

PATENTED
216009
M266131

WISE IN ROW

