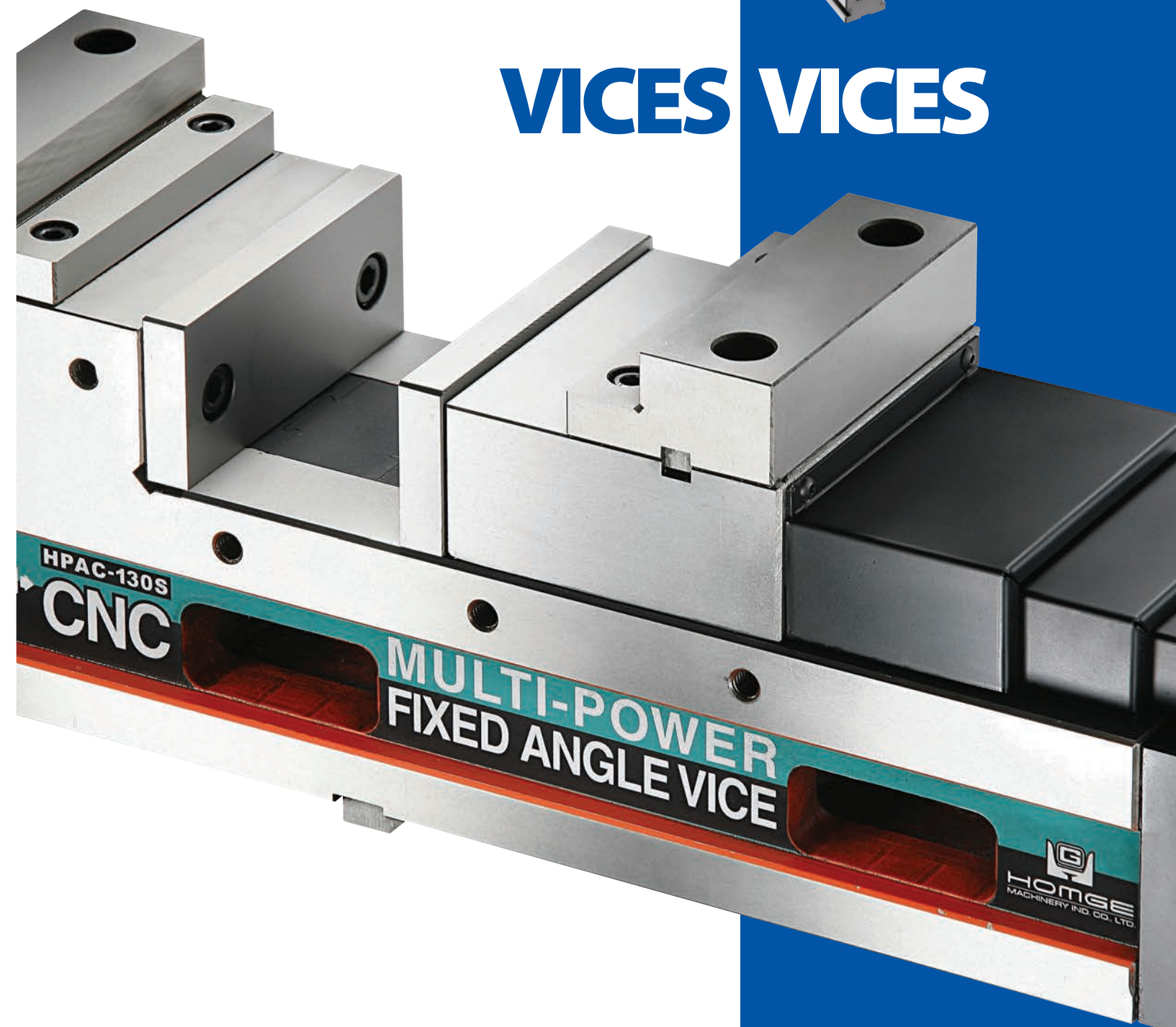


# VICES VICES





**PATENTED**  
**216009**  
**M266131**

V-01~12

## VICE IN ROW

**Model: HRV-50, 75, 100**

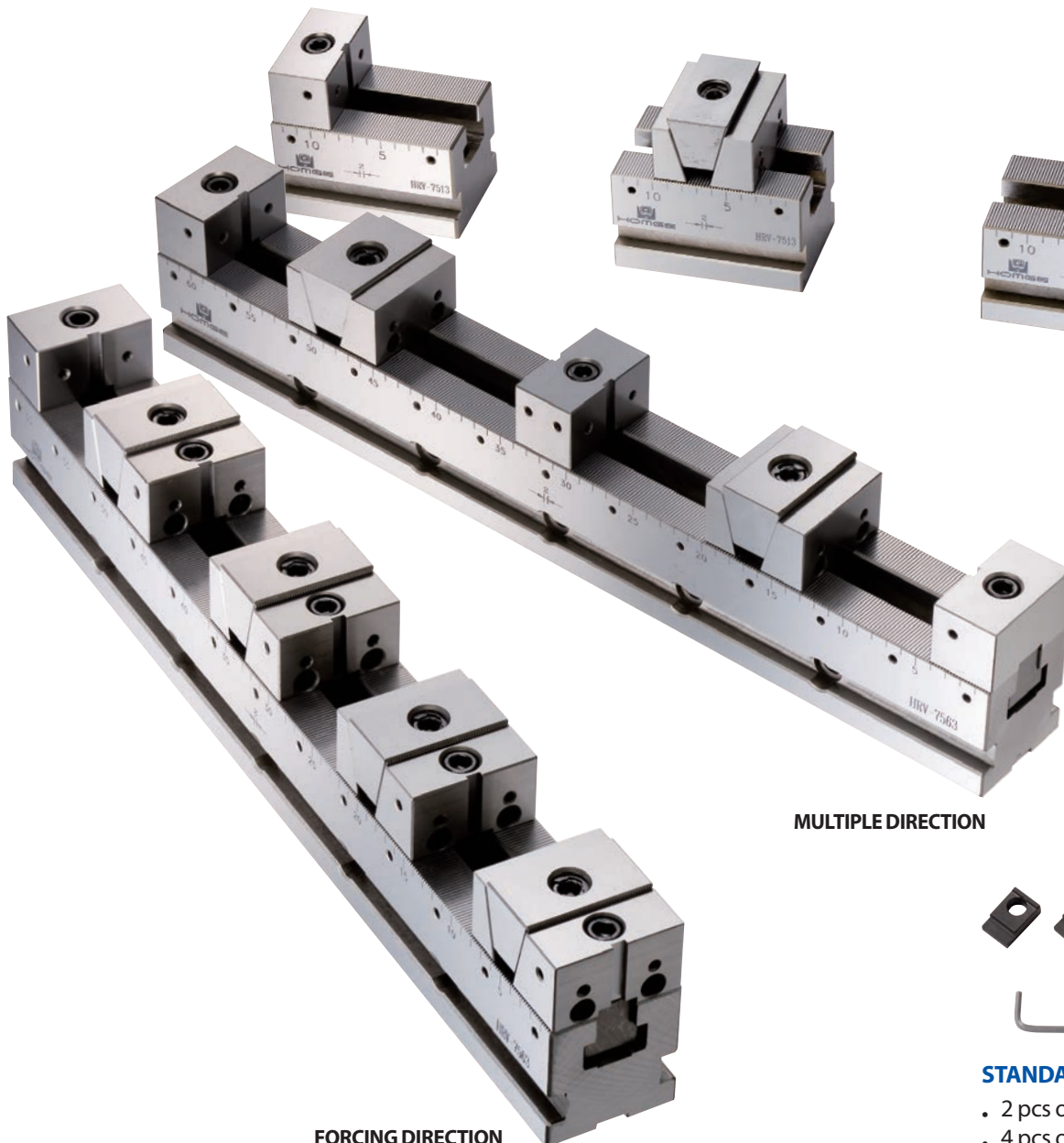
Adjustable vice can clamp working piece in square, round or irregular shapes. It enhances machine revolving rate and shortens time of changing molds.

**Saves cost.**

### FEATURES:

HRV-series' VICE IN-ROW is a kind of multiple clamp vice. Full set of this vice is made of **Tool Steel** with heat treatment more than **HRC 60°** of Hardness and then ground precisely to ensure durability. It enlarges clamping dimension. No matter what shape of working piece, such as square, round, cylindrical or any irregular shapes, it can be positioned quickly. Precision gear locating datum plane is adjustable so working piece can be fixed easily.

This vice is suitable for CNC Machining Centers and Surface Grinder, ...etc.



**MULTIPLE DIRECTION**

**FORCING DIRECTION**

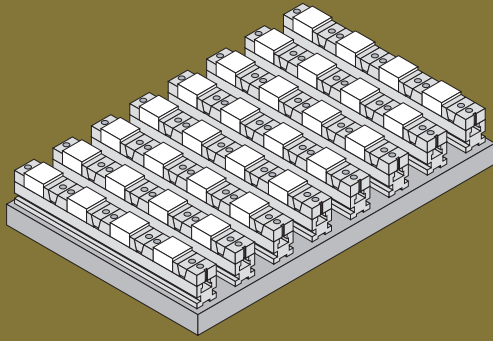


### STANDARD ACCESSORIES:

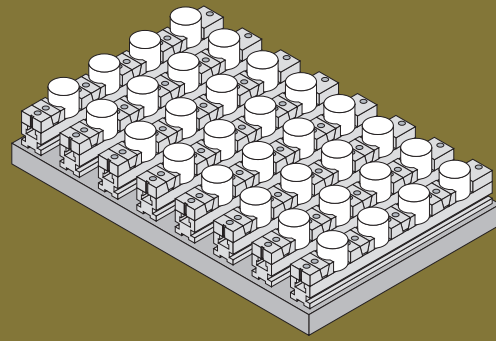
- 2 pcs of Alignment Wedge
- 4 pcs of Clamp
- 1 pc of Wrench



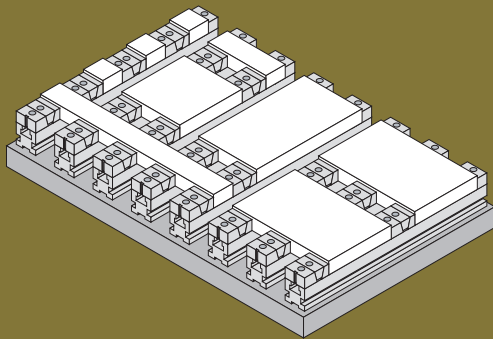
## CLAMPING EXAMPLE



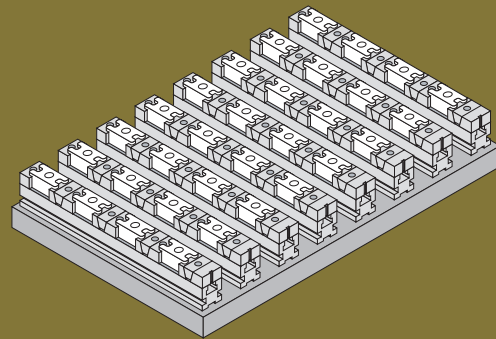
By clamping lots of rectangular small working pieces at the same time, the working table of the machine can be used completely and keep the machine operate efficiently.



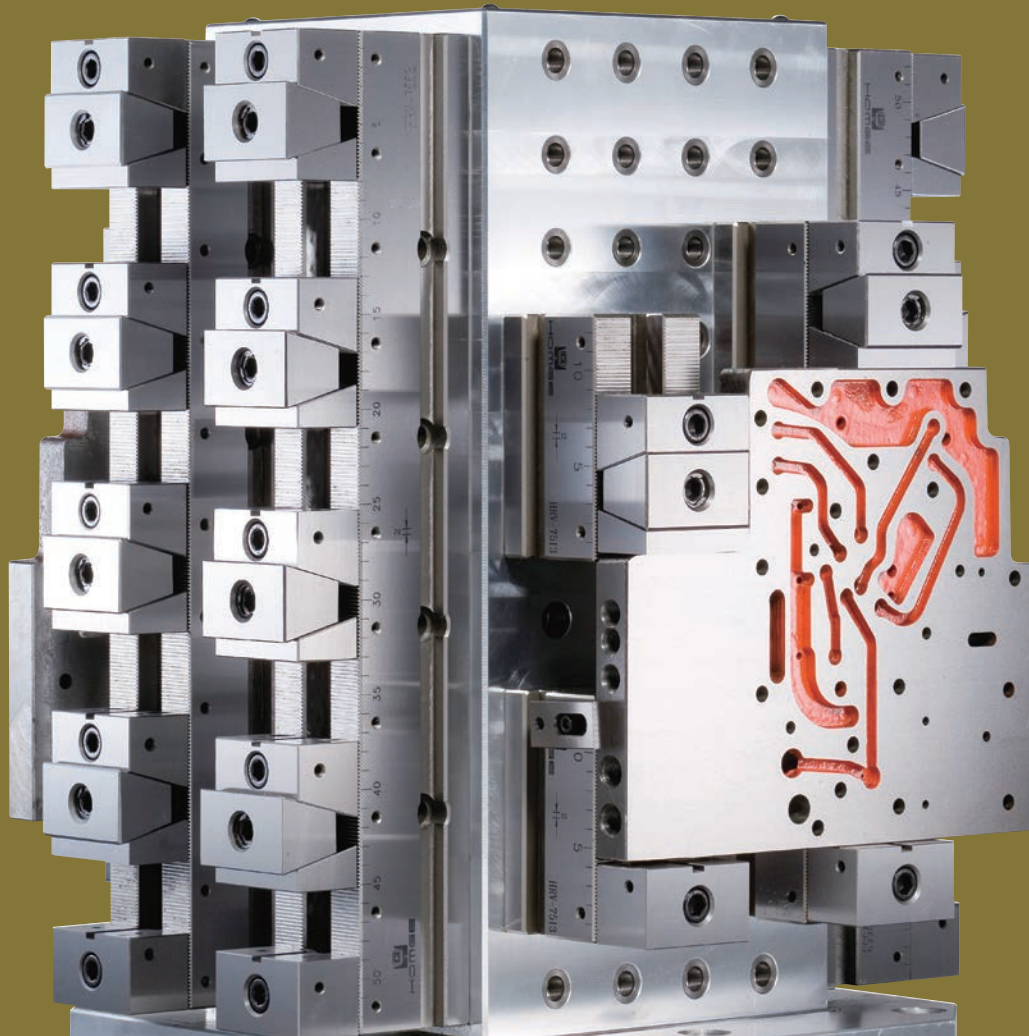
Cylindrical working pieces can be easily clamped by using optional accessory ( V Jaw ).



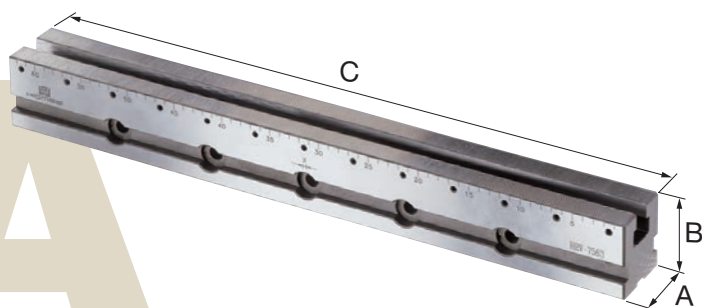
One or couple of larger working pieces can be clamped flexibly at the same time.



Irregular shape of working pieces can be clamped by using optional jaw which can be special tailored to meet the clamping requirement of the working pieces.



## ASSEMBLED PARTS:



### MAIN BODY

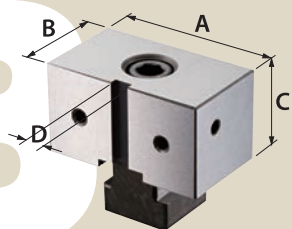
Unit: mm

Model	A	B	C
HRV-50A30	50	50	300
HRV-50A40	50	50	400
HRV-50A50	50	50	500
HRV-50A60	50	50	600
HRV-50A70	50	50	700
HRV-75A43	75	75	430
HRV-75A53	75	75	530
HRV-75A63	75	75	630
HRV-75A73	75	75	730
HRV-100A55	100	75	550
HRV-100A65	100	75	650
HRV-100A75	100	75	750

### For Forcing Direction

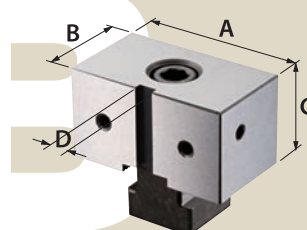
### For Multiple Direction

Unit: mm



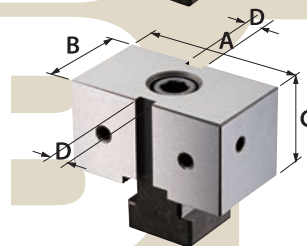
#### FIXED MOUTHPIECE SET

Model	A	B	C	D
HRV-50B	48	35	25	8
HRV-75B	73	42	40	8
HRV-100B	98	55	50	8



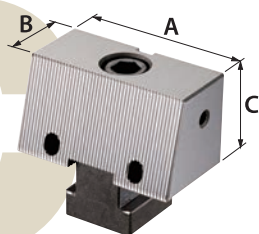
#### FIXED MOUTHPIECE SET

Model	A	B	C	D
HRV-50B	48	35	25	8
HRV-75B	73	42	40	8
HRV-100B	98	55	50	8



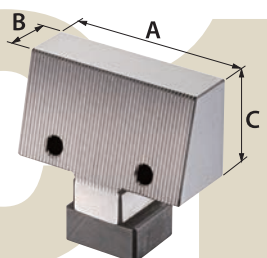
#### FIXED MOUTHPIECE SET

Model	A	B	C	D
HRV-50B1	48	35	25	8
HRV-75B1	73	42	40	8
HRV-100B1	98	55	50	8



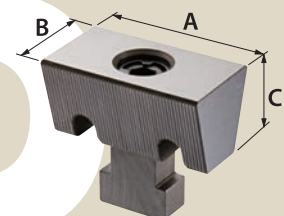
#### SINGLE BEVEL FIXED MOUTHPIECE SET

Model	A	B	C
HRV-50C	48	27	25
HRV-75C	73	30	40
HRV-100C	98	35	50



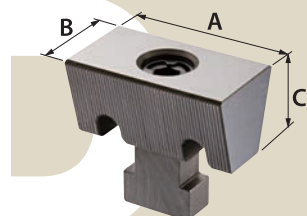
#### SINGLE BEVEL FIXED MOUTHPIECE SET

Model	A	B	C
HRV-50C1	48	20	25
HRV-75C1	73	20	40
HRV-100C1	98	28	50



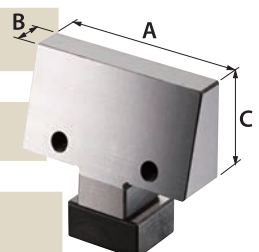
#### WEDGE SET

Model	A	B	C
HRV-50D	48	26	21
HRV-75D	73	42	36
HRV-100D	98	50	45



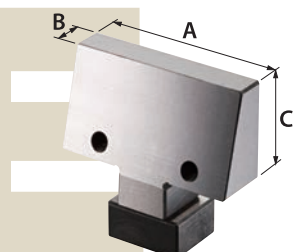
#### WEDGE SET

Model	A	B	C
HRV-50D	48	26	21
HRV-75D	73	42	36
HRV-100D	98	50	45



#### SINGLE BEVEL MOVEABLE MOUTHPIECE SET

Model	A	B	C
HRV-50E	48	13	25
HRV-75E	73	12	40
HRV-100E	98	23	50



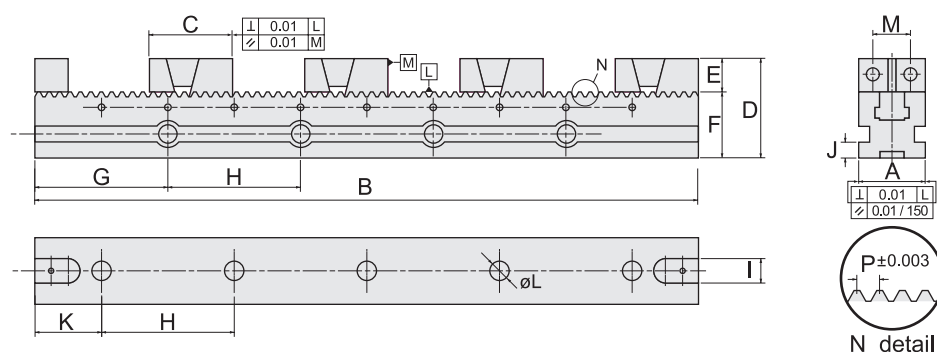
#### SINGLE BEVEL MOVEABLE MOUTHPIECE SET

