



The Productivity Devices Company

The Ultimate Machining Vise
Modular and Interchangeable

 **STEEL** HRc 60
PULL DOWN
ACCURATE within 0.0008"

800-992-0236

+1-913-365-1045

sales@vektek.com

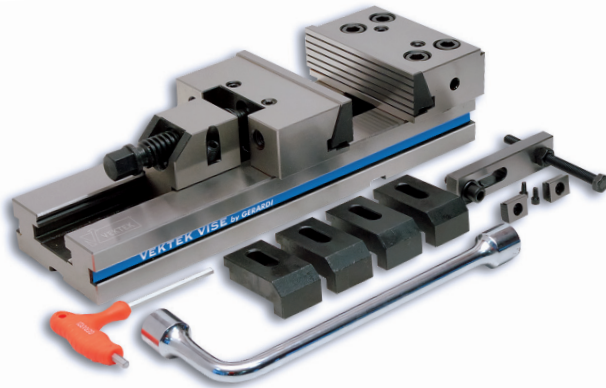
www.vektek.com



VEKTEK VISE *by GERARDI*

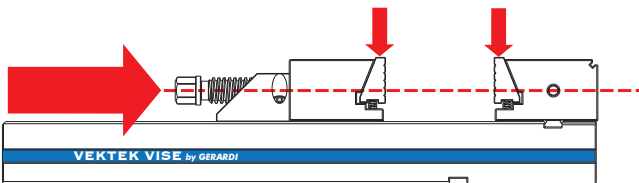
Standard Vise

Precision Modular Vises Series



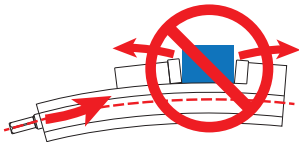
The most popular!

- All steel construction hardened and ground HRC 60
- Accuracy within 0.0008"
- Geometrically toleranced surfaces and locators make initial setup and gang operation easy.
- Pull down jaws help hold the part against the vise base while clamping and can be locked in the down position if pull down action is not needed.
- Space saving shorter vise base frees several inches of "Z" travel for parts and spindle.
- No wear (5 year warranty)
- Long bases are available to hold larger parts, up to 20" or more. The jaw carrier is normally within the base length dimension and never extends beyond the vise base when used to hold smaller parts.



Pull-down & Concentric Forces

The screw is on the top portion of the vise to avoid any contortion or jaw bending.



Other vises have screws on the bottom of the vise creating uneven torque in the jaws.

FEATURES

1 VERSATILITY

The optional jaws (ordered separately) have a 5mm X 5mm step which allows the use of the reversible rear jaw step. Combines with the magnetic parallel plates, intermediate movable jaw and step in the prismatic movable jaw which allows you to clamp plates. The prismatic jaw "V" slot jaws hold round workpieces either vertically or horizontally.

2 HIGHEST ACCURACIES 0.0008"

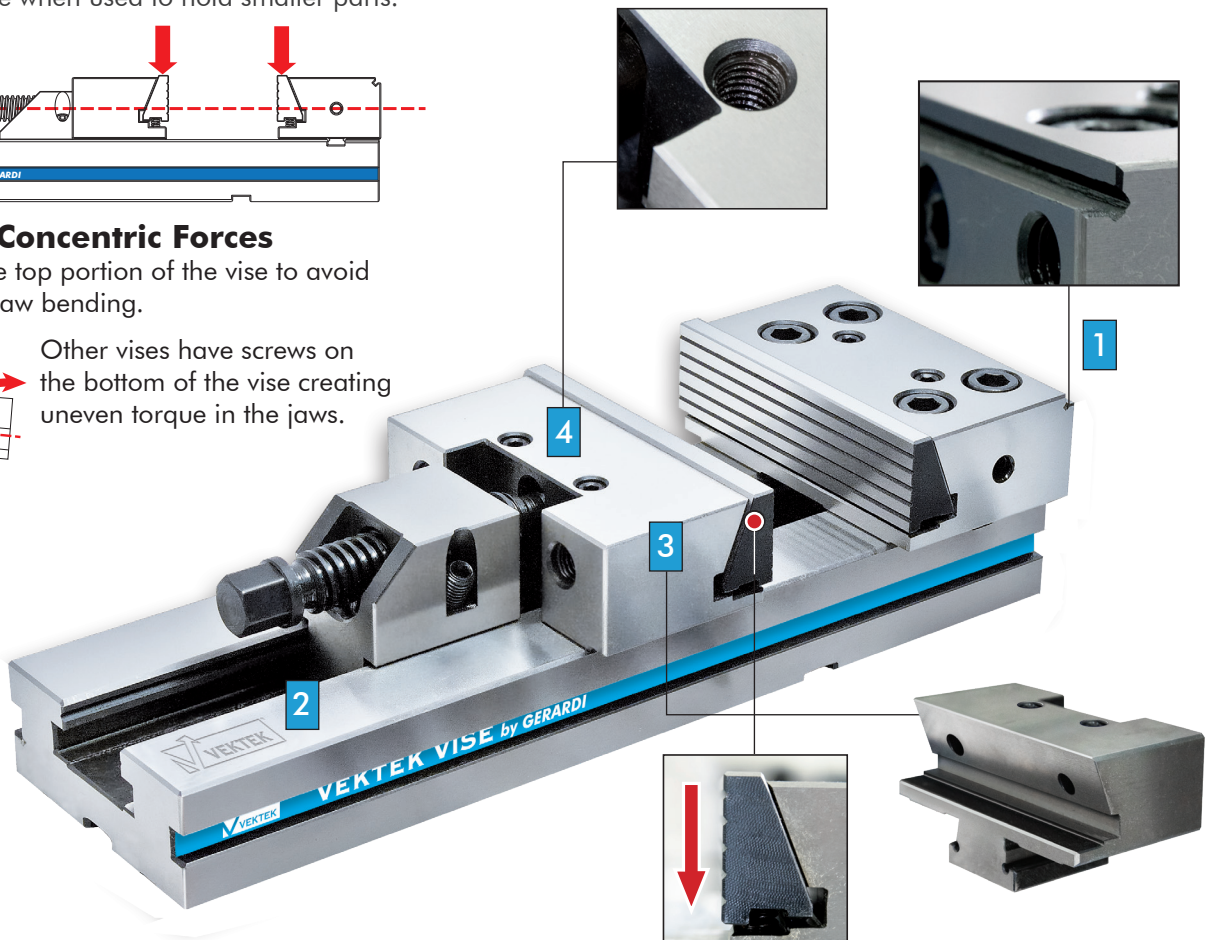
Solid vise base. Every sliding and coupling surface is precisely ground. Tight tolerances are guaranteed by checking with automated CMMs. Perfect alignment with the machine axis is ensured by longitudinal and cross keyways for easy installation and setup.

