

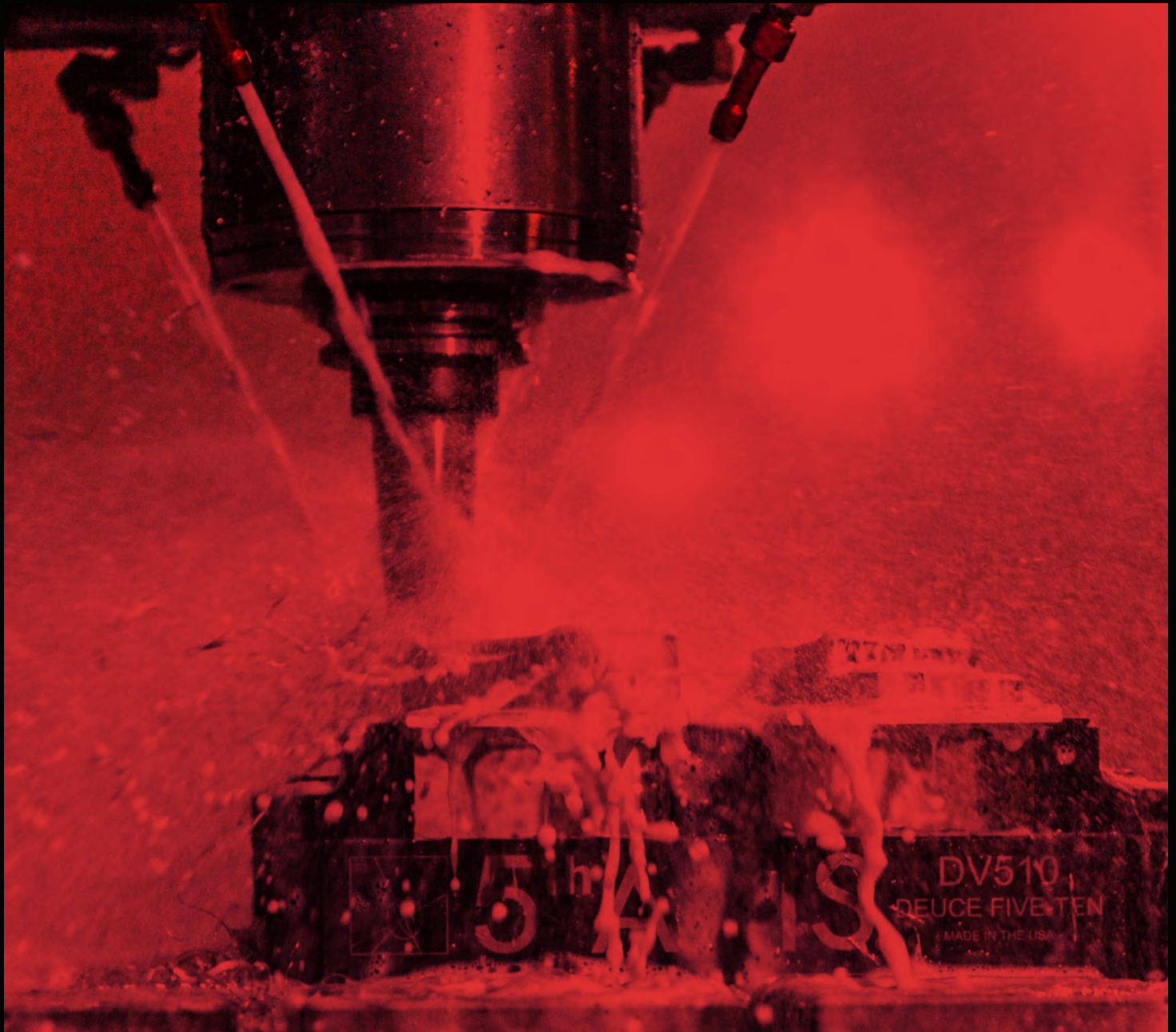


Workholding Evolved.

VOLUME

5

VICES - FIXTURES - QUICK CHANGE SYSTEMS



52mm RockLock Overview

ROCKLOCK™ 52mm

52mm RockLock

Maximum efficiency
with 52mm

ROCKLOCK™
QUICK CHANGE SYSTEM



Reduce Setup and
Changeover Time



Simple Modular
Design

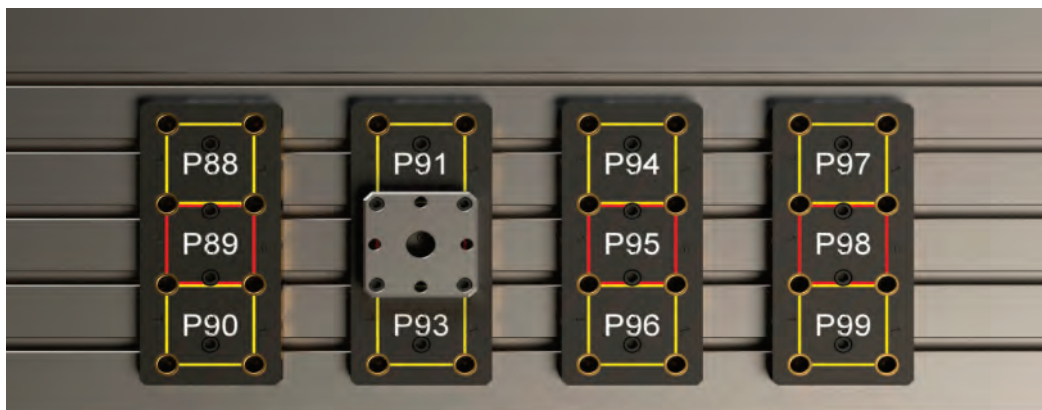


Solutions Available
for 3, 4, & 5 Axis
Machines



READY TO ROCK SETUP

Example shown for Haas VF-2/VF-3 [GI54 Work Coordinates]



1. Starting with an empty machine table, install 5th Axis 3613S plates for your specific table. Thread bolts into t-nuts, but do not torque bolts.
2. Space plates 3" (76.2mm) apart from each other. Use a mallet to initially align and straighten plates.
3. Install master pallet (RL96-MP) in center position (P89, P92, P95, P98) to indicate straight. Once aligned and indicated straight, torque mounting bolts to torque specifications.
4. For every position, install master pallet and set X and Y axes with touch probe or indicator for each work offset position.
5. Set Z zero on the top mounting surface of the RockLock 3613S base for all work offsets.
6. R2R system is ready to use.

Double Station Vises

Part Number	DV75150X-J1	DV75150X-J2	DV75150X-J3
			
Fixture Size	75mm x 150mm x 56mm	75mm x 150mm x 64mm	75mm x 150mm x 64mm
Jaw Width	75mm	75mm	75mm
Jaw Set	Hardened Steel 3 Piece Master Jaw Set Serrated Dovetail	6061 Aluminum Machinable Jaw Set	1018 Steel Machinable Jaw Set
Vise Type	Double Station	Double Station	Double Station
Compatible Pull Studs	4x PS16F (Sold separately)	4x PS16F (Sold separately)	4x PS16F (Sold separately)
Additional Vise Specs	See Page 47	See Page 47	See Page 47

Self-Centering Vises and Round Bar Fixture

Part Number	V75100X	V75150X	R52-CERX-32	R52-CERX-40
				
Size	75mm x 100mm x 56mm	75mm x 150mm x 56mm	75mm x 75mm x 68mm	75mm x 75mm x 68mm
Jaw Width	75mm	75mm	Utilizes Standard ER32 Collet Nut	Utilizes Standard ER40 Collet Nut
Fixture	V75100X	V75150X	CER32	CER40
Overall Clamping Range	0 - 76.3mm	0 - 128.8mm	Accepts Only ER32 Size Collet	Accepts Only ER40 Size Collet
Vise Type	Self-Centering	Self-Centering	Round Bar Fixture	Round Bar Fixture
Compatible Pull Studs	4x PS16F (Sold separately)	4x PS16F (Sold separately)	4x PS16F (Included)	4x PS16F (Included)
Additional Vise Specs	See Page 53	See Page 53	See Page 66	See Page 66

Metric Dovetail Fixtures

Part Number	R52-DM12	R52-2DM12	R52-P12DM12
			
Size	75mm x 75mm x 51mm	75mm x 75mm x 51mm	126mm x 126mm x 134mm
Fixture	DM12	2x DM12	12x DM12
Stock	12mm and Above	12mm and Above	12mm and Above
Compatible Pull Studs	4x PS16F (Included)	4x PS16F (Included)	4x PS16F (Included)
Additional Fixture Specs	See Page 61	See Page 61	See Page 64

Part Number	R52-DM25	R52-P4DM25	R52-DM50
			
Size	75mm x 75mm x 55mm	Ø152mm x 65mm	75mm x 75mm x 63mm
Fixture	DM25	4x DM25	DM50
Stock	25mm and Above	25mm and Above	50mm and Above
Compatible Pull Studs	4x PS16F (Included)	4x PS16F (Included)	4x PS16F (Included)
Additional Fixture Specs	See Page 61	See Page 64	See Page 61

To see the full product offering scan here:



Low Profile Adapters

Part Number	RL52A-4 RL52S-4	RL52A-4-96 RL52S-4-96	RL52A-4-TRT100
			
Size	Ø116mm x 25mm	Ø116mm x 25mm	Ø116mm x 25mm
Subcategory	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter
Materials	Aluminum (RL52A-4) or Steel (RL52S-4)	Aluminum (RL52A-4-96) or Steel (RL52S-4-96)	Aluminum (RL52A-4-TRT100)
Mounting	Drill Your Own M10 @ 50mm-100mm	2x M10 SHCS @ 96mm	HAAS TRT 100
Additional RockLock Specs	See Page 8	See Page 8	See Page 8

Low Profile Adapters and Integrated Tombstone

Part Number	RL52A-44 RL52S-44	RL52A-4560 RL52S-4560	RL52A-A96	RL52A-T31
				
Size	103.5mm x 103.5mm x 25mm	122.0mm x 102.1mm x 25mm	124.0mm x 124.0mm x 25mm	Ø160mm x 167mm
Subcategory	Low Profile Adapter	Low Profile Adapter	96mm to 52mm Adapter	52mm Integrated Tombstone 96mm Base
Materials	Aluminum (RL52A-44) or Steel (RL52S-44)	Aluminum (RL52A-4560) or Steel (RL52S-4560)	Aluminum (RL52A-A96)	Aluminum (RL52A-T31)
Mounting	2x SB1210 (Included) and 2x M12 or 1/2" @ Ø82mm 90°	4x M10 @ Ø116mm 60°	96mm Spacing and Includes 4x PS20F	96mm Spacing and Includes 4x PS20F
Additional RockLock Specs	See Page 9	See Page 9	See Page 9	See Page 9

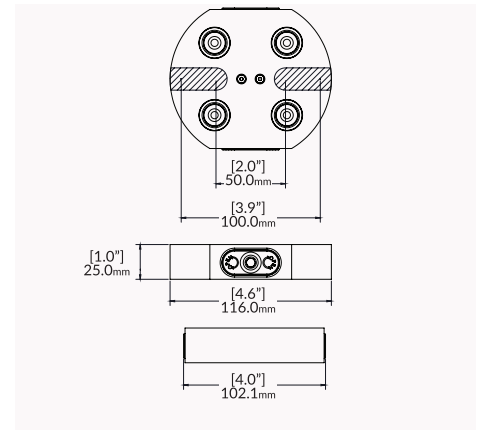
RL52A-4 / RL52S-4



Size: Ø116mm x 25mm
Bolt Pattern: Drill Your Own Custom M10 @ 50mm-100mm
Material Construction:
 Aluminum (RL52A-4)
 Steel (RL52S-4)

This circular RockLock adapter is built for small and medium sized rotaries and trunnions with 50mm to 100mm bolt circle.

Repeatability of +/- 8 µm.



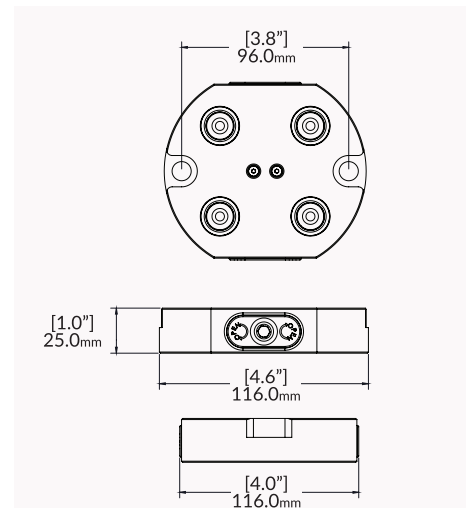
RL52A-4-96 / RL52S-4-96



Size: Ø116mm x 25mm
Bolt Pattern: 2x M10 SHCS @ 96mm
Material Construction:
 Aluminum (RL52A-4-96)
 Steel (RL52S-4-96)

This circular RockLock adapter is built for small and medium sized rotaries and trunnions with 96mm bolt circle.

Repeatability of +/- 8 µm.

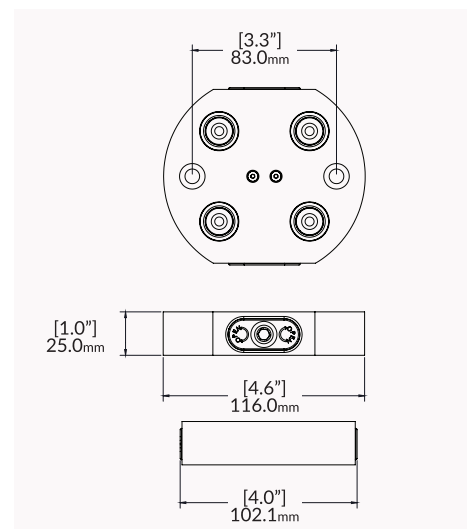


RL52A-4-TRT100

Size: Ø116mm x 25mm
Bolt Pattern: 2x 5/16" @ 82.98mm
Material Construction:
 Aluminum (RL52A-4-TRT100)

This circular RockLock adapter is built for the Haas TRT100 trunnion.

Repeatability of +/- 8 µm.

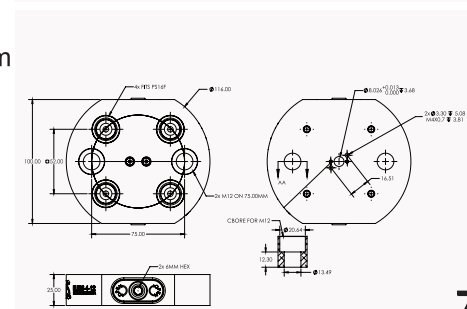


RL52A-4-12

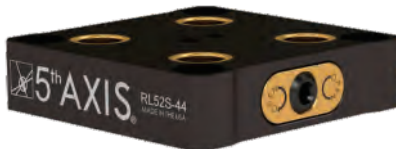


Size: 116mm x 100mm x 25mm
Bolt Pattern: 2x M12 at 180° on 75mm PCD
Material Construction:
 Aluminum (A)

This circular RockLock adapter is built for small and medium sized rotaries and trunnions with 75mm bolt circle.



RL52A-44 / RL52S-44

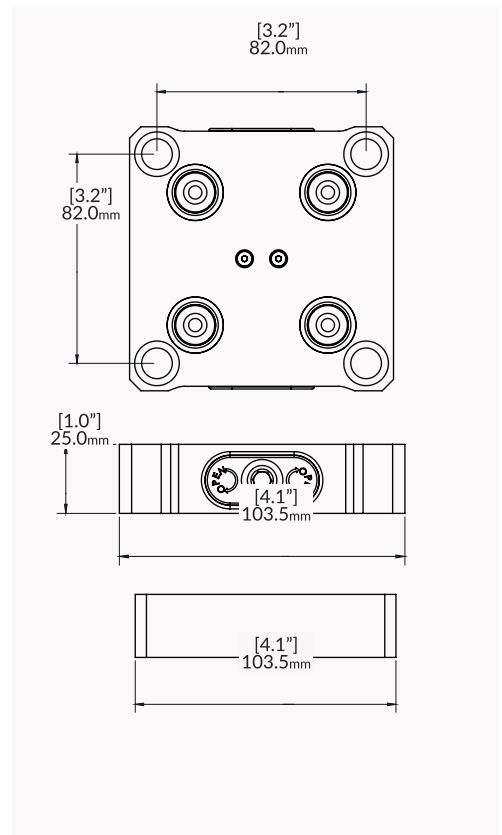


Size: 103.5mm x 103.5mm x 25mm
Spacing: 2x SB1210 (Included) and 2x M12 or 1/2" @ Ø82mm 90°.
 Through hole Ø12.02mm
Material Construction:
 Aluminum (RL52A-44)
 Steel (RL52S-44)

This square low profile adapter is built for custom tombstones.

Ships with 2x shoulder bolts (SB1210) for locating.

Repeatability of +/- 8 µm.



RL52A-4560 / RL52S-4560

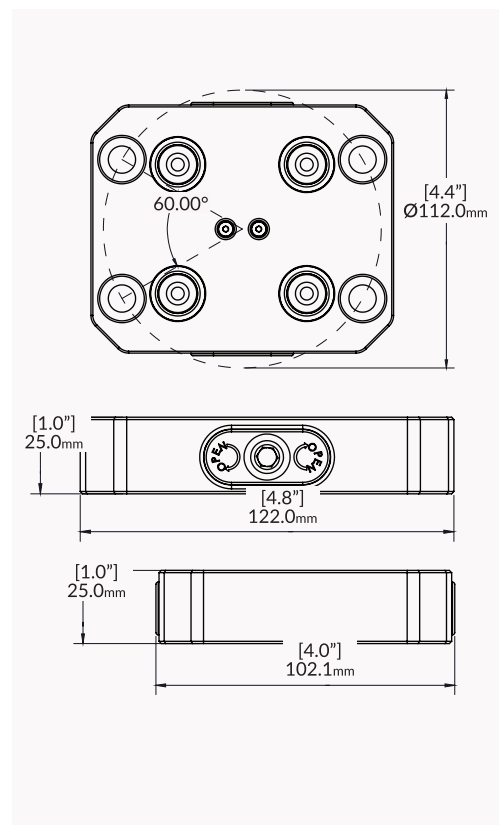


Size: 122.0mm x 102.1mm x 25.0mm
Spacing: 4x M10 @ Ø116mm
Material Construction:
 Aluminum (RL52A-4560)
 Steel (RL52S-4560)

This rectangular low profile adapter is built for small and medium sized rotaries with 60-degree T-slot spacing.

Ships with 2x rounded T-Slot nuts (14mm x M10) for maximum bolt circle capability.

Repeatability of +/- 8 µm.



RL52A-A96



Size: 124.0mm x 124.0mm x 25.0mm

Bolt Pattern: 96mm Spacing and Includes 4x PS20F

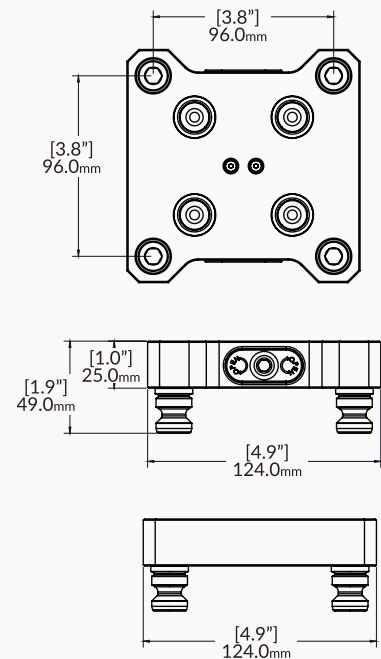
Material Construction: Aluminum (RL52A-A96)

The RL52A-A96 allows for the quick and easy conversion between the 96mm system and the 52mm system.

96mm spacing on the bottom of the unit and the integrated 52mm system on the top quickly adapts 52mm top tooling to the 96mm risers and adapters.

The unit includes 4x PS20F and 96mm RockLock pattern on the bottom for mounting to any RL96 base.

Repeatability of +/- 8 μ m.



RL52A-T31



Size: Ø160mm X 167.0mm

Spacing: Includes 4x PS20F

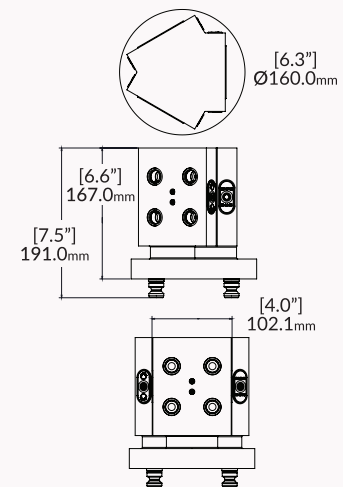
Material Construction: Aluminum (RL52A-T31)

This 3-sided integrated RockLock tombstone can be mounted onto any RL96 base.

52mm spacing on the 3 faces of the tombstone. 96mm spacing on the bottom of the tombstone.

4x PS20F are included.

Repeatability of +/- 8 μ m.



RL52A-P330

3-Sided Integrated RockLock Pyramid

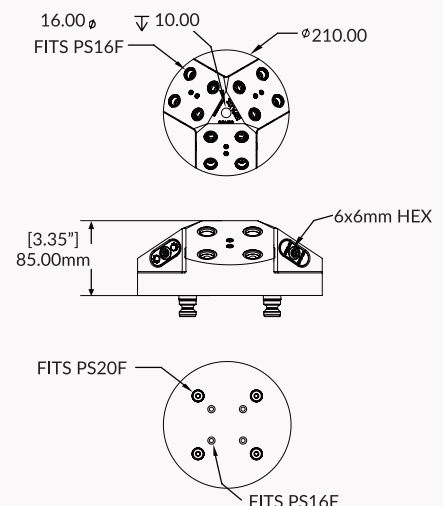


Size: Ø210.00mm x 85mm

Mounting Pattern: 96mm RockLock

Material Construction: Aluminum (A)

The RL52A-P300 is a 3-sided (52mm quick change) pyramid ideal for increasing throughput on multi-axis machines. This pyramid was designed and optimized to work with 5 axis universal machines as well as robotic pallet changers.





PS16F

PULL STUD

Size: 52mm Pull Studs

Material Construction: S7 Tool Steel

The PS16F is necessary to use any 5th Axis 52mm base. The 52mm spacing on 5th Axis vises and adapters allow for compatibility with other competitive systems.

**Please note that pull studs must stay with the corresponding company's base plate. If you are using a 5th Axis 52mm RockLock base plate you will need 5th Axis pull studs (PS16F). The spacing and thread allows the top tooling to be interchangeable between the competitive systems.*



PS16F-PY

SINGLE PULL STUD WITH POKA-YOKE INSERT

Size: 52mm Pull Studs

Material Construction: S7 Tool Steel

Poka-yoke is a Japanese term that means "mistake-proofing" or "inadvertent error prevention". The PS16F-PY is a single modified pull stud with an aluminum ring. The ring is placed inside one of the locating holes in the RockLock base, allowing for only the single poka-yoke pull stud to fit inside the locating hole with the corresponding ring. This will prevent operators from changing the orientation and misloading a part.



PS16F-4PY

PULL STUDS WITH POKA-YOKE INSERT

Size: 52mm Pull Studs

Material Construction: S7 Tool Steel

3x Standard PS16F Pull Studs and one Poka-Yoke (PS16F-PY).



R52-BLANK

Size: 52mm Pull Studs

Material Construction: 6061 Aluminum

Blank 6061 aluminum block with 4x PS16F pull studs included. Quickly build your own fixture / subplate with the R52-Blank.



R52-HTS

Size: 52mm Pull Studs

Material Construction: 6061 Aluminum

Quick change adapter for the Renishaw OTS Tool Setter. Accurately remove and relocate the tool probe when its not in use. The part number includes the adapter plate and 4x PS16F pull studs.