Model	A	B	C
HRV-50E	48	13	25
HRV-75E	73	12	40
HRV-100E	98	23	50

*Assembled Parts & Optional Accessories are Available for Being Ordered Separately*



## DIMENSIONS



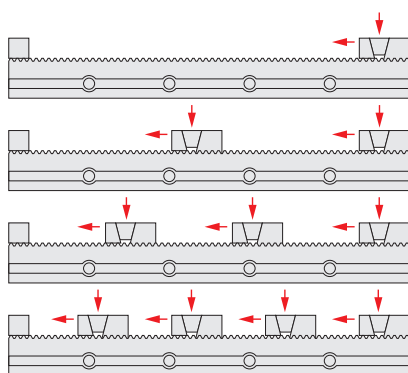
## SPECIFICATIONS (Material: Tool steel. Hardness: over HRC 60°)

Unit: mm

NO	Model	A	B	C	D	E	F	G	H	I	J	K	L	M	P	KG
V-01	HRV-5030	50	300	66	75	25	50	70	80	18	10	30	14	24	1.5	7
V-02	HRV-5040		400					80				40				9
V-03	HRV-5050		500					90				50				10
V-04	HRV-5060		600					100				60				11
V-05	HRV-5070		700					110				70				12
V-06	HRV-7543	75	430	85	115	40	75	115	100	18	17	65	14	40	2	20
V-07	HRV-7553		530					115				65				25.5
V-08	HRV-7563		630					115				65				29.5
V-09	HRV-7573		730					65				115				33.5
V-10	HRV-10055	100	550	108	125	50	75	75	100	18	17	125	14	60	2.5	39.5
V-11	HRV-10065		650					125				75				44
V-12	HRV-10075		750					125				75				49

## FORCING DIRECTION

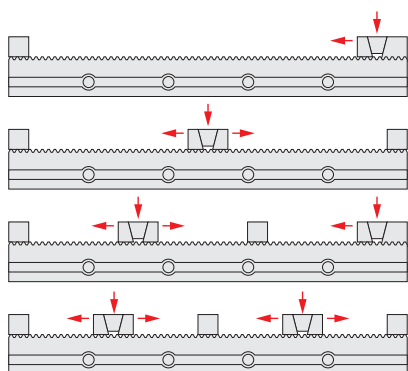
## Maximum range of the working pieces to be clamped



NO	Model				
V-01	HRV-5030	199	66	22	—
V-02	HRV-5040	299	116	55	25
V-03	HRV-5050	399	166	89	50
V-04	HRV-5060	499	216	122	75
V-05	HRV-5070	599	266	155	100
V-06	HRV-7543	300	109	44	—
V-07	HRV-7553	400	159	77	49
V-08	HRV-7563	500	209	111	62
V-09	HRV-7573	600	259	144	87
V-10	HRV-10055	390	142	58	—
V-11	HRV-10065	490	192	92	42
V-12	HRV-10075	590	242	125	67

## MULTIPLE DIRECTION

## Maximum range of the working pieces to be clamped

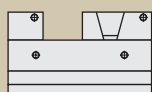
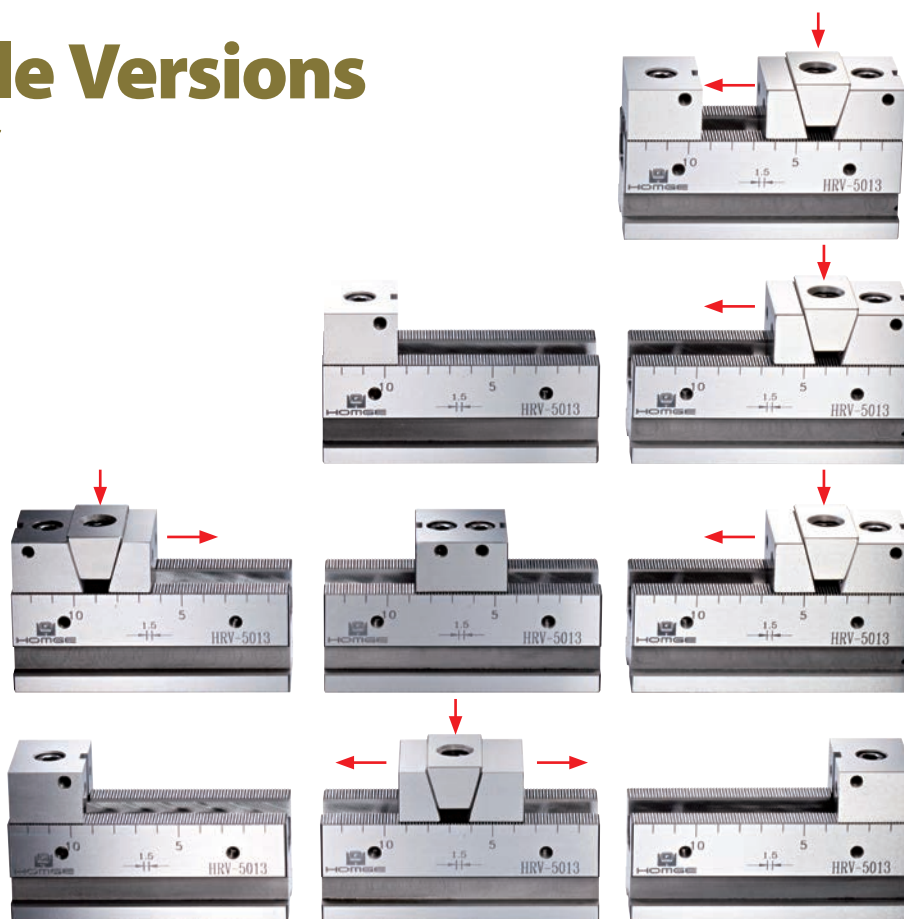


NO	Model				
V-01	HRV-5030	199	90	34	—
V-02	HRV-5040	299	140	68	43
V-03	HRV-5050	399	190	100	68
V-04	HRV-5060	499	240	134	93
V-05	HRV-5070	599	290	168	118
V-06	HRV-7543	300	130	63	51
V-07	HRV-7553	400	180	96	76
V-08	HRV-7563	500	230	129	101
V-09	HRV-7573	600	280	163	126
V-10	HRV-10055	390	170	78	45
V-11	HRV-10065	490	220	112	71
V-12	HRV-10075	590	270	145	96

# HRV Adjustable Versions

*Various combinations for  
Multiple usages*

**Model:** HRV-5013 (A,B,C,D,E)  
HRV-7515 (A,B,C,D,E)  
HRV-10018 (A,B,C,D,E)

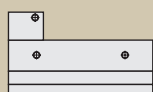


**Model**

HRV-5013-A

HRV-7515-A

HRV-10018-A

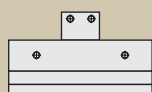


**Model**

HRV-5013-B

HRV-7515-B

HRV-10018-B

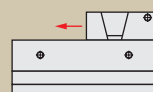


**Model**

HRV-5013-C

HRV-7515-C

HRV-10018-C

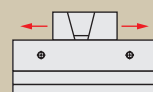


**Model**

HRV-5013-D

HRV-7515-D

HRV-10018-D



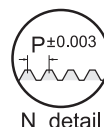
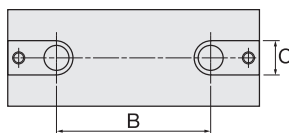
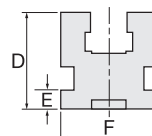
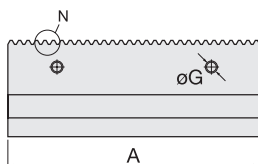
**Model**

HRV-5013-E

HRV-7515-E

HRV-10018-E

## DIMENSIONS



N detail

## SPECIFICATIONS

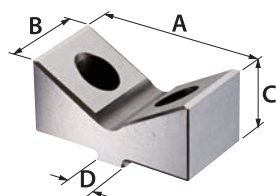
Unit: mm

Model	A	B	C	D	E	F	G	P	Weight (kg)
HRV-5013	130	80	18	50	10	50	M6	1.5	2
HRV-7515	150	100	18	75	17	75	M6	2	4
HRV-10018	180	100	18	75	17	100	M6	2.5	7



## OPTIONAL ACCESSORIES:

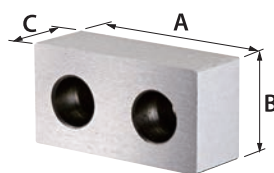
### "V" JAW (FOR FIXED JAW)



Unit: mm

Model	A	B	C	Dh7
HRV-50-VJ	48	25	21	8
HRV-75-VJ	73	40	32	8
HRV-100-VJ	98	50	44	8

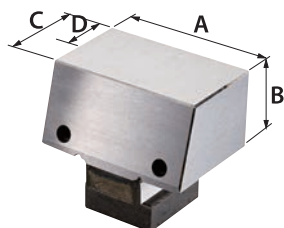
### FIXED SOFT JAW (FOR MOVEABLE JAW)



Unit: mm

Model	A	B	C
HRV-50-FMJ	48	25	16
HRV-75-FMJ	73	40	19
HRV-100-FMJ	98	50	19

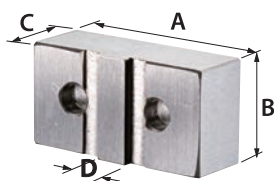
### MOVEABLE SOFT JAW



Unit: mm

Model	A	B	C	D
HRV-50-MSJ	48	25	28	20
HRV-75-MSJ	73	40	30	20
HRV-100-MSJ	98	50	29	20

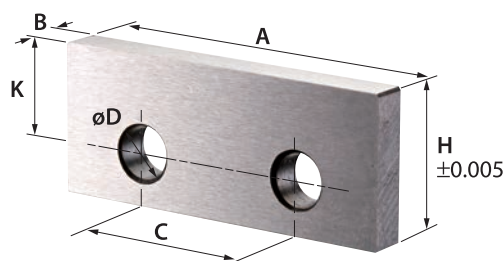
### FIXED SOFT JAW (FOR FIXED JAW)



Unit: mm

Model	A	B	C	Dh7
HRV-50-FFJ	48	25	16	8
HRV-75-FFJ	73	40	19	8
HRV-100-FFJ	98	50	19	8

### SUPPORTING BLOCK

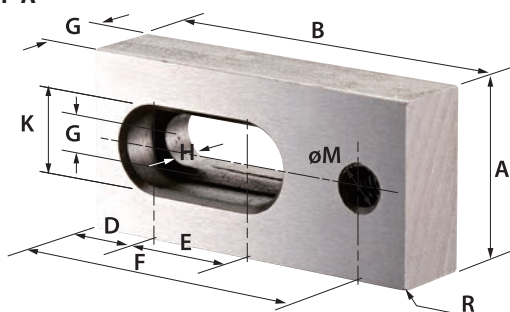


Unit: mm

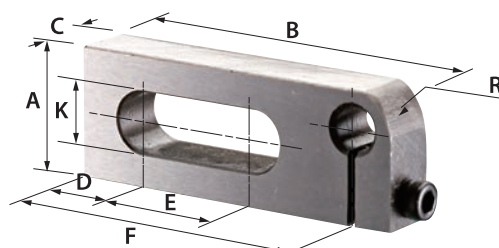
Model	A	B	C	D	H	L
SB-50A	47.5	3	24	6.8	17	13
SB-50B		5			20	
SB-50C		5			22	
SB-75A	74.5	3	40	6.8	25	20
SB-75B		5			30	
SB-75C		5			35	
SB-75D		5			37	
SB-100A	97.5	5	60	6.8	35	25
SB-100B		5			40	
SB-100C		5			45	
SB-100D		5			47	

### DATUM PLATE (FOR HRV-50, 75, 100)

Model: DP-A



Model: DP-B



Unit: mm

Model	A	B	C	D	E	F	G	H	K	M	R
DP-A	25	50	12	10	15	43	6.5	7	11	M6	1
DP-B	19	50	9	10	15	43			11	M6	5

**PATENTED**  
142711  
M278511  
M287204  
M320459  
M338717

V-13~15

# MULTI-POWER CNC SUPER VICE

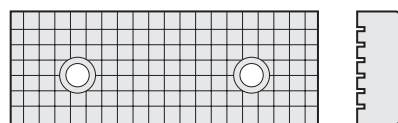
Model: HPAQ-160, 200, 250,  
160L, 200L



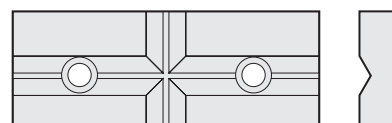
- Shortest Length with Big Jaw Opening
- Extremely High Accuracy and Repeatability
- Special MULTI-POWER design enhances clamping force of **0~8000KG**



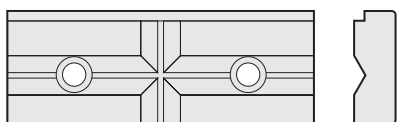
## OPTIONAL ACCESSORIES:



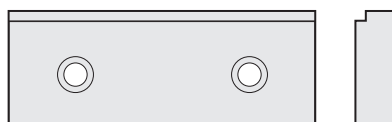
1) Cross Grooved Jaws



2) 'V' Jaws

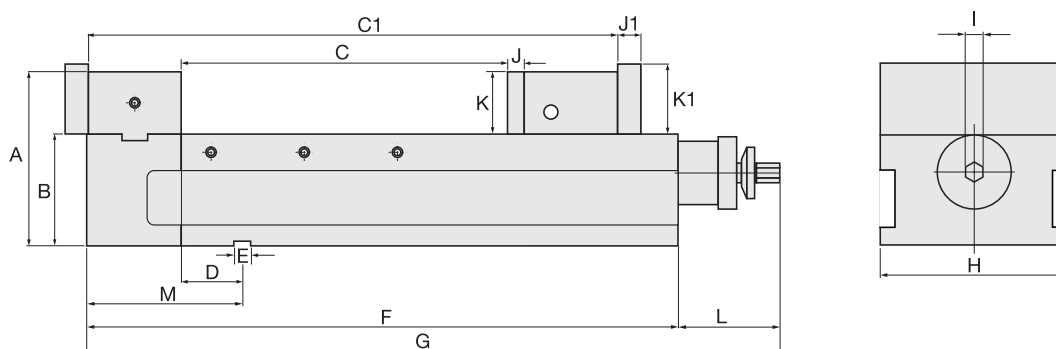


3) Combined Jaws



4) Step Jaws

## DIMENSIONS



## SPECIFICATIONS (Material: FCD 60 Ductile Iron. Hardness: HRC 50°)

Unit: mm

NO	Model	A	B	C	C1	D	E	F	G	H
V-13	HPAQ-160	168	115±0.01	0-300	195-490	57±0.02	18	560	677	160
V-14	HPAQ-200	187	120±0.01	0-350	220-570	66±0.02	18	637	754	200
V-15	HPAQ-250	187	120±0.01	0-350	220-580	66±0.02	18	646	763	250
V-13L1	HPAQ-160L-400	168	115±0.01	0-400	206-600	57±0.02	18	665	792	160
V-13L2	HPAQ-160L-500	168	115±0.01	0-500	206-700	57±0.02	18	765	892	160
V-13L3	HPAQ-160L-650	168	115±0.01	0-650	206-860	57±0.02	18	925	1042	160
V-14L1	HPAQ-200L-480	187	120±0.01	0-480	236-710	66±0.02	18	795	912	200
V-14L2	HPAQ-200L-730	187	120±0.01	0-730	236-960	66±0.02	18	1045	1162	200
V-14L3	HPAQ-200L-1140	187	120±0.01	0-1140	236-1370	66±0.02	18	1435	1560	200
NO	Model	I	J	J1	K	K1	L	M	Max. Clamping Force	Weight (kg)
V-13	HPAQ-160	19	15	21	53	63	117	145	8000 kg	73
V-14	HPAQ-200	19	18	25	66	75	117	168	8000 kg	120
V-15	HPAQ-250	19	18	25	66	75	117	168	8000 kg	156
V-13L1	HPAQ-160L-400	19	15	21	53	63	117	145	8000 kg	83
V-13L2	HPAQ-160L-500	19	15	21	53	63	117	145	8000 kg	92
V-13L3	HPAQ-160L-650	19	15	21	53	63	117	145	8000 kg	107
V-14L1	HPAQ-200L-480	19	18	25	66	75	117	168	8000 kg	144
V-14L2	HPAQ-200L-730	19	18	25	66	75	117	168	8000 kg	175
V-14L3	HPAQ-200L-1140	19	18	25	66	75	117	168	8000 kg	217

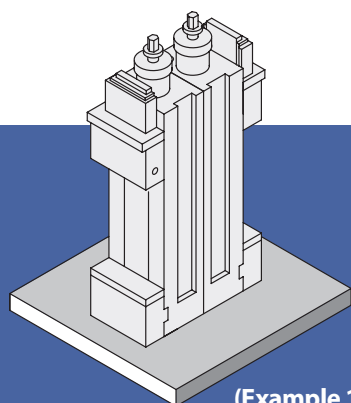


**PATENTED**  
142711  
M278511  
M287204  
M320459  
M338717

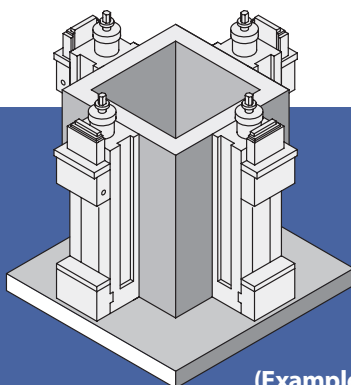
# MULTI-POWER CNC SUPER VICE

Model: HPAQ-160, 200, 250, 160L, 200L

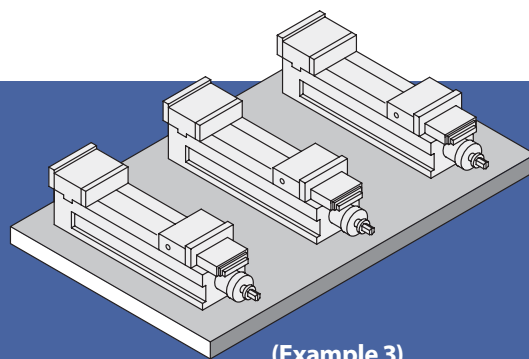
The extremely big jaw opening of model HPAQ-160 Jaw Opening 300mm and 495mm is used for thin work piece clamping.