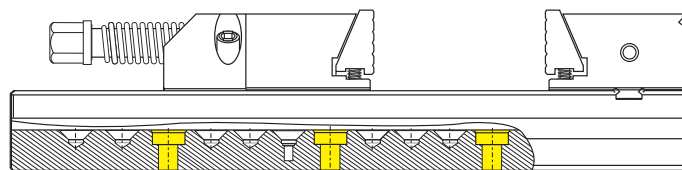
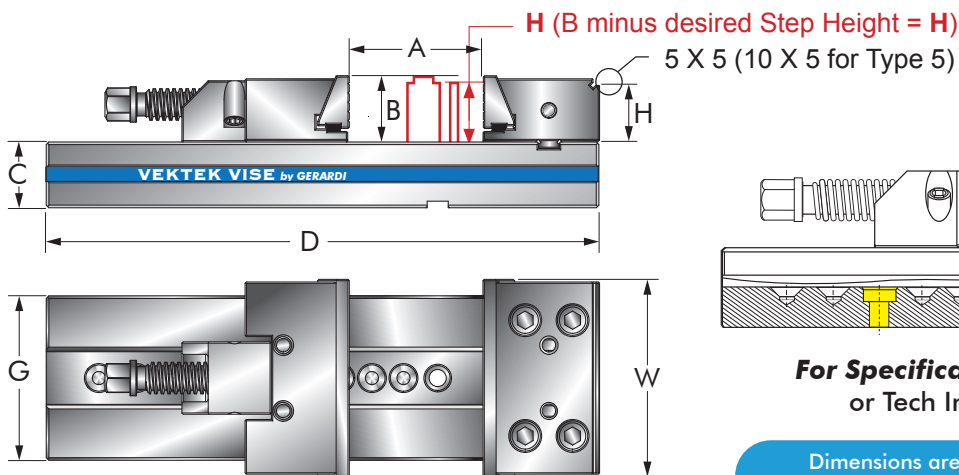
3 RIGIDITY AND SAFETY

Both jaw bodies are built in one solid piece to guarantee higher rigidity and no bending. The jaw plates are designed with a pull down angle. During the clamping operation, a downward force is created holding the workpiece against the vise base for precise and safe clamping. Pull down action can be limited by fixing the jaws in the down position with the retention screws.

4 JAW HOLES FOR SPECIAL APPLICATIONS

Four extra tapped holes over the jaws for stacking soft jaws over the existing jaw set.





For Specifications: Download CAD drawing
or Tech Info from www.vektek.com

Dimensions are shown in millimeters, inch dimension
conversions (X") are for reference and comparison purposes.