**Requires any 52mm RockLock base unit.*

***Tool setter sold separately.*



RL52-MP

52mm Master Pallet

Size: 52mm Pull Studs

Material Construction: 4140 Steel

Mount the RockLock base onto the machine, drop in the master pallet, dial in your setup, and torque your mounting bolts once you have reached the desired location. This is the fastest, most accurate way to set up the RockLock system. Use the bore to find center and the edge to set rotation.

See page 33 for more info.

Maximum efficiency
with 96mm

ROCKLOCK™ QUICK CHANGE SYSTEM



Reduce Setup and
Changeover Time



Simple Modular
Design



Solutions Available
for 3, 4, & 5 Axis
Machines

Vise



PS20F



Base



ROCKLOCK™ QUICK CHANGE SYSTEM

- Repeatability less than 8 μ m
- Industry standard 96mm pull stud spacing
- Steel or aluminum body construction



96mm Pull Stud Spacing



Robust Single Actuation Screw



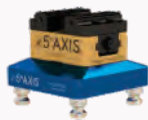
Steel Locating Features



Patented free float design ensures equal force on all 4 pull studs. Compatible with other 96mm 4 pull stud systems. Simply change out the pull studs to ensure that the manufacturer's base plate and pull studs match.

RockLock 96mm Compatible Self-Centering Vises

Part Number	V562X	V510X
		
Size	126mm x 152mm x 74mm	126mm x 254mm x 74mm
Compatible Pull Studs	4x PS20F (Sold separately)	4x PS20F (Sold separately)
Overall Clamping Range	0 - 153.6mm	0 - 254.8mm
Additional Vise Specs	See Page 53	See Page 53

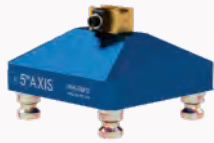
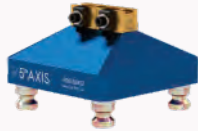
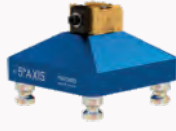
Part Number	R96-V75100X	R96-2V75100X	R96-V75150X	R96-2V75150X	R96-V75100T4	R96-V75XT4
						
Size	125mm x 126mm x 88mm	150mm x 177mm x 78mm	126mm x 150mm x 88mm	150mm x 177mm x 78mm	126mm x 126mm x 267mm	126mm x 126mm x 200mm
Vise	V75100X	2x V75100X	V75150X	2x V75150X	Compatible with V75100X (Vises Sold Separately)	Compatible with V75100X, V75150X, & DV75150X (Vises Sold Separately)
Vise Overall Clamping Range	0 - 76.3mm	N/A	0 - 128.8mm	N/A	N/A	N/A
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)
Vise Type	Self-Centering	Self-Centering	Self-Centering	Self-Centering	Self-Centering	Self-Centering or Double Station
Additional Vise Specs	See Page 53	See Page 53	See Page 53	See Page 47	See Page 33	See Page 33

RockLock 96mm Double Station Vises

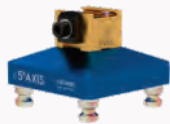
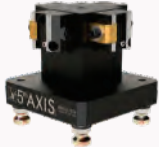
Part Number	R96-DV75150X-J1	R96-2DV75150X-J1	DV56-J1*	DV510-J1*	DV510-J4*
					
Size	126mm x 150mm x 88mm	150mm x 177mm x 78mm	126mm x 152mm x 73mm	126mm x 258mm x 73mm	126mm x 258mm x 73mm
Vise	DV75150X-J1	2x DV75150-J1	DV56-J1	DV510-J1	DV510-J4
Jaw Set	Hardened Steel 3 Piece Master Jaw Set	Hardened Steel 3 Piece Master Jaw Set	Hardened Steel 3 Piece Master Jaw Set	Hardened Steel 3 Piece Master Jaw Set with 2 inch center	Hardened Steel 3 Piece Master Jaw Set with 1 inch center
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Sold separately)	4x PS20F (Sold separately)	4x PS20F (Sold separately)
Vise Type	Double Station	Double Station	Fixed Jaw / Double Station	Fixed Jaw / Double Station	Fixed Jaw / Double Station
Additional Vise Specs	See Page 45	See Page 47	See Page 48	See Page 49	See Page 49

Part Number	R96-DV75150X-J2	R96-2DV75150X-J2	DV56-J2*	DV510-J2*	R96-DV75150X-J3	R96-2DV75150X-J3	DV56-J3*	DV510-J3*
								
Size	126mm x 151mm x 88mm	150mm x 177mm x 78mm	126mm x 152mm x 89mm	126mm x 258mm x 89mm	126mm x 151mm x 88mm	150mm x 177mm x 78mm	126mm x 152mm x 89mm	126mm x 258mm x 89mm
Vise	DV75150-J2	2x DV75150-J2	DV56-J2	DV510-J2	DV75150-J3	2x DV75150-J3	DV56-J3	DV510-J3
Jaw Set	6061 Aluminum Soft Jaw Set	6061 Aluminum Soft Jaw Set	6061 Aluminum Soft Jaw Set	6061 Aluminum Soft Jaw Set	1018 Steel Machinable Jaws	1018 Steel Machinable Jaws	1018 Steel Machinable Jaws	1018 Steel Machinable Jaws
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Sold separately)	4x PS20F (Sold separately)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Sold separately)	4x PS20F (Sold separately)
Vise Type	Double Station	Double Station	Double Station	Double Station	Double Station	Double Station	Double Station	Double Station
Additional Vise Specs	See Page 47	See Page 47	See Page 48	See Page 50	See Page 46	See Page 46	See Page 46	See Page 46

Dovetail Fixtures

Part Number	R96-DM12	R96-2DM12	R96-P12DM12	R96-DM25
				
Size	126mm x 126mm x 67mm	126mm x 126mm x 67mm	126mm x 126mm x 133mm	126mm x 126mm x 75mm
Fixture	DM12	2x DM12	12x DM12	DM25
Stock Size	12mm and Above	12mm and Above	12mm and Above	25mm and Above
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)
Additional Fixture Specs	See Page 64	See Page 64	See Page 64	See Page 61

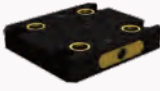
Dovetail Fixtures

Part Number	R96-P4DM25	R96-DM50	R96-D115T41	R96-CERX-40
				
Size	Ø152mm x 65mm	126mm x 126mm x 76mm	126mm x 126mm x 107mm	126mm x 126mm x 81mm
Fixture	4x DM25	DM50	4x D115 *Fixtures sold separate*	CER40
Stock Size	25mm and Above	50mm and Above	25mm and Above	Utilizes Standard ER40 Collet Nut
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)
Additional Fixture Specs	See Page 64	See Page 60	See Page 34	See Page 66

To see the full product offering scan here:



Low Profile Bases

Part Number	RL96A-56 RL96S-56	RL96A-6760 RL96S-6760	RL96A-6790 RL96S-6790	RL96A-67 RL96S-67	RL96S-67M	RL96A-60100 RL96S-60100	RL96A-66 RL96S-66
							
Size	158mm x 126mm x 30mm	174mm x 158mm x 30mm	156mm x 158mm x 30mm	158mm x 176mm x 30mm	158mm x 176mm x 30mm	158mm x 150mm x 30mm	158mm x 150mm x 30mm
Subcategory	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter
Materials	Aluminum (RL96A-56) or Steel (RL96S-56)	Aluminum (RL96A-6760) or Steel (RL96S-6760)	Aluminum (RL96A-6790) or Steel (RL96S-6790)	Aluminum (RL96A-67) or Steel (RL96S-67)	Steel (RL96S-67M)	Aluminum (RL96A-60100) or Steel (RL96S-60100)	Aluminum (RL96A-66) or Steel (RL96S-66)
Mounting	2x M12 SHCS @ 100mm - 101.6mm	4x M12 @ Ø170.0mm 60°	4x M10 @ Ø184.5mm 90°	4x 1/2" SB @ 6.0" x 4.0"	4x M12 SB @ 150mm x 100mm	4x M10 @ Ø100mm 90°	Drill your own mounting holes
Additional RockLock Specs	See Page 20	See Page 20	See Page 21	See Page 21	See Page 21	See Page 22	See Page 22

Risers

Part Number	RL96A-38	RL96A-411	RL96A-3915	RL96A-4816
				
Size	Ø 201.9mm x 75.0mm	Ø 276mm x 100mm	381mm x 230mm x 80mm	400mm x 200mm x 100mm
Subcategory	Single Position Riser	Single Position Riser	Multi-Position Riser	Multi-Position Riser
Materials	Aluminum (RL96A-38)	Aluminum (RL96A-411)	Aluminum (RL96A-3915)	Aluminum (RL96A-4816)
Mounting	4x M12 bolts @ 90° on Ø 178.0mm or 3x M12 bolts @ 120° on Ø 178.0mm	4x M12 bolts @ 90° on Ø 9.92"	4x M16 bolts @ 200mm square	4x M12 @ 320mm x 160mm rectangle (80mm T-slots) or 4x M16 @ 360mm x 126mm rectangle (63mm T-slots)
Additional RockLock Specs	See Page 23	See Page 23	See Page 24	See Page 24

Multi-Position Plates

Part Number	RL96A-3613S1	RL96A-3613S2	RL96A-3613S3
			
Size	158mm x 338mm x 30mm	158mm x 338mm x 30mm	158mm x 338mm x 30mm
Subcategory	Multi-Position Horizontal Plate	Multi-Position Horizontal Plate	Multi-Position Horizontal Plate
Materials	Aluminum (RL96A-3613S1)	Aluminum (RL96A-3613S2)	Aluminum (RL96A-3613S3)
Mounting	2x M12 SHCS @ 96mm or 250mm	4x M12 SHCS Equally Spaced @ 80mm	4x M12 SHCS Equally Spaced @ 100mm
Additional RockLock Specs	See Page 25	See Page 25	See Page 25

Tombstones, Right Angle Plate, and Single Position Riser

Part Number	RL96A-4004U	RL96A-3002 RL96S-3002	RL96A-3003 RL96S-3003	RL96A-90DEG	RL96A-356* RL96S-356*
					
Size	230mm x 230mm x 600mm	300mm x 300mm x 400mm	300mm x 300mm x 400mm	149.4mm x 158mm x 200mm	158mm x 126mm x 75mm
Subcategory	96mm Integrated Tombstone	96mm Integrated Tombstone	96mm Integrated Tombstone	Right Angle Plate	Single Position Riser
Materials	Aluminum	Aluminum (RL96A-3002) or 1018 Steel (RL96S-3002)	Aluminum (RL96A-3003) or 1018 Steel (RL96S-3003)	Aluminum (RL96A-90DEG)	Aluminum (RL96A-356) or Steel (RL96S-356)
Mounting	80mm Grid 100mm Grid	Machine Specific*	Machine Specific*	4x PS20F (Included) or 2x M12 SHCS @ 100mm - 101.6mm (4")	4x PS20F (Included)
Additional RockLock Specs	See Page 31	See Page 29	See Page 29	See Page 30	See Page 30

*Submit table drawing upon inquiry.

RL96A-56 / RL96S-56



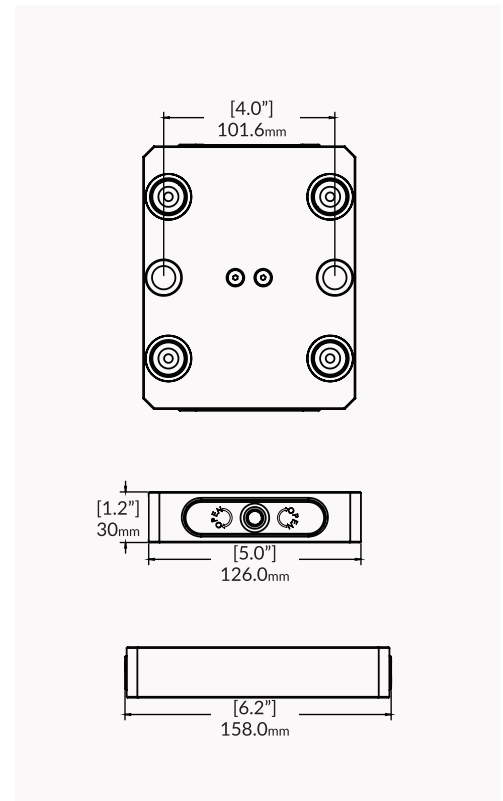
Size: 158mm x 126mm x 30mm

Spacing: 2x M12 SHCS @ 100mm - 101.6mm

Material Construction:
Aluminum (RL96A-56)
Steel (RL96S-56)

The adapter has two enlarged counterbores to allow mounting from 100mm to 101.6mm for M12 or 1/2-13 SHCS for simple mounting to T-slots.

Repeatability of +/- 8 μ m.



RL96A-6760 / RL96S-6760



Size: 174mm x 158mm x 30mm

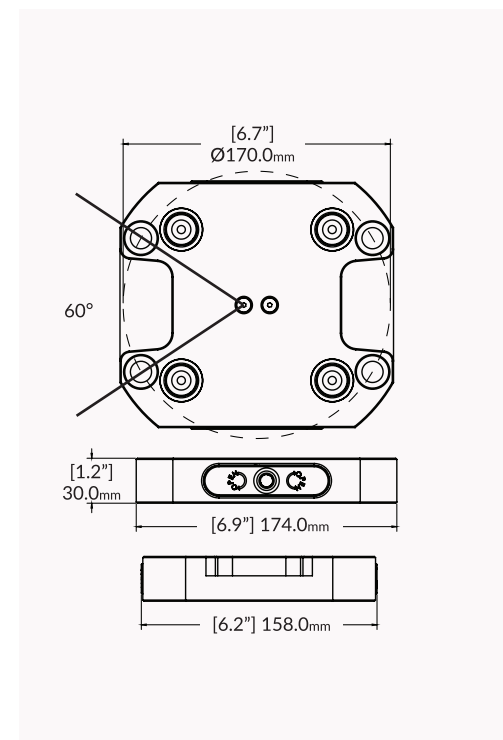
Spacing: 4x M12 @ Ø170.0mm on 60°

Material Construction:
Aluminum (RL96A-6760)
Steel (RL96S-6760)

The RL96-6760 series quick change adapter was built for the Haas TR-210 series rotaries, Hurco VMX30 series rotaries, and any other rotary with 60 degree radial T-slots.

A quick turn of the wrench actuates the cam mechanism to lock and release your fixtures and vises for fast changeover.

Repeatability of +/- 8 μ m.



RL96A-6790 / RL96S-6790

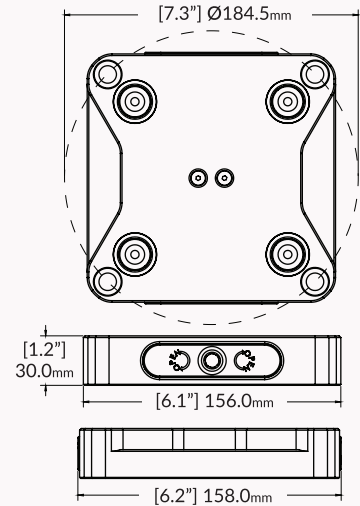


Size: 156mm x 158mm x 30mm
Spacing: 4x M10 @ Ø184.5mm
Material Construction:
 Aluminum (RL96A-6790)
 Steel (RL96S-6790)

The RL96-6790 quick change adapter was built for any rotary with 90 degree radial T-slots.

A quick turn of the wrench actuates the cam mechanism to lock and release your fixtures and vises for fast changeover.

Repeatability of +/- 8 µm.



RL96A-67 / RL96S-67

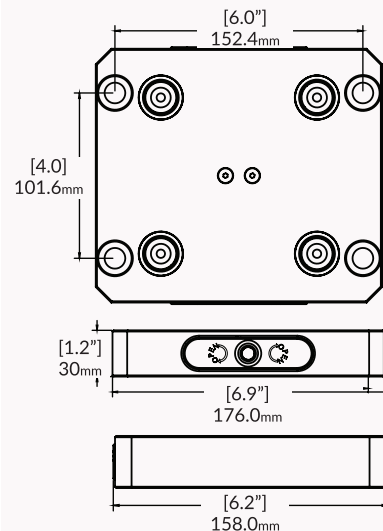


Size: 158.0mm x 176.0mm x 30mm
Spacing: 4x 1/2" SB @ 6.0" x 4.0". Through hole Ø0.501"
Material Construction:
 Aluminum (RL96A-67)
 Steel (RL96S-67)

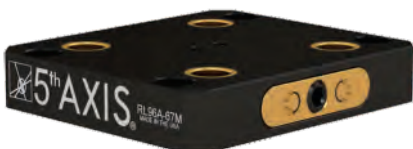
The RL96-67 was built specifically for horizontal machining centers.

Bolt pattern 6.0" x 4.0" allows for easy mounting to most standard tombstone grid pattern spacing.

Repeatability of +/- 8 µm.



RL96S-67M

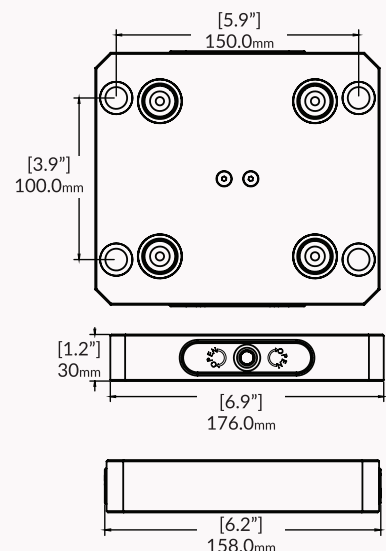


Size: 158.0mm x 176.0mm x 30mm
Spacing: 4x M12 @ 150.0mm x 100.0mm. Through hole Ø12.02mm
Material Construction:
 Steel (RL96S-67)

The RL96-67M was built specifically for tombstones on horizontal machining centers.

Bolt pattern 150mm x 100mm allows for easy mounting to most standard tombstone grid pattern spacing.

Repeatability of +/- 8 µm.



RL96A-60100 / RL96S-60100



Size: 158mm x 150mm x 30mm

Spacing: 4x 100mm

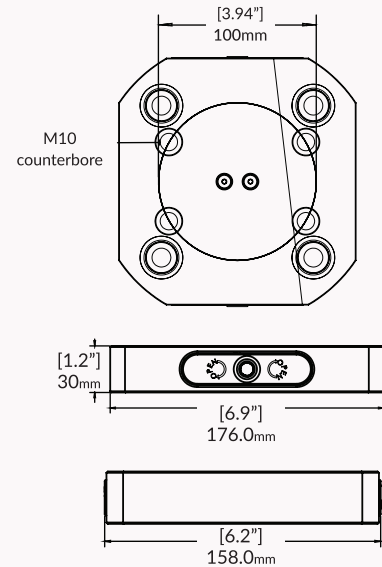
Material Construction:

Aluminum (RL96A-60100)

Steel (RL96S-60100)

The RL96-60100 series quick change adapter was built with 4x counterbores with 100mm spacing. Fitments include the new Haas TRT160 and many others.

Repeatability of +/- 8 μ m.



RL96A-66/ RL96S-66



Size: 158mm x 150mm x 30mm

Spacing: Drill your own

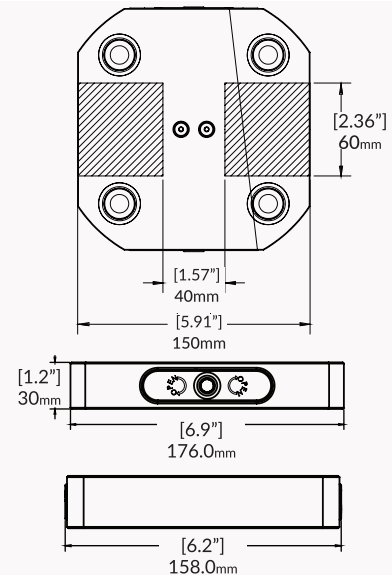
Material Construction:

Aluminum (RL96A-66)

Steel (RL96S-66)

The RL96-66 series quick change adapter was built to accommodate a variety of machines that are not part of our standard offering. The blank adapter allows for drilling your own mounting holes.

Repeatability of +/- 8 μ m.



RL96A-DDR / RL96S-DDR



Size: 150mm x 158mm x 34.5mm

Spacing: Specific to DDR

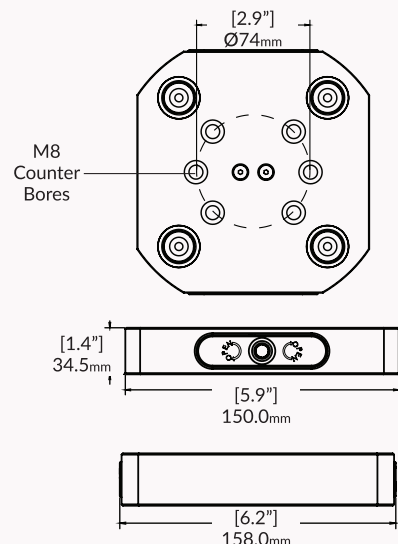
Material Construction:

Aluminum (RL96A-DDR)

Steel (RL96S-DDR)

The RL96-DDR was built for the Fanuc DDR rotary table.

Repeatability of +/- 8 μ m.



RL96A-38



Size: Ø 201.9mm x 75.0mm

Spacing:

4x M12 bolts @ 90° on Ø 78mm

or

3x M12 bolts @ 120° on Ø 178mm

Material Construction:

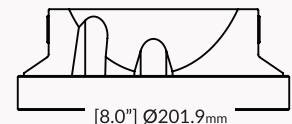
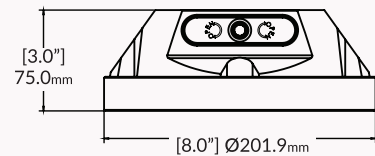
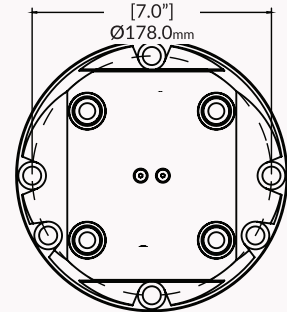
Aluminum (RL96A-38)

The RL96A-38 series quick change adapter was built for medium sized rotaries and smaller 5 axis machines (~300mm range).

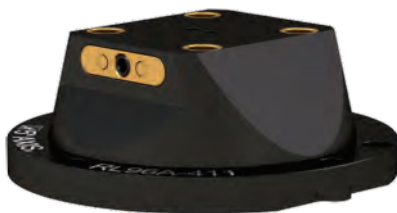
With bolt patterns at 60 degrees and 90 degrees this adapter is flexible and fits on a majority of the most popular rotaries and 5 axis tables on the market.

The 3" overall height makes it ideal for smaller parts that you want to raise above the table.

Repeatability of +/- 8 µm.



RL96A-411



Size: Ø 276mm x 100mm

Spacing:

4x 1/2-13 or M12 bolts @ 90° on Ø 252.0mm or

3x 1/2-13 or M12 bolts @ 120° on Ø 252mm

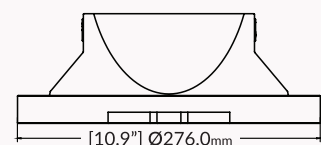
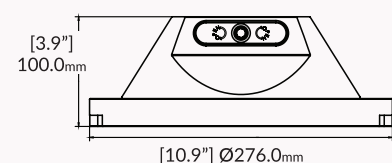
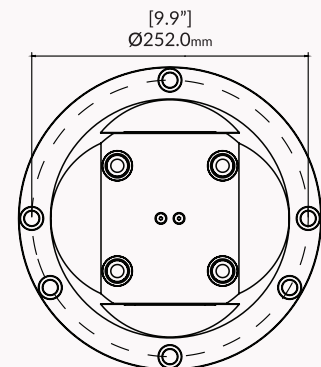
Material Construction:

Aluminum (RL96A-411)

The RL96A-411 is an integrated RockLock riser built into one of our most popular adapters.

The 11" diameter adapter x 4" overall height is ideal for medium to large 5 axis machines like the DMG Mori DMU50 and DMU60 as well as the Haas UMC-750 and UMC-750SS.