(Example 1)



(Example 2)



(Example 3)



## ICE

**1.** Vice Fixed Jaw is made of **high quality steel** and **HARDENED** to **HRC 55°**. Vice body is made of Ductile Iron above FCD 60 grade for high precision and durability. With a force of 4500kg, the shape will deflect less than **0.005mm**.

**2.** Slide ways are **HARDENED** to **HRC 50°** to further increase durability and maintain positioning height over long use.

**3.** The **Special ANGLE-LOCK SYSTEM** with compact design and high-grade iron of over FCD 60 grade for high rigidity automatically pulls the work-piece down to the accurate position of within **0.005mm** under 4500kg of pressure. This vice is most suitable for precision mould making on Machining Centers.

**4.** Vice can be mounted horizontally or vertically.

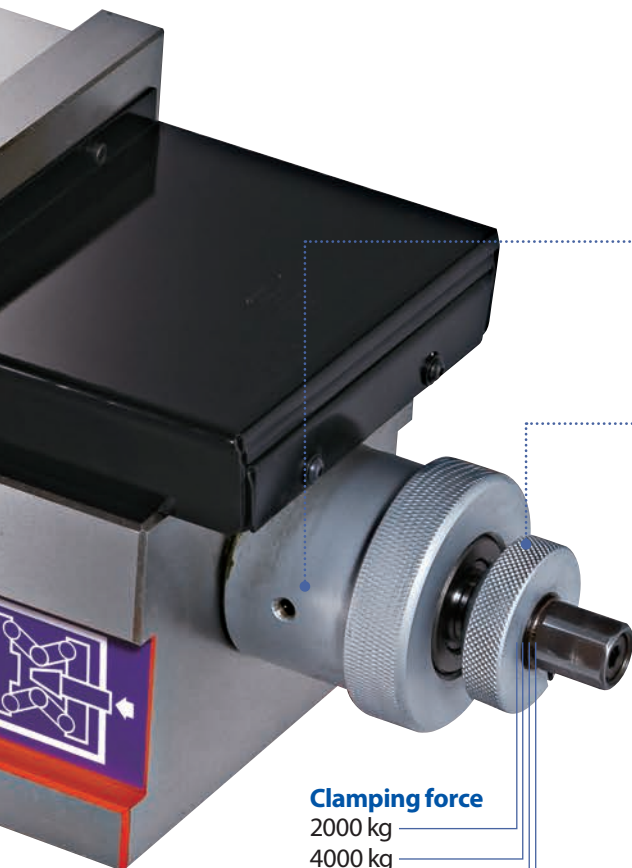
**5.** The patented MULTI-POWER SYSTEM built of **HIGH GRADE BEARING STEEL** doubles the clamping force.

*With the first half a turn  
the vice will clamp with 2500kg pressure.*

*With a second half turn  
it will apply 4500kg of clamping force.*

**This special patented system makes the clamping force constant.**

**6.** **Adjusting stop ring:** This simple and effective presetting device enables to **preset each desired clamping force** and it guarantees to repeat each clamping operation at the same clamping force.



#### Clamping force

2000 kg  
4000 kg  
6000 kg  
8000 kg



#### STANDARD ACCESSORIES:

- 2 pcs of Alignment Wedge
- 4 pcs of Clamp

#### OPTIONAL ACCESSORIES:

- Cross Grooved Jaws
- 'V' Jaws
- Combined Jaws
- Step Jaws

The patented MULTI-POWER SYSTEM built of **HIGH GRADE BEARING STEEL** provides extremely high clamping pressure. The pressure is more consistent and eliminates all leakage and maintenance problems associated with Hydraulic Vices.

***Fixed height*** so several vices can be used together.

This vice is highly suitable for **precision mould making** on machining centers as well as **heavy duty machining** which require high clamping force with high accuracy.

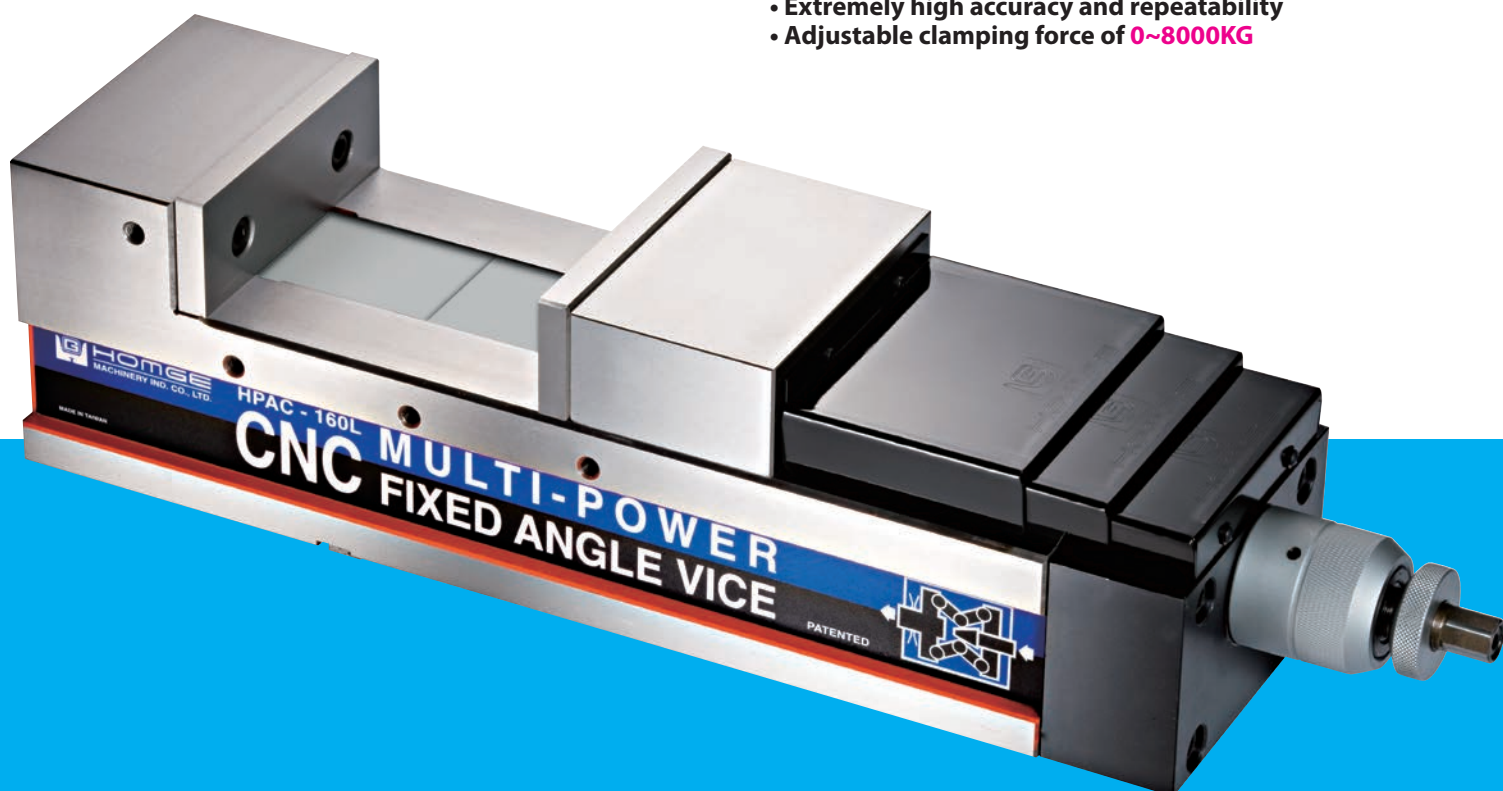
**PATENTED**  
142711  
M287204  
M320459

V-16~18

## MULTI-POWER CNC PRECISION FIXED ANGLE VICE

Model: HPAC-130, 160, 160L, 200

- Extremely high accuracy and repeatability
- Adjustable clamping force of **0~8000KG**

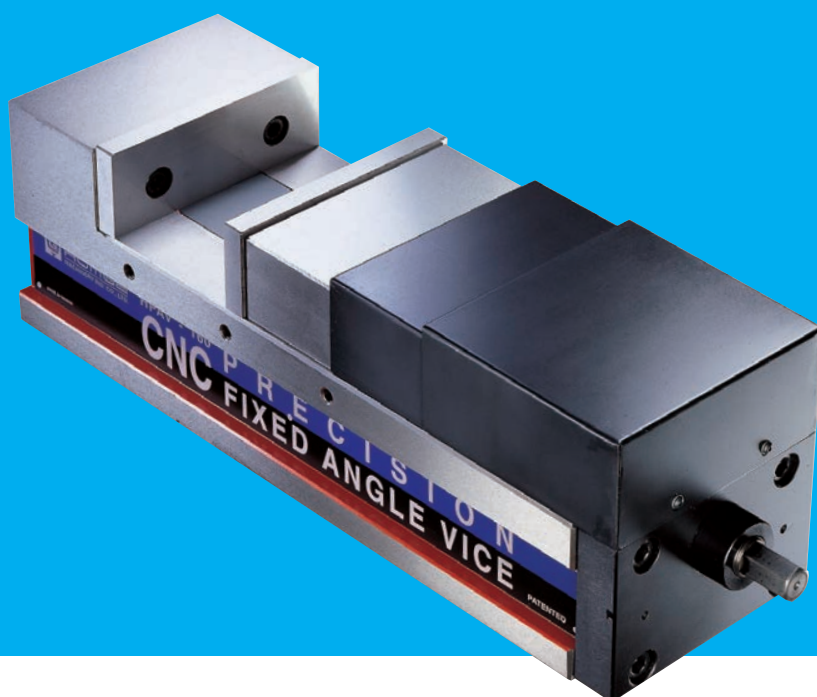


V-19~21

## CNC PRECISION FIXED ANGLE VICE

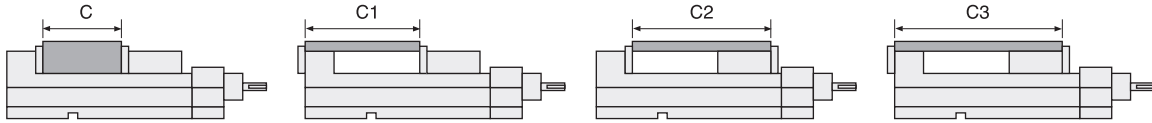
Model: HPAV-130, 160, 160L, 200

This vice has the same features as model HPAC above but has standard clamping screw instead of the MULTI-POWER SYSTEM.

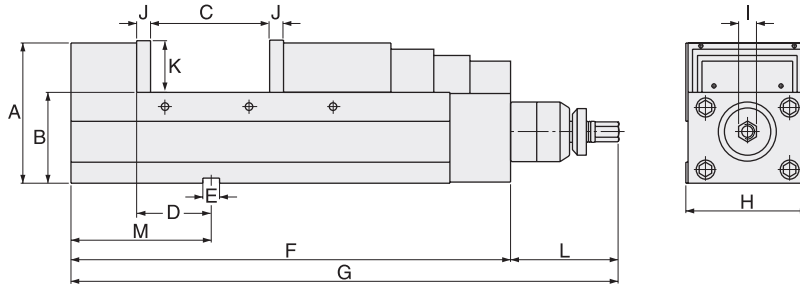




## DIMENSIONS FOR 4 JAW PLATE POSITIONS



## DIMENSIONS

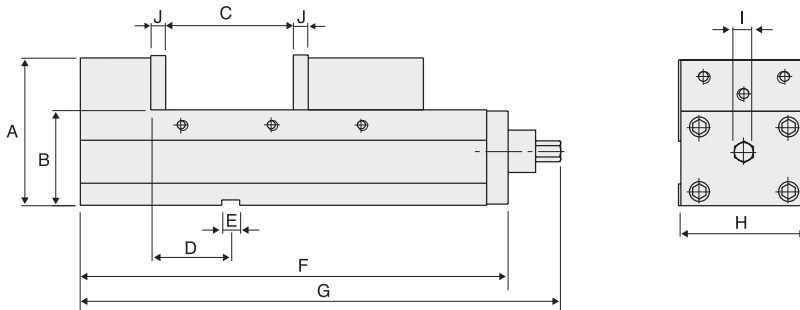


## SPECIFICATIONS (Material: FCD 60 Ductile Iron, Hardness: HRC 50°)

Unit: mm

NO	Model	A	B	C	C1	C2	C3	D	E	F
V-16	HPAC-130	147	95 ± 0.01	0 - 190	70 - 260	115 - 305	185 - 375	80 ± 0.02	18	475
V-17	HPAC-160	160	105 ± 0.01	0 - 250	85 - 325	140 - 375	220 - 460	80 ± 0.02	18	560
V-17A	HPAC-160L	160	105 ± 0.01	<b>0 - 300</b>	85 - 375	110 - 395	190 - 480	80 ± 0.02	18	580
V-18	HPAC-200	170	110 ± 0.01	0 - 290	90 - 380	155 - 440	240 - 530	100 ± 0.02	18	635
NO	Model	Max. damping Force	G	H	I	J	K	L	M	Weight (kg)
V-16	HPAC-130	6000kg	583	131	19	15	55	120	150	47
V-17	HPAC-160	8000kg	670	161	19	15	58	120	165	65
V-17A	HPAC-160L	8000kg	690	161	19	15	58	120	165	67
V-18	HPAC-200	8000kg	743	201	19	18	63	120	197	95

## DIMENSIONS



## SPECIFICATIONS (Material: FCD 60 Ductile Iron, Hardness: HRC 50°)

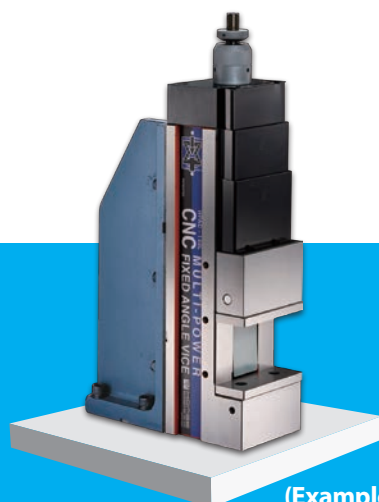
Unit: mm

NO	Model	A	B	D	E	F	G	H
V-19	HPAV-130	147	95 ± 0.01	80 ± 0.02	18	440	520	131
V-20	HPAV-160	160	105 ± 0.01	80 ± 0.02	18	525	564	161
V-20A	HPAV-160L	160	105 ± 0.01	80 ± 0.02	18	545	584	161
V-21	HPAV-200	170	110 ± 0.01	100 ± 0.02	18	600	680	201
NO	Model	I	J	C	C1	C2	C3	Weight (kg)
V-19	HPAV-130	19	15	0-190	70-260	115-305	185-375	42
V-20	HPAV-160	19	15	0-250	85-325	140-375	220-460	60
V-20A	HPAV-160L	19	15	<b>0 - 300</b>	85-375	110-395	190-480	62
V-21	HPAV-200	19	18	0-290	90-380	155-440	240-530	90

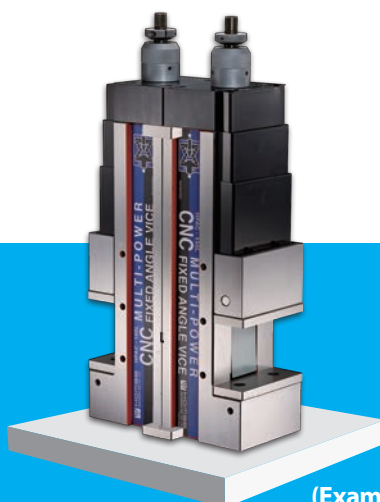
**PATENTED**  
142711  
M287204  
M320459

# MULTI-POWER CNC PRECISION FIXED ANGLE VICE

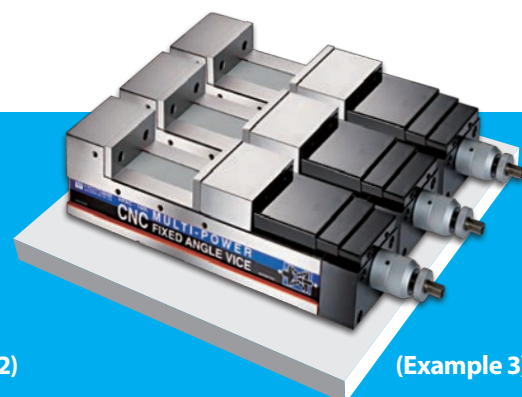
**Model: HPAC-130, 160, 160L, 200**



(Example 1)



(Example 2)



(Example 3)

ION

**1.** Vice body is made of **Ductile Iron** above **FCD 60** grade for high precision and durability and is made in one solid piece. It has very high rigidity and with a force of 4500kg, the shape will deflect less than **0.01mm**.

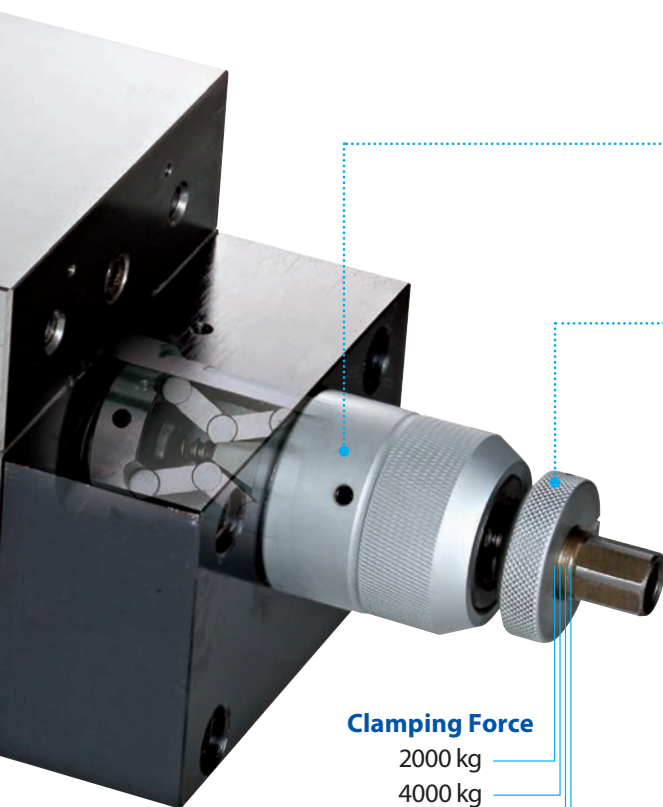
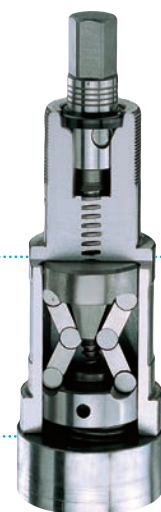
**2.** Slide ways are **HARDENED** to **HRC 50°** to further increase durability and maintain positioning height over long use.