Vise Type		2	3		4				5				
Clamp Force		25 kN (5620 lbs)	30 kN (6744 lbs)		30 kN (6744 lbs)				40 kN (8992 lbs)				
Jaw Width	W	125mm (4.92")	150mm (5.91")		175mm (6.89")				200mm (7.87")				
Max Opening	A	150 (5.91")	200 (7.87")	300 (11.81")	200 (7.87")	300 (11.81")	400 (15.75")	500 (19.69")	200 (7.87")	300 (11.81")	400 (15.75")	500 (19.69")	600 (23.62")
Jaw	B	40	50		60				65				
	C	40	50		58				70				
Base	D	345 (13.58")	420 (16.54")	520 (20.47")	455 (17.91")	555 (21.85")	655 (25.79")	755 (29.72")	495 (19.49")	595 (23.43")	695 (27.36")	795 (31.30")	895 (35.24")
	G	95	125		145				170				
	H	33	43		53				53				
Screw Travel		59mm (2.32 in)	59mm (2.32 in)		63mm (2.48 in)				88mm (3.46 in)				
Weight		12.8 kg (28.2 lbs)	25.5 kg (56 lbs)	29 kg (64 lbs)	37 kg (82 lbs)	42 kg (93 lbs)	47 kg (104 lbs)	52 kg (115 lbs)	64 kg (141 lbs)	69 kg (152 lbs)	74 kg (163 lbs)	79 kg (174 lbs)	84 kg (185 lbs)
Model No.		V30210000	V30320000	V30330000	V30420000	V30430000	V30440000	V30450000	V30520000	V30530000	V30540000	V30550000	V30560000

For Vise Type

Magnetic Parallel Plates - FOR CUSTOM Specify Step Height **H** (mm)

	2	3	4	5
H = (mm)	H	H	H	H
Model No.	V43132000-25 V43132000-30 V43132000-33	V43133000-25 V43133000-35 V43133000-43	V43134000-25 V43134000-40 V43134000-53	V43135000-25 V43135000-40 V43135000-53

Intermediate Movable Jaw - FOR CUSTOM Specify Step Height **H** (mm)
To be used with magnetic parallel plates

	2	3	4	5
H = (mm)	H	H	H	H
Model No.	V12122000-33	V12123000-43	V12124000-53	V12125000-53

Prismatic Movable Jaw

Model No.	V22172000	V22173000	V22174000	V22175000
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Jaw Plate with Standard Hardness Gripper Inserts

Model No.	V1242G200-G01	V1242G300-G01	V1242G400-G01	V1242G500-G01
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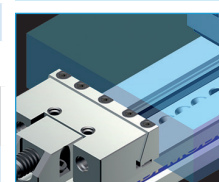
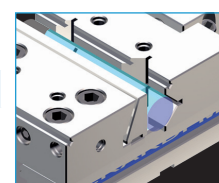
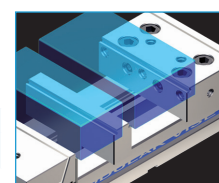
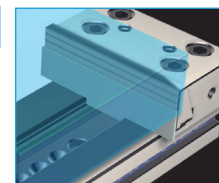
ADDITIONAL GRIPPERS	Standard Hardness	Soft Material	Hardened Material
Model No.	V42201000-G01	V42201000-G11	V42201000-G02

When ordering the above accessories, select the standard H desired and specify after Model No.

To receive other than standard offset, specify your desired H dimension after Model No.

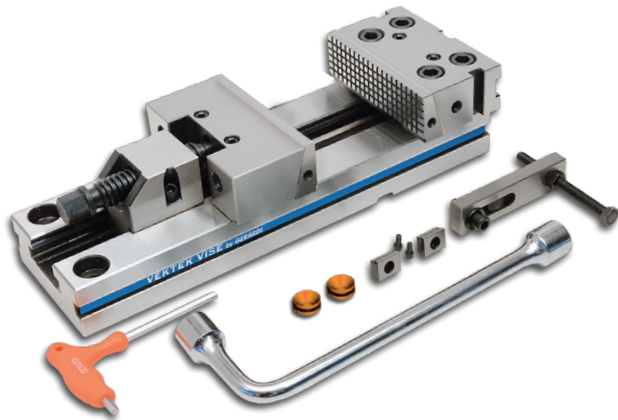
Dimensions B minus desired Step Offset = H to order

Example: **H** (mm)
V43132000-XX



Flex Vise™

**Innovative quick change jaw
guide system for pull-down jaws**



Same as Standard, PLUS...

- Vertical operation as a 2 sided tower on horizontal machines.
- Quick change jaws with comb guiding feature for easy changes.
- Great savings in vise resetting times and jaw changes.
- More effective protection from chips.
- Increased and more precise guided pull down action.
- Highest repositioning accuracy.

FEATURES

- NO WEAR
- QUICK CLAMPING
- MODULARITY & VERSATILITY
- CHANGE JAWS IN SECONDS
- HIGHEST ACCURACIES 0.0008"
- RIGIDITY & SAFETY
- SPACE SAVING DESIGN

1 HIGHEST REPOSITIONING ACCURACY CUTS SETUP TIME

Geometrically toleranced bases assure the jaw position relative to the locating keys and vise base surfaces, cutting setup times dramatically.