Repeatability of +/- 8 µm.



RL96A-3915



Size: 381mm x 230mm x 80mm

Spacing:

4x M16 bolts @ 200mm square

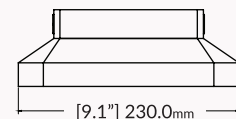
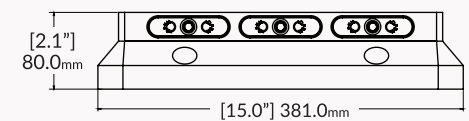
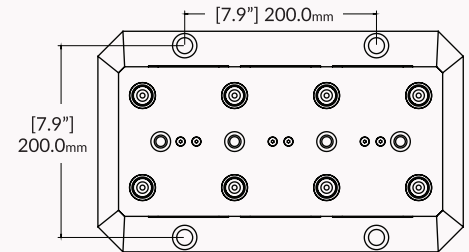
Material Construction:

Aluminum (RL96A-3915)

The RL96A-3915 was built with larger machines in mind (400mm-500mm tables).

Utilize one singular large vise or accommodate two smaller workholding units to maximize machine efficiency and reduce changeover time.

Repeatability of +/- 8 μ m.



RL96A-4816



Size: 400mm x 200mm x 100mm

Spacing:

4x M12 @ 320mm x 160mm

rectangle (80mm T-slots) or

4x M16 @ 360mm x 126mm

rectangle (63mm T-slots)

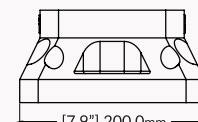
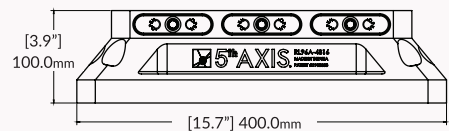
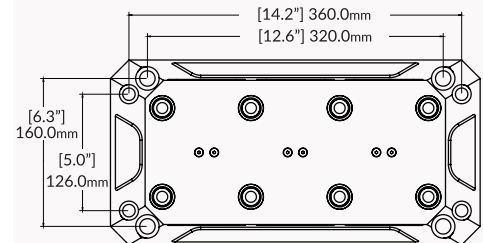
Material Construction:

Aluminum (RL96A-4816)

The RL96A-4816 is an integrated multi-position RockLock riser built into one of the largest adapters in the product line.

Utilize one large vise or accommodate two smaller vises with this riser.

Repeatability of +/- 8 μ m.

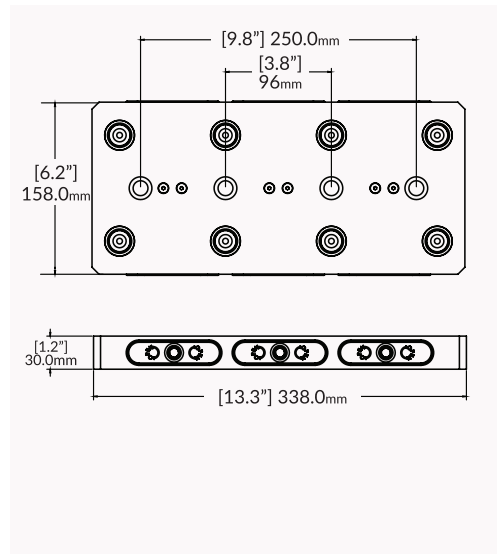


RL96A-3613S1

Size: 158mm x 338mm x 30mm
Spacing: 2x M12 SHCS @ 96mm or 250mm
Material Construction:
 Aluminum (RL96A-3613S1)



The RL96A-3613S1 is a multi-position RockLock plate built for maximum efficiency on small to medium vertical mills. The nested RockLock 96mm pattern allows for the operator to utilize one single large vise or two smaller vises. 125mm T-slot spacing for 3 axis mills. Repeatability of +/- 8 μ m.

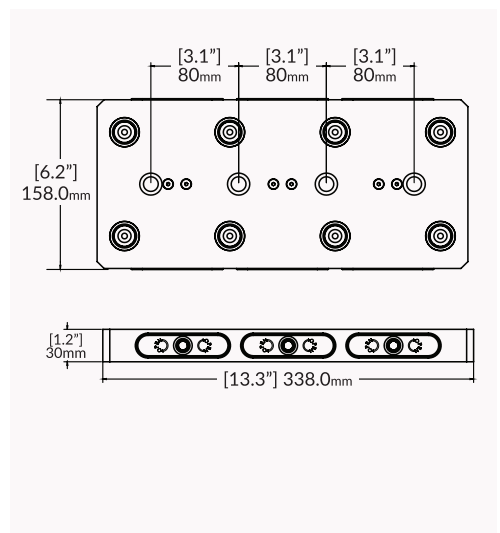


RL96A-3613S2

Size: 158mm x 338mm x 30mm
Spacing: 4x M12 SHCS Equally Spaced @ 80mm
Material Construction:
 Aluminum (RL96A-3613S2)



The RL96A-3613S2 is a multi-position RockLock plate built for maximum efficiency on small to medium vertical mills. The nested RockLock 96mm pattern allows for the operator to utilize one single large vise or two smaller vises. 80mm T-slot spacing for 3 axis mills. Repeatability of +/- 8 μ m.

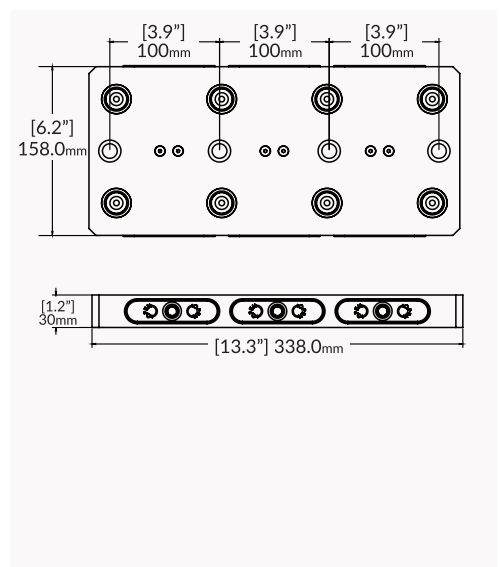


RL96A-3613S3

Size: 158mm x 338mm x 30mm
Spacing: 4x M12 SHCS Equally Spaced @ 100mm
Material Construction:
 Aluminum (RL96A-3613S3)



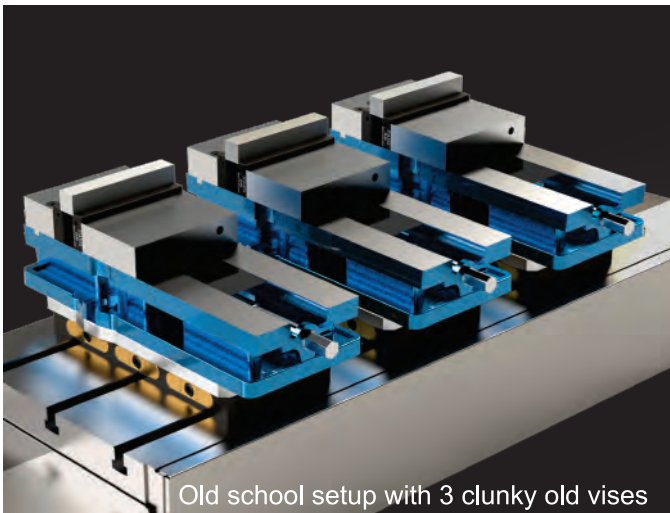
The RL96A-3613S3 is a multi-position RockLock plate built for maximum efficiency on small to medium vertical mills. The nested RockLock 96mm pattern allows for the operator to utilize one single large vise or two smaller vises. 100mm T-slot spacing for 3 axis mills. Repeatability of +/- 8 μ m.



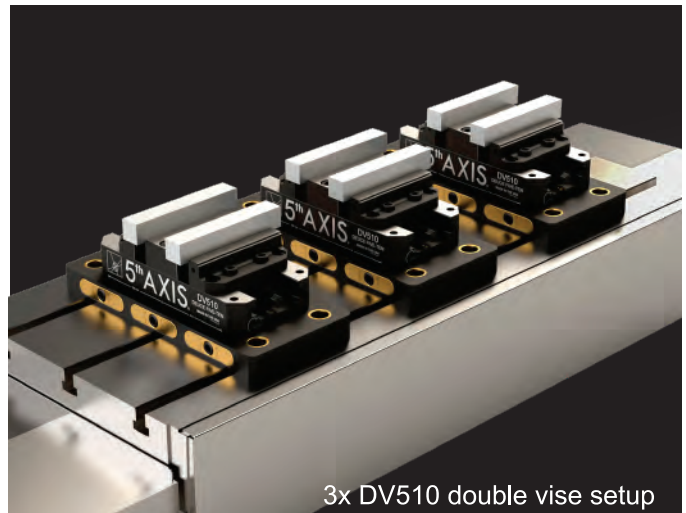
More Parts Per Cycle = More Profit

Profitability Through Efficiency

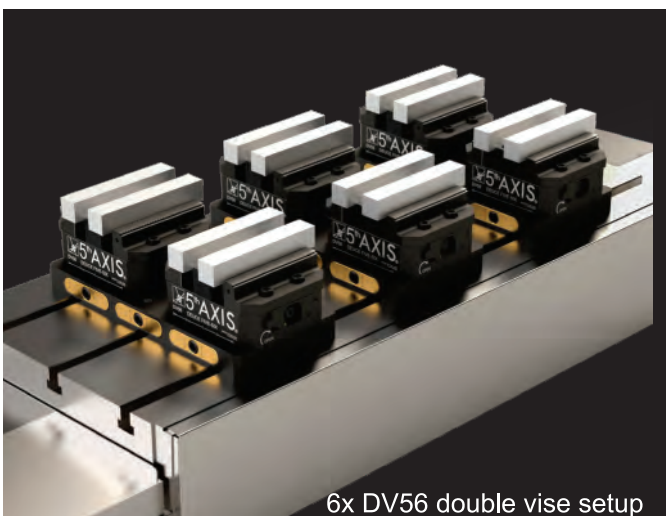
3 Parts Per Cycle



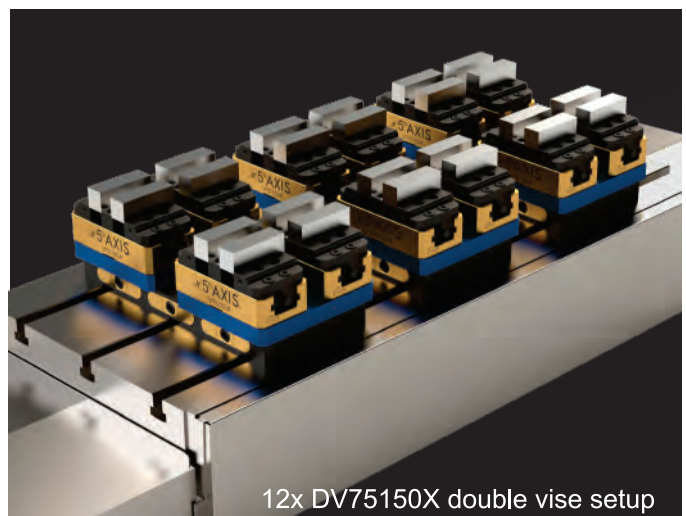
6 Parts Per Cycle



12 Parts Per Cycle



24 Parts Per Cycle



Multi-Position Horizontal Plates

ROCKLOCK™ 96mm

96mm RockLock

RL96S-68 / RL96A-68

96mm Low Profile Base



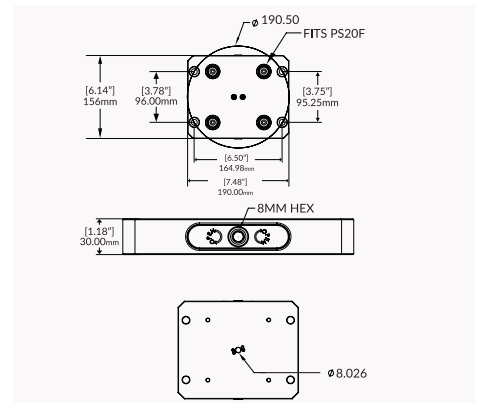
Size: 190mm x 156mm x 30mm

Material Construction:

Steel (RL96S-68)

Aluminum (RL96A-68)

The RL96-68 is a 6" x 8" low profile 96mm quick change adapter plate. Designed for the new Haas TRT-210 rotary.



RL96A-2710 96mm Riser

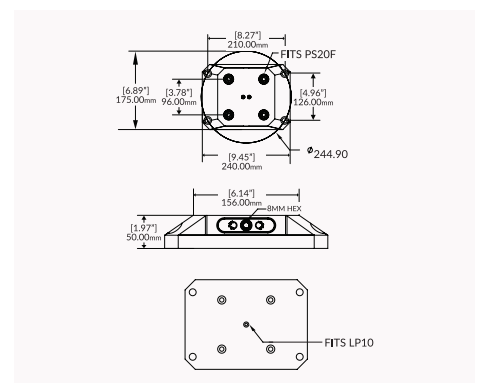


Size: 175mm x 240mm x 50mm

Mounting: 4x M12 on 126mm x 210mm grid

Material Construction: Aluminum (A)

The RL96A-2710 is a single position riser built for the new Haas UMC500. The RL96A-2710 integrates with the RockLock system for maximum changeout efficiency.



RL96S-6695 96mm Low



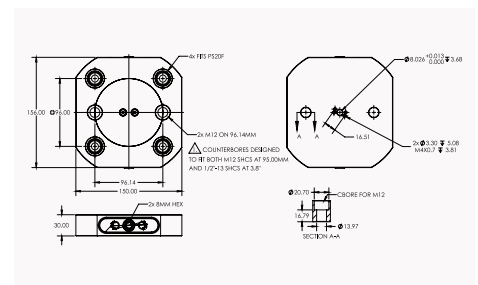
Size: 156mm x 150mm x 30mm

Mounting: 2x M12 at 180° on 96.14mm PCD

Material: Steel (S)

Weight: 9 lbs.

The RL96-66 series quick change adapter was built specifically for the MAM pallet on the Matsuura MAM-72 series machines.



RL96A-6695

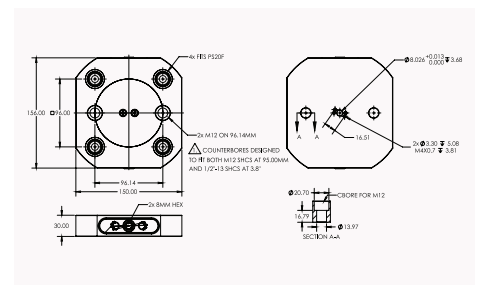


Size: 156mm x 150mm x 30mm

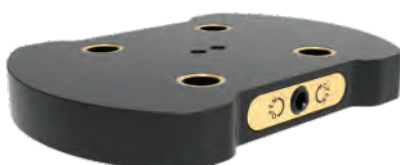
Mounting: 2x M12 at 180° on 96.14mm PCD

Material: Aluminum (A)

The RL96-66 series quick change adapter was built specifically for the MAM pallet on the Matsuura MAM-72 series machines.



RL96A-10 96mm Low Profile



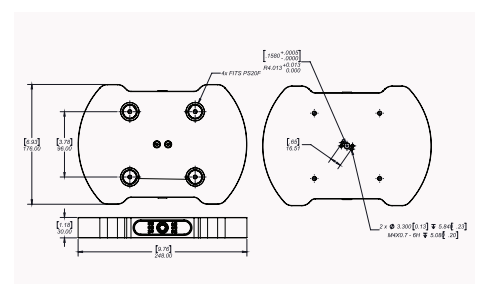
Size: Ø248mm x 30mm

Mounting: DIY Ø248mm

Material: Aluminum (A)

Weight: 6 lbs.

The RL96-66 series quick change adapter was built as a DIY mounting base for medium to large rotary tables.



RL96A-2715

96mm Riser



Size: 175mm x 240mm x 50mm

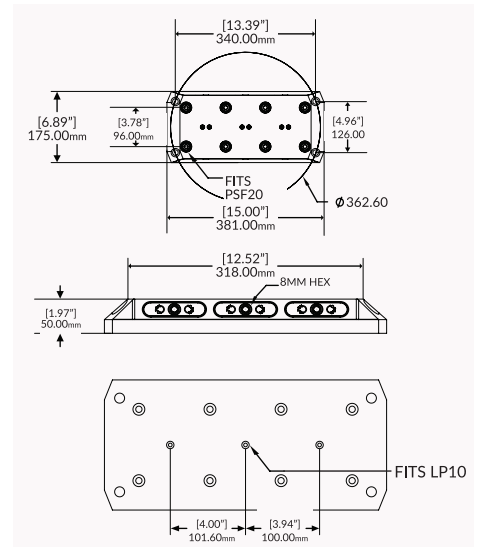
Mounting:

4x M12 on 126mm x 210mm grid

Material Construction: Aluminum (A)

The RL96A-2715 is a multi-position riser built for the new Haas UMC-500.

The RL96A-2715 provides maximum changeout efficiency with the RockLock system.



RL96A-488

Riser Adapter



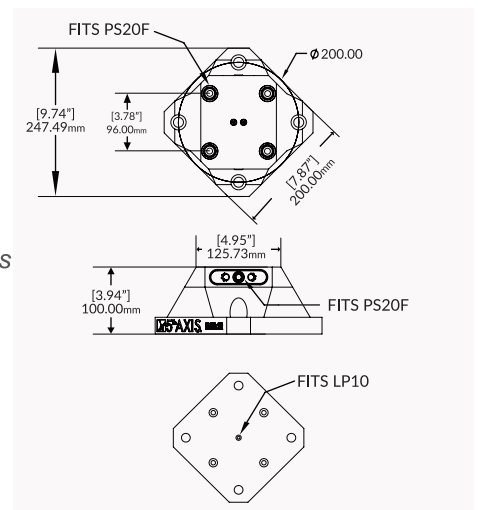
Size: 200mm x 200mm x 100mm

Mounting:

4x M12 @ 90° on 200mm PCD

Material Construction: Aluminum (A)

The RL96A-488 riser adapter provides multiple mounting options to meet various application needs and functions with the RockLock system to reduce setup time.



RL96A-T31

3-Sided Integrated RockLock Tombstone

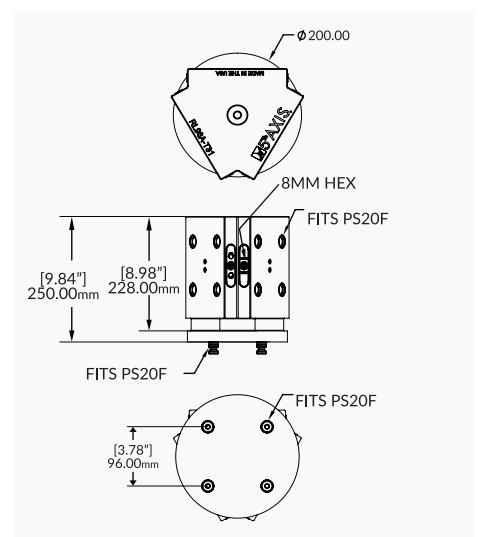


Size: Ø200mm x 250mm

Mounting: 96mm, includes pull studs

Material Construction: Aluminum (A)

Ideal for automated systems, the RL96A-T31 tombstone provides three mounting sides for part manufacturing. The RL96A-T31 can be mounted onto any 96mm RockLock base.

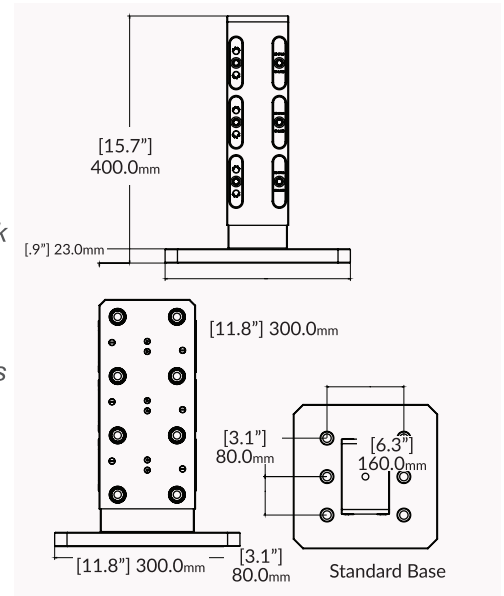


RL96A-3002 / RL96S-3002



Size: 300mm x 300mm x 400mm
Spacing: Custom
Material Construction:
 Aluminum (RL96A-3002)
 Steel (RL96S-3002)

This two sided 300mm tombstone integrates the RockLock 96mm quick change system. This tombstone is perfect for mid-sized 5 axis machines. It is also a perfect fit for 300mm horizontal machining centers offered by Kitamura and Kitagawa. All units feature hardened steel internals and locating features. All tombstones are built to order, and the base plate is customized to your machine table or pallet specs. Repeatability of +/- 8 µm.

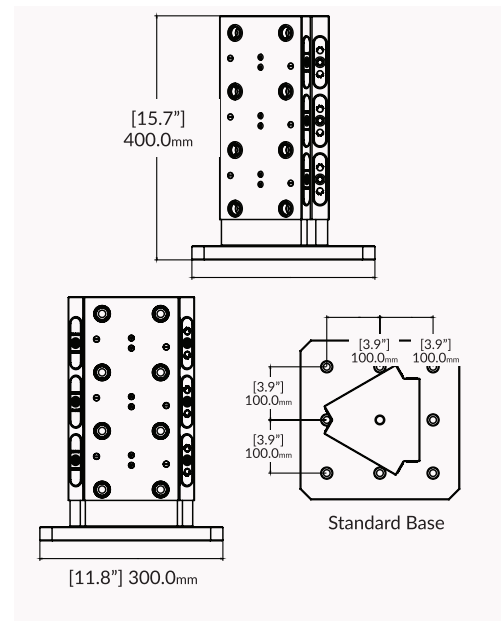


RL96A-3003 / RL96S-3003



Size: 300mm x 300mm x 400mm
Spacing: Custom
Material Construction:
 Aluminum (RL96A-3003)
 Steel (RL96S-3003)

This three sided 300mm tombstone integrates the RockLock 96mm quick change system. This tombstone is perfect for mid sized 5 axis machines. It is also a perfect fit for 300mm horizontal machining centers. All units feature hardened steel internals and locating features. All tombstones are built to order, and the base plate is customized to your machine table or pallet specs. Repeatability of +/- 8 µm.



RL96A-90DEG



Size: 149.4mm x 158mm x 200mm

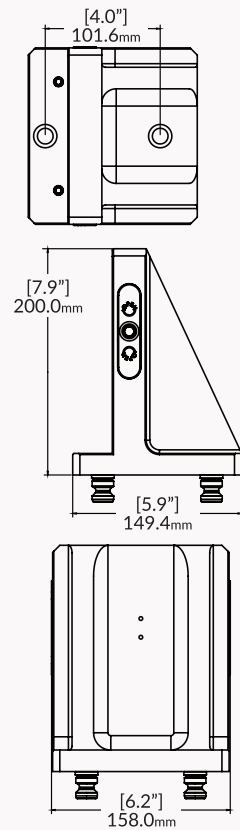
Spacing: RockLock PS20F or
2x M12 SHCS @
100mm - 101.6mm

Material Construction:
Aluminum (RL96A-90DEG)

The 90° right angle RockLock plate is the perfect low cost solution for multi-side machining. Machine 5 sides of a part without a 5 axis machine. The unit features pull studs on the bottom so that it can be mounted onto any 96mm RockLock plate. It also has 2 counter bores for traditional mounting to machine T-slots at 4" or 100mm.

Simply machine your material, unlock the system, rotate the material, lock the system and continue machining.

Includes 4x PS20F.
Repeatability of +/- 8 µm..