**3.** Using high-grade iron of over FCD 60 grade for high rigidity and also **ANGLE-LOCK SYSTEM** which automatically pulls the work-piece down to the accurate position of within **0.01mm** under 4500kg of pressure, this vice is most suitable for precision mould making on Machining Centers.

**4.** Vice can be mounted horizontally or vertically.

**5.** The patented MULTI-POWER SYSTEM built of **HIGH GRADE BEARING STEEL** doubles the clamping force.  
*With the **first half a turn** the vice will clamp with **2500kg** pressure.*  
*With a **second half turn** it will apply **4500kg** of clamping force.*  
**This special patented system makes the clamping force constant.**

**6.** **Adjusting stop ring:** this simple and effective presetting device enables to **preset each desired clamping force** and it guarantees to repeat each clamping operation at the same clamping force.



**Clamping Force**

2000 kg

4000 kg

6000 kg

8000 kg



#### STANDARD ACCESSORIES:

- 2 pcs of Alignment Wedge
- 4 pcs of Clamp

#### OPTIONAL ACCESSORIES:

- Cross Grooved Jaws
- 'V' Jaws
- Combined Jaws
- Step Jaws
- Front / Back Jaws

The patented MULTI-POWER SYSTEM built of **HIGH GRADE BEARING STEEL** provides extremely high clamping pressure. The pressure is more consistent and eliminates all leakage and maintenance problems associated with Hydraulic Vices.

***Fixed height so several vices can be used together.***

This product is suitable for multi-unit applications on both horizontal and vertical CNC Machining Centers as well as conventional Milling Machines where heavy duty machining requires a very high clamping force.



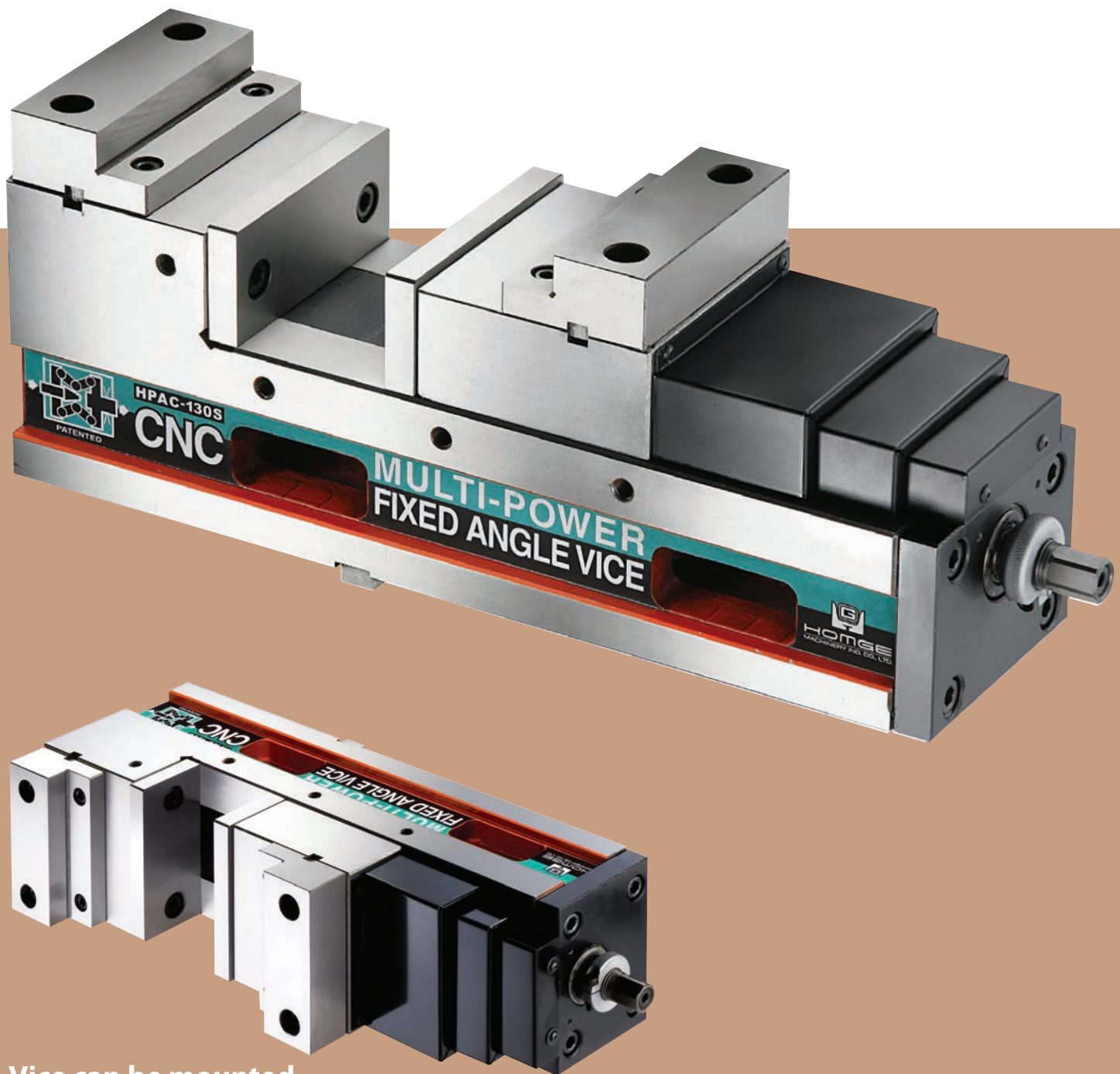
**PATENTED**  
142711  
M287204  
M320459

V-22A / 22 / 22B

## **MULTI-POWER CNC PRECISION FIXED ANGLE VICE**

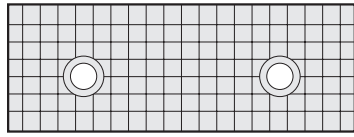
**Model: HPAC-100S,130S,160S**

- Shortest Length with Big Jaw Opening
- Extremely High Accuracy and Repeatability
- Special MULTI-POWER design enhances clamping force of **0 ~ 8000KG**

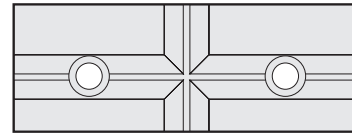


**Vice can be mounted  
horizontally or vertically.**

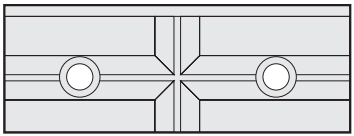
## OPTIONAL ACCESSORIES:



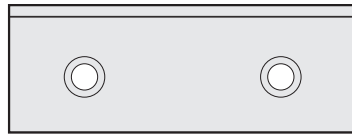
1) Cross Grooved Jaws



2) 'V' Jaws



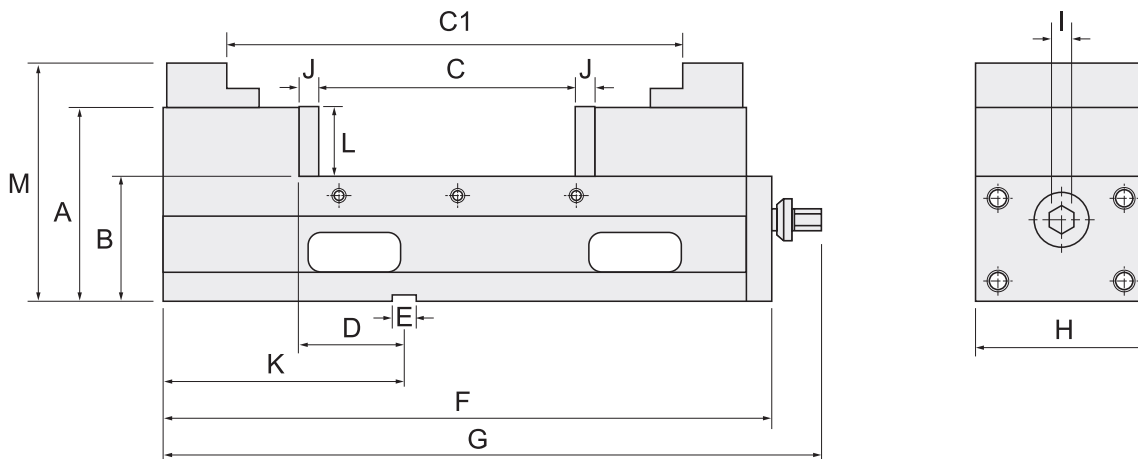
3) Combined Jaws



4) Step Jaws



## DIMENSIONS



## SPECIFICATIONS (Material: FCD 60 Ductile Iron. Hardness: HRC 50°)

Unit: mm

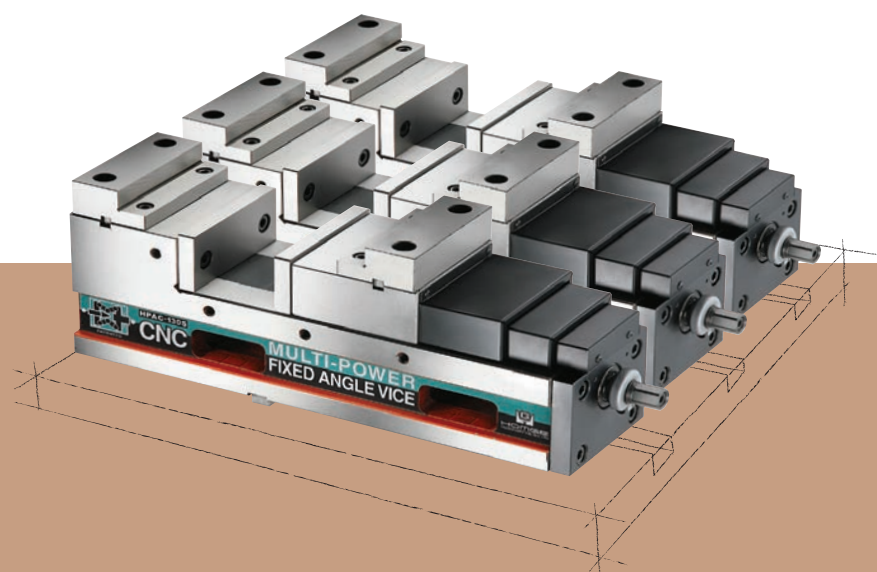
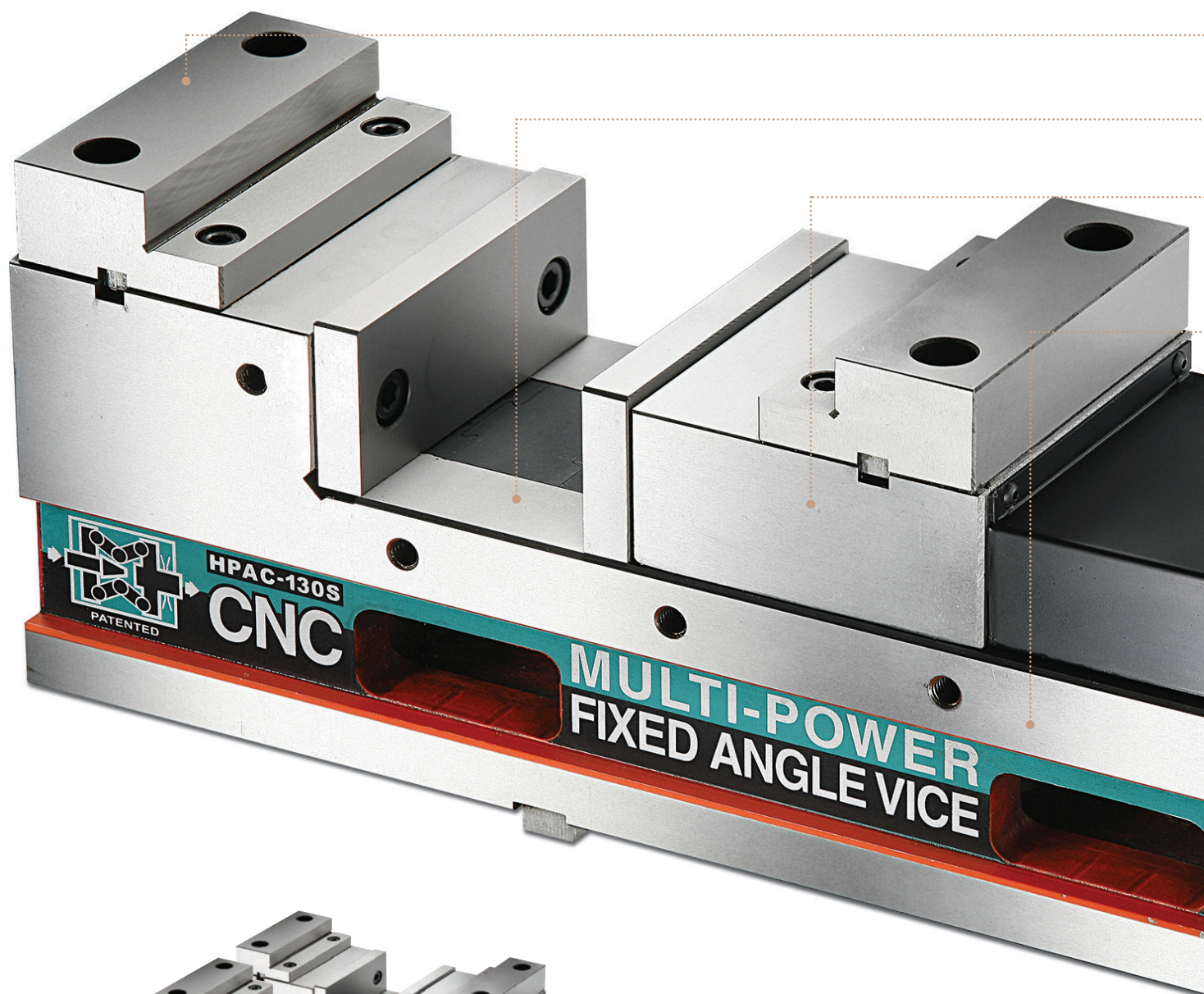
NO	Model	A	B	C	C1	D	E	F	G
V-22A	HPAC-100S	127	85 ± 0.01	0-170	115-280	75 ± 0.02	18	414	460
V-22	HPAC-130S	147	95 ± 0.01	0-190	155-340	75 ± 0.02	18	462	510
V-22B	HPAC-160S	160	105 ± 0.01	0-250	190-430	80 ± 0.02	18	532	580
NO	Model	Max. clamping Force	H	I	J	K	L	M	Weight (kg)
V-22A	HPAC-100S	5000kg	100	19	15	178	44	153	32
V-22	HPAC-130S	6000kg	131	19	15	178	55	181	46.5
V-22B	HPAC-160S	8000kg	160	19	15	183	58	196	64



**PATENTED**  
142711  
M287204  
M320459

# MULTI-POWER CNC PRECISION FIXED ANGLE VICE

Model: HPAC-100S, 130S, 160S



*Fixed height  
Special for*



ON

**1.** The patented MULTI-POWER SYSTEM is built of **HIGH GRADE BEARING STEEL** which doubles the clamping force. Adjustable clamping force of **0~8000kg**. With this special patented system the clamping force remains the same.

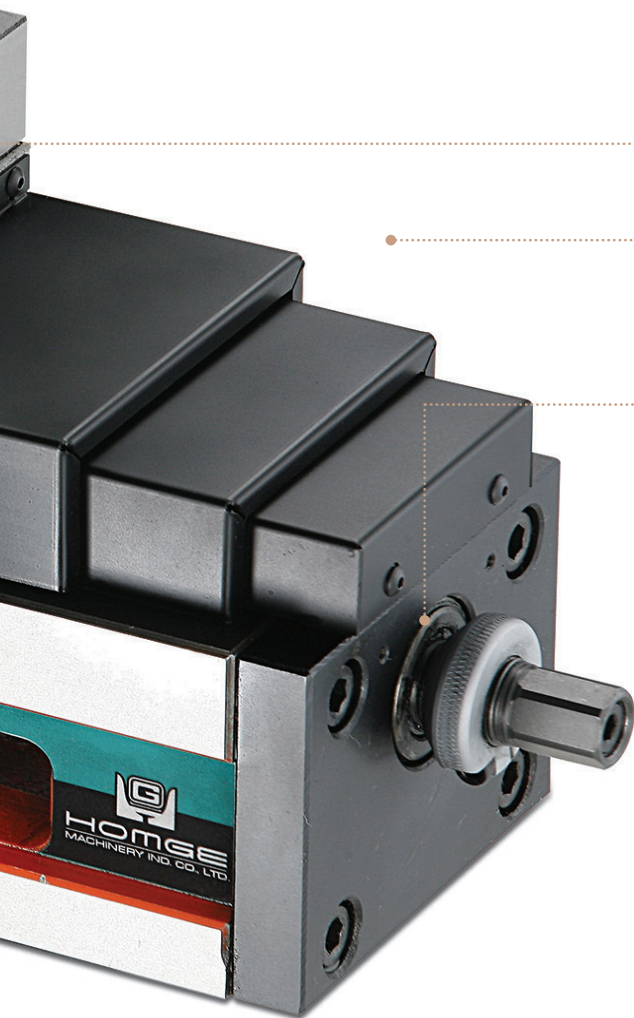
**2.** Slide ways are **HARDENED** to **HRC 50°** to further increase durability and maintain positioning height over long use.

**3.** Using high-grade iron of over FCD 60 grade for high rigidity and also **ANGLE-LOCK SYSTEM**, which automatically pulls the work-piece down to the accurate position of within 0.01mm under 4500kg of pressure, this vice is most suitable for precision mould making on Machining Centers.

**4.** Vice body is made of **Ductile Iron** above **FCD 60** grade for high precision and durability. *It is made in one solid piece and has very high rigidity with a force of 4500kg, the shape will deflect less than 0.01mm.*

**5.** Vice can be mounted horizontally or vertically.

**6. Adjusting stop ring:** this simple and effective presetting device enables to **preset each desired clamping force** and it guarantees to repeat each clamping operation at the same clamping force.



