
48837	0.11 (0.05)