RL96A-356 / RL96S-356



Size: 158mm x 126mm x 75mm

Spacing: RockLock PS20F 96mm

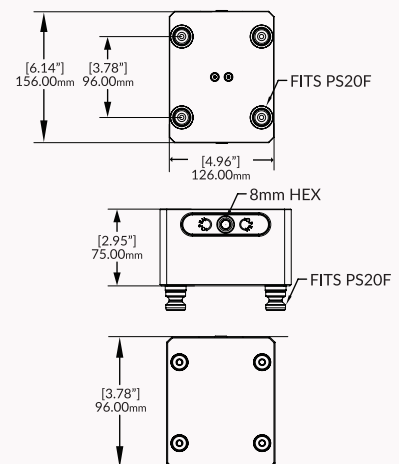
Material Construction:
Aluminum (RL96A-356)
Steel (RL96S-356)

Built to give extra rise from any RockLock bases.

The small profile was created to reduce any interference.

Includes 4x PS20F.

Repeatability of +/- 8 µm.



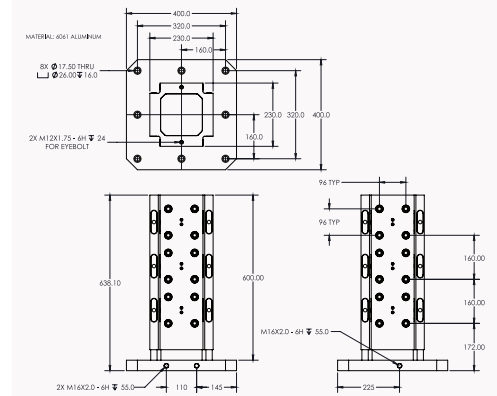
RL96A-4004U

400mm Four-Sided RockLock™ Tombstone, Aluminum



Size: 230mm x 230mm x 600mm
Material Construction: Aluminum
Mounting: 80mm grid
of Positions: 12 total, 3 per side
Weight: 175lb
Weight w/ Freight: 218lb

This lightweight four sided 400mm tombstone integrates the RockLock 96mm quick change system. This tombstone is perfect for pallet exchange systems with low weight restrictions.



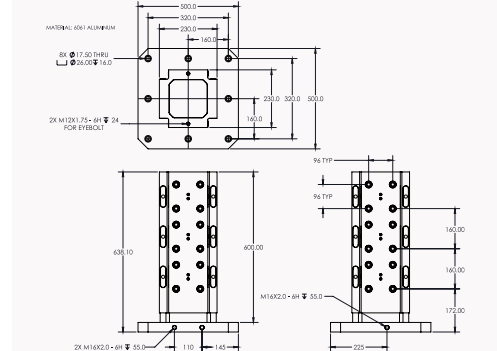
RL96A-5004U

500mm Four-Sided RockLock™ Tombstone w/500mm Base, Aluminum



Size: 230mm x 230mm x 600mm
Base: 500mm
Material Construction: Aluminum
Mounting: 100mm grid
of Positions: 12 total, 3 per side
Weight: 195lb
Weight w/ Freight: 200lb

This lightweight four-sided 500mm tombstone features the integrated RockLock 96mm quick change system. This tombstone is perfect for pallet exchange systems with low weight restrictions. All units feature hardened steel internals and locating features. This tombstone has a baseplate with 80mm /100mm grid spacing.



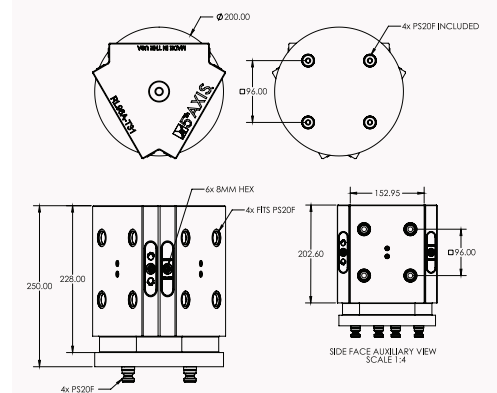
RL96A-T31

3-Sided Integrated RockLock™ Tombstone (96mm)



Size: Ø 200mm x 250mm
Material Construction: Aluminum
Mounting: 96mm RockLock™, includes 4x PS20F pull studs
of Positions: 3 total, 1 per side
Weight: 37lbs

Constructed with aerospace-grade aluminum, the RockLock base embodies the perfect blend of versatility and robust durability. Its industry standard 96mm pull stud spacing ensures a seamless fit into your machining setup, reducing unnecessary bulk while maximizing workspace efficiency.



MT-4004A

400mm Four-Sided Machinable Tombstone, Aluminum



Size: 230mm x 230mm x 600mm

Base: 400mm x 400mm

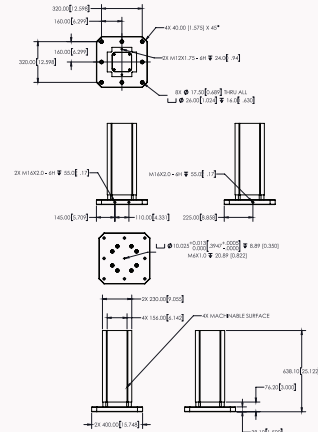
Material Construction: Aluminum

Mounting: Machinable

Weight: 155lb

Weight w/ Freight: 218lb

We set out to create the worlds most robust and competitively priced 400mm machinable aluminum tombstone.



MT-5004A

500mm Four-Sided Machinable Tombstone, Aluminum



Size: 230mm x 230mm x 600mm

Base: 500mm x 500mm

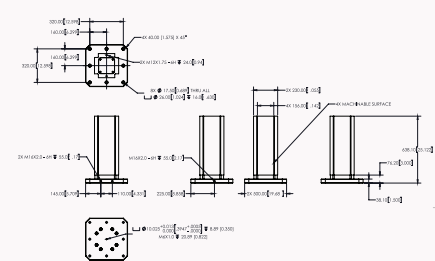
Material Construction: Aluminum

Mounting: Machinable

Weight: 175lb

Weight w/ Freight: 285lb

The MT-4004A is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs.



RL96S-4004

400mm Four-Sided RockLock™ Tombstone, 96mm Cast Iron



Size: 230mm x 230mm x 600mm

Material Construction: Cast Iron

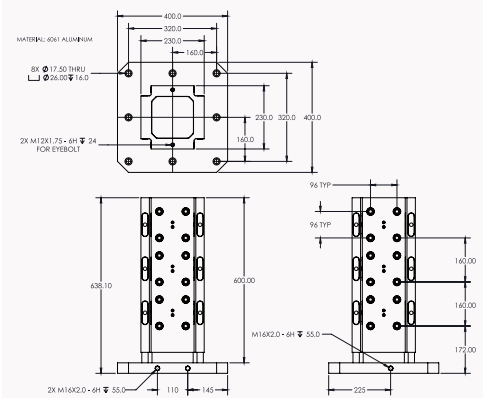
Mounting: 80mm grid/ 100mm grid

of Positions: 12 total, 3 per side

Weight: 400lb

Weight w/ Freight: 510lb

Enhance your machining efficiency with our robust four-sided 400mm CNC tombstone.



RL52S-4004

400mm Four-Sided RockLock™ Tombstone, 52mm Cast Iron



Size: 230mm x 230mm x 600mm

Material Construction: Cast Iron

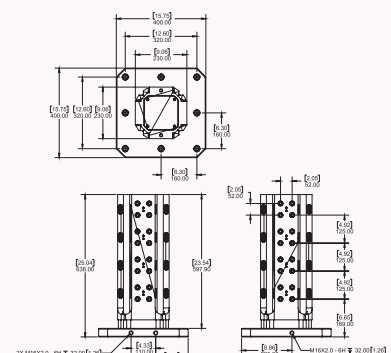
Mounting: 80mm grid/ 100mm grid

of Positions: 12 total, 3 per side

Weight: 400lb

Weight w/ Freight: 510lb

Enhance your machining efficiency with our robust four-sided 400mm CNC tombstone.



R96-V75100T4



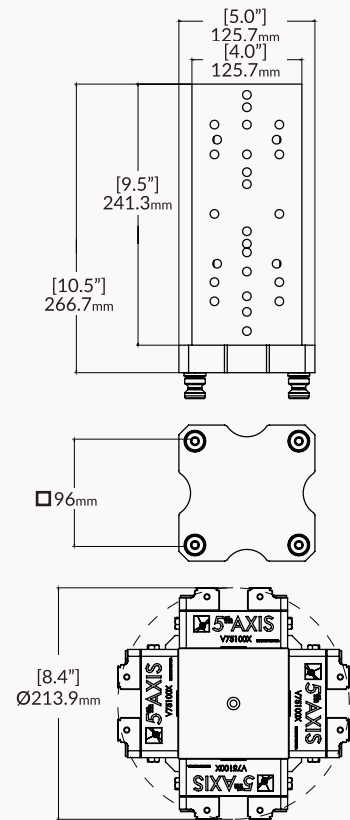
*Vises sold separately

Size: 125.7mm x 125.7mm x 266.7mm

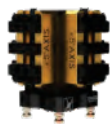
Mounting: RockLock PS20F

Material Construction:
Aluminum (RL96A-V75100T4)

The R96-V75100T4 is an ultra compact mini tombstone designed to work with smaller 4 and 5 Axis machines. The goal was to create a 4 sided tombstone to increase productivity while maintaining a compact footprint. The tombstone is built for the V75100X self-centering vise (see page 45). The nested bolt pattern allows for the vises to be mounted vertically or rotated horizontally. The entire tombstone will quick change onto any 96mm RockLock base plates. With a maximum of 12 vises on the tombstone, the machine can run unattended. This minimizes tool changes and frees operators up to run multiple machines. Includes 4x PS20F. Repeatability of +/- 8 µm.



R96-V75XT4



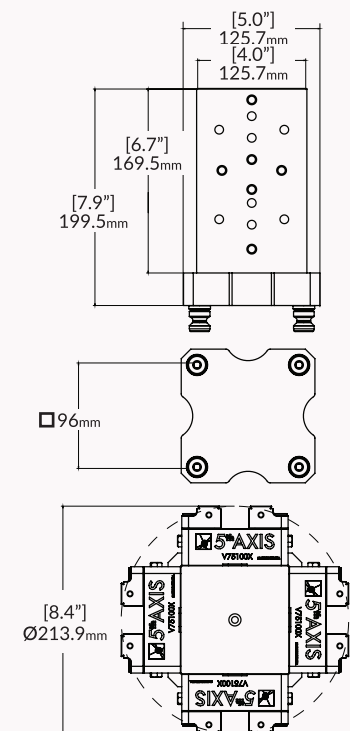
*Vises sold separately

Size: 125.7mm x 125.7mm x 200mm

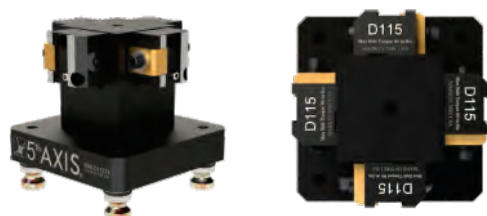
Mounting: RockLock PS20F

Material Construction:
Aluminum (RL96A-V75XT4)

The R96-V75XT4 is a mini tombstone designed to work with smaller 4 and 5 Axis machines. The goal was to create a 4 sided tombstone to increase productivity while maintaining a compact footprint. This tombstone can accommodate the following self-centering vises: V75100X and V75150X (see page 45). It will also fit the DV75150X double station vise (see page 39). The entire tombstone will quick change on any 96mm RockLock base plates. With a maximum of 8 vises on the tombstone, the machine can run unattended. This minimizes tool changes and frees operators up to run multiple machines. Includes 4x PS20F. Repeatability of +/- 8 µm.

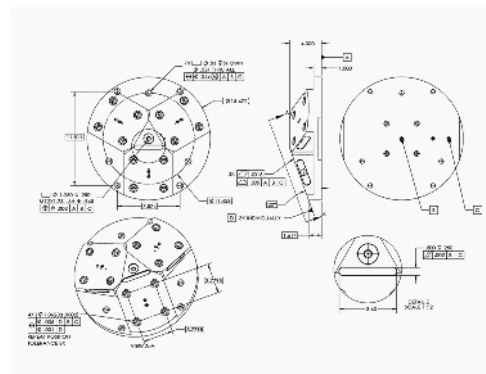


*Built for small or medium rotaries.
Able to utilize quantity 4 D115
dovetail fixtures in order to
maximize part density allowing
minimal interference. Quantity 4
PS20F Pull studs are included.*

[illegible]

RL96A-P320

Weight: 47 lbs





PS20F

PULL STUD

Size: 96mm Pull Studs

Material Construction: S7 Tool Steel

The PS20F is required to use any 5th Axis 96mm base. The 96mm spacing allows for compatibility with other systems.

**Please note that pull studs must stay with the corresponding company's base plate. If you are using a 5th Axis 96mm RockLock base plate you will need 5th Axis pull studs (PS20F). The spacing and thread allows for the top tooling to be interchangeable between the different systems.*



PS20F-PY

SINGLE PULL STUD WITH POKA-YOKE INSERT

Size: 96mm Pull Studs

Material Construction: S7 Tool Steel

Poka-yoke is a Japanese term that means "mistake-proofing". The PS20F-PY is a single modified pull stud with an aluminum ring. The ring is placed inside one of the locating holes in the RockLock base, allowing for only the single poka-yoke pull stud to fit inside the locating hole with the corresponding ring. This will prevent operators from changing the orientation and misloading a part.



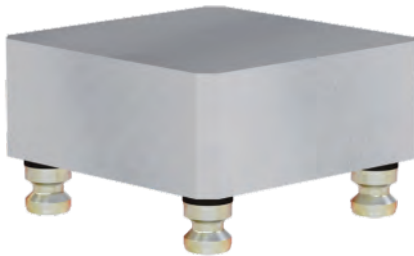
PS20F-4PY

PULL STUDS WITH POKA-YOKE INSERT

Size: 96mm Pull Studs

Material Construction: S7 Tool Steel

3x Standard PS20F Pull Studs and one Poka-Yoke (PS20F-PY).



R96-BLANK

Size: 96mm Pull Studs

Material Construction: 6061 Aluminum

Blank 6061 aluminum block with quantity 4 PS20F pull studs included. Quickly build your own fixture or subplate with the R96-Blank.

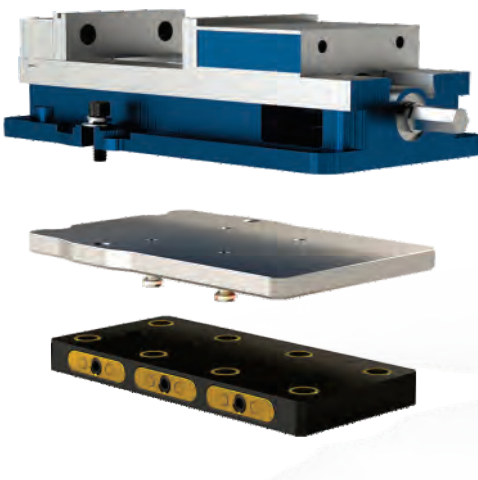


RL96-MP

Size: 96mm Pull Studs

Material Construction: Steel

Mount the RockLock base onto the machine, drop in the master pallet, dial in your setup, and torque your mounting bolts once you have reached the desired location. This is the fastest, most accurate way to set up the RockLock system. See page 33 for more info.



RL96-KD688 / RL96-KDX6*

Size: RL96-KD688: 13" x 8.25" x .78"

RL96-KDX6: 13" x 6.92" x .78"

Material Construction:

Aluminum (RL96-KD688)

Aluminum (RL96-KDX6)

The RL96-KD688 is built to upgrade your Kurt D-series 6" vise to the RockLock quick-change system. Never indicate your Kurt vise in again! Simply bolt your Kurt vise onto the adapter and you will be off and running. Part number includes adapter + 4x PS20F pull studs.

The RL96-KDX6 is built for the newer style DX6 crossover vise. Upgrade your new Kurt DX6 to RockLock quick-change system from 5th Axis. Part number includes adapter quantity 4 PS20F pull studs.



*Vise and RockLock base sold separately



5th Axis Workholding products are designed to adapt to automated systems increasing throughput. Create profitability through efficiency.

EROWA
system solutions
SOLUTIONS



148mm



320mm



400mm

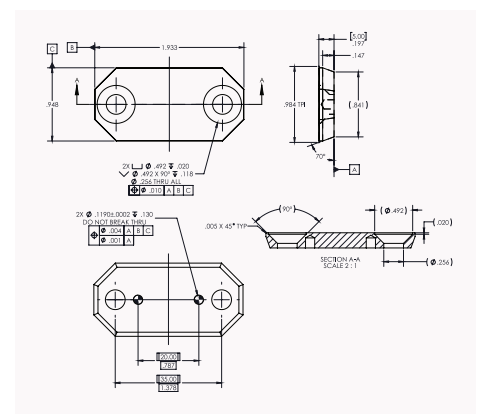


AS-96

96mm Custom Gripper

Automation Solutions, Gripper Assembly, 96mm

industrial robot automation.

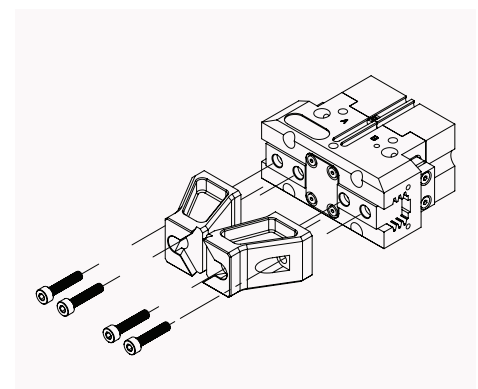


AG-12

52mm Custom Gripper

Automation Solutions, Gripper Assembly, 52mm

industrial robot automation.



Automation Solutions



Available in 52mm
and 96mm Pull Stud
Spacing



Clamp / Unclamp
Confirmation



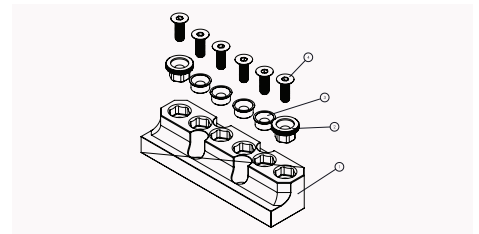
Steel Locating
Features



V562X-5RG

Round Stock Gripper Jaw
(For V562X & V510X)

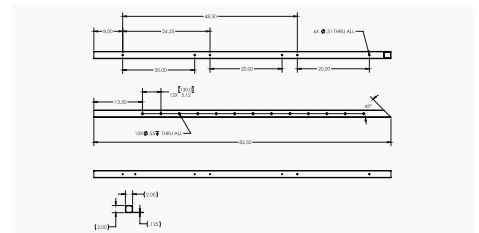
5" wide, X-Series compatible hard
jaws to support round raw stock



AS-RS

Automation Rack Shelf

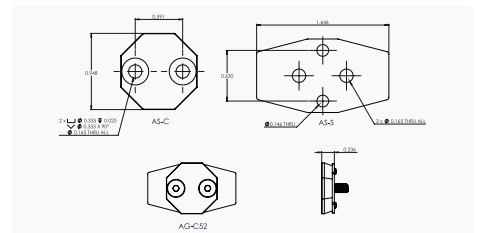
Single Shelf for Automation Racks.



AG-C

52mm Low Profile Cleat

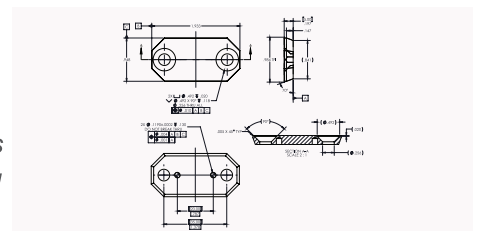
Our innovative cleat design
simplifies and secures the
movement of tooling using robotic
systems.



AS-C96

96mm Low Profile Cleat

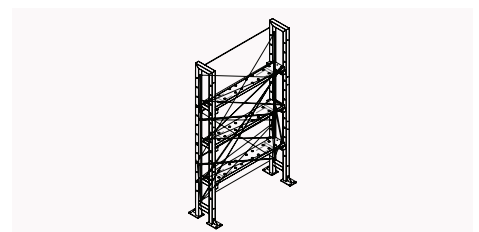
Our innovative cleat design simplifies
and secures the movement of tooling
using robotic systems.



AS-R3

Single Rack & Shelf Kit

Single Rack & Shelf Kit with 3-shelf
assembly.



RL52P-66B



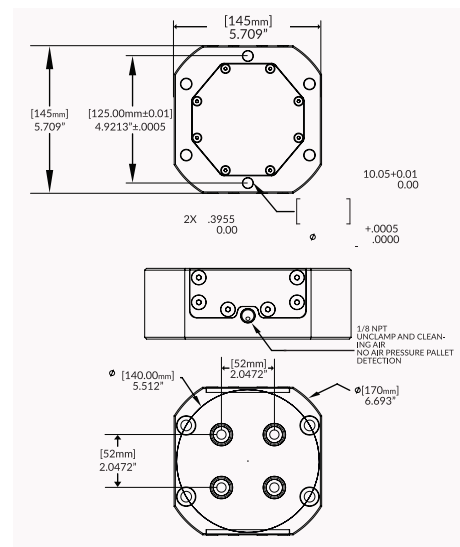
The RL52P-66B is a 52mm pneumatic RockLock unit.

Working pressure range:

80 PSI (.55 MPa) MIN /
120 PSI (.83 MPa) MAX

Side-Port

- 52mm pull stud spacing
- Air to open / spring to close
- Built for manual operation
- 1 port for clamp / unclamp
- No cleaning air / clamp confirmation



RL52P-66A Bottom-Port

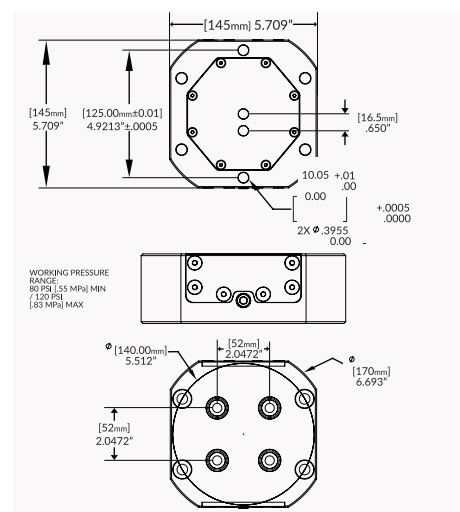


The RL52P-66A is a 52mm pneumatic RockLock unit that uses air to open and spring to close.

Working pressure range:

80 PSI (.55 MPa) MIN /
120 PSI (.83 MPa) MAX

- 52mm pull stud spacing
- Air to open / spring to close
- Built for automation applications
- 1 port for clamp / unclamp
- 1 port for cleaning / clamp confirmation



RL96P-67B Side-Port

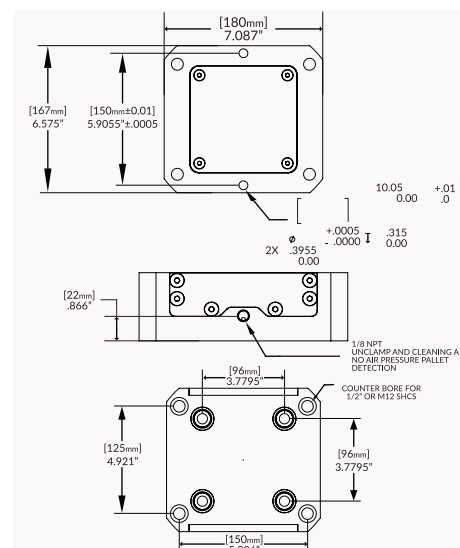


The RL96P-67B is a 96mm pneumatic RockLock unit.