#### STANDARD ACCESSORIES:

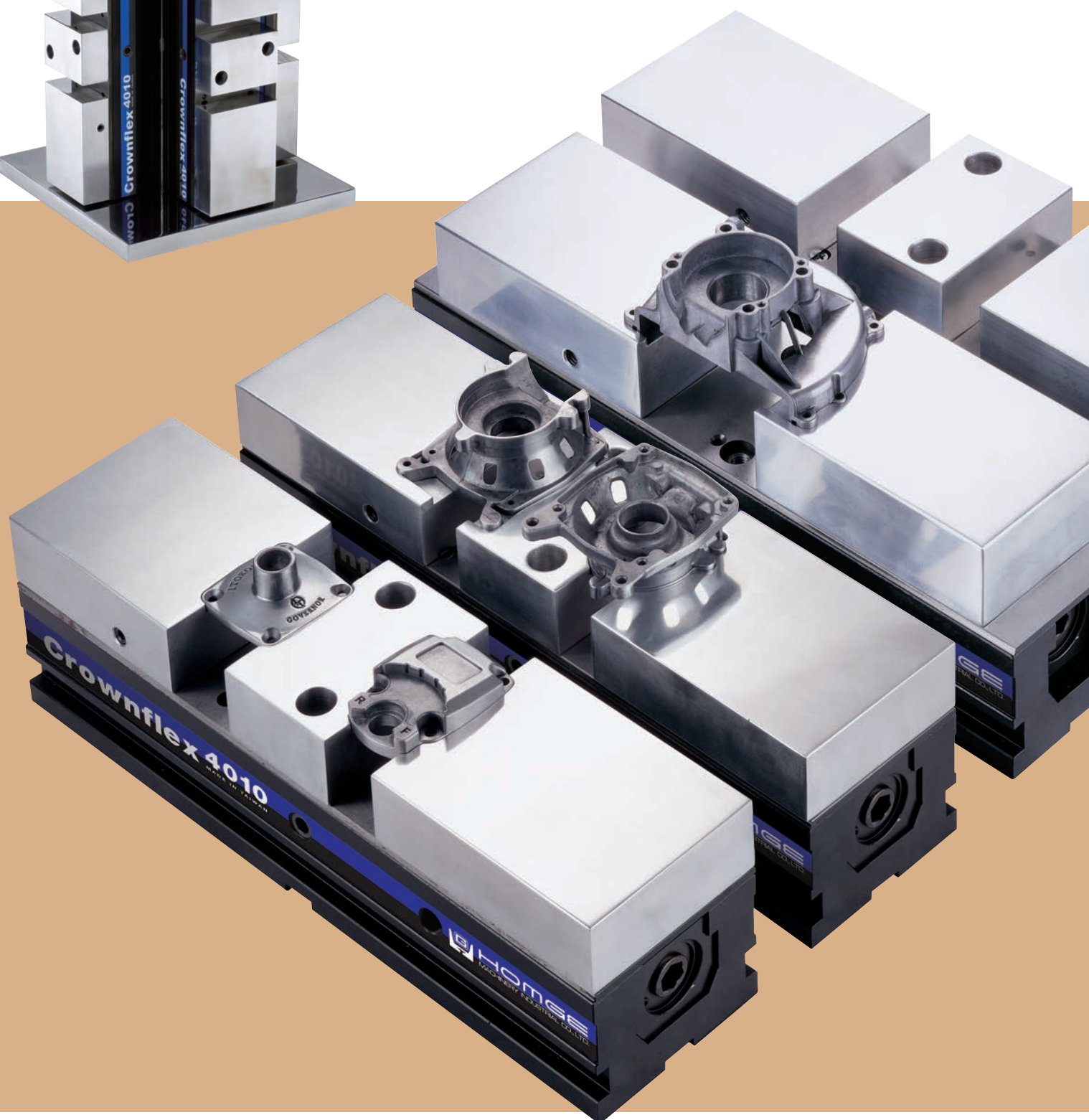
- 2 pcs of Alignment Wedge
- 4 pcs of Clamp

#### OPTIONAL ACCESSORIES:

- Cross Grooved Jaws
- 'V' Jaws
- Combined Jaws
- Step Jaws

so several vices can be used together.  
High Speed CNC Machining Center

**PATENTED**  
**215753**  
**209782**



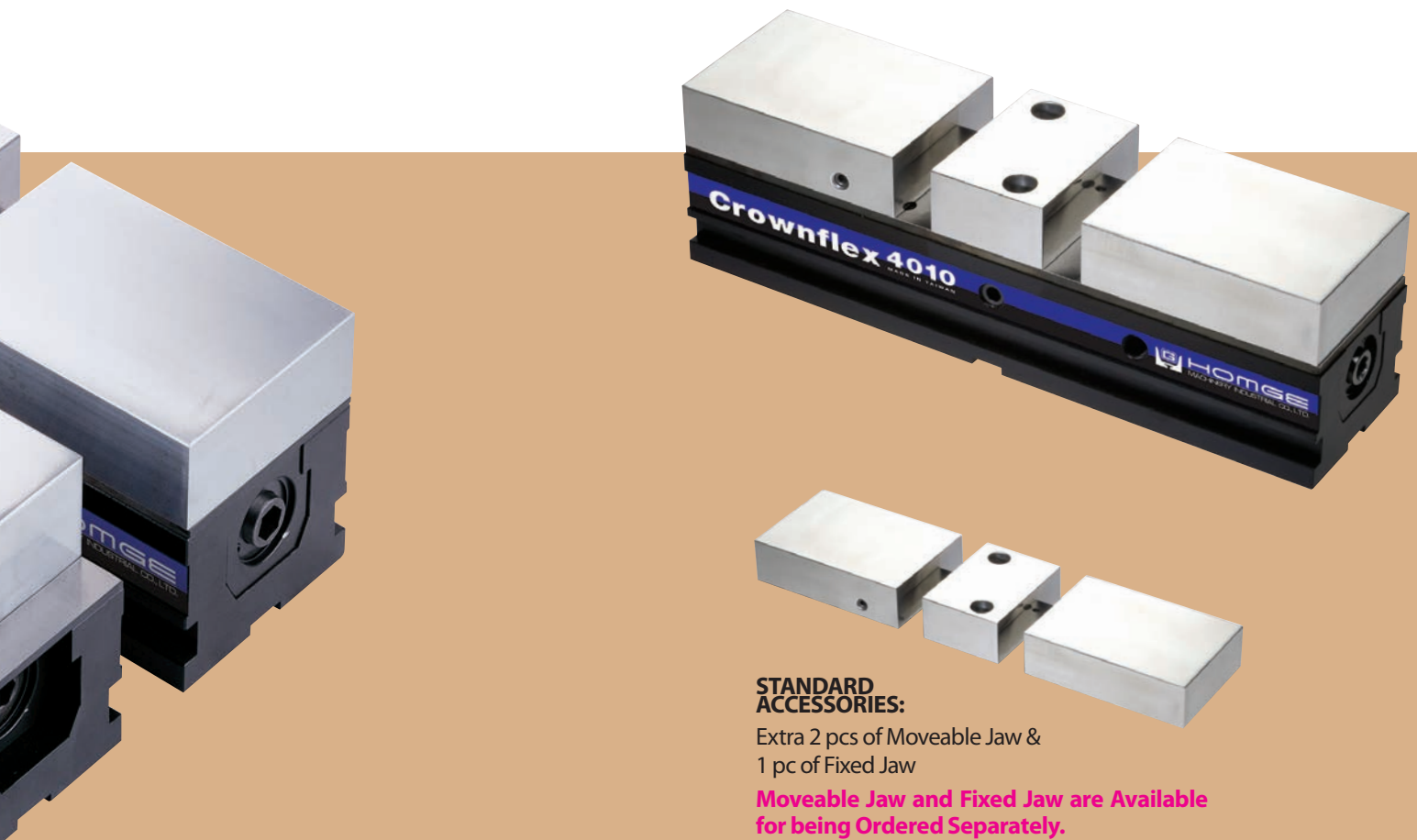
V-23~24

## ALUMINUM VICE

**Model: Crownflex-4010, 5015**

The vice body is made of high tensile aluminum alloy and designed for continuous, light-duty operation. It is suitable to use with the groove and hole systems of CNC machining centers and milling machines.

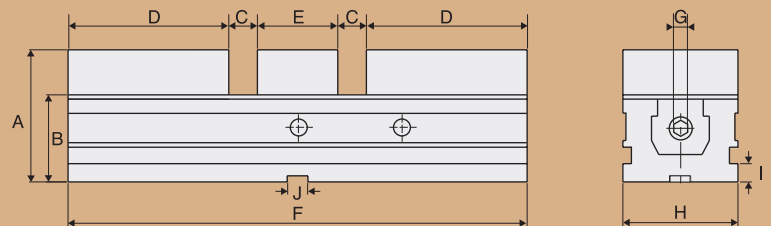
- Quick change jaws
- Double and centralized chucking in one system
- Centralized chucking for high precision



### STANDARD ACCESSORIES:

Extra 2 pcs of Moveable Jaw &  
1 pc of Fixed Jaw

**Moveable Jaw and Fixed Jaw are Available  
for being Ordered Separately.**

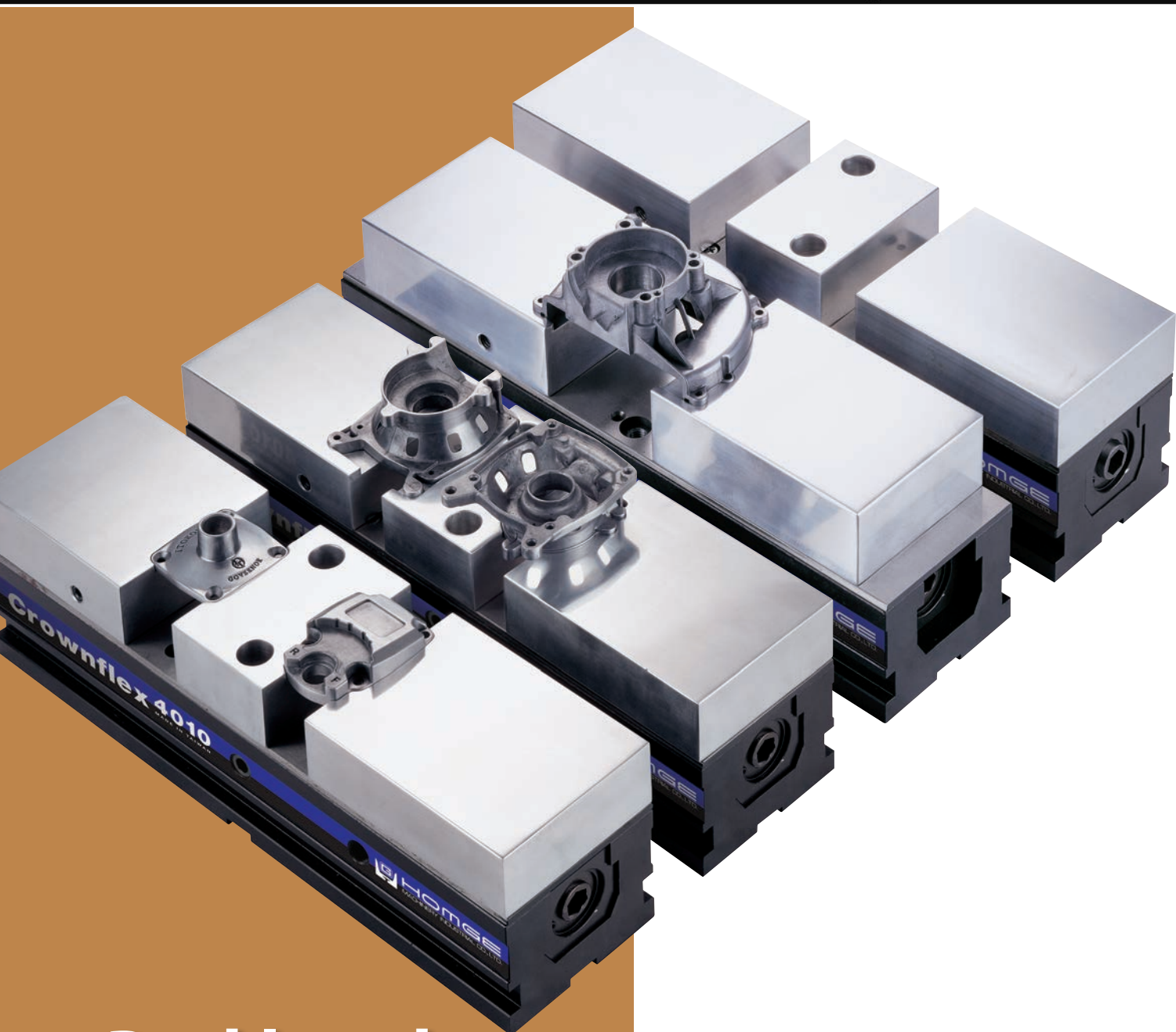


### SPECIFICATIONS (Material: Aluminum Alloy, Durable hard anodized vice body)

Unit: mm

NO	Model	A	B	C	D	E	F	G	H	I	J	Weight (kg)
V-23	4010	117	78	25	140	70	400	12	100	14	18	12.5
V-24	5015	144	95	25	185	80	500	14	150	22	18	30





## Double and centralized chucking in one system

It is a versatile vice whether milling, drilling or grinding, offers flexible applications, high precision clamping and excellent repeatability. High tensile aluminum alloy ensures durability and exceptional stability.

A centralized chucking system that always locates symmetrically on zero. It is formed from the double chucking system by simply screwing in the centering bolts. The changeover time from double chucking will be within a minute.

**PATENTED**  
**215753**  
**209782**

# ALUMINUM VICE

## Model: Crownflex - 4010, 5015

Steel balls recessed in the body allowing the cover plate to be positioned without “play” due to an undersize of the taper bore. This guarantees absolute and exact positioning.

Setup takes place easily in seconds whether changing jaws or changing from centralized to double chucking for the vice.

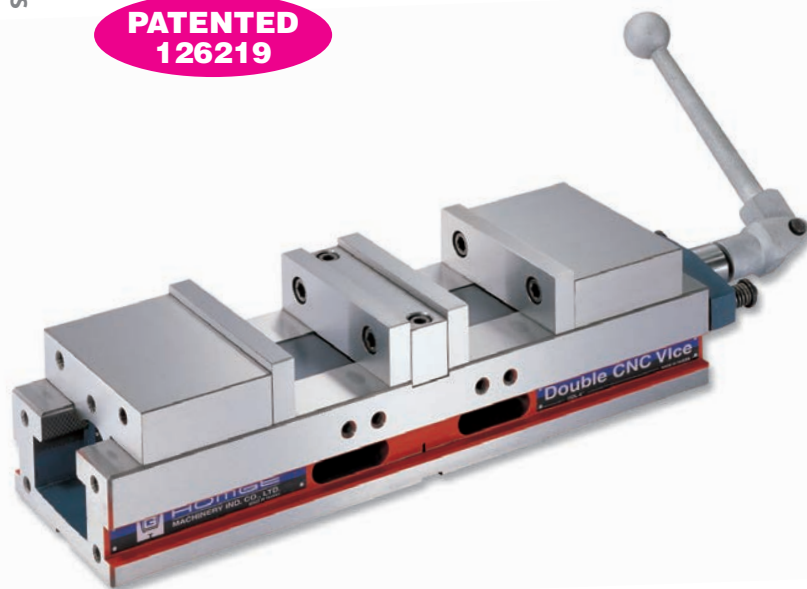


### **Integral jaw brake for easier handling**

It is a compact structure of integral jaw brake for this vice. Once set up, the brake function remains active in repetitive chucking operations. This function greatly facilitates clamping operations, especially when it is being used vertically.



**PATENTED**  
**126219**



V-25~26

## DOUBLE CNC PRECISION VICE

Model: HDL-4", 6"

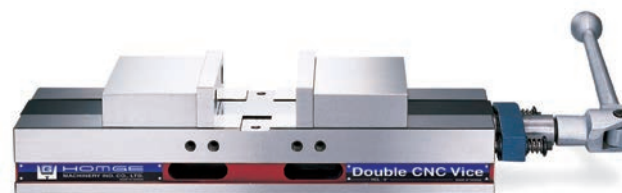
Increases the workholding capacity of CNC Machining Centers by holding 2 pieces in each vice. The design is also compact allowing several vices to be fitted to the work table.



The vice can hold 2 workpieces of different sizes. The maximum opening difference is **70mm**.



Centre Jaw maybe removed to hold larger workpieces.



Once the Centre Jaw is removed the vice is self centring.

### STANDARD ACCESSORIES:

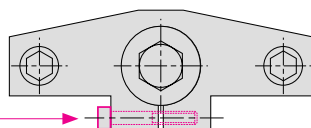
- 2 pcs of Alignment Wedge
- 4 pcs of Clamp

### OPTIONAL ACCESSORY:

Soft Jaws (4 pcs / per set)

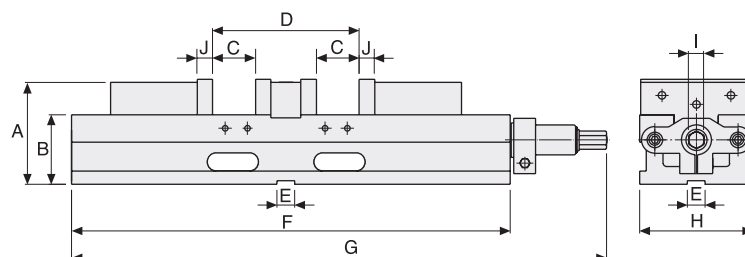


A special **SPRING DEVICE** allows an extra tolerance of up to **5mm** in workpiece size enabling quick positioning and clamping.



If the tolerance of work-piece is more than 5mm, please adjust this screw.