2 GREAT SAVINGS IN JAW CHANGING TIMES

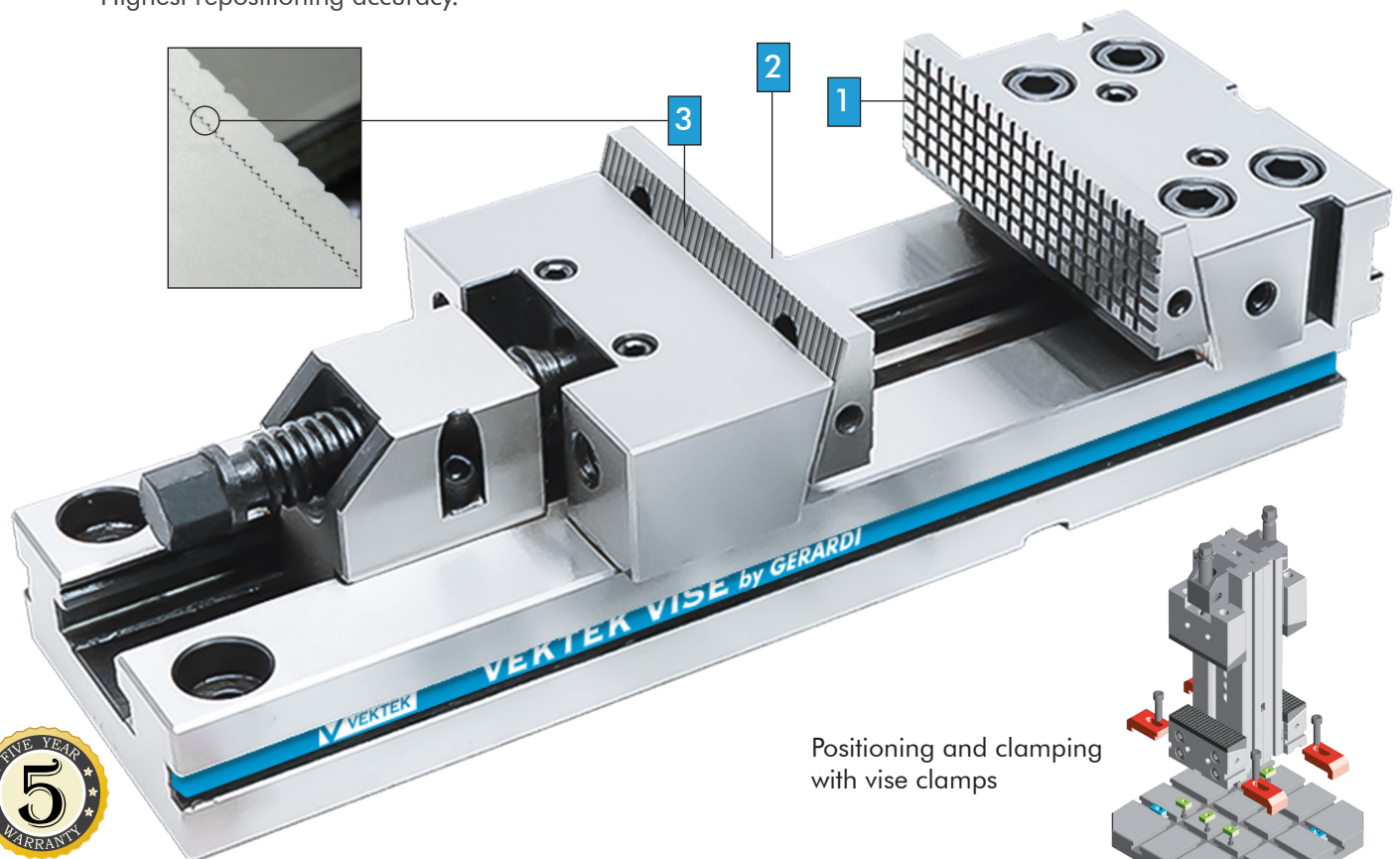
Thanks to the manual interchangeable quick jaw plate, guiding comb and quick change mechanism.

3 PULL DOWN ACTION

Guided pull down action thanks to the matching comb guided jaws and carriers. Serrations also help prevent entry of chips which can cause mis-alignment.

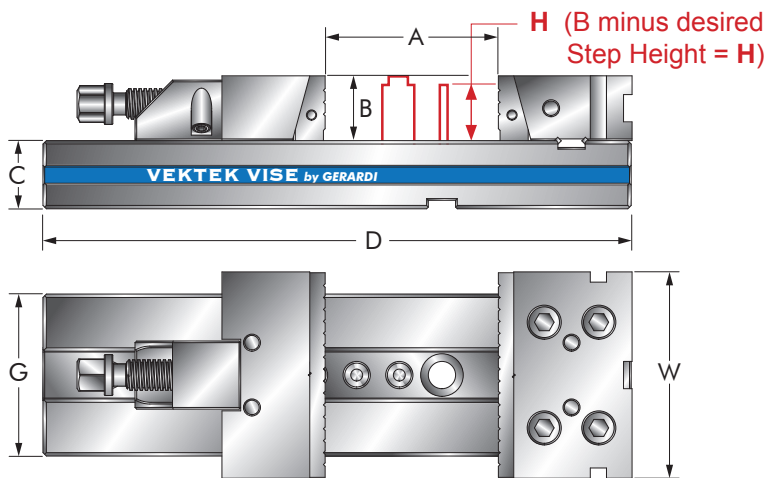
2 PRECISION LOCATING HOLES

Allows for minimum of set up time with perfect alignment each time!