Working pressure range:

80 PSI (.55 MPa) MIN /
130 PSI (.86 MPa) MAX

- 96mm pull stud spacing
- Air to open / spring to close
- Built for manual operation
- 1 port for clamp / unclamp
- No cleaning air / clamp confirmation



RL96P-67A



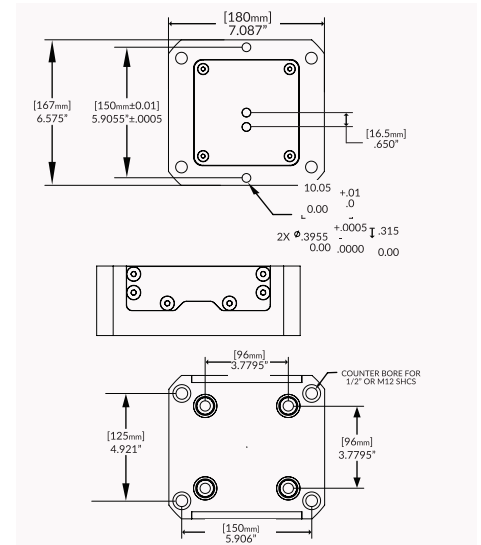
The RL96P-67A is a 96mm pneumatic RockLock unit that uses air to open and spring to close.

Working pressure range:

80 PSI (.55 MPa) MIN /
130 PSI (.86 MPa) MAX

Bottom Port

- 96mm pull stud spacing
- Air to open / spring to close
- Built for automation applications
- 1 port for clamp / unclamp
- 1 port for cleaning / clamp confirmation



RL52E-66



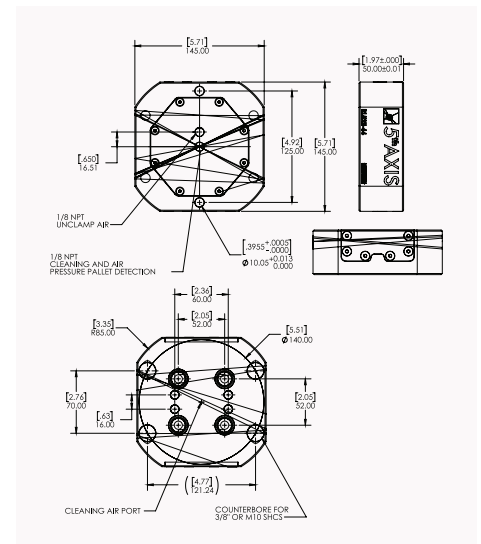
The RL52E-66 is a 52mm pneumatic RockLock unit that uses air to open and spring to close.

Working pressure range:

80 PSI (.55 MPa) MIN /
130 PSI (.86 MPa) MAX

Bottom Port

- 52mm pull stud spacing
- Air to open / spring to close
- Built for automation applications
- 1 port for clamp / unclamp
- 1 port for cleaning / clamp confirmation



RL96E-67



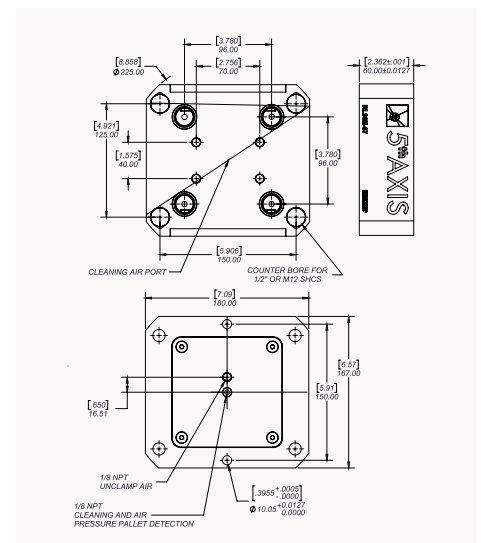
The RL96E-67 is a 96mm pneumatic Chuck with Ejectors RockLock™ unit that uses air to open and spring to close.

Working pressure range:

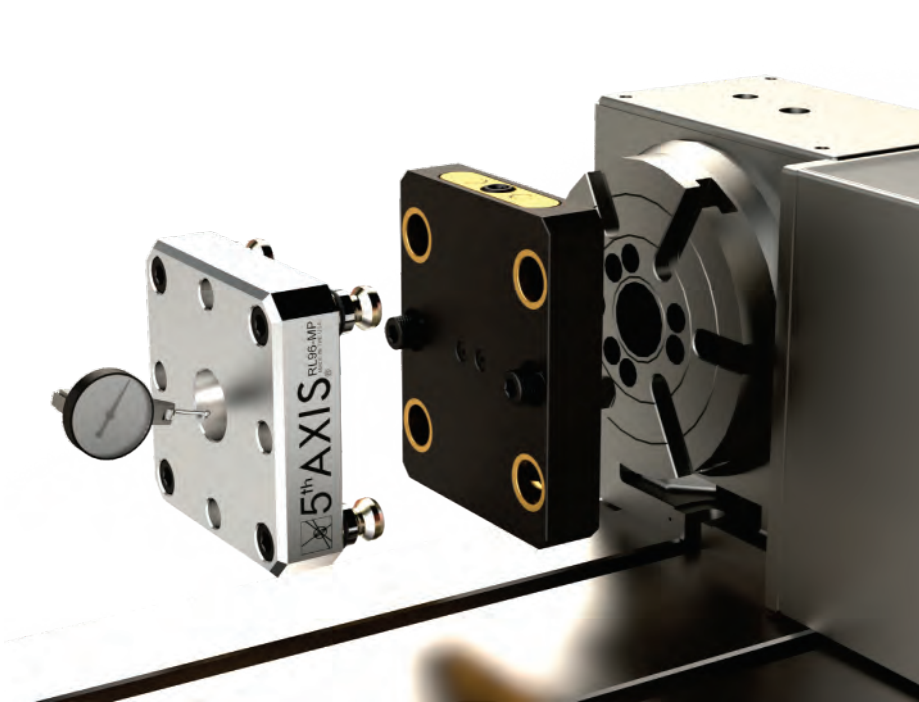
80 PSI (.55 MPa) MIN /
130 PSI (.86 MPa) MAX

Bottom Port

- 96mm pull stud spacing
- Air to open / spring to close
- Built for automation applications
- 1 port for clamp / unclamp
- 1 port for cleaning / clamp confirmation



Master Alignment Pallet



Available in 96mm and 52mm



Ensures RockLock repeatability less than 8 μm



Precision milled and press fit pull studs*



One Master Pallet for all your RockLock systems

Guarantees accuracy of the RockLock system. The Master Pallets are used to set up 52mm and 96mm RockLock systems.

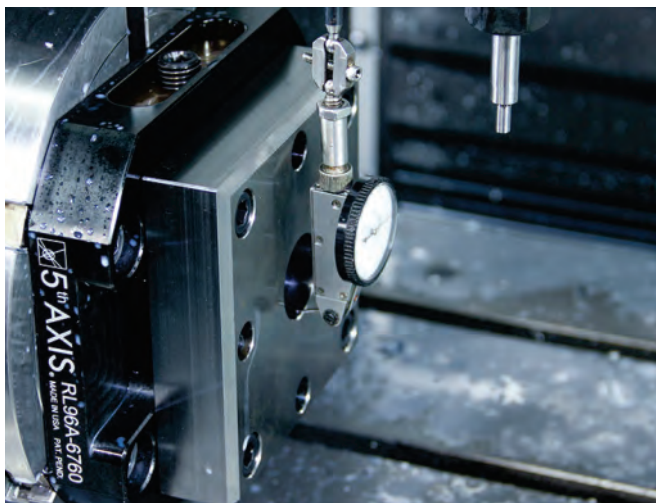
Mount the RockLock base onto the machine, drop in the Master Pallet, dial in your setup, and torque your mounting bolts once you have reached the desired location.

Master Pallet will only be used on the initial setup or if you move the setup from one machine to another. This is the fastest, most accurate way to set up the RockLock system.

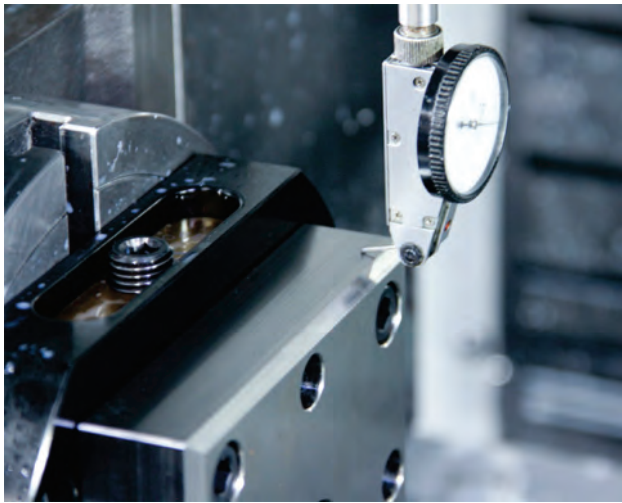
*Do not remove pull studs.

**Instructional video provided on our website.

***CMM report provided with purchase of Master Pallet.



Precision center bore allows for indication of rotation.



Precision milled sides allow for indication of center line.

Master Pallets

Part Number	RL52-MP	RL96-MP
		
Size	75mm x 75mm x 25.4mm	125.73mm x 125.73mm x 30.48mm
Mounting	RockLock PS16F Pull Studs Included	RockLock PS20F Pull Studs Included
Materials	Steel	Steel

Double Station Vises

Double Station

Double Station Visers

BUILT FOR 3-AXIS



Convert from double station to single position fixed jaw*

Quickly change jaws / convert to soft jaws

Compact footprint maximizes table space

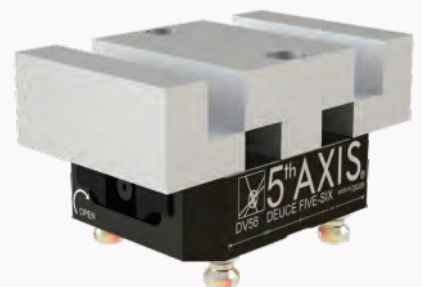
Not a self-centering vise



Double Station



Single Station Fixed Jaw



Machinable Jaws

*Only applies to DV56 and DV510

Quickly Convert From Double To Single Fixed Station*



Double Station

This configuration utilizes the center portion as the fixed position.



Independent Movement

Each jaw moves independently. This allows for stock of different sizes and ensures proper clamping.



Reversible Jaw

Jaws can quickly and easily be reversed for increased clamping range.



Removing Center Jaw

The center jaw is bolted through the base and held in position with precision bushings.



Shoulder Bolts Lock Back Jaw

The vise base has two precision bores that allow for shoulder bolts to lock the back jaw when switching to a single station.

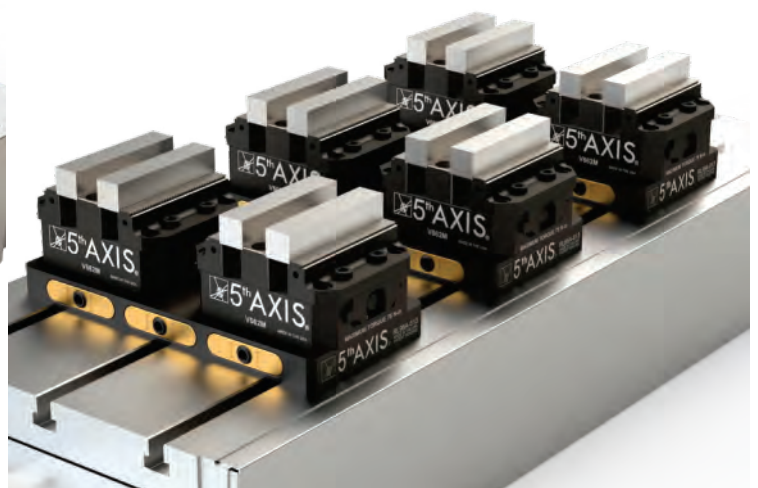
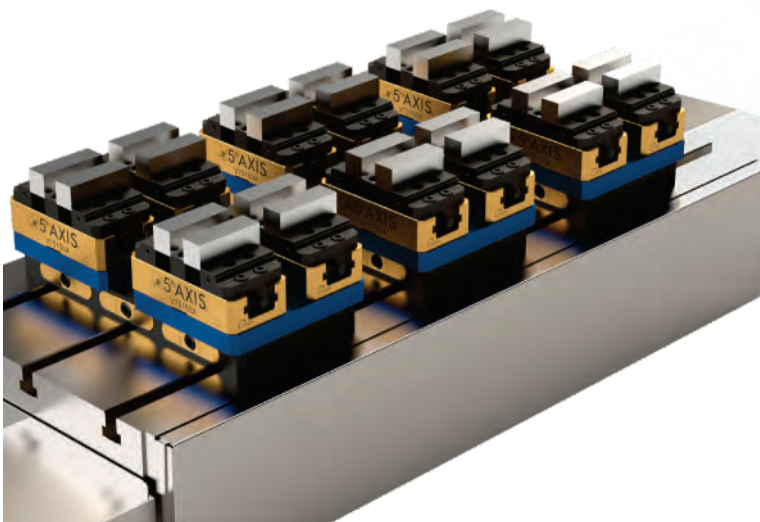


Fixed Jaw*

In this configuration the vise operates like any traditional machine vise.

*DV56 and DV510 only

Maximize Your Table Space



*Only applies to DV56 and DV510

Double Station Vises

Master Hard Jaws

Part Number	DV75150X-J1	DV56-J1	DV510-J1	DV510-J4
				
Size	75mm x 150mm x 56mm	125.7mm x 152.4mm x 72.9mm	125.7mm x 258.3mm x 73.4mm	125.7mm x 258.3mm x 73.4mm
Jaw Type	Hardened Steel 3 Piece Master Jaw Set Serrated / 45° Dovetail	Hardened Steel 3 Piece Master Jaw Set Serrated / 45° Dovetail	Hardened Steel 3 Piece Master Jaw Set with 2" Center Serrated / 45° Dovetail	Hardened Steel 3 Piece Master Jaw Set with 1" Center Serrated / 45° Dovetail
Jaw Width	75mm	125.7mm	125.7mm	125.7mm
Clamping Force	13.5 kN @ 60 Nm	20.0 kN @ 75 Nm	20.0 kN @ 75 Nm	20.0 kN @ 75 Nm
Max Torque	60 Nm	75 Nm	75 Nm	75 Nm
Forward Clamping Range	0 - 37.02mm	0 - 28.5mm	0 - 66.7mm	0 - 79.4mm
Reverse Clamping Range	17.26mm - 55.02mm	31.0mm - 64.2mm	30.9mm - 102.3mm	30.9mm - 115mm
Single Station Forward Clamping Range	N/A	0 - 75.9mm	0 - 177.5mm	0 - 177.5mm
Single Station Reverse Clamping Range	N/A	56.8mm - 147.3mm	56.8mm - 248.7mm	56.8mm - 248.7mm



DV75150X-J1 shown on the RL96A-3613S1 base plate

Aluminum Jaws

Part Number	DV75150X-J2	DV56-J2	DV510-J2
			
Size	75mm x 150mm x 64.1mm	125.7mm x 152.4mm x 89mm	125.7mm x 258.3mm x 88.5mm
Jaw Type	6061 Aluminum Machinable Jaw Set	6061 Aluminum Machinable Jaw Set	6061 Aluminum Machinable Jaw Set
Jaw Width	75mm	125.7mm	125.7mm
Clamping Force	13.5 kN @ 60 Nm	20.0 kN @ 75 Nm	20.0 kN @ 75 Nm
Max Torque	60 Nm	75 Nm	75 Nm

Steel Jaws

Part Number	DV75150X-J3	DV56-J3	DV510-J3
			
Size	75mm x 150mm x 64.1mm	125.7mm x 152.4mm x 89mm	125.7mm x 258.3mm x 88.5mm
Jaw Type	1018 Steel Machinable Jaw Set	1018 Steel Machinable Jaw Set	1018 Steel Machinable Jaw Set
Jaw Width	75mm	125.7mm	125.7mm
Clamping Force	13.5 kN @ 60 Nm	20.0 kN @ 75 Nm	20.0 kN @ 75 Nm
Max Torque	60 Nm	75 Nm	75 Nm

Double Station Vises

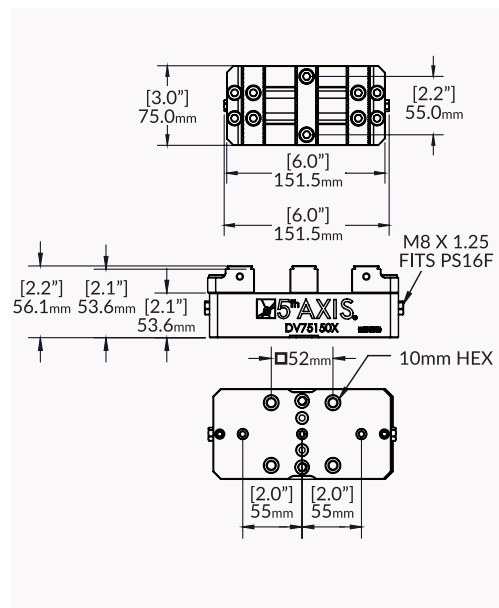
DV75150X-J1 Master Hard Jaws



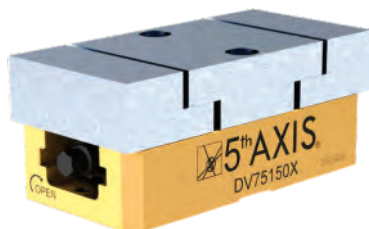
Size: 75mm x 150mm x 56.1mm
Jaw Set Material:
 Hardened Steel 3 Piece Master Jaw Set
 with Serrated / 45° Dovetail
Jaw Width: 75mm
Clamping Force: 13.5 kN @ 60 Nm
Max Torque: 60 Nm
Forward Clamping Range:
 0-37.02mm
Reverse Clamping Range: 17.23 - 55.02mm

Double station vise with serrated and dovetail master jaws. Perfect for making parts that are less than 55mm x 75mm.

Cannot be used in single station configuration



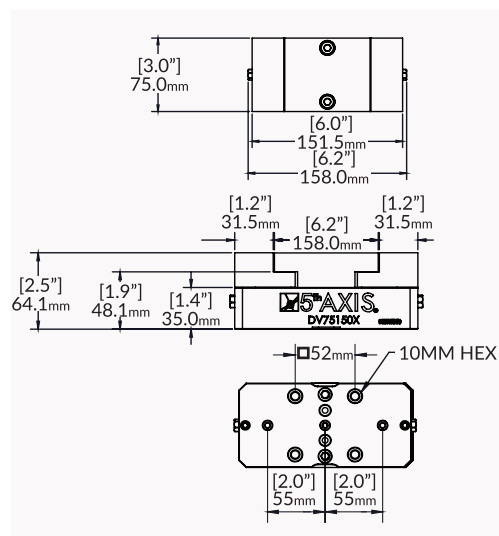
DV75150X-J2 Aluminum Jaws



Size: 75mm x 150mm x 56.1mm
Jaw Set Material:
 6061 Aluminum Machinable Jaw Set
Jaw Width: 75mm
Clamping Force: 13.5 kN @ 60 Nm
Max Torque: 60 Nm

Double station vise with 6061 aluminum machinable jaws. Perfect for secondary operation work.

Cannot be used in single station configuration



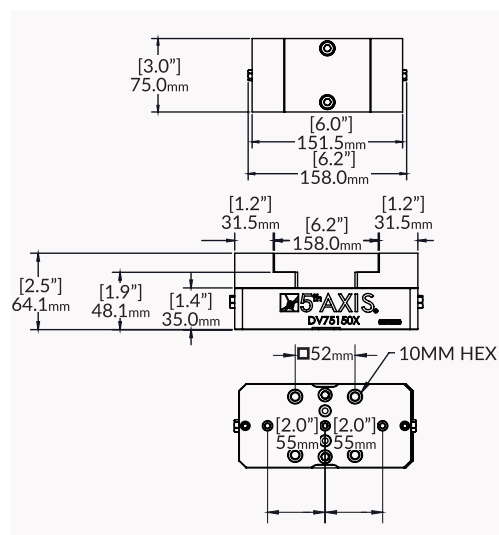
DV75150X-J3 Steel Jaws



Size: 75mm x 150mm x 56.1mm
Jaw Set Material:
 1018 Steel Machinable Jaw Set
Jaw Width: 75mm
Clamping Force: 13.5 kN @ 60 Nm
Max Torque: 60 Nm

Double station vise with 1018 steel machinable jaws. Perfect for secondary operation work.

Cannot be used in single station configuration



DV56-J1 Master Hard Jaws



Size: 125.7mm x 152.4mm x 72.9mm

Jaw Set Material:

Hardened Steel 3 Piece Master Jaw Set
with Serrated / 45° Dovetail

Jaw Width: 75mm

Max Torque: 75 Nm

Forward Clamping Range: 0 - 28.5mm

Reverse Clamping Range: 31mm - 64.2mm

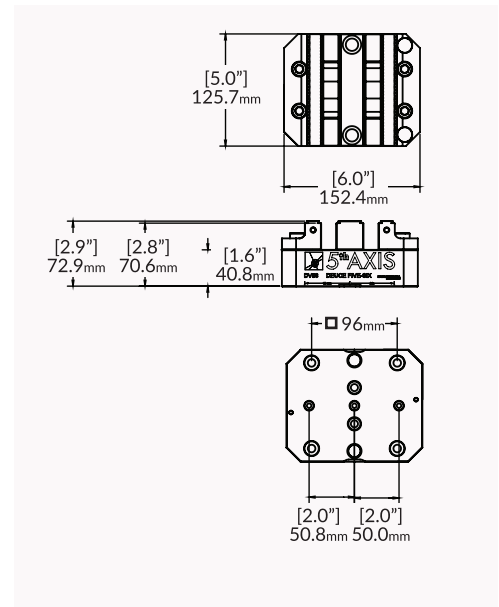
Fixed Jaw Forward Clamping Range:

0 - 75.9mm

Fixed Jaw Reverse Clamping Range:

56.8 - 147.3mm

Quickly convert the DV56-J1 from a double station to a fixed single jaw vise. Perfect for parts smaller than 64.2mm x 125.7mm.



DV56-J2 Aluminum Jaws



Size: 125.7mm x 152.4mm x 89mm

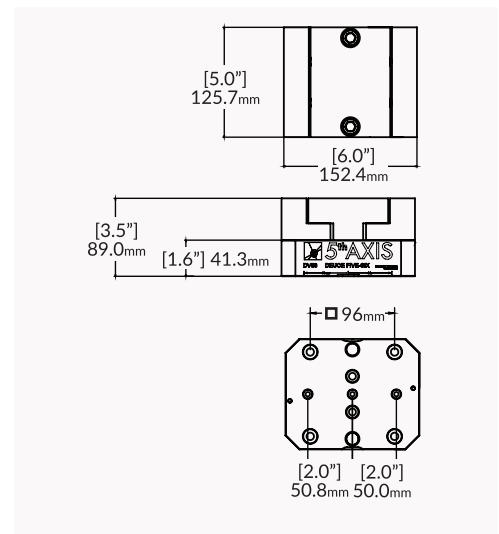
Jaw Set Material:

6061 Aluminum Machinable Jaw Set

Jaw Width: 75mm

Max Torque: 75 Nm

Double station vise with 6061 aluminum machinable jaws. Perfect for secondary operation work.



DV56-J3 Steel Jaws



Size: 125.7mm x 152.4mm x 89mm

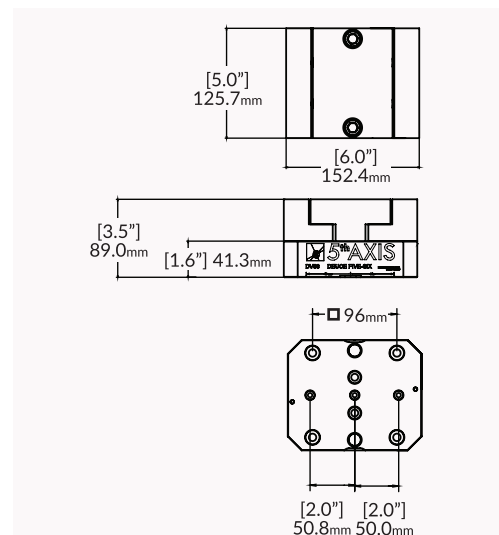
Jaw Set Material:

1018 Steel Machinable Jaw Set

Jaw Width: 75mm

Max Torque: 75 Nm

Double station vise with 1018 steel machinable jaws. Perfect for secondary operation work.