### DIMENSIONS



### SPECIFICATIONS (Material: FCD 55 Ductile Iron. Hardness: HRC 50°)

Unit: mm

NO	Model	A	B	C	D	E	F	G	H	I	J	Weight (kg)
V-25	HDL-4"	92	63 ± 0.01	74	200	18	395	480	104	14	14	20
V-26	HDL-6"	118	80 ± 0.01	100	270	18	517	615	154	19	18	46

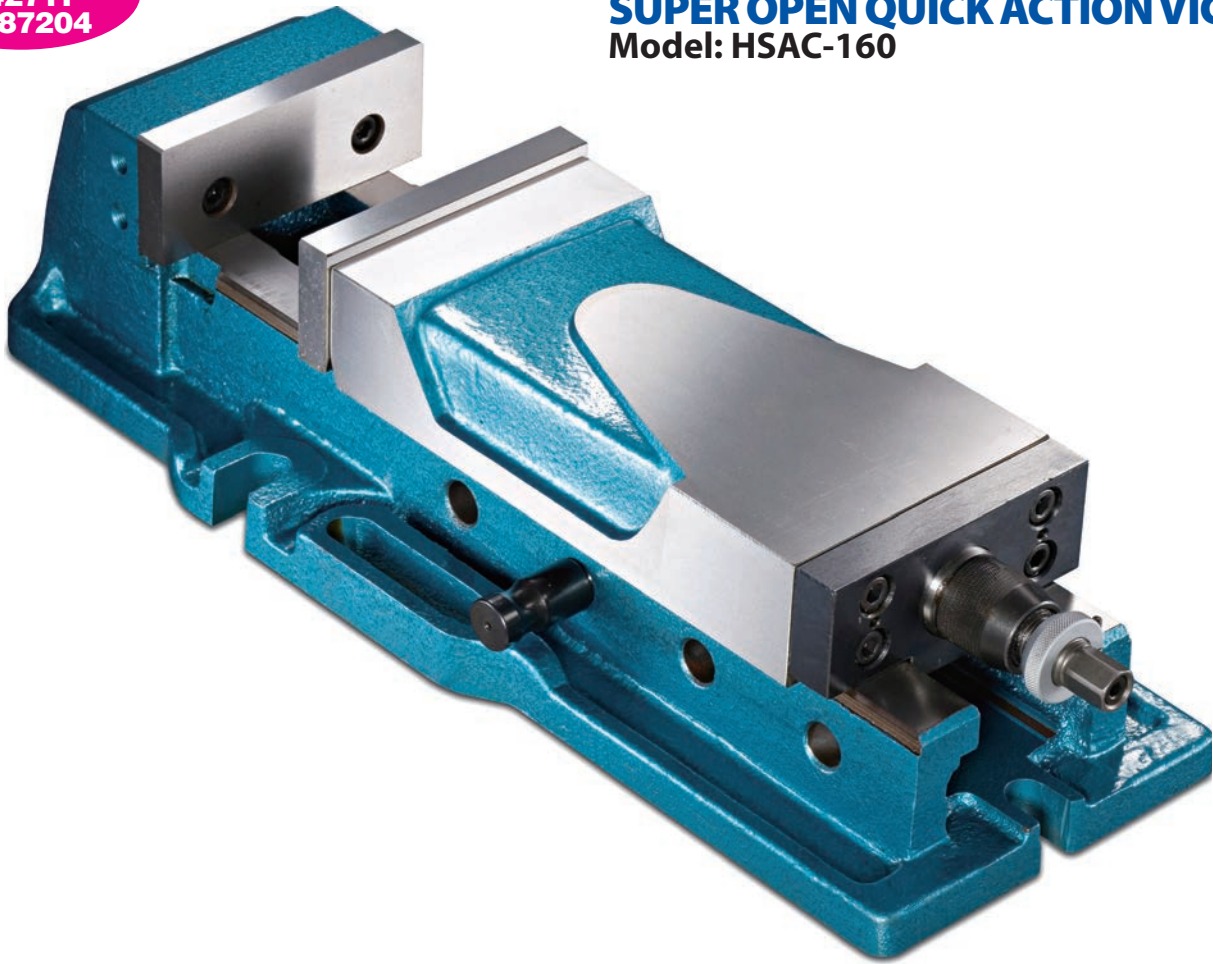


**PATENTED**  
**142711**  
**M287204**

**V-27**

## **SUPER OPEN QUICK ACTION VICE**

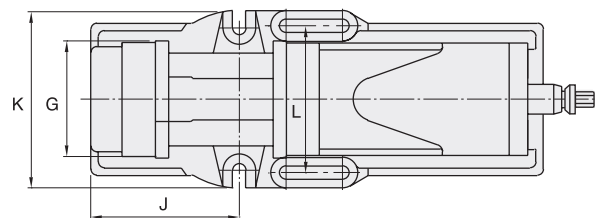
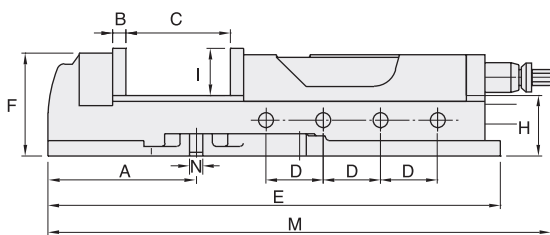
**Model: HSAC-160**



The patented MULTI-POWER SYSTEM built of **HIGH GRADE BEARING STEEL** provides extremely high clamping pressure. The pressure is more consistent and eliminates all leakage and maintenance problems associated with Hydraulic Vices.

- Patented **MULTI-POWER SYSTEM** provides extremely high clamping force of **0~4500kg**.
- No risk of loss of clamping pressure.
- No risk of oil leakage like Hydraulic Vices.
- More compact than Hydraulic Vices.
- Body has **ONE-PIECE CONSTRUCTION** for high rigidity and precision.
- **ANGLE-LOCK MECHANISM** provides downward pressure on Jaw to ensure parallel clamping.
- Both surfaces of Slideways are **HEAT TREATED**.
- Large opening capacity up to **300mm**.

### **DIMENSIONS**



### **SPECIFICATIONS** (Material: FCD 60 Ductile Iron, Hardness: HRC 50°)

Unit: mm

NO	Model	A	B	C	D	E	F	G	H	I	J	K	L	M	N	Weight (kg)
V-27	HSAC-160	200	15	300	77	610	139	158	82	63	200	240	190	915	18	58

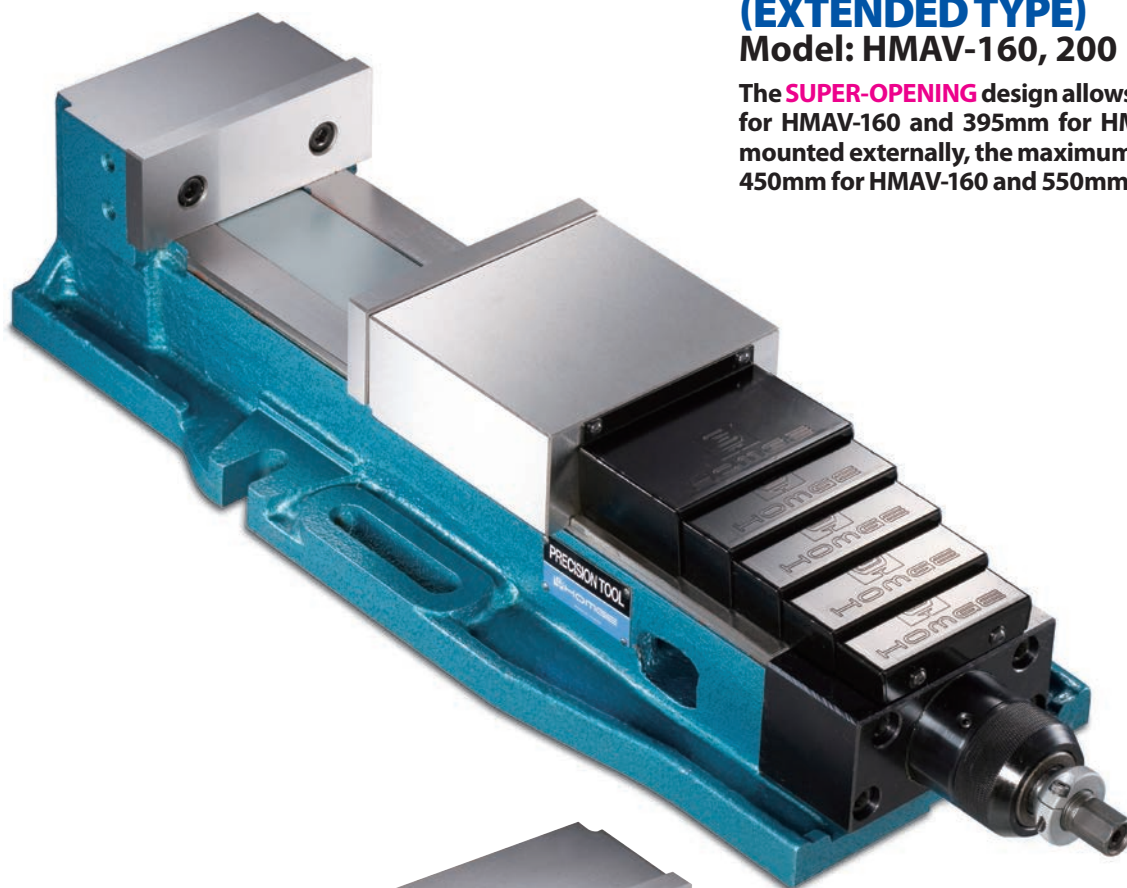
**PATENTED**  
142711  
M287204

V-28~29

## **MULTI-POWER FIXED ANGLE PRECISION VICE (EXTENDED TYPE)**

**Model: HMAV-160, 200**

The **SUPER-OPENING** design allows the jaws to open 310mm for HMAV-160 and 395mm for HMAV-200. With the Jaws mounted externally, the maximum work holding capacity is 450mm for HMAV-160 and 550mm for HMAV-200.

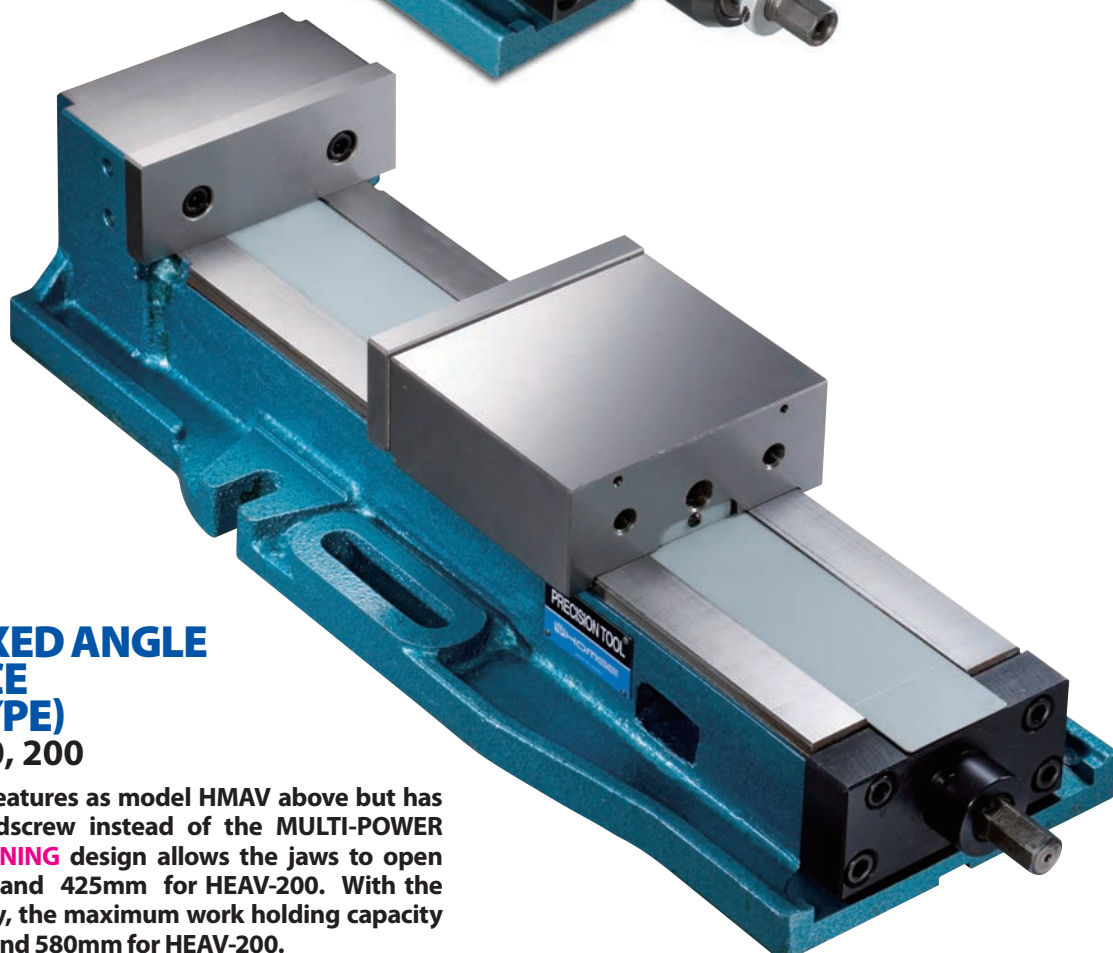


V-30~31

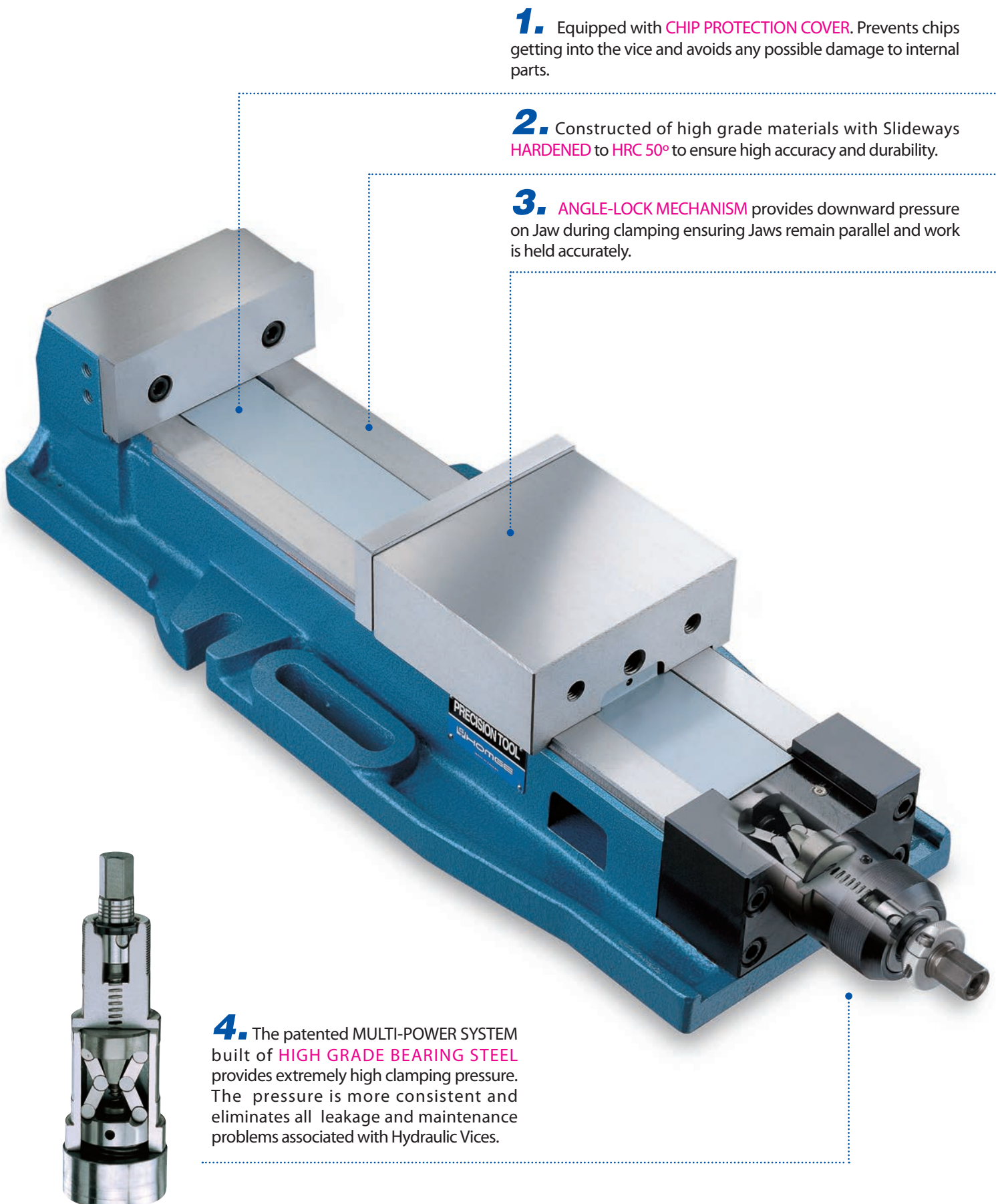
## **STANDARD FIXED ANGLE PRECISION VICE (EXTENDED TYPE)**

**Model: HEAV-160, 200**

This vice has the same features as model HMAV above but has standard clamping Leadscrew instead of the MULTI-POWER SYSTEM. The **SUPER-OPENING** design allows the jaws to open 340mm for HEAV-160 and 425mm for HEAV-200. With the Jaws mounted externally, the maximum work holding capacity is 480mm for HEAV-160 and 580mm for HEAV-200.







**1.** Equipped with **CHIP PROTECTION COVER**. Prevents chips getting into the vice and avoids any possible damage to internal parts.

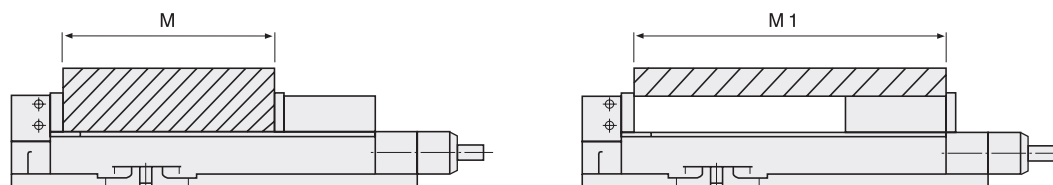
**2.** Constructed of high grade materials with Slideways **HARDENED** to **HRC 50°** to ensure high accuracy and durability.

**3.** **ANGLE-LOCK MECHANISM** provides downward pressure on Jaw during clamping ensuring Jaws remain parallel and work is held accurately.

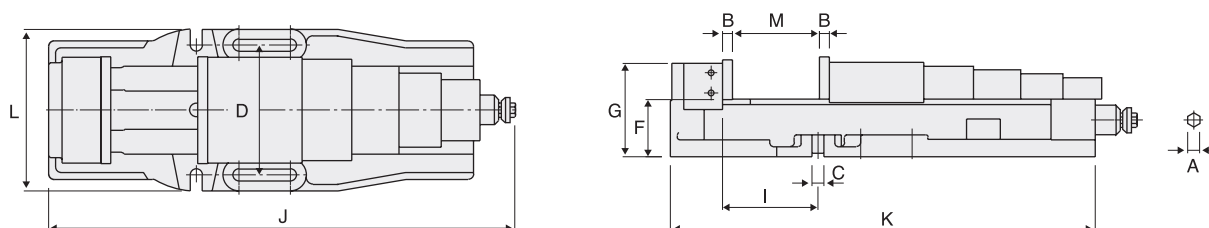
**4.** The patented **MULTI-POWER SYSTEM** built of **HIGH GRADE BEARING STEEL** provides extremely high clamping pressure. The pressure is more consistent and eliminates all leakage and maintenance problems associated with Hydraulic Vices.