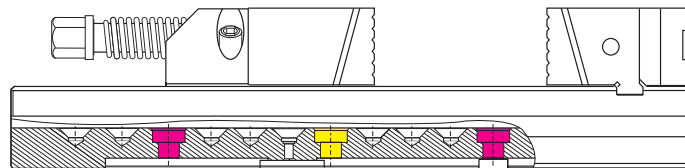


Positioning and clamping
with vise clamps





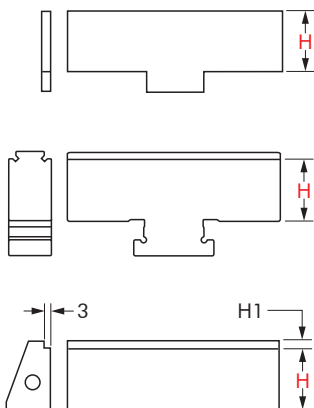
2 PRECISION LOCATING HOLES



For Specifications: Download CAD drawing or Tech Info from www.vektek.com

Dimensions are shown in millimeters, inch dimension conversions (X") are for reference and comparison purposes.

Vise Type	2	3	4	5
Clamp Force	25 kN (5620 lbs)	30 kN (6744 lbs)	30 kN (6744 lbs)	40 kN (8992 lbs)
Jaw Width W	121mm (4.76")	146mm (5.75")	171mm (6.73")	196mm (7.72")
Max Opening A	150 (5.91")	200 (7.87")	300 (11.81")	400 (15.75")
Jaw B	38	48	58	63
C	40	50	58	70
Base D	345 (13.58")	420 (16.54")	520 (20.47")	455 (17.91")
G	95	125	145	170
Screw Travel	59mm (2.32 in)	65mm (2.56 in)	63mm (2.48 in)	88mm (3.46 in)
Weight	12.9 kg (28.5 lbs)	25.5 kg (56.2 lbs)	29 kg (64.0 lbs)	37 kg (81.6 lbs)
Model No.	V11A20000	V11A32000	V11A33000	V11A42000
				V11A43000
				V11A44000
				V11A45000
				V11A52000
				V11A53000
				V11A54000
				V11A55000
				V11A56000

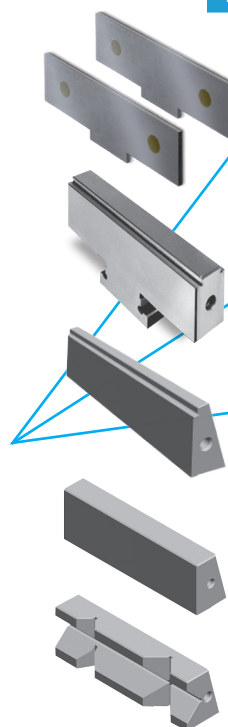


When ordering the above accessories, select the standard H desired and specify after Model No.

To receive other than standard offset, specify your desired H dimension after Model No.

Dimensions B minus desired Step Offset = H to order

Example: H (mm)
V43132000-XX



For Vise Type 2 3 4 5

Magnetic Parallel Plates - FOR CUSTOM Specify Step Height H (mm)

H = (mm)	H	H	H	H
Model No.	V43132000-25 V43132000-30 V43132000-33	V43133000-25 V43133000-35 V43133000-43	V43134000-25 V43134000-40 V43134000-53	V43135000-25 V43135000-40 V43135000-53

Intermediate Movable Jaw - FOR CUSTOM Specify Step Height H (mm)
To be used with magnetic parallel plates

H = (mm)	H	H	H	H
Model No.	V12122000-33	V12123000-43	V12124000-53	V12125000-53

Interchangeable Jaw Plate - FOR CUSTOM Specify Step Height H (mm)

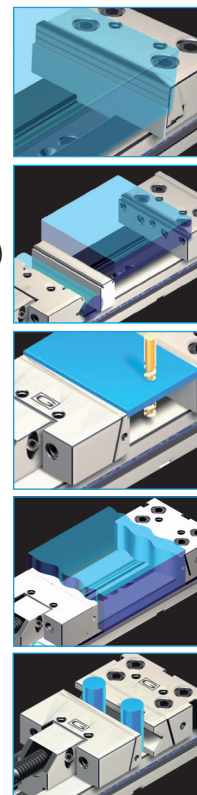
H = (mm)	H	H	H	H
Model No.	V4230E201-33 H1 5	V4230E301-43 H1 5	V4230E401-53 H1 5	V4230E501-53 H1 10