Double Station Vises

DV510-J1 Master Hard Jaws



Size: 125.7mm x 258.3mm x 73.4mm

Jaw Set Material:

Hardened Steel 3 Piece Master Jaw Set with 2" Center and Serrated / 45° Dovetail Jaws

Jaw Width: 125.7mm

Max Torque: 75 Nm

Forward Clamping Range:

0 - 66.7mm

Reverse Clamping Range:

30.9mm - 102.3mm

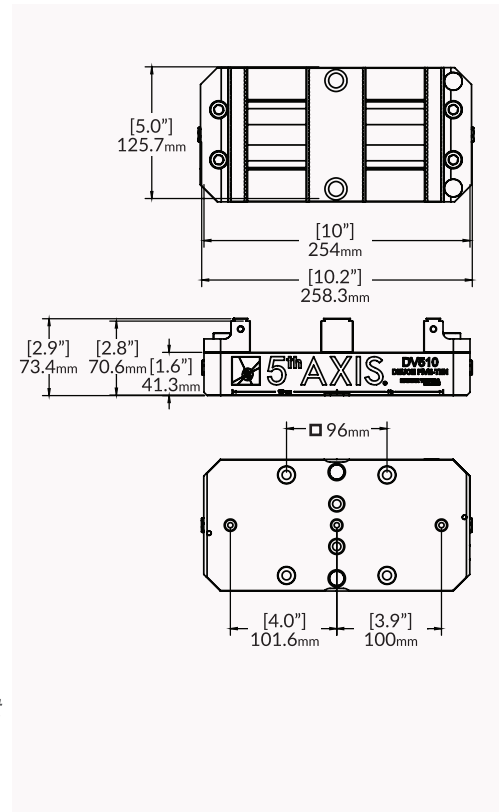
Fixed Jaw Forward Clamping Range:

0 - 177.5mm

Fixed Jaw Reverse Clamping Range:

56.8mm - 248.7mm

Double station vise that converts to a fixed jaw vise. 3 piece hard jaw set with a 2" center, serrations, and 45° dovetail master jaw.



DV510-J4 Master Hard Jaws



Size: 125.7mm x 258.3mm x 73.4mm

Jaw Set Material:

Hardened Steel 3 Piece Master Jaw Set with 1" Center and Serrated / 45° Dovetail Jaws

Jaw Width: 125.7mm

Max Torque: 75 Nm

Forward Clamping Range:

0 - 79.4mm

Reverse Clamping Range:

30.9mm - 115mm

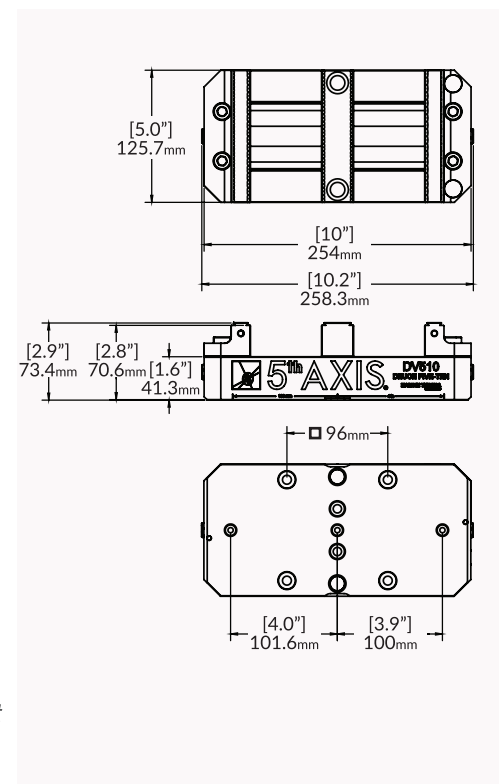
Fixed Jaw Forward Clamping Range:

0 - 177.5mm

Fixed Jaw Reverse Clamping Range:

56.8mm - 248.7mm

Double station vise that converts to a fixed jaw vise. 3 piece hard jaw set with a 1" center, serrations, and 45° dovetail master jaw.



DV510-J2 Aluminum Jaws



Size: 125.7mm x 258.3mm x 88.5mm

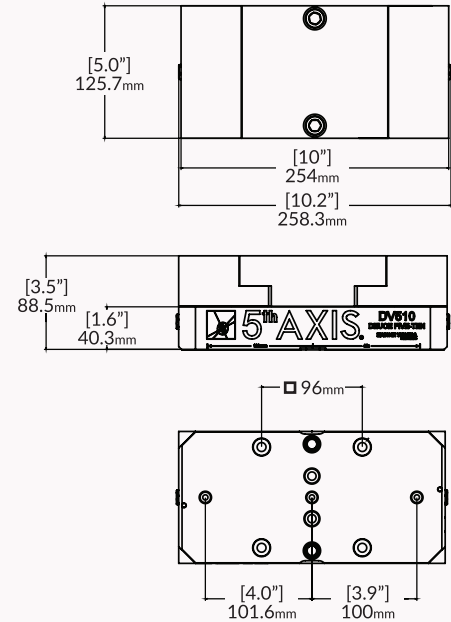
Jaw Set Material:

6061 Aluminum Machinable Jaw Set

Jaw Width: 125.7mm

Max Torque: 75 Nm

Double station vise with 6061 aluminum machinable jaws. Perfect for secondary operation work



DV510-J3 Steel Jaws



Size: 125.7mm x 258.3mm x 88.5mm

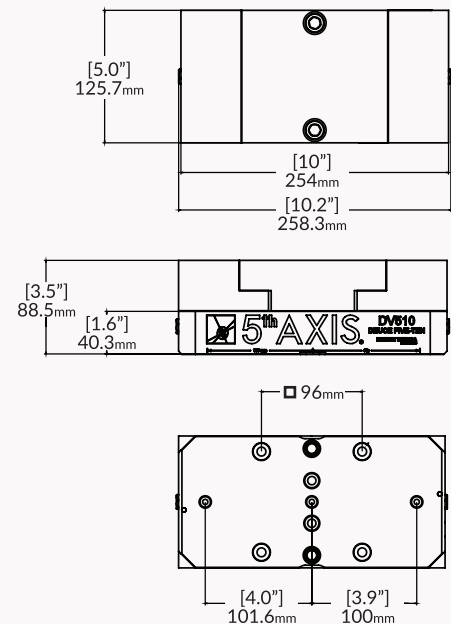
Jaw Set Material:

1018 Steel Machinable Jaw Set

Jaw Width: 125.7mm

Max Torque: 75 Nm

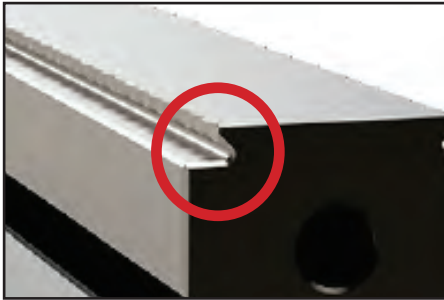
Double station vise with 1018 steel machinable jaws. Perfect for secondary operation work



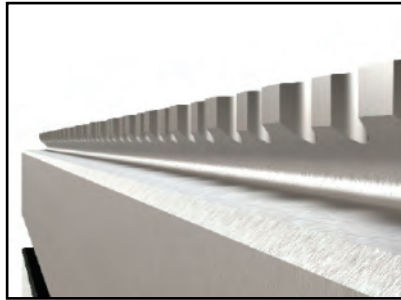
Self-Centering Vises

Self-Centering

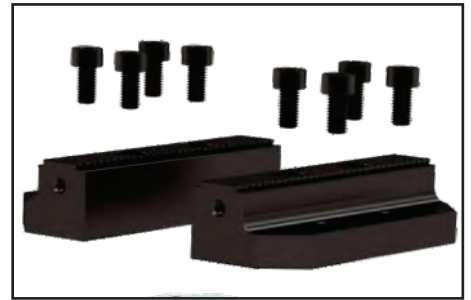
Self-Centering Vises



Built in 45° dovetail can be utilized for increased clamping force



Serrated gripper teeth for superior bite into soft material



Quick change jaws without disassembling vise

30% more clamping force
with new X-series vises



Pre-drilled for pull studs

Hardened steel

+/- 0.0127mm on center

Large leadscrew

Jaws are easy to remove

Easy mounting to machine

Part Number	V75100X	V75150X
		
Size	75mm x 100mm x 56mm	75mm x 150mm x 56mm
Jaw Width	75mm	75mm
Clamping Force	22.2 kN @ 60 Nm	22.2 kN @ 60 Nm
Max Torque	61 Nm	61 Nm
Forward Clamping Range	0 - 43.6mm	0 - 94.1mm
Reverse Clamping Range	38.5mm - 76.3mm	38.5mm - 128.8mm

Part Number	V562X	V510X
		
Size	125.7mm x 152.4mm x 73.6mm	125.7mm x 254mm x 73.6mm
Jaw Width	125.7mm	126mm
Clamping Force	25.1 kN @ 75 Nm	25.1 kN @ 75 Nm
Max Torque	75 Nm	75 Nm
Forward Clamping Range	0 - 78.0mm	0 - 184.7mm
Reverse Clamping Range	60.3mm - 128.0mm	60.3mm - 234.7mm

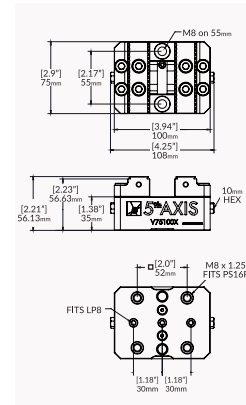
Self-Centering Vises

V75100X Metric



Size: 75mm x 100mm x 56mm
Jaw Width: 75mm
Forward Jaws Clamping Range:
 0 - 43.6mm
Reverse Jaws Clamping Range:
 38.5mm - 76.3mm
Clamping Force: 13.5 kN @ 60 Nm

The V75100X is the most recent revision of our V75100 vise. Now equipped with 4 bolt jaw mounting to reduce jaw lift providing robust clamping and sharper teeth for a better bite.

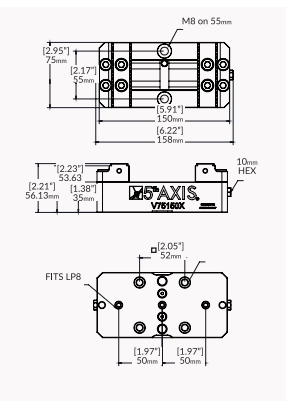


V75150X Metric



Size: 75mm x 150mm x 56mm
Jaw Width: 75mm
Forward Jaws Clamping Range:
 0 - 92.8mm
Reverse Jaws Clamping Range:
 38.5mm - 128.8mm
Clamping Force: 13.5 kN @ 60 Nm

The V75150X was created out of customer demand for a small self-centering vise with an increased clamping range over the popular V75100X vise. The base is 50mm longer than the standard V75100X, allowing the max workpiece size to increase from 76mm to 128mm. The new 4 bolt jaw mounting design reduces jaw lift and the sharper teeth provide a superior bite in raw material.



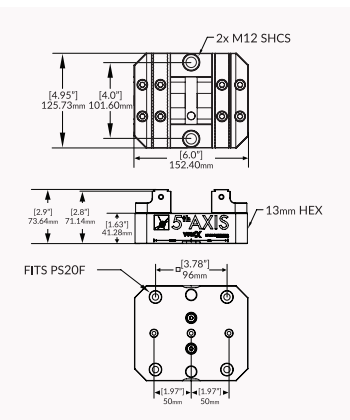
V562X Metric



Size: 125.7mm x 152.4mm x 73.6mm
Jaw Width: 125.7mm
Forward Jaws Clamping Range:
 0 - 78.0mm
Reverse Jaws Clamping Range:
 60.3mm - 128.0mm
Clamping Force: 25.1 kN @ 75 Nm
Torque Vise Assembly: 75 Nm

The V562X is the updated version of the best selling self-centering vise in the product line (V562M). The new model features 30% more clamping force due to the updated 4 jaw mounted bolts keyed jaw and truck.

The V562X is built from heat treated 4100 series steel and is precision ground and hard milled to ensure accuracy and repeatability.

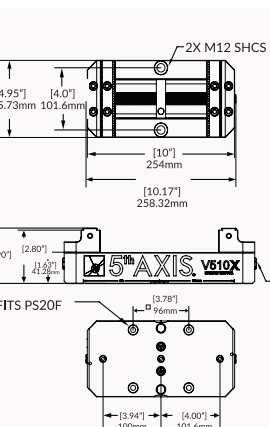


V510X Metric



Size: 125.7mm x 254mm x 73.6mm
Jaw Width: 125.7mm
Forward Jaws Clamping Range:
 0 - 184.7mm
Reverse Jaws Clamping Range:
 60.3mm - 234.7mm
Clamping Force: 25.1 kN @ 75 Nm
Torque Vise Assembly: 75 Nm

The V510X has all of the robust features of the V562X including the added clamping range. The V510X is a perfect fit for shops looking for a small footprint vise with a larger clamping range. The V510X is built from hardened and ground 4100 series steel to ensure accuracy and repeatability.



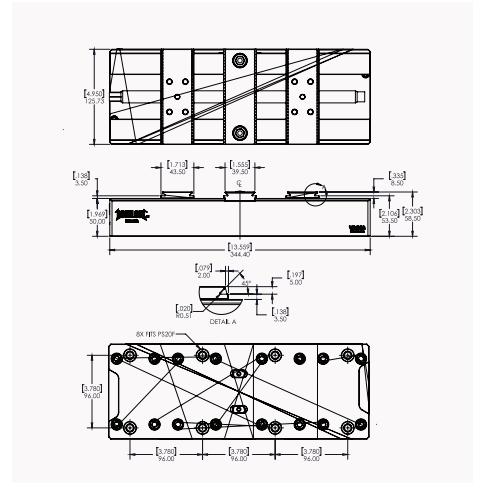
LITEVISE VA513

Metric



Size: 344mm x 125mm x 50mm
(13" x 5" x 2")
Jaw Width: 125mm (5")
Clamping Force: 22.2 kn @ 61 Nm
(5000lbs)
Max Torque: 61 Nm
**Clamping Range - Lower Gripper
Jaws:** .188" - 4" (Double Station)
**Clamping Range - Master Tall
Gripper Jaws:** .375" - 5.25" (Double
Station)
Weight: .20 lbs

*Are you ready to elevate your
CNC machining operations with
unparalleled precision and efficiency?
Meet LiteVise, the game-changing
lightweight vise designed to optimize
your workflow and deliver exceptional
results.*

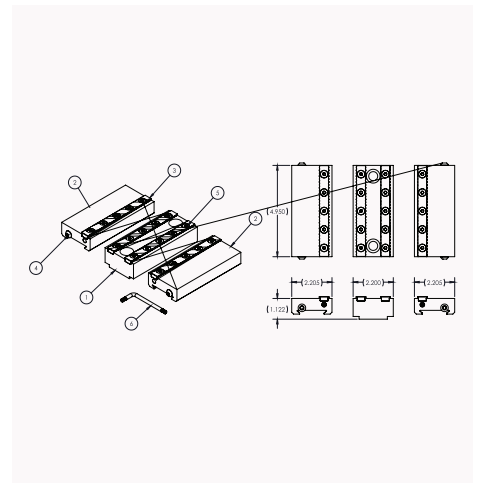


VA513-GJ-A

**Master Gripper Jaws
Set**



*Crafted from billet aluminum,
these machinable jaws are built
to withstand the rigors of daily
use in a variety of industrial and
manufacturing environments. Their
robust construction ensures a
long lifespan, providing you with
reliable performance and reduced
maintenance costs over time. The
gripper strips are built from hardened
steel and TiN coated for longevity.*

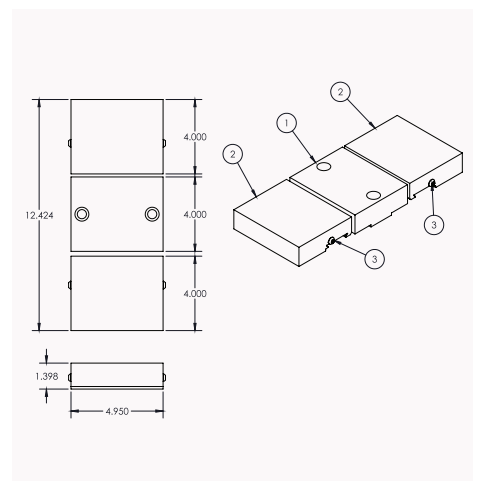


VA513-MJ-A

**Aluminum Soft Jaws
Set**



*Crafted from billet aluminum,
these machinable jaws are built
to withstand the rigors of daily
use in a variety of industrial and
manufacturing environments. Their
robust construction ensures a
long lifespan, providing you with
reliable performance and reduced
maintenance costs over time. The
gripper strips are built from hardened
steel and TiN coated for longevity.*



Self-Centering Vises

Self-Centering

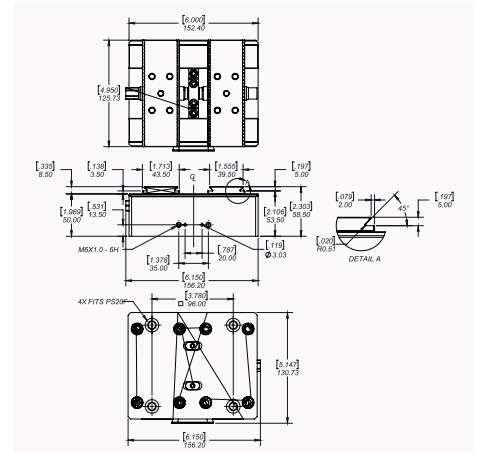
LITEVISE VA56

Metric



Size: 152mm x 125mm x 50mm
Jaw Width: 125mm
Clamping Force: 22.2 kn @ 61 Nm
Max Torque: 61 Nm
Clamping Range - Lower Gripper Jaws: .375" - 3"
Clamping Range - Master Tall Gripper Jaws: .375" to 5.25"
Weight: .10 lbs

Are you ready to elevate your CNC machining operations with unparalleled precision and efficiency? Meet LiteVise, the game-changing lightweight automation vise designed to optimize your workflow and deliver exceptional results.

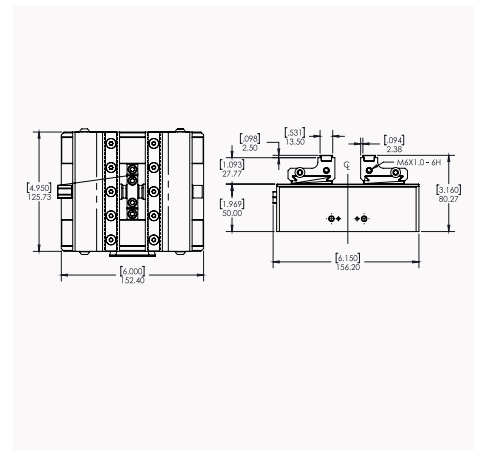


VGA-VA5

Aluminum Master
Gripper Jaw Set

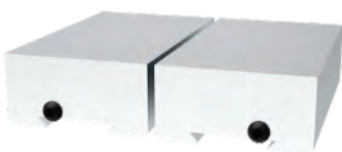


Crafted from billet aluminum, these machinable jaws are built to withstand the rigors of daily use in a variety of industrial and manufacturing environments. Their robust construction ensures a long lifespan, providing you with reliable performance and reduced maintenance costs over time. The gripper strips are built from hardened steel and TiN coated for longevity.

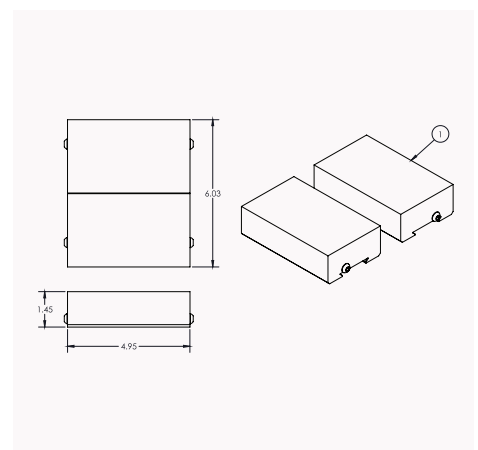


VGJ-VA5

Aluminum Soft Jaw
Set



Crafted from billet aluminum, these machinable jaws are built to withstand the rigors of daily use in a variety of industrial and manufacturing environments. Their robust construction ensures a long lifespan, providing you with reliable performance and reduced maintenance costs over time.



Double Station Pin Vises



Cost-Effective



Lightweight

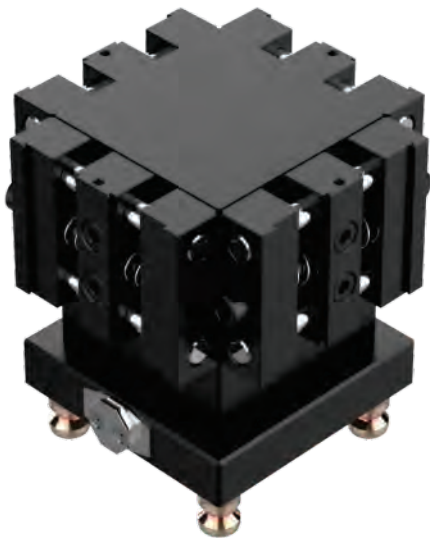
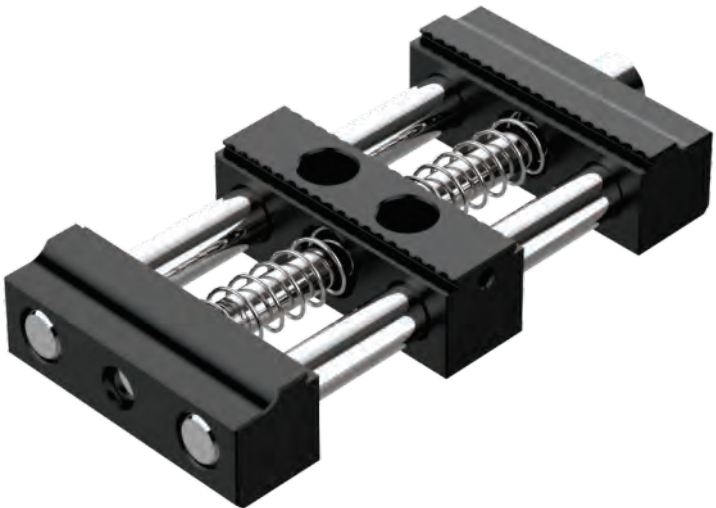


Compact Design

High-precision, quality vises in a skeleton design that makes them lighter, more compact, and cost-effective.

Ideal for high volume part production, Pin Vises have a small footprint, allowing more parts on a table for higher productivity. Pin Vises are also lightweight for automated applications where weight is a consideration.

Pin Vise tombstones, pyramids, and plates are configured with 96mm RockLock quick-change systems.