## DIMENSIONS FOR 2 JAW PLATE POSITIONS



## DIMENSIONS

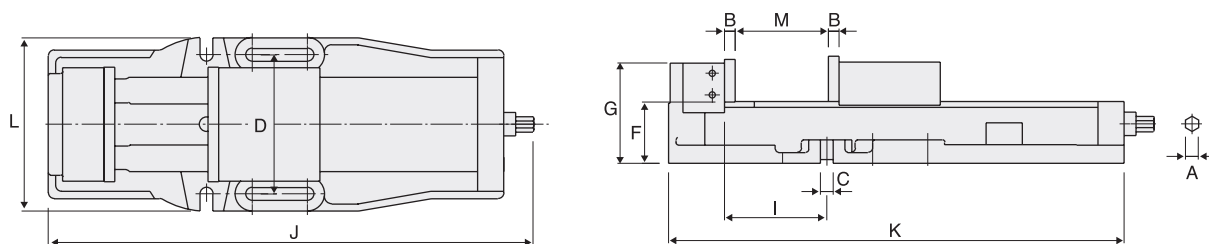


## SPECIFICATIONS (Material: FCD 60 Ductile Iron. Hardness: HRC 50°)

Unit: mm

NO	Model	A	B	C	D	F	G	I
V-28	HMAV-160	19	15	18	192	85 ± 0.01	140	141 ± 0.01
V-29	HMAV-200	19	18	18	240	97 ± 0.01	160	190 ± 0.01
NO	Model	J	K	L	M	M1	Weight (kg)	
V-28	HMAV-160	740	628	240	0-310	140-450	50	
V-29	HMAV-200	830	720	280	0-395	155-550	95	

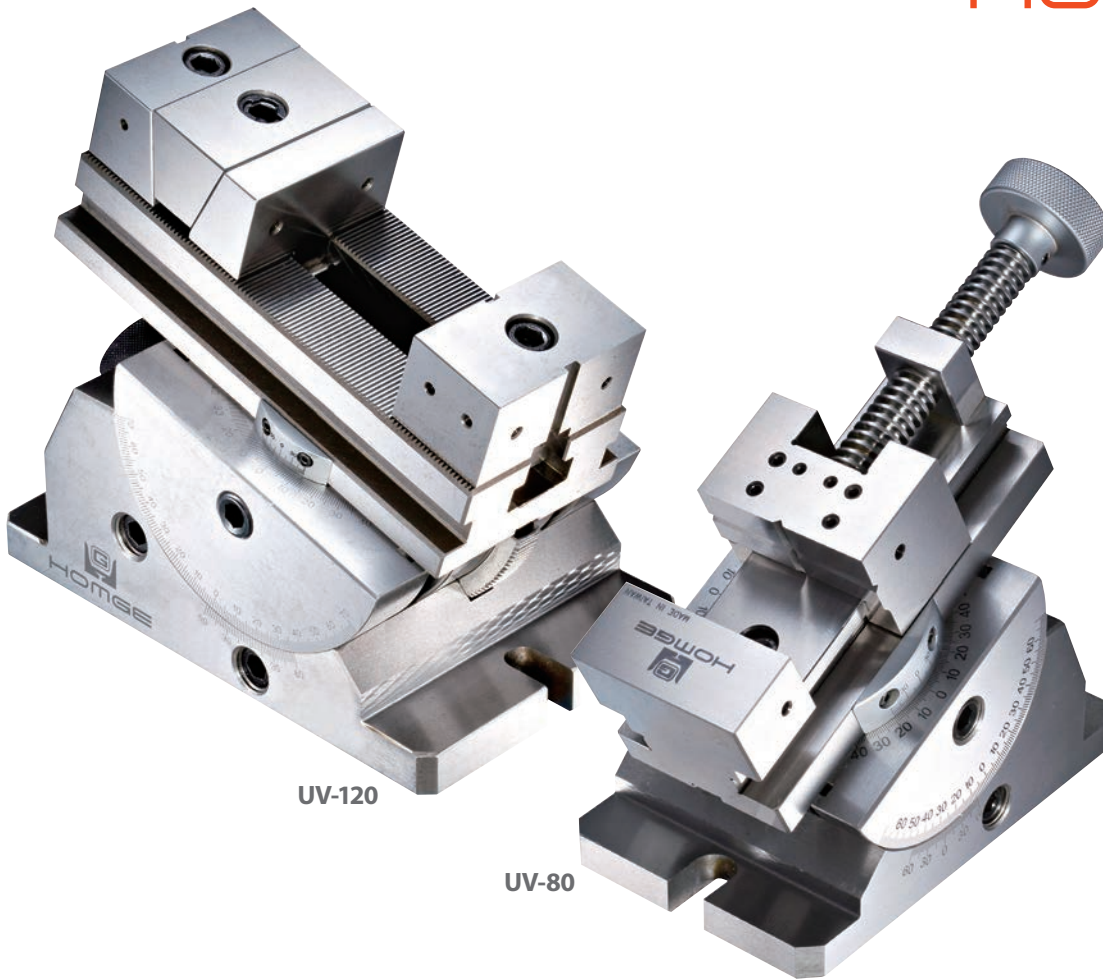
## DIMENSIONS



## SPECIFICATIONS (Material: FCD 60 Ductile Iron. Hardness: HRC 50°)

Unit: mm

NO	Model	A	B	C	D	F	G	I
V-30	HEAV-160	19	15	18	192	85 ± 0.01	140	141 ± 0.01
V-31	HEAV-200	19	18	18	240	100 ± 0.01	160	190 ± 0.01
NO	Model	J	K	L	M	M1	Weight(kg)	
V-30	HEAV-160	683	628	240	0-340	140-480	50	
V-31	HEAV-200	775	720	280	0-425	155-580	95	



UV-120

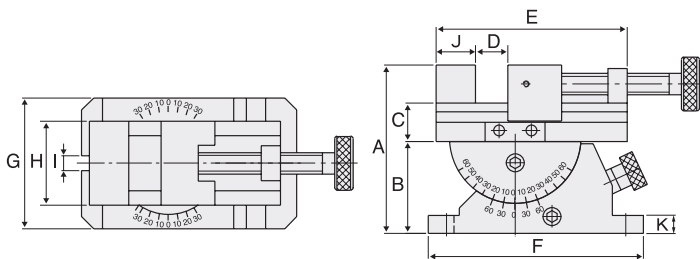
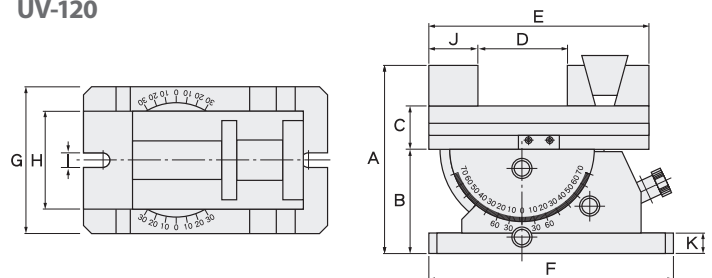
UV-80

**STANDARD ACCESSORY:**

- 1 pc of T Wrench

**V-32~33****PRECISION UNIVERSAL VICE****Model: UV-80, 120**

- Precision graduation for accurate reading
- Horizontal swivel through **360°**
- Tilts **45°** vertically
- Its swivelling and tilting features make this unit well suited for straight or inclined surface, angular drilling machining on various machine tools as precision grinding machine, boring and milling machine, electrical discharge machine, etc.

**UV-80****UV-120****SPECIFICATIONS** (Material: S50C / FCD 55 Ductile Iron. Hardness: HRC 56°)

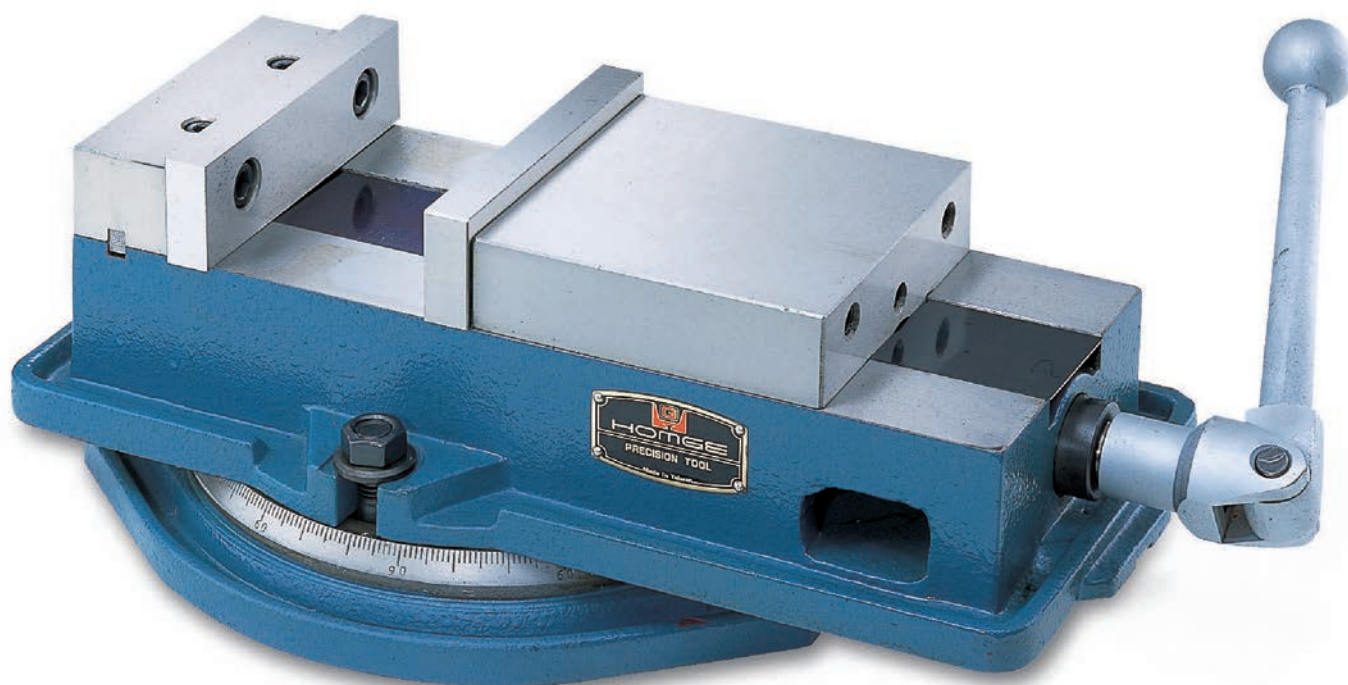
Unit: mm

NO	Model	A	B	C	D	E	F	G	H	I	J	K	Weight (kg)
V-32	UV-80	137	75	32	80	160	180	110	70	12.5	32	15	12
V-33	UV-120	231	128	53	110	270	300	180	120	18	60	25	43

V-34~38

**PRECISION ANGLE LOCK  
MACHINE VICE**

Model: HAV-4", 5", 6", 8", 12"

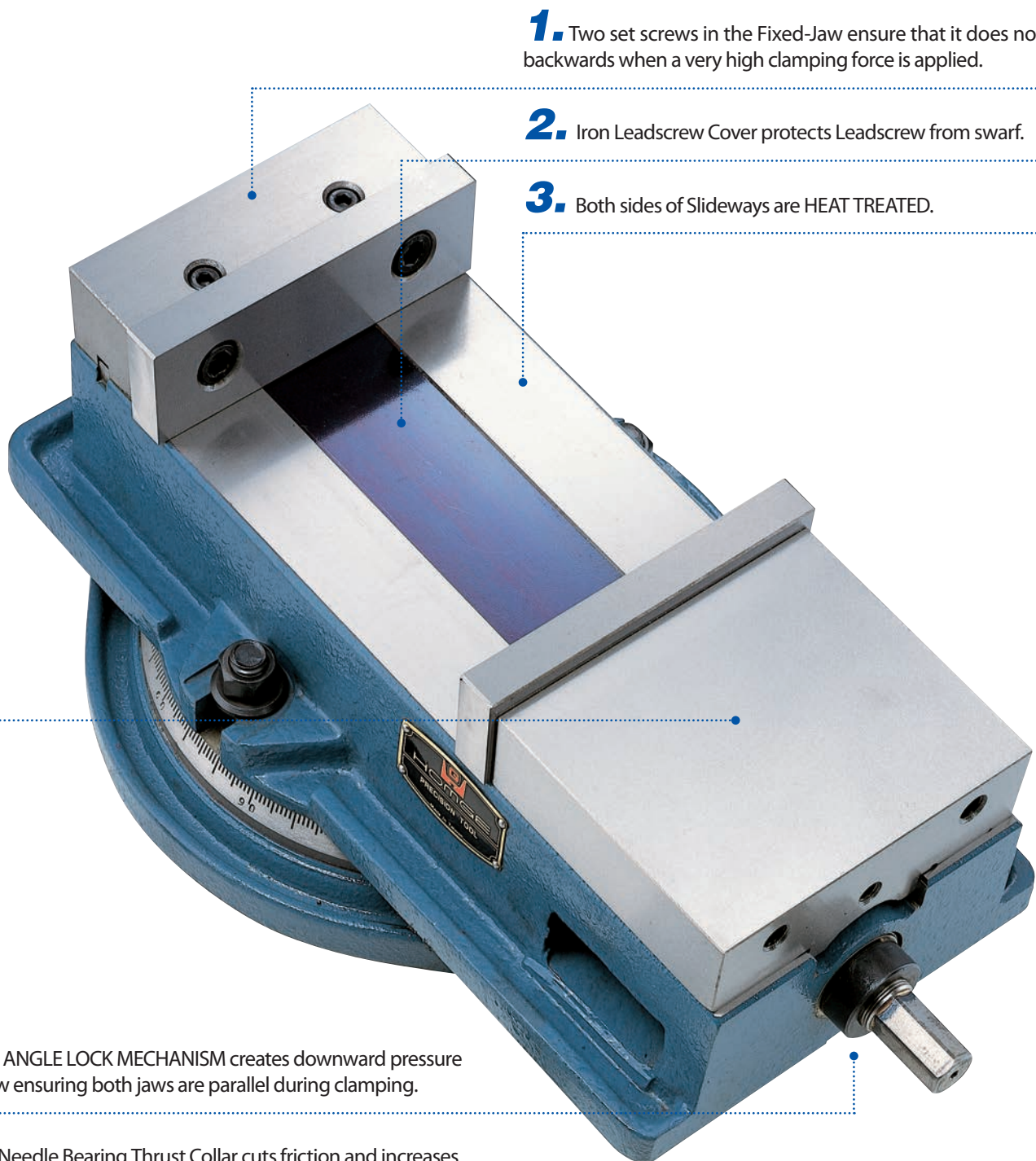


V-39

**PRECISION ANGLE LOCK  
MACHINE VICE**

Model: 6" SUPER-OPEN 8"





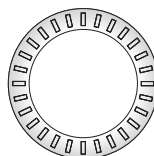
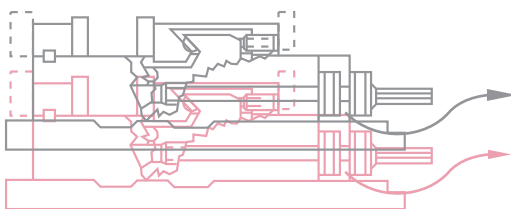
**1.** Two set screws in the Fixed-Jaw ensure that it does not tilt backwards when a very high clamping force is applied.

**2.** Iron Leadscrew Cover protects Leadscrew from swarf.

**3.** Both sides of Slideways are HEAT TREATED.


**4.** ANGLE LOCK MECHANISM creates downward pressure on Jaw ensuring both jaws are parallel during clamping.

**5.** Needle Bearing Thrust Collar cuts friction and increases clamping pressures 80%.




# 4 JAW PLATE POSITIONS

## 1




Important ground surfaces include: top and bottom of bed and stationary and movable jaws.

## 2




Flame hardening of the bed for added wear and strength.

## 3



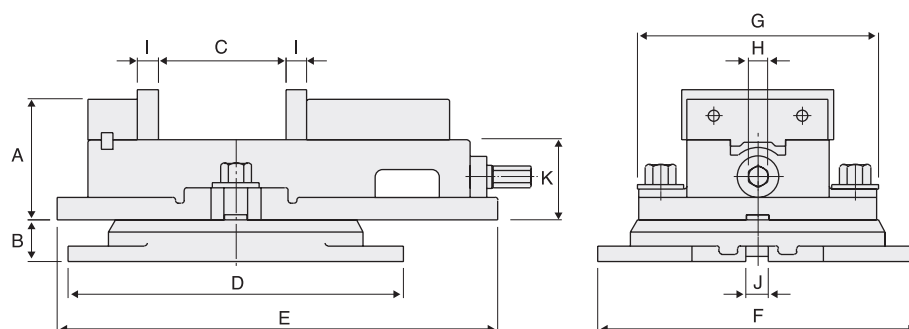
Totally enclosed special treated screw.

## 4







4 jaw plate positions allowing extra Capacity with the jaw plates in the outside position.