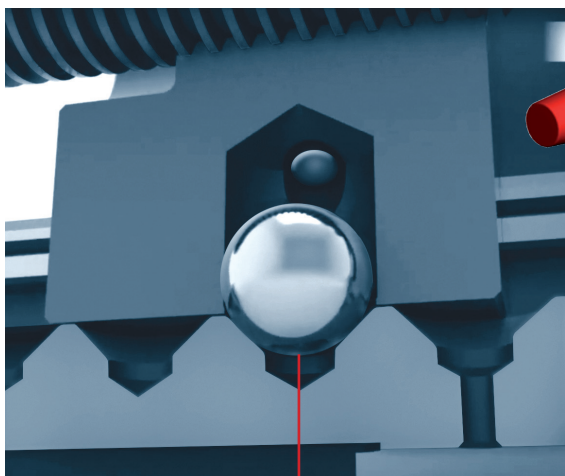
Soft Interchangeable Jaw Plate

Model No.	V4230B201	V4230B301	V4230B401	V4230B501
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Prismatic Interchangeable Jaw Plate

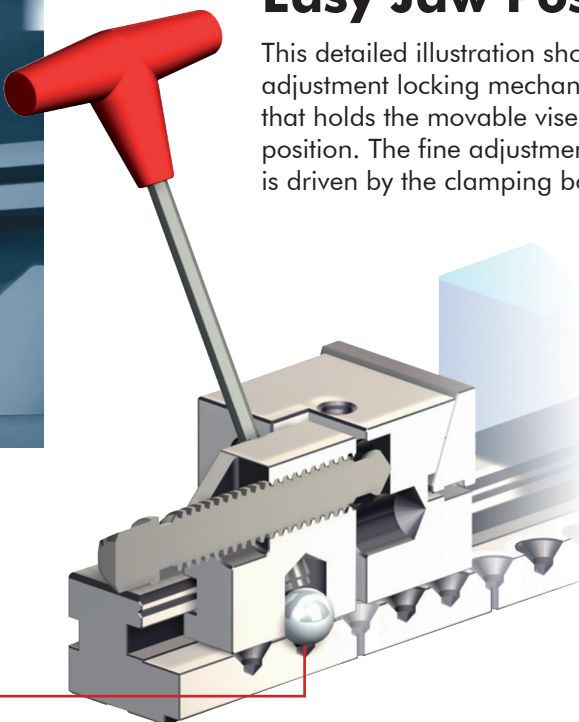
Model No.	V4230F201	V4230F301	V4230F401	V4230F501
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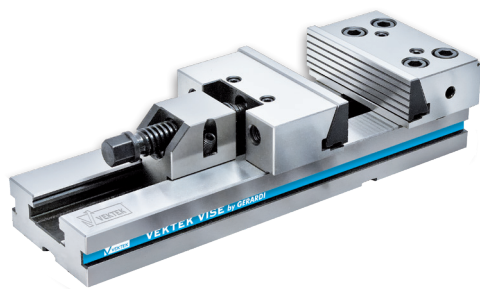


Easy Jaw Positioning!

This detailed illustration shows the gross adjustment locking mechanical support that holds the movable vise jaw security in position. The fine adjustment and clamping is driven by the clamping bolt.



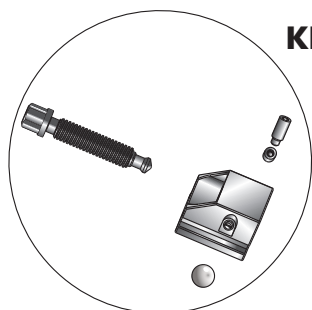
REPLACEMENT PART KIT FOR: **Standard Vise**



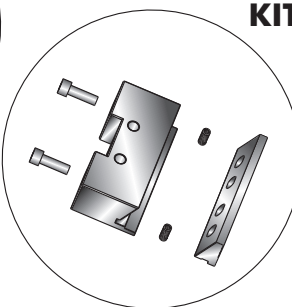
WISE NUMBER	KIT 1 Model No.	KIT 2 Model No.	KIT 3 Model No.
V30210000	V22582000	V21272000	V21202000
V30320000 V30330000	V22583000	V21273000	V21203000
V30420000, V30430000 V30440000, V30450000	V22584000	V21274000	V21204000
V30520000, V30530000 V30540000, V30550000 V30560000	V22585000	V21275000	V21205000

PLVG3020 / PLVG3030 / PLVG3040 / PLVG3050

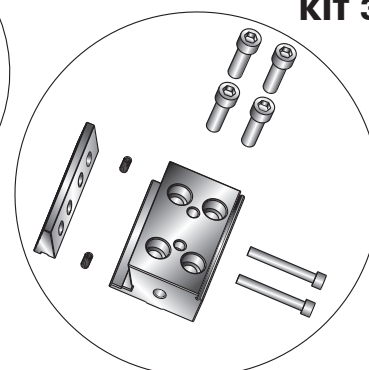
KIT 1



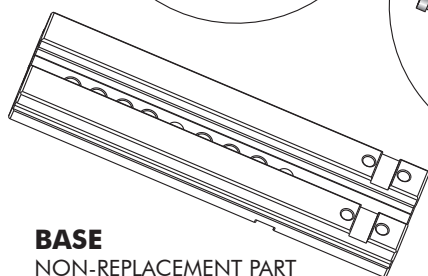
KIT 2



KIT 3

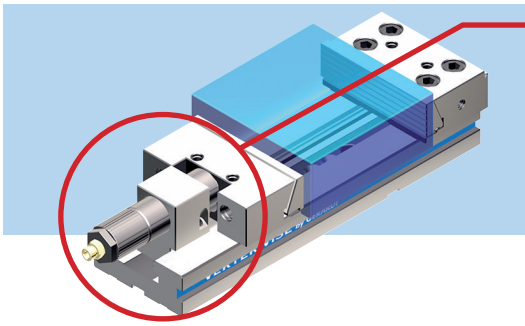


Actual KITS may vary from illustrations depending upon the model selected.



BASE
NON-REPLACEMENT PART

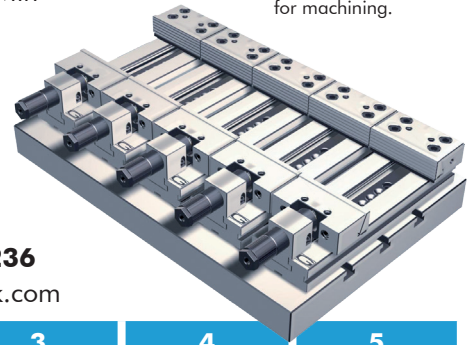




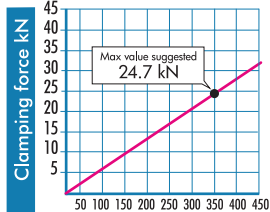
Add HYDRAULIC POWER to ANY Vektek Vise

It's easy to add hydraulic power to the Vektek Vise by simply replacing the mechanical clamping support with a hydraulic clamping support. The single acting hydraulic cylinder will require a hydraulic power source, operational control and some plumbing, easily purchased from Vektek.

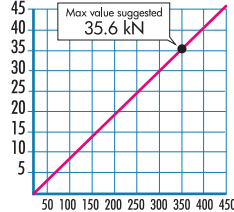
Multiple vises can be arranged to hold large or multiple parts for machining.



FOR VISE TYPE 2-3-4



5



Oil pressure in bar (1 bar = 14.5 psi)

Effective area 7,07 cm²

Effective area 10,17 cm²

Some factor as lubrication, clamping on the machine table, frictions and more can modify above values within a $\pm 10\%$ range.

For optimum operation do not exceed chart values.

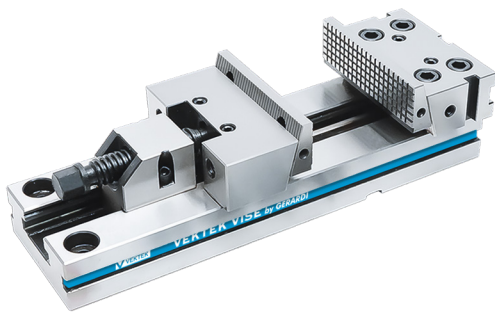
For more information

contact Team Vektek: **800-992-0236**

sales@vektek.com

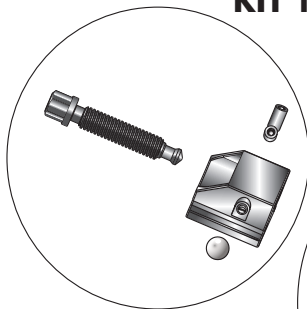
Vise Type	2	3	4	5
Model Number	V22712000	V22713000	V22714000	V22715000
Cylinder stroke	26mm (1.02 in.)	26mm (1.02 in.)	26mm (1.02 in.)	40mm (1.57 in.)
Oil Volume	18.38 cm ³ (1.12 in ³)	18.38 cm ³ (1.12 in ³)	18.38 cm ³ (1.12 in ³)	40.68 cm ³ (2.48 in ³)

REPLACEMENT PART KIT FOR: Flex Vise™

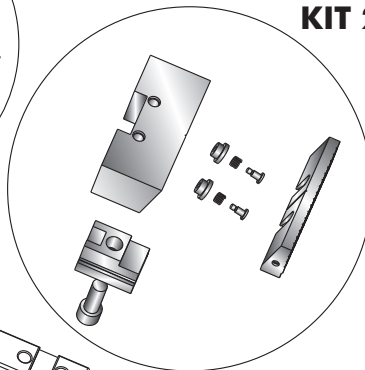


VISE NUMBER	KIT 1 Model No.	KIT 2 Model No.	KIT 3 Model No.
V11A20000	V22582000	V4127A200	V4120A200
V11A32000 V11A33000	V22583000	V4127A300	V4120A300
V11A42000, V11A43000 V11A44000, V11A45000	V22584000	V4127A400	V4120A400
V11A52000, V11A53000 V11A54000, V11A55000 V11A56000	V22585000	V4127A500	V4120A500

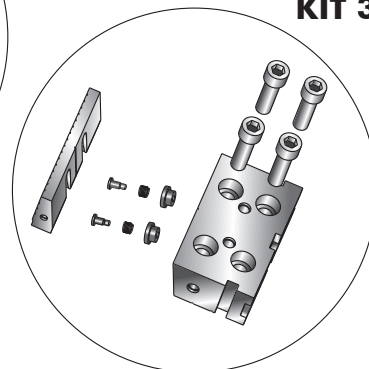
KIT 1



KIT 2



KIT 3



PLVG1a20 / PLVG1a30 / PLVG1a40 / PLVG1a50

Actual KITS may vary from illustrations depending upon the model selected.

BASE

NON-REPLACEMENT PART



The Productivity Devices Company

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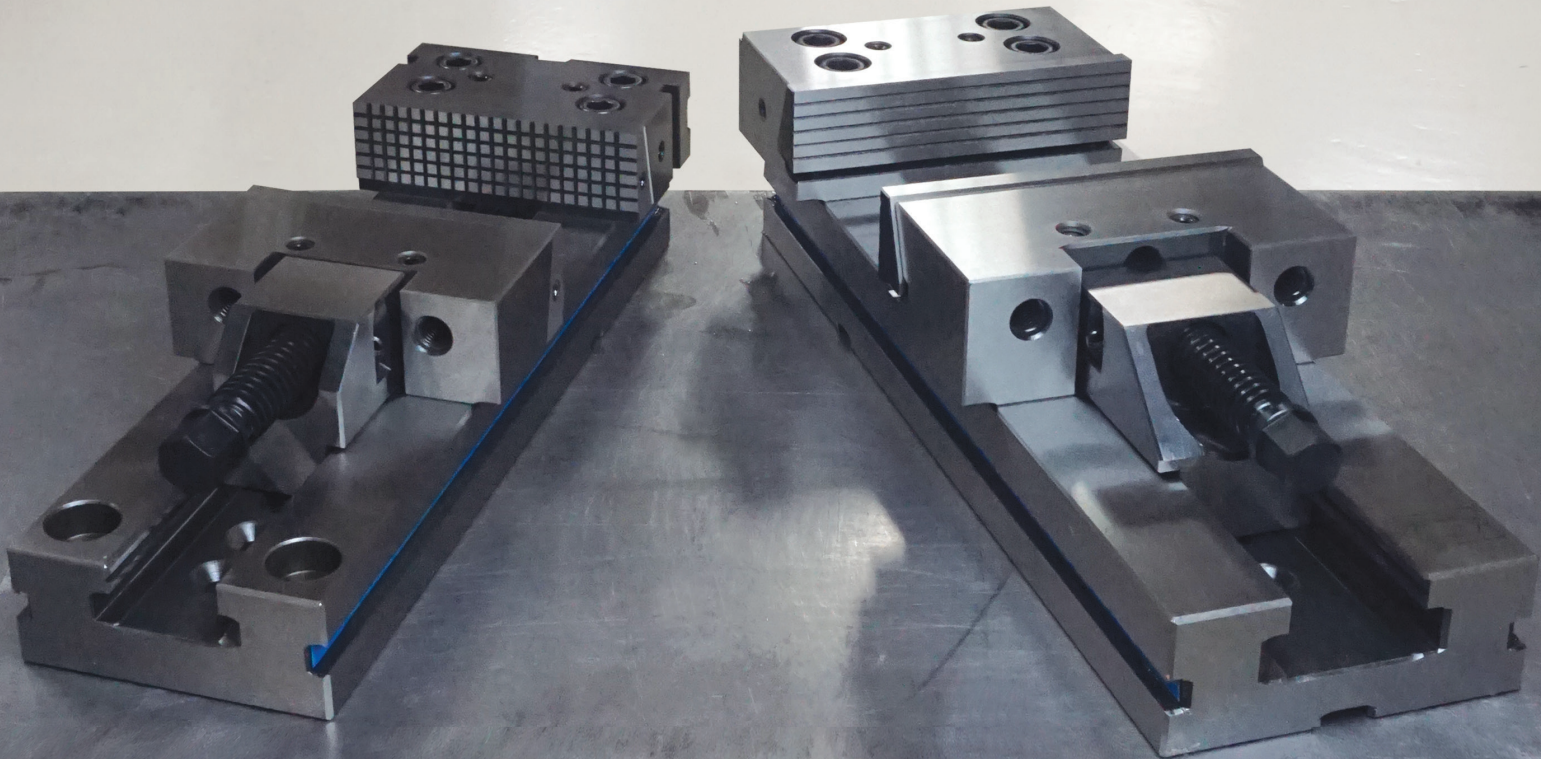
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The Ultimate Machining Vise
Modular and Interchangeable



VEKTEK VISE

Revised May 2021