High volume applications

Available in 4" & 6" models

Clamping range:
0.25" - 2.5"

Hardened steel

Extreme low-profile design

Serrated gripper teeth
and integrated 45° dovetail

Double Station Pin Vises

Part Number	PV3X-4A	PV3X-4B
		
Size	75mm x 111.6mm x 25mm [2.95" x 4.39" x 0.98"]	75mm x 111.6mm x 25mm [2.95" x 4.39" x 0.98"]
Jaw Width	75mm [2.95"]	75mm [2.95"]
Clamping Range	19.05mm - 38.10 mm [0.75" - 1.50"]	6.35mm - 25.40mm [0.25" - 1.00"]

Part Number	PV3X-6A	PV3X-6B
		
Size	75mm x 161.6mm x 25mm [2.95" x 6.36" x 0.98"]	75mm x 161.6mm x 25mm [2.95" x 6.36" x 0.98"]
Jaw Width	75mm [2.95"]	75mm [2.95"]
Clamping Ranges Based on Bolt Size*	150: 44.45mm - 63.50mm [1.75" - 2.50"]	150: 31.75mm - 50.80mm [1.25" - 2.00"]
	130: 31.75mm - 50.80mm [1.25" - 2.00"]	130: 19.05mm - 38.10mm [0.75" - 1.50"]
	100: 19.05mm - 38.10mm [0.75" - 1.50"]	100: 6.35mm - 25.40mm [0.25" - 1.00"]

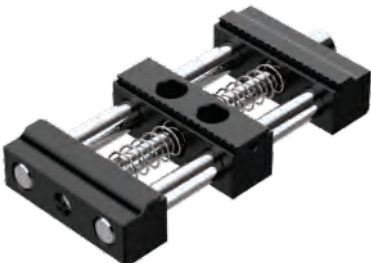
*PV3X-6A & PVX3-6B pin vises come with three different bolt lengths to provide different clamping range options.

PV3X-4



The PV3X-4 is a 4" pin vise that offers a low-cost, low profile solution ideal for 3 axis, horizontal, and lights out manufacturing.

PV3X-6



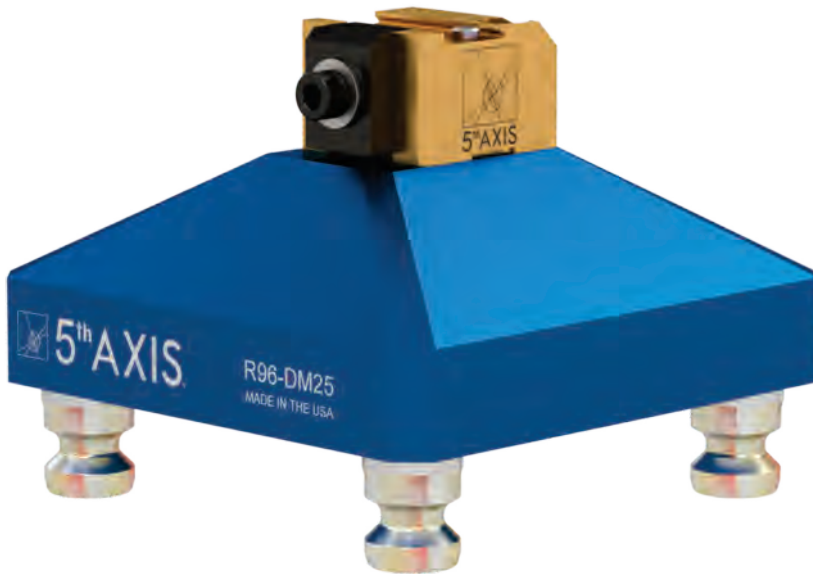
The PV3X-6A & 6B are 6" pin vises that come with three sets of bolts with different lengths to provide three clamping range options.

PMV3XS



The PMV3X is a 1018 steel machinable jaw version of the PV3X-6 pin vises.

Dovetail Fixtures



45° dovetail for increased clamping force



Locating pins for precise repeatability



Low profile design



Hardened steel clamp and body

Dovetail Fixtures

Part Number	DM12	DM25	DM50
			
Size	21mm x 32mm x 19mm	37mm x 41mm x 27mm	50mm x 50mm x 38mm
Stock Size	12mm - 25mm	25mm - 75mm	50mm and Above
Dovetail Depth	2.54mm	2.54mm	5.08mm

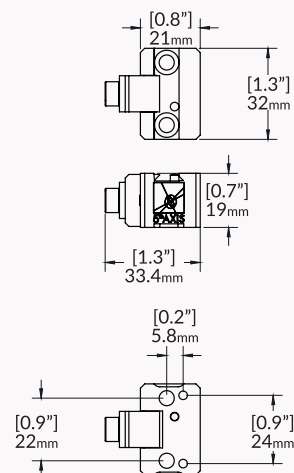
Dovetail Fixtures

DM12 Metric



Size: 21mm x 32mm x 19mm
Material: 4100 Series Steel
Stock Size: 12mm - 25mm
Dovetail Depth Required: 2.54mm

The DM12 is the smallest dovetail fixture in the 5th Axis workholding line. The DM12 features a wedge style clamp for superior gripping force and a low profile design that optimizes tool clearance. This micro dovetail fixture is the perfect choice for multi-axis work on smaller parts.

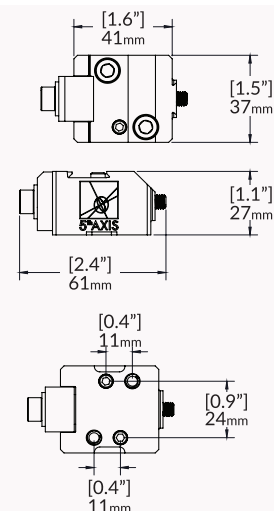


DM25 Metric



Size: 37mm x 41mm x 27mm
Material: 4100 Series Steel
Stock Size: 25mm - 75mm
Dovetail Depth Required: 2.54mm

The DM25 is the most versatile dovetail fixture in the 5th Axis workholding line. It is a simple and robust dovetail fixture built for stock under 75mm. The DM25 features a robust clamp for superior gripping force and a low profile design that optimizes tool clearance. This dovetail fixture is the perfect choice for multi-axis work on small to medium sized parts.

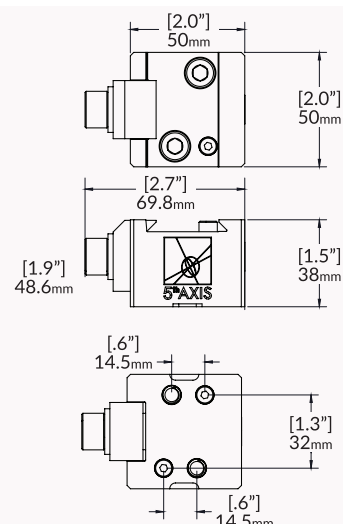


DM50 Metric



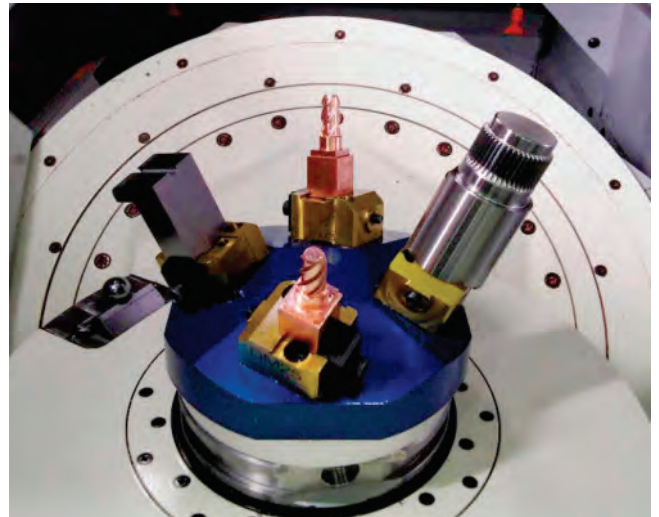
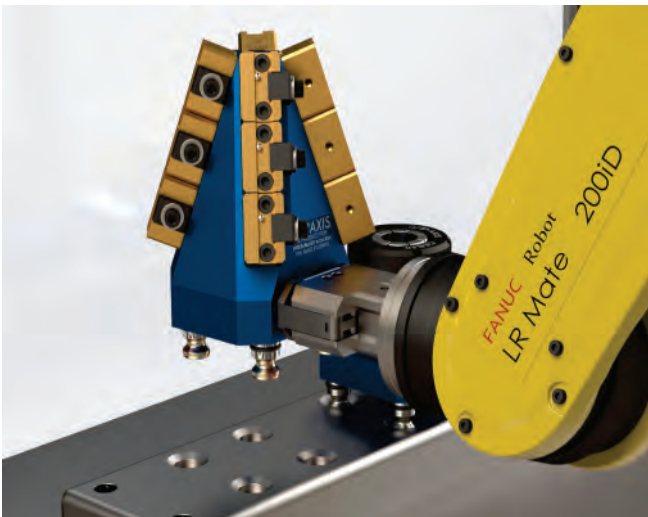
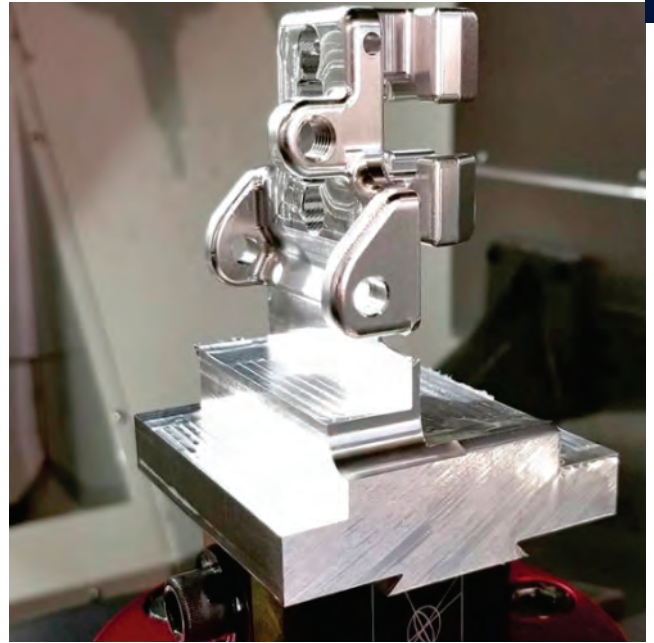
Size: 50mm x 50mm x 38mm
Material: 4100 Series Steel
Stock Size: 50mm+
Dovetail Depth Required: 5.08mm

The DM50 is a simple and robust dovetail fixture built for stock 50mm and above. It features a wedge style clamp for superior gripping force, and a low profile design that optimizes tool clearance.



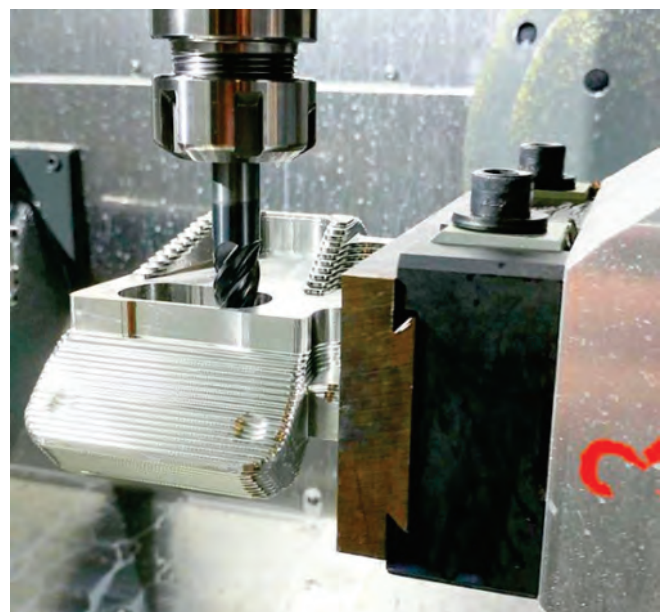
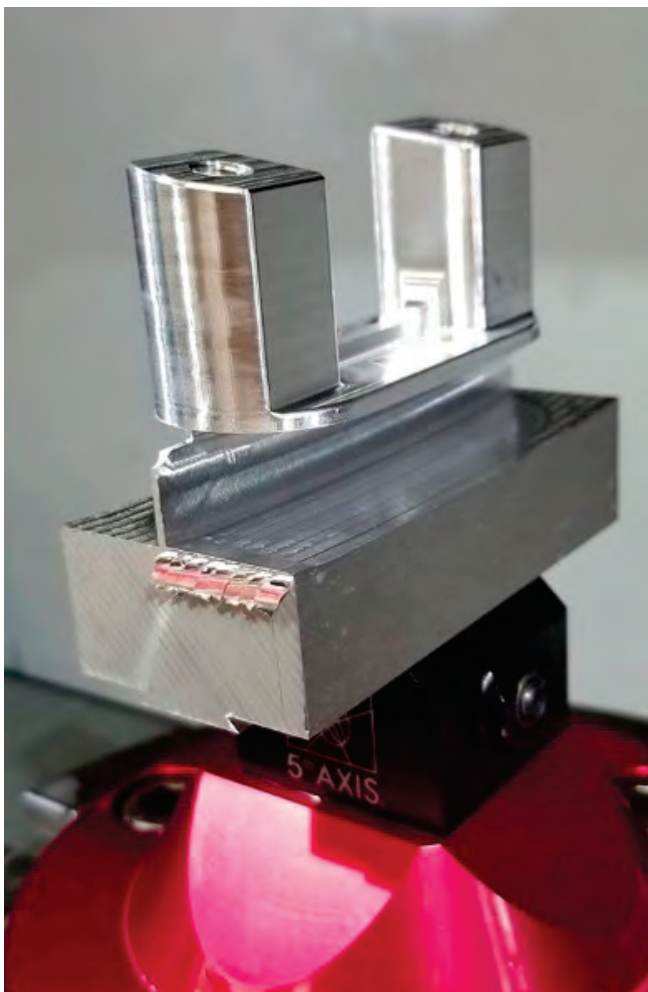
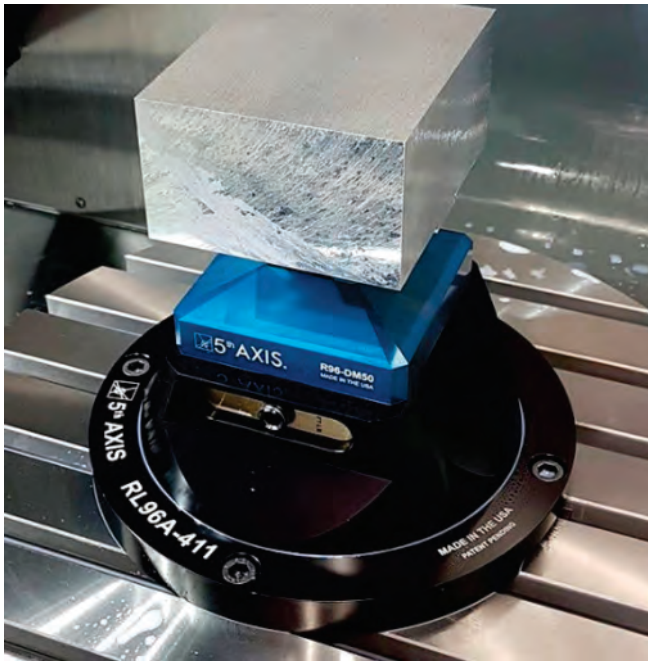
To see the full product offering scan here:





Real workholding applications provided by customers

Dovetail Fixtures Examples



Real workholding applications provided by customers

R52-P12DM12



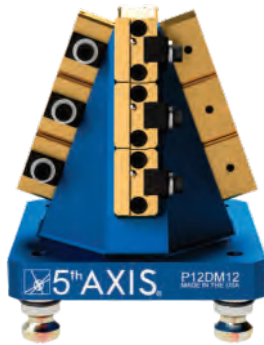
Metric

Spacing: 125.73mm x 125.73mm x 133.5mm

Material Construction: 6061 Aluminum

Built for our 52mm RockLock Quick Change System, the R52-P12DM12 provides maximum amount of flexibility. This 4-sided pyramid utilizes twelve DM12 dovetail fixtures for stock under 25mm. The orientation of the fixtures on the pyramid ensures optimal tool clearance for multiple parts. Machine up to 12 parts on this compact unit. The modular design allows for fixtures to be added or removed depending on the length of the workpiece.

R96-P12DM12



Metric

Spacing: 125.73mm x 125.73mm x 133.5mm

Material Construction: 6061 Aluminum

Built for our 96mm RockLock Quick Change System, the R96-P12DM12 provides maximum amount of flexibility. This 4 sided pyramid utilizes twelve DM12 dovetail fixtures for stock under 25mm. The orientation of the fixtures on the pyramid ensures optimal tool clearance for multiple parts. Machine up to 12 parts on this compact unit. The modular design allows for fixtures to be added or removed depending on the length of the workpiece.

R52-P4DM25



Metric

Spacing: Ø152.4mm x 64.9mm

Material Construction: 6061 Aluminum

This compact pyramid utilizes 4 DM25 dovetail fixtures. The small foot print ensures no space is wasted allowing simultaneous machining of four parts. Run more parts per cycle and minimize pallet and tool changes. This versatile fixture can be mounted on trunnions, pallets, and machine tables using our 52mm RockLock Quick Change System.

R96-P4DM25



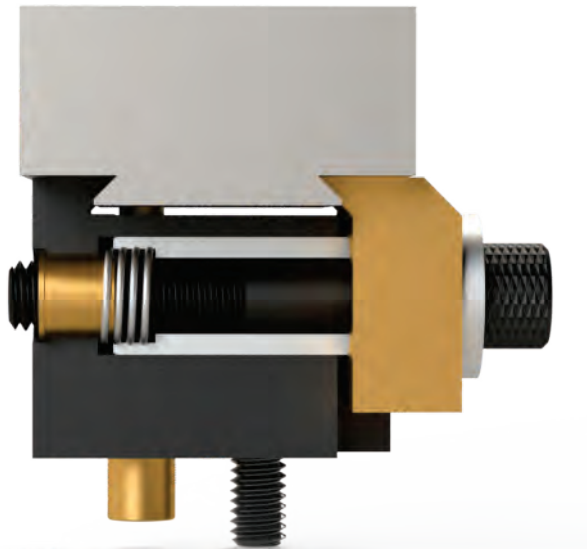
Metric

Spacing: Ø152.4mm x 64.9mm

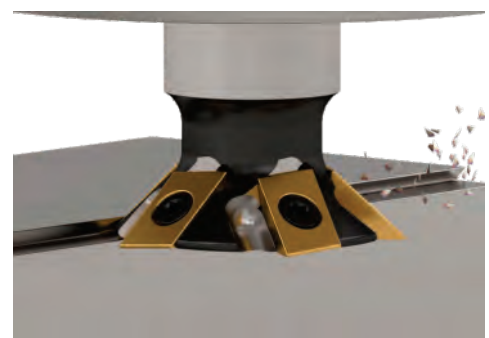
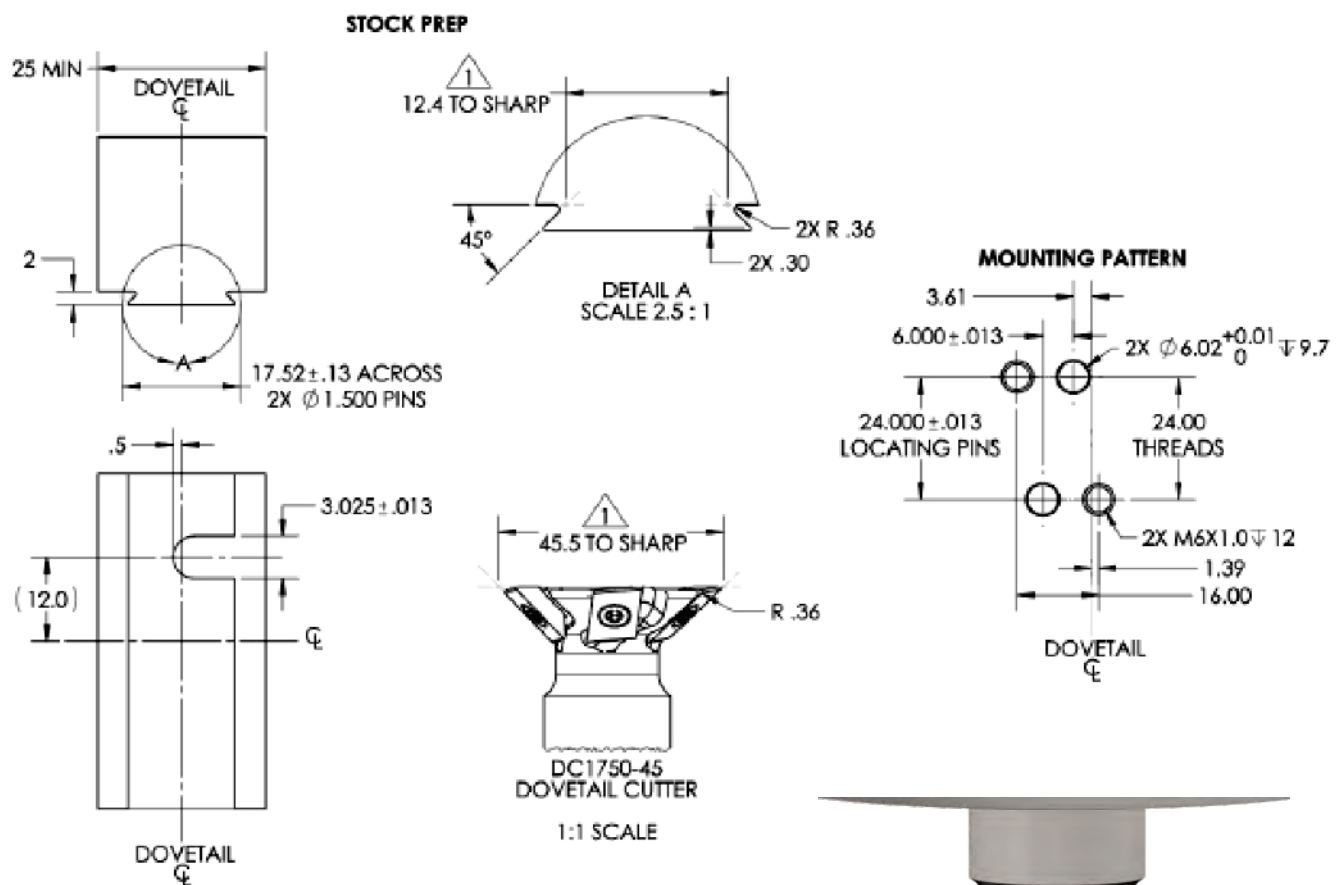
Material Construction: 6061 Aluminum

This compact pyramid utilizes 4 DM25 dovetail fixtures. The small foot print ensures no space is wasted allowing simultaneous machining of four parts. Run more parts per cycle and minimize pallet and tool changes. This versatile fixture can be mounted on trunnions, pallets, and machine tables using our 96mm RockLock Quick Change System.

Dovetail Fixtures



Sample Dovetail Stock Prep (DM25)



CERX-40 & CERX-32



The CERX-40 and CERX-32 are quick and efficient fixtures for holding round stock. The collets utilize your existing set of standard ER40 and ER32 collets allowing you to clamp different diameters of stock. The bodies are manufactured from hardened alloy steel to exacting standards.

Part Number	R52-CERX-40	R96-CERX-40
		
Size	75mm X 75mm x 68mm	126mm x 126mm x 81mm
Mounting	Includes PS16F	Includes PS20F
Stock Size	ER40 Collet	ER40 Collet

Part Number	R52-CERX-32	R96-CERX-32
		
Size	75mm X 75mm x 68mm	126mm x 126mm x 81mm
Mounting	Includes PS16F	Includes PS20F
Stock Size	ER32 Collet	ER32 Collet



Dovetail Cutters

DC1750-I

45° Indexable Dovetail Cutter, 1" shank

All of our fixtures feature 45° dovetail.

DC1750-M

45° Indexable Dovetail Cutter, 25mm shank

All of our fixtures feature 45° dovetail.

DC1750-B

Inserts for Dovetail Cutter

Compatible with all 5th Axis dovetail cutters.



Thumb Screws

Replacement Thumbscrews:

TS10 - Used on V75100X, V75150X, DV75150X

TS13 - Used on DV56, DV510, V552M, V562M, and V510M

TS17 - Used on V6105M

Thumb screws are included with every vise. Fits standard 3/8" drives.