## DIMENSIONS



## SPECIFICATIONS

Unit: mm/inch

NO	Model									A		B								
V-34	HAV-4"	107	4	154	5 <sup>15</sup> / <sub>16</sub>	220	8 <sup>9</sup> / <sub>16</sub>	271	10 <sup>1</sup> / <sub>2</sub>	87	3 <sup>27</sup> / <sub>64</sub>	30	1 <sup>5</sup> / <sub>16</sub>							
V-35	HAV-5"	110	4 <sup>1</sup> / <sub>4</sub>	163	6 <sup>1</sup> / <sub>2</sub>	249	9 <sup>3</sup> / <sub>4</sub>	304	12	98	3 <sup>55</sup> / <sub>64</sub>	32	1 <sup>1</sup> / <sub>4</sub>							
V-36	HAV-6"	138	5 <sup>1</sup> / <sub>2</sub>	201	8	304	12	368	14 <sup>1</sup> / <sub>2</sub>	110	4 <sup>1</sup> / <sub>4</sub>	40	1 <sup>1</sup> / <sub>2</sub>							
V-37	HAV-8"	198	7 <sup>3</sup> / <sub>4</sub>	264	10 <sup>3</sup> / <sub>4</sub>	402	15 <sup>13</sup> / <sub>16</sub>	476	18 <sup>3</sup> / <sub>4</sub>	136	5 <sup>27</sup> / <sub>64</sub>	55	2 <sup>3</sup> / <sub>16</sub>							
V-38	HAV-12"	320	12 <sup>5</sup> / <sub>8</sub>	400	15 <sup>3</sup> / <sub>4</sub>	480	18 <sup>7</sup> / <sub>8</sub>	560	22	219	8 <sup>5</sup> / <sub>8</sub>	—	—							
NO	Model	C		D		E		F		G		H		I		J		K		Weight (kg)
V-34	HAV-4"	107	4	242	9 <sup>1</sup> / <sub>2</sub>	318	12 <sup>33</sup> / <sub>64</sub>	230	9 <sup>1</sup> / <sub>16</sub>	172	6 <sup>3</sup> / <sub>4</sub>	14	9 <sup>9</sup> / <sub>16</sub>	15	1 <sup>19</sup> / <sub>32</sub>	16	5 <sup>5</sup> / <sub>8</sub>	58	2 <sup>9</sup> / <sub>32</sub>	20
V-35	HAV-5"	110	4 <sup>1</sup> / <sub>4</sub>	280	11	355	14	256	10 <sup>1</sup> / <sub>16</sub>	210	8 <sup>1</sup> / <sub>4</sub>	15	1 <sup>19</sup> / <sub>32</sub>	15	1 <sup>19</sup> / <sub>32</sub>	16	5 <sup>5</sup> / <sub>8</sub>	66	2 <sup>19</sup> / <sub>32</sub>	29
V-36	HAV-6"	138	5 <sup>1</sup> / <sub>2</sub>	336	13 <sup>1</sup> / <sub>4</sub>	405	15 <sup>15</sup> / <sub>16</sub>	300	11 <sup>3</sup> / <sub>4</sub>	238	9 <sup>3</sup> / <sub>8</sub>	19	3 <sup>3</sup> / <sub>4</sub>	18	3 <sup>3</sup> / <sub>4</sub>	18	3 <sup>3</sup> / <sub>4</sub>	72	2 <sup>54</sup> / <sub>64</sub>	41
V-37	HAV-8"	198	7 <sup>3</sup> / <sub>4</sub>	422	16 <sup>5</sup> / <sub>8</sub>	555	21 <sup>3</sup> / <sub>4</sub>	380	15	305	12	19	3 <sup>3</sup> / <sub>4</sub>	24	1 <sup>15</sup> / <sub>16</sub>	18	3 <sup>3</sup> / <sub>4</sub>	84	3 <sup>5</sup> / <sub>16</sub>	80
V-38	HAV-12"	320	12 <sup>5</sup> / <sub>8</sub>	—	—	738	29 <sup>1</sup> / <sub>16</sub>	—	—	408	16 <sup>1</sup> / <sub>16</sub>	19	3 <sup>3</sup> / <sub>4</sub>	24	1 <sup>15</sup> / <sub>16</sub>	—	—	102	4	125

## SPECIFICATIONS (Material: FCD 55 Ductile Iron. Hardness: HRC 45°)

Unit: mm/inch

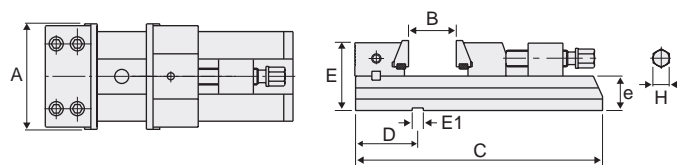
NO	Model				
----	-------	--	--	--	--

**STANDARD ACCESSORIES:**

- 2 pcs of Alignment Wedge
- 4 pcs of Clamp

**V-40~47****PRECISION RAPID VICE****Model: HG-100,150(A,B,C,D), 200(A,B,C)**

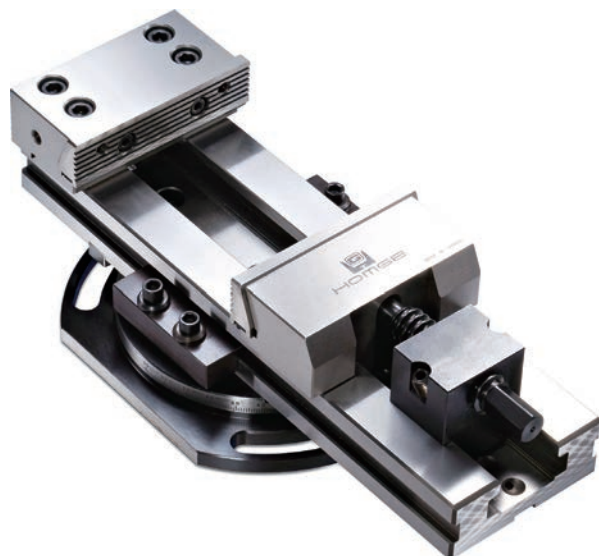
- Designed with an instant clamping Hex-Nut for quick adjustment when clamping different work-pieces with irregular lengths.
- Movable Jaw can be easily moved for clamping etc.
- Jaws are slotted for increased grip on workpiece.
- Movable Jaw is short in length for maximum opening capacity.
- Tapered Jaws provide more stable clamping.
- Made entirely of steel the Vice is strong and powerful and retains accuracy.
- Compact design allows maximum workholding capacity on machine.



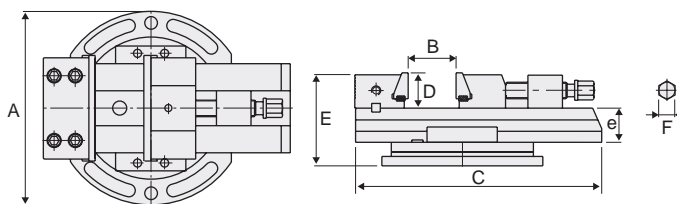
Unit: mm

**SPECIFICATIONS** (Material: S50C. Hardness: HRC 58°~60°)

NO	Model	A	B	D	E	E1	e	C	H	Clamping force	Weight (kg)
V-40	HG-100	100	100	73 ± 0.02	68	14	37 ± 0.01	250	12	2T	8
V-41	HG-150A	150	150	88 ± 0.02	95	18	48 ± 0.01	350	23	4T	23
V-42	HG-150B		200					400			25
V-43	HG-150C		250					450			27
V-44	HG-150D		300					500			29
V-45	HG-200A	205	200	85 ± 0.02	126	18	63 ± 0.01	470	26	5T	55
V-46	HG-200B		250					520			63
V-47	HG-200C		300					570			73

**V-48~54****PRECISION RAPID VICE WITH SWIVEL BASE****Model: HG-150S(A,B,C,D),HG-200S(A,B,C)****STANDARD ACCESSORIES:**

- 2 pcs of Alignment Wedge
- 4 pcs of Clamp



Unit: mm

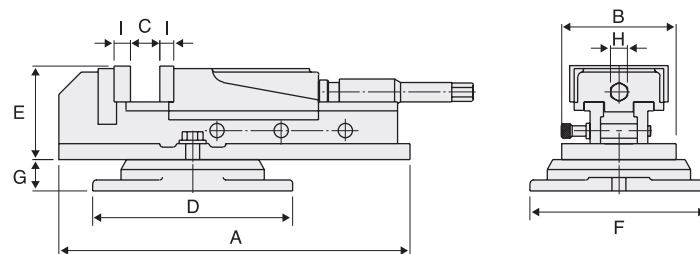
**SPECIFICATIONS** (Material: S50C. Hardness: HRC 58°~60°)

NO	Model	A	B	D	E	e	C	F	Clamping force	Weight (kg)
V-48	HG-150SA	275	150	50	128	48 ± 0.01	350	23	4T	33
V-49	HG-150SB		200				400			35
V-50	HG-150SC		250				450			37
V-51	HG-150SD		300				500			39
V-52	HG-200SA	350	200	69	163	63 ± 0.01	470	26	5T	65
V-53	HG-200SB		250				520			73
V-54	HG-200SC		300				570			83



**V-55~57****SUPER-OPEN MILLING VICE****Model: H-400, 600, 800****8" JAW OPENING ON H-400 VICE****11" JAW OPENING ON H-600 VICE****14" JAW OPENING ON H-800 VICE**

Except the Hydraulic System, it has almost the same features with HH-Type HYDRAULIC MACHINE VICE.



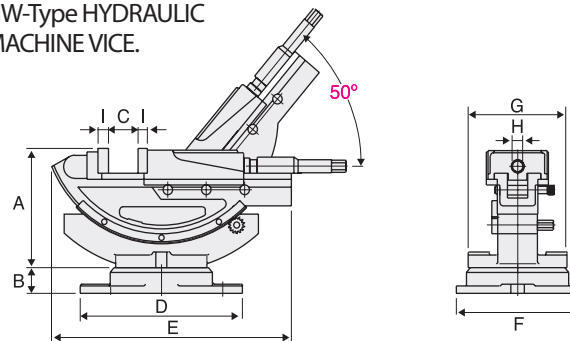
Unit: mm/inch

**SPECIFICATIONS**

NO	Model	A		B		C		D		E		F		G		H		I		Weight (kg)
V-55	H-400	394	15 <sup>33</sup> / <sub>64</sub>	148	5 <sup>53</sup> / <sub>64</sub>	200	8	224	8 <sup>13</sup> / <sub>16</sub>	105	4	204	4 <sup>1</sup> / <sub>8</sub>	35	1 <sup>3</sup> / <sub>8</sub>	19	3 <sup>3</sup> / <sub>4</sub>	15	1 <sup>19</sup> / <sub>32</sub>	19
V-56	H-600	535	2 <sup>11</sup> / <sub>16</sub>	200	7 <sup>7</sup> / <sub>8</sub>	275	11	280	1 <sup>11</sup> / <sub>64</sub>	142	5 <sup>19</sup> / <sub>32</sub>	256	10 <sup>5</sup> / <sub>64</sub>	32	1 <sup>1</sup> / <sub>4</sub>	19	3 <sup>3</sup> / <sub>4</sub>	15	1 <sup>19</sup> / <sub>32</sub>	45
V-57	H-800	605	2 <sup>13</sup> / <sub>16</sub>	250	10	336	14	336	1 <sup>15</sup> / <sub>64</sub>	144	5 <sup>43</sup> / <sub>64</sub>	300	1 <sup>113</sup> / <sub>16</sub>	40	1 <sup>37</sup> / <sub>64</sub>	19	3 <sup>3</sup> / <sub>4</sub>	15	1 <sup>19</sup> / <sub>32</sub>	75

**V-58~59****TILTING SUPER-OPEN VICE****Model: HHY-100, 150****Our most popular angle milling vice**

- Tilts up and down.
- Base swivels.
- High quality casting with ground finish.
- Easy and light operating, 4 holes can be firmly clamped quickly.
- Type HHY-150 jaw's opening 310mm, 2 times larger than the normal milling vices.
- Except the Hydraulic system, it has almost the same features with HW-Type HYDRAULIC MACHINE VICE.



Unit: mm

**SPECIFICATIONS**

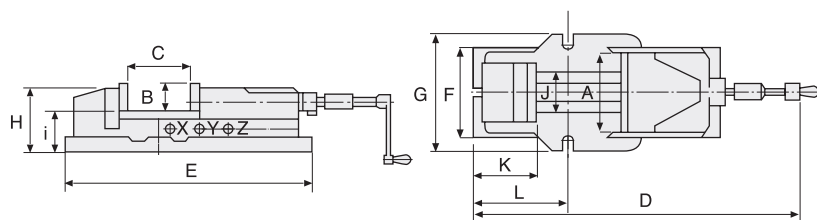
NO	Model	A	B	C	D	E	F	G	H	I	Weight (kg)
V-58	HHY-100	195	42	170	270	405	228	168	19	15	29
V-59	HHY-150	214	40	310	336	485	300	238	19	15	58



## V-60~63

**HYDRAULIC MACHINE VICE****Model: HH-100, 125, 150, 200**

- Constructed with HYDRAULIC CYLINDER, which absorbs cutting vibration and improves the precision of machining whilst maintaining a high clamping force.
- The clamping force can be adjusted accurately by use of a DIAL.
- Vice Body is made of high tensile cast iron. The Slideways are hardened and ground to ensure rigidity, durability and minimal deformation.
- The vice Jaws are made of a special hardened ALLOY STEEL and are precision ground.



Unit: mm

**SPECIFICATIONS**

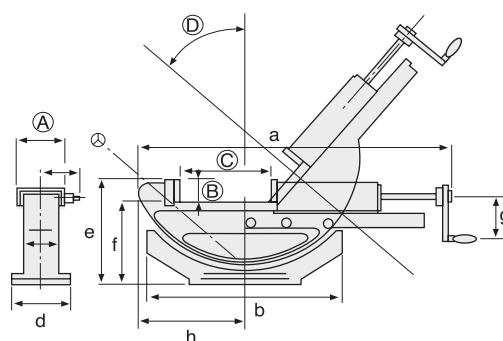
NO	Model	A	B	C	D	E	F	G	H	I	J	K	L	Clamping Force	Weight(kg) Body	Weight (kg) Swivel Base
V-60	HH-100	100	36	170	525	430	130	160	94	60	78	100	155	2500	16	6
V-61	HH-125	125	46	220	670	540	165	185	118	72	97	117	185	3500	33	7
V-62	HH-150	150	51	300	800	620	200	240	133	82	116	125	207	4500	54	16
V-63	HH-200	200	62	300	900	700	225	280	160	100	160	150	265	8500	90	20



## V-64~65

**TILTING HYDRAULIC MACHINE VICE****Model: HW-100, 150**

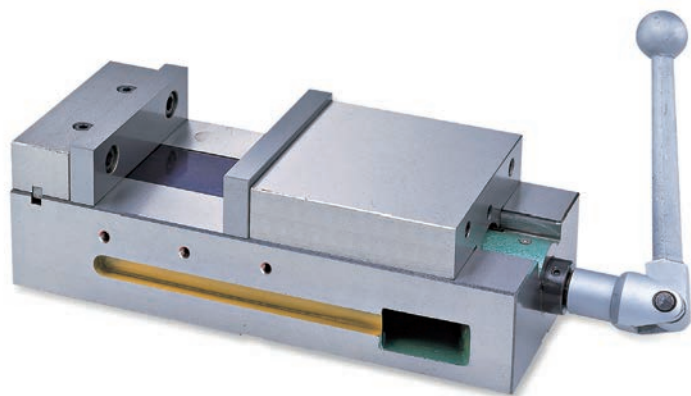
- Constructed with the same specifications as the HH-Type above.
- Having the added tilting function it is particularly well suited to many jig and fixture making applications as well as being more versatile for general machining work.



Unit: mm

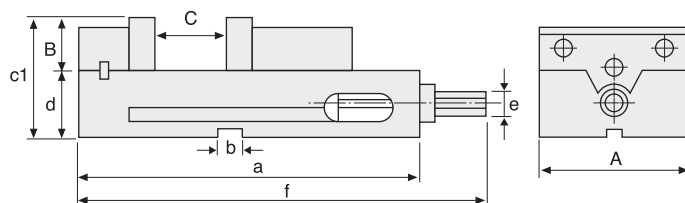
**SPECIFICATIONS**

NO	Model	A	B	C	D	a	b	c	d	e	f	g	h	Weight (kg) Body	Weight (kg) Swivel Base
V-64	HW-100	100	36	170	50°	505	325	65	160	177	141	80	170	23	4
V-65	HW-150	150	51	300	50°	775	410	95	240	237	186	100	200	60	10

**V-66****LOCK II MACHINE VICE****Model: HMC-6"**

This is the "Just Right" vice for use on all your tape controlled machine tools. What the vice doesn't have is a coolant through. This enables you to anchor a series of these vices snuggle side-by-side on the machine bed. A number of similar parts can be clamped and machined at the same time, with minimum center-to-center machining distance. Up goes your production rate; down goes costs. Both sides are precision ground square to bottom and parallel with each other and so the vice can also be used at vertical position with its vice bed perfectly perpendicular to the machine table.

- Can be placed side-by-side on your N / C equipment.
- Permits fast accurate multiple machining.
- Sides ground.
- **ACCURACY** Both sides square to bottom to 0.01mm and parallel with each other to 0.02mm (All others same as HAV-6" Vice.)
- Keyways on bottom to steady jaw plate.



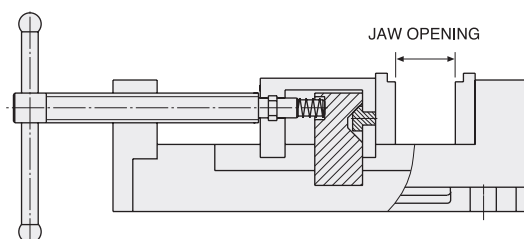
Unit: mm

**SPECIFICATIONS** (Material: FCD 55, Ductile Iron)

NO	Model	A	B	C	a	b	c1	d	e	f	Weight (kg)
V-66	HMC-6"	156	44	146	370	18	119	75	19	438	32

**V-67~68****ANGLE LOCK DRILL PRESS VICE****Model: HDV-100, 130**

- **ANGLE LOCK MECHANISM** produces downward pressure on Jaw during clamping, ensuring that both Jaws are parallel and work is held accurately.
- Built of high tensile (FCD 55) Ductile Iron .
- Slideways and underside of vice are precision ground.
- The Stepped Jaw Plates are hardened to HRC 50° and precision ground.

**SPECIFICATIONS** (Material: FCD 55, Ductile Iron)

Unit: mm

NO	Model	JAW PLATE HEIGHT	JAW PLATE WIDTH	JAW OPENING	Weight (kg)
V-67	HDV-100	43	100	90	6.6
V-68	HDV-130	43	130	90	8.2



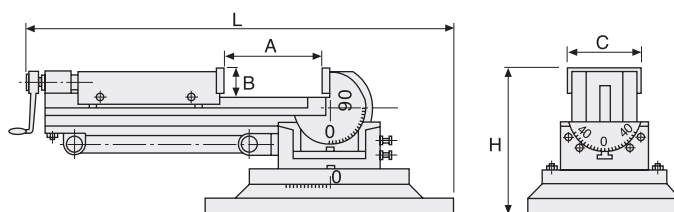


## V-69~71

**UNIVERSAL 3-WAY TILING VICE****Model: HY-3", 4", 5"**

Material is highest quality **Ductile Iron 80,000 PSI ...**  
**It's durable and won't be broken.**

- Angles can be set in three dimensions.
- The 360° turnable base is graduated in degrees.
- The vice can be elevated through 90° from the horizontal to the vertical position, and it can also be tilted on its lower angle setting base up to 45° in both the left and right directions.
- The vice can be securely locked in all of its three settings.

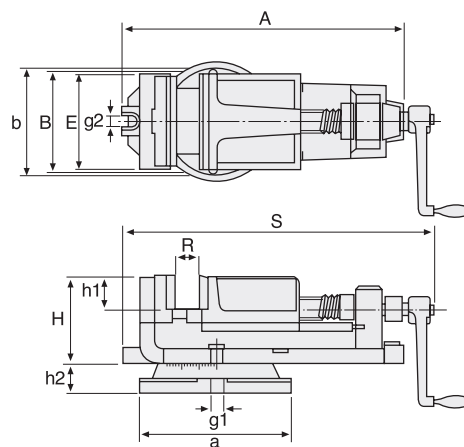
**SPECIFICATIONS** (Material: FCD 55. Ductile Iron)

Unit: mm

NO	Model	A	B	C	H	L	Vertical Height	Weight (kg)
V-69	HY-3"	90	30	80	150	396	386	17
V-70	HY-4"	105	38	106	172	460	470	33
V-71	HY-5"	140	40	132	205	625	590	45



## V-72~75

**K-TYPE MACHINE VICE****Model: HKV-100, 125, 150, 200****SPECIFICATIONS**

Unit: mm

NO	Model	E	A	B	H	R	S	a	b	h1	h2	g1	g2	Weight (kg)
V-72	HKV-100	100	267	106	75	65	295	160	114	30	25	10	10	10
V-73	HKV-125	125	340	130	99	80	400	210	155	38	23	10	10	16
V-74	HKV-150	150	421	160	105	114	462	245	175	40	40	13	13	26
V-75	HKV-200	200	576	215	144	150	620	340	230	58	45	17	17	52