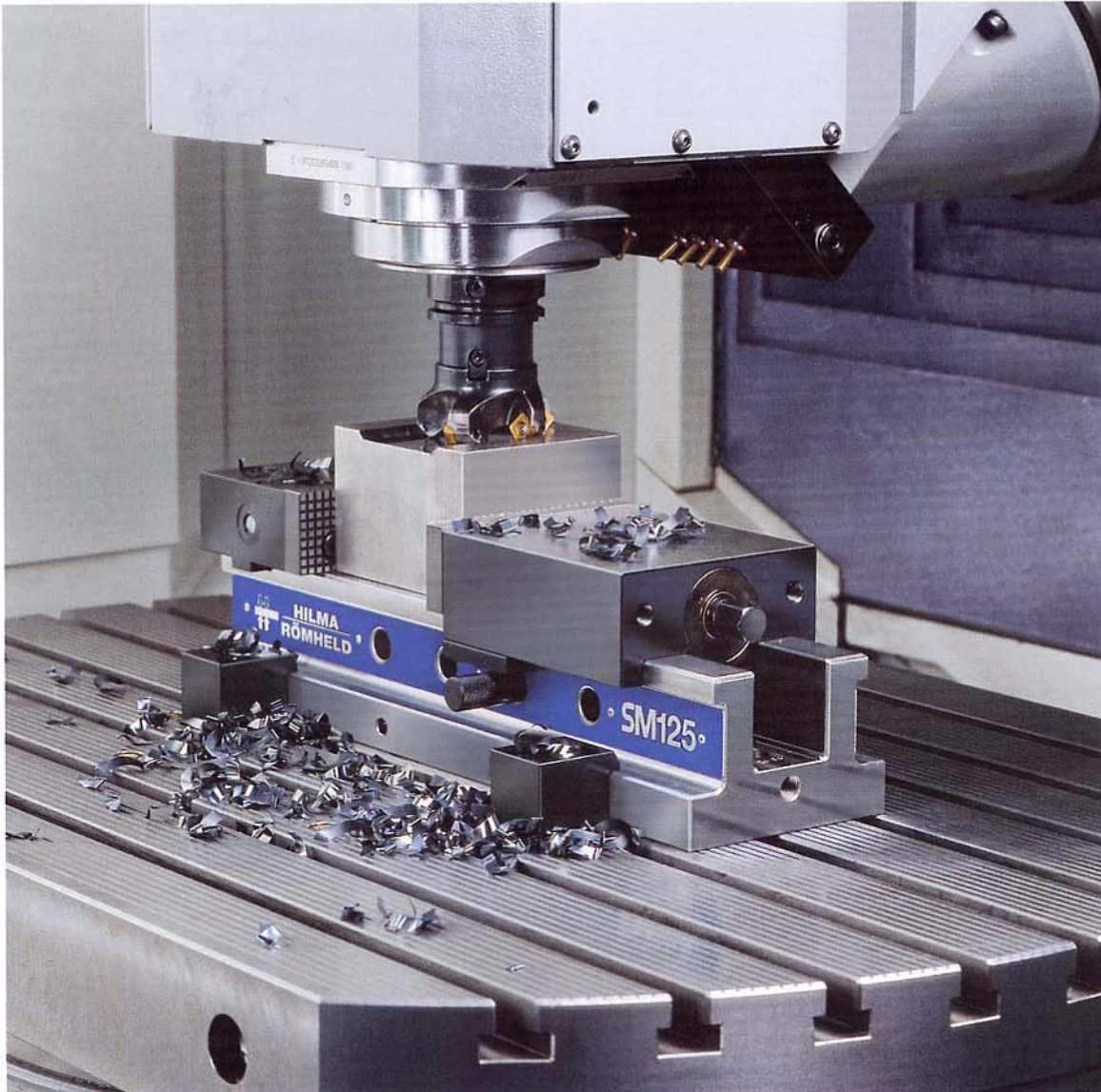


Hydro Machine Vices Standard

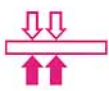


The most cost effective clamping system for die and mould making, for the construction of jigs and fixtures as well as for normal production.

Especially suited for use on conventional machine tools. In combination with the swivel base (optional extra) the vice can be swivelled in any desired position.

The field-proven details ensure high functional reliability and a long service life of this low-cost clamping system.

- ◆ Slide and base made from steel, guideways hardened and ground
- ◆ New compact design (jaw widths 100, 125 and 160 mm)
- ◆ Safe and easy clamping by optimised hydraulic system
- ◆ High precision and accuracy
- ◆ Wide range of accessories



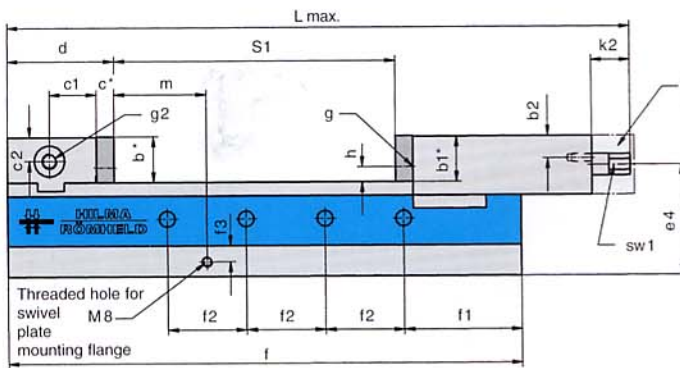
Swivel base,
see overleaf

- 1 Standard threaded holes in both sides of the fixed jaw for precision workpiece stops
- 2 Interchangeable hardened jaws (1st side plain, 2nd side serrated)
- 3 Guideways hardened and ground
- 4 Rapid coarse adjustment of the clamping range using a socket pin
- 5 Lead screw and hydraulic system well-protected inside in the slide
- 6 Unparalleled service facility: the slide can be easily removed
- 7 An angular drive (optional extra) facilitates operation, e.g. if a workpiece is to be clamped longitudinally on the machine bed (jaw width 100 – 160 mm)

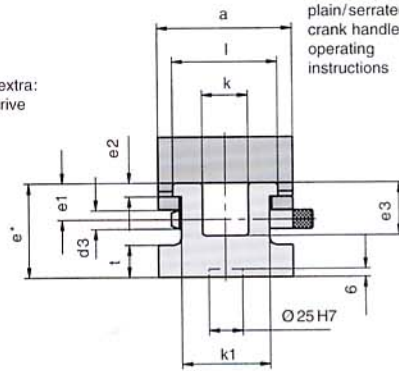
The clamping pressure is continuously built up using a crank handle.



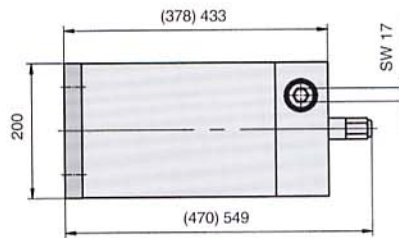
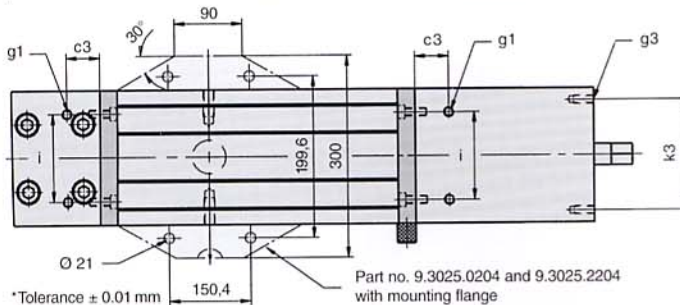
Technical data



Optional extra:
angular drive



Scope of supply:
reversible
standard jaws,
plain/serrated,
crank handle,
operating
instructions



*Tolerance ± 0.01 mm
Part no. 9.3025.0204 and 9.3025.2204
with mounting flange

Part no. 9.3025.2204
with integral angular drive

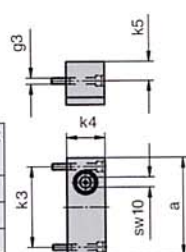
Part no.	Type	Jaw width		Clamping force		Effort on the crank Crank throw		Clamping width		Overall length		Weight kg
		a	mm	kN	N	mm	S1	L max.				
9.3022.0303	SM 100	100	25	50	80	205	461+3	18.5				
9.3023.0303	SM 125	125	40	75	100	225	522+4	31.5				
9.3024.0303	SM 160	160	50	95	125	309	679+5	58.5				
9.3025.0204	SM 200	200	100	125	200	343	941	112				
9.3025.2204	SM 200	200	100	125	200	343	1020	117				

Type	Dimensions in mm																															
	b	b1	b2	c	c1	c2	c3	d	d3	e	e1	e2	e3	e4	f	f1	f2	f3	g	g1	g2	g3	h	i	k	k1	k2	k3	l	m	t	sw1
SM 100	34	33.5	16.5	13	35	17.5	25	80	12	70	27	10	39	92	380	87	58	11	M 6 x 8	M 8 x 12	M 12 x 18	M 6 x 11	11	65	34	65.5	30	82	78g6	52	24	14
SM 125	45	44	22	15	36	23	30	100	16	82	33	13	49	98	430	105	60	14	M 8 x 10	M 10 x 13	M 12 x 18	M 10 x 14	14	80	45	84.5	35	96	98g6	75	27	17
SM 160	54	53	28	18	50	27	45	120	20	95	38	15	57	115	550	120	80	14	M 10 x 11	M 12 x 16	M 20 x 27	M 10 x 14	17	100	60	104.5	43	126	125g6	87	27	19
SM 200	67	66	-	18	45	31	-	128	28	100	50	18	75	124	690	190	115	-	M 10 x 12	-	M 20 x 27	-	23	140	75	134.5	-	-	160g6	102	25	24

Angular drive

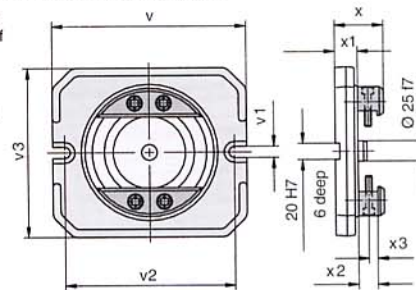
with crank handle and fastening screws.
Maintenance-free. Recommended when normal
operation is difficult or even impossible.
Ideal for retrofit.

Part no.	for type	Dimensions in mm					Weight kg
		a	g3	k3	k4	k5	
9.3294.0505	SM 100	100	M 6	82	37	19.5	1.6
9.3294.0605	SM 125	125	M 10	96	43	23	2.3
9.3294.0705	SM 160	160	M 10	126	46	29	3.4



Swivel base with mounting flanges

Important accessory
for easy swivelling of
the hydro machine
vice in any desired
position.
Precision engraved,
clearly readable
scale $4 \times 90^\circ$.
Supplied with
annular slot nuts
and fastening
screws (suitable
for retrofit).



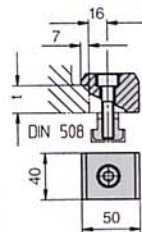
(For size 200 no mounting flange is required).

Part no.	for type	Dimensions in mm								Weight kg
		v	v1	v2	v3	x	x1	x2	x3	
9.3741.0208	SM 100	240	14	210	210	60	28	23.8	11	8.6
9.3741.0308	SM 125	290	14	256	260	69	32	26.8	14	14.5
9.3741.0408	SM 160	350	18	316	320	73	36	26.8	14	24.5
9.3741.0508	SM 200	400	22	360	370	-	40	-	-	26

Set of clamping claws including screws

For safe clamping on the machine bed.

Part no. for a set of 4	Slot mm	n mm	Screw
9.3777.2011	14	24	M 12 x 45 DIN 912
9.3777.3011	14	27	M 12 x 45 DIN 912
9.3777.3021	18	27	M 16 x 50 DIN 912



Subject to change without notice. Printed in Germany