Threaded Locating Pins

Replacement Locating Pins:

LP6 - 6mm OD

LP8 - 8mm OD

LP10 - 10mm OD

Locating pins are included with every vise.

*Inserts sold separately.

CAD models available for download at 5thaxis.com/downloads



Machinable 6061 Aluminum Jaws

METRIC

VAJ75X - 75mm x 45mm x 25mm (Compatible with V75100 / V75100X)

VAJ52X - 125.73 mm x 62.23 mm x 34.29 mm (Compatible with V562X / V510X)

VAJ52M - 125mm x 50mm x 34mm (Compatible with V552M / V562M / V510M)

VAJ610M - 151mm x 78mm x 47mm (Compatible with V6105M)



Machinable 1018 Steel Jaws

METRIC

VSJ75X - 75mm x 45mm x 25mm (Compatible with V75100 / V75100X)

VSJ52M - 125mm x 50mm x 34mm (Compatible with V552M / V562M / V510M)

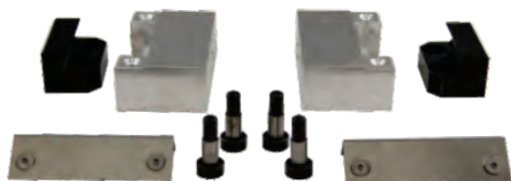
VSJ610M - 151mm x 78mm x 47mm (Compatible with V6105M)



DJ6 Gripper Jaws

DJ6 - Compatible with standard 6" Kurt Vise.

The DJ6 gripper jaws with built-in 45° dovetails are the perfect accessory for your 6" machine vise. Jaws are heat treated and precision ground for superior repeatability and longevity. The jaws are 55 HRC, TiN coated and feature a 25mm step depth.



Anti-Lift Jaws

AL75A - Anti-Lift Aluminum Machinable Jaws, Starter Set. Includes steel cleats, aluminum machinable jaws, and brackets. (Compatible with V75100, V75100X, V75150X)

AL75-2A - Set of 2, Replacement Anti-Lift Machinable Aluminum Jaws. (Compatible with V75100, V75100X, V75150X)

AL75S - Anti-Lift Steel Machinable Jaws, Starter Set. Includes steel cleats, steel machinable jaws, and brackets. (Compatible with V75100, V75100X, V75150X)

AL75-2S - Set of 2, Replacement Anti-Lift Machinable Jaws, Steel. (Compatible with V75100, V75100X, V75150X)

AL52A - Anti-Lift Aluminum Machinable Jaws, Starter Set. Includes steel cleats, aluminum machinable jaws, and brackets. (Compatible with V552 / V562 / V552M / V562M / V510M)

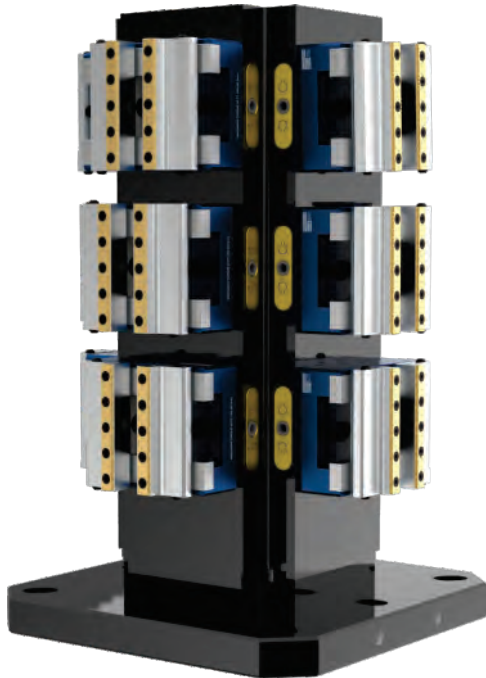
AL52-2A - Set of 2, Replacement Anti-Lift Machinable Aluminum Jaws. (Compatible with V552 / V562 / V552M / V562M / V510M)

AL52-2S - Set of 2, Replacement Anti-Lift Machinable Jaws, Steel. (Compatible with V552 / V562 / V552M / V562M / V510M)

Our Anti-Lift Jaws use a cleat and angled soft jaw to pull the jaw in and down when torque is applied to the lead screw. This design decreases jaw lift and jaw deflection commonly seen in self-centering vises.



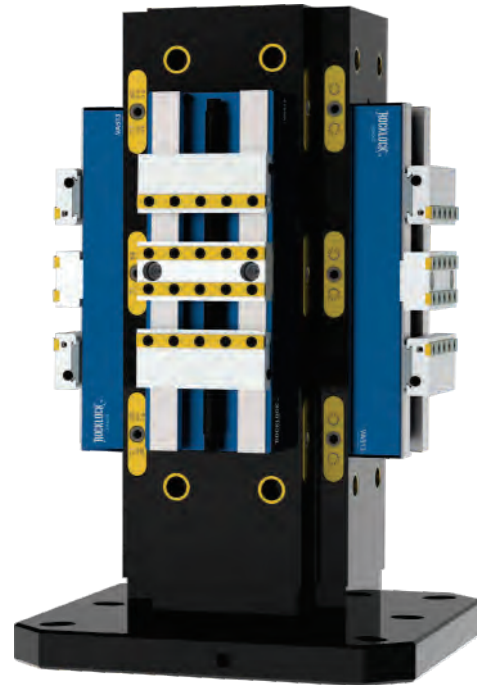
RockLock Examples



400mm Tombstone configuration

Part number shown: RL96A-4004U

Qty. 12: VA56 vises with optional jaws



400mm Tombstone configuration

Part number shown: RL96A-4004U

Qty. 4: VA513 vises with optional jaws



R96-V75XT4 Tombstone configuration

Part number shown: R96-V75XT4 with 4X DV75150X

200mm tall mini tombstone designed to work with smaller 4 and 5 Axis machines.



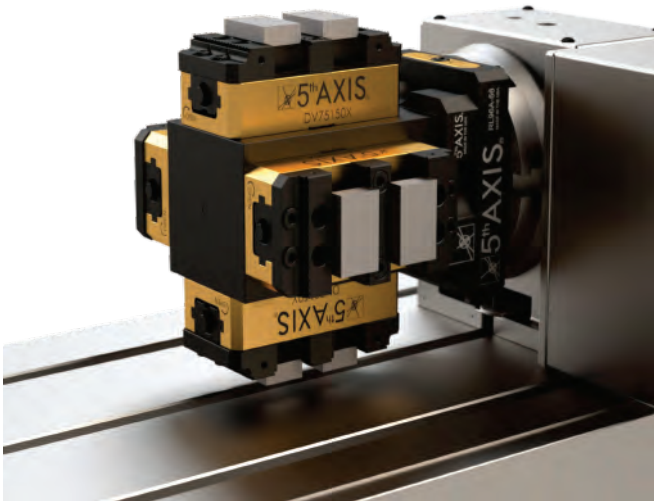
R96-V75100T4 Tombstone configuration

Part number shown: R96-V75100T4 with 8X V75100X

266mm tall mini tombstone designed to work with smaller 4 and 5 Axis machines.

RockLock Examples

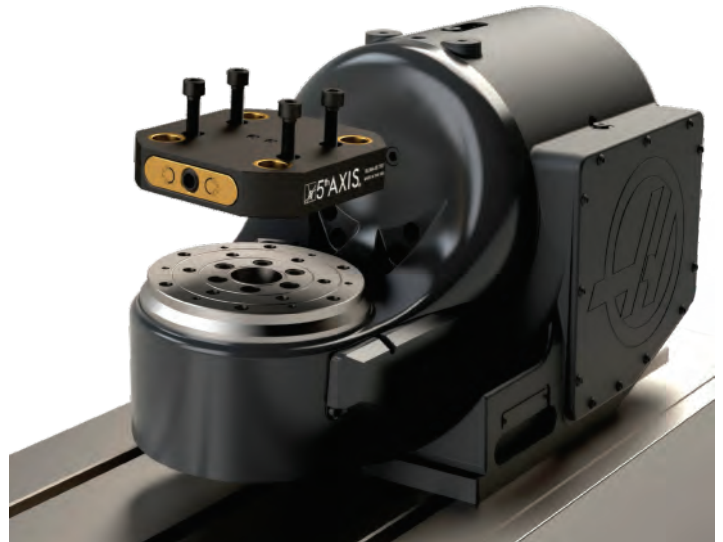
RockLock



4th Axis tombstone config-

Part number shown: R96-V75XT4 with 4x DV75150X + RL96A-56 adapter

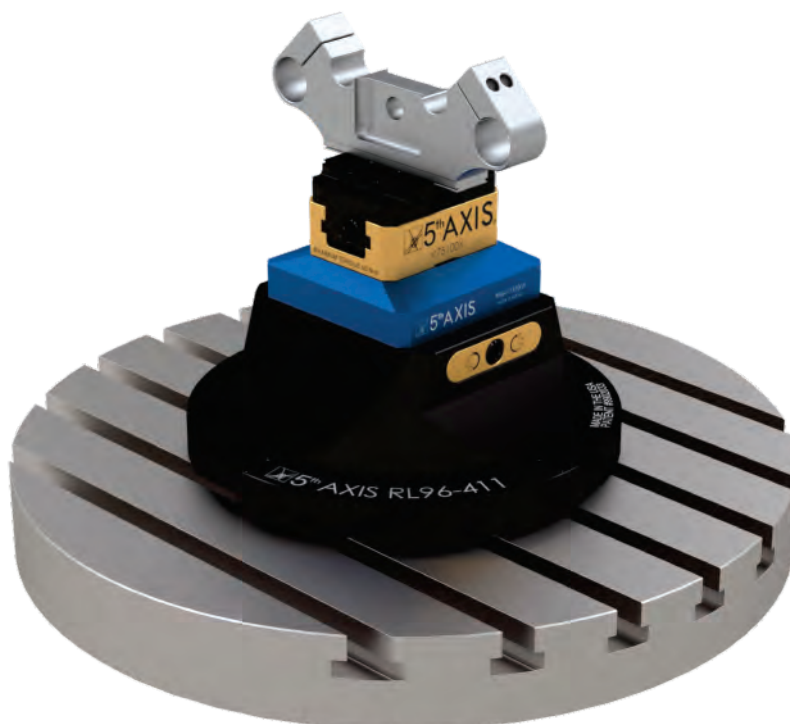
Turn your vertical with a rotary into a mini horizontal. Produce 8 times more parts on your rotary table.



Haas TRT160 configuration

Part number shown: RL96A-60100

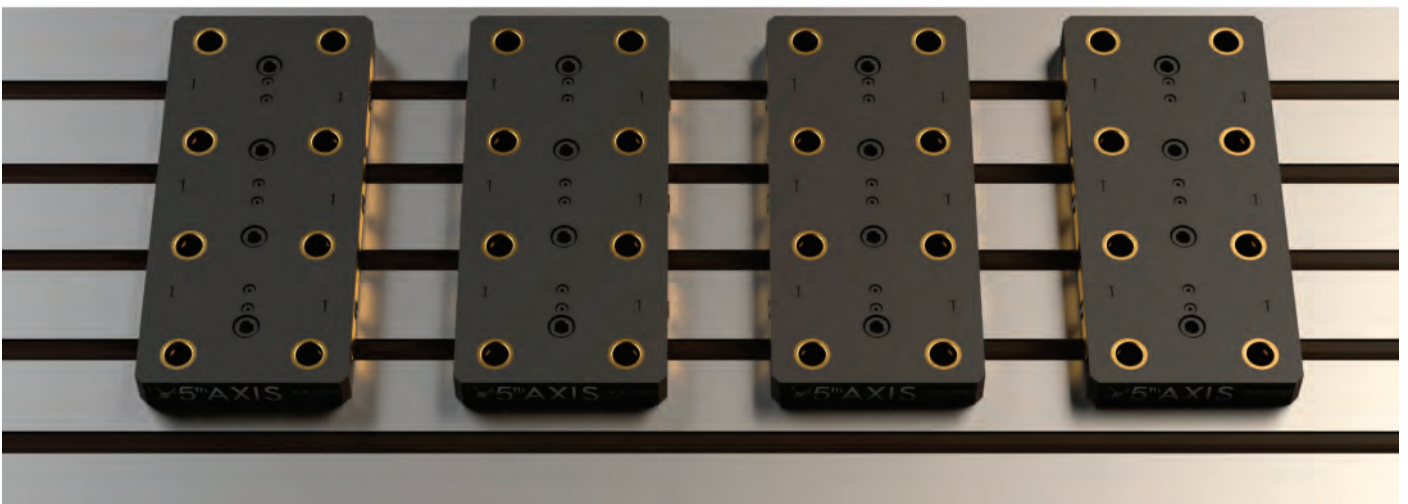
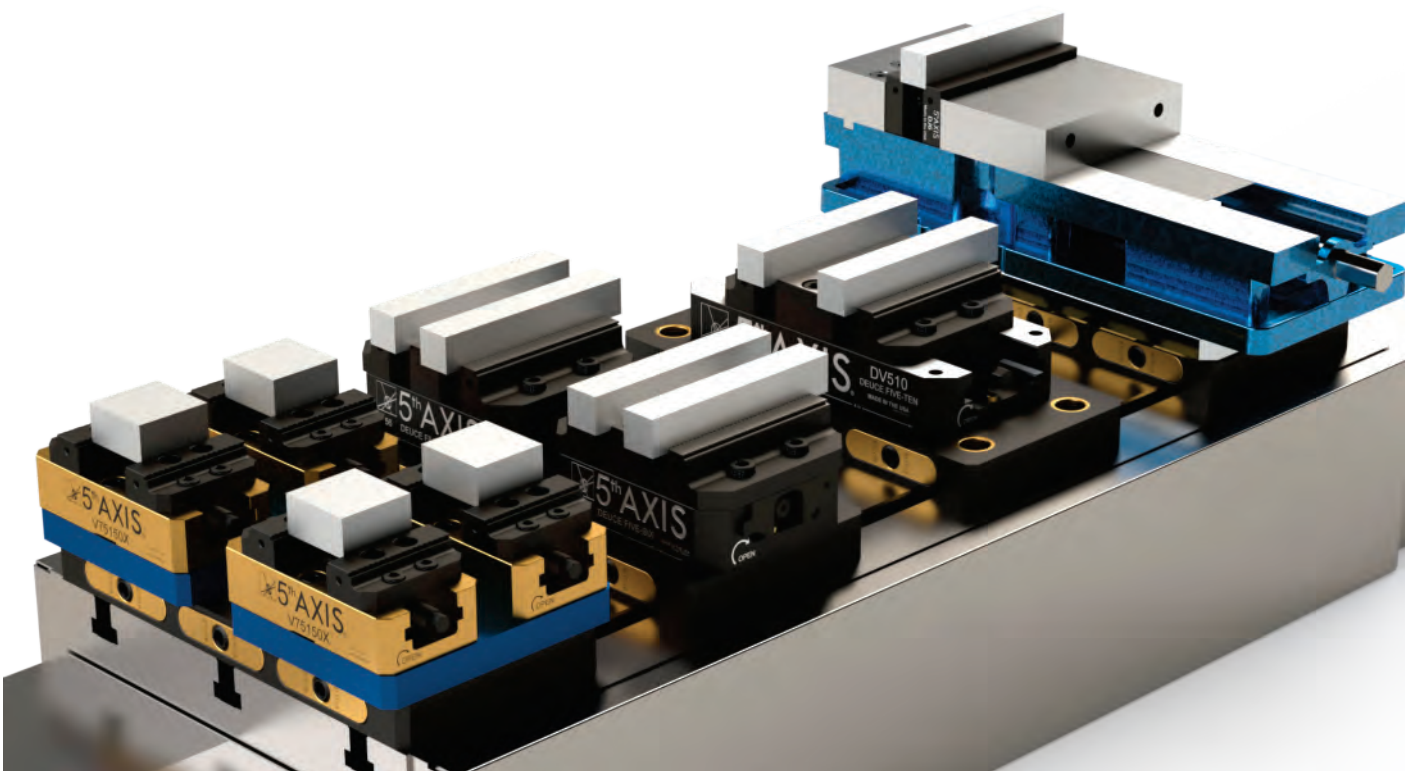
New 4 bolt 96mm RockLock adapter. Designed for the new style Haas TRT160 rotary.

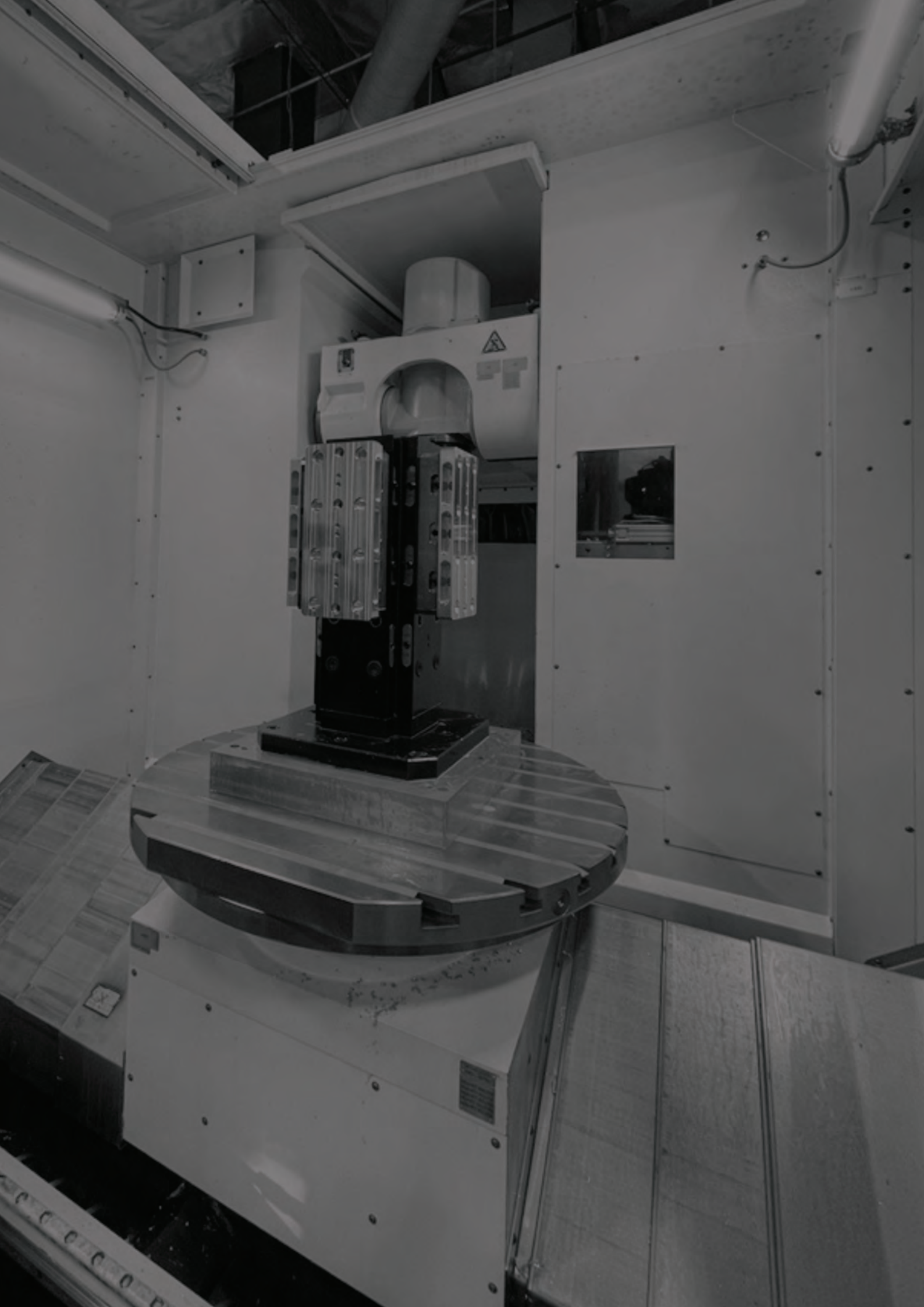


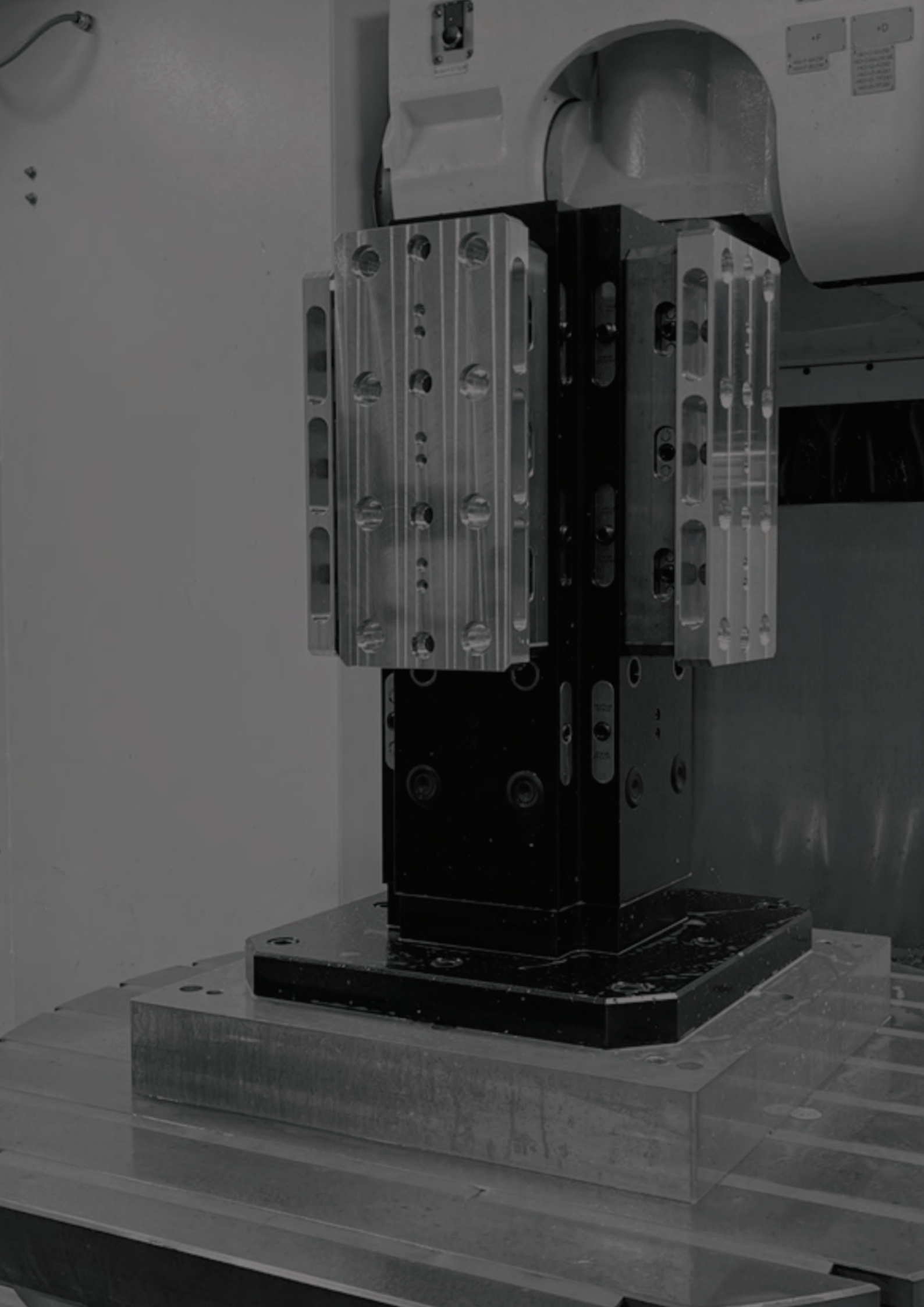
BUILT FOR 3 AXIS

Simplify Programming

Reduce Changeover Time









ROCKLOCK™

QUICK CHANGE SYSTEM



Made in USA



7140 Engineer Rd.
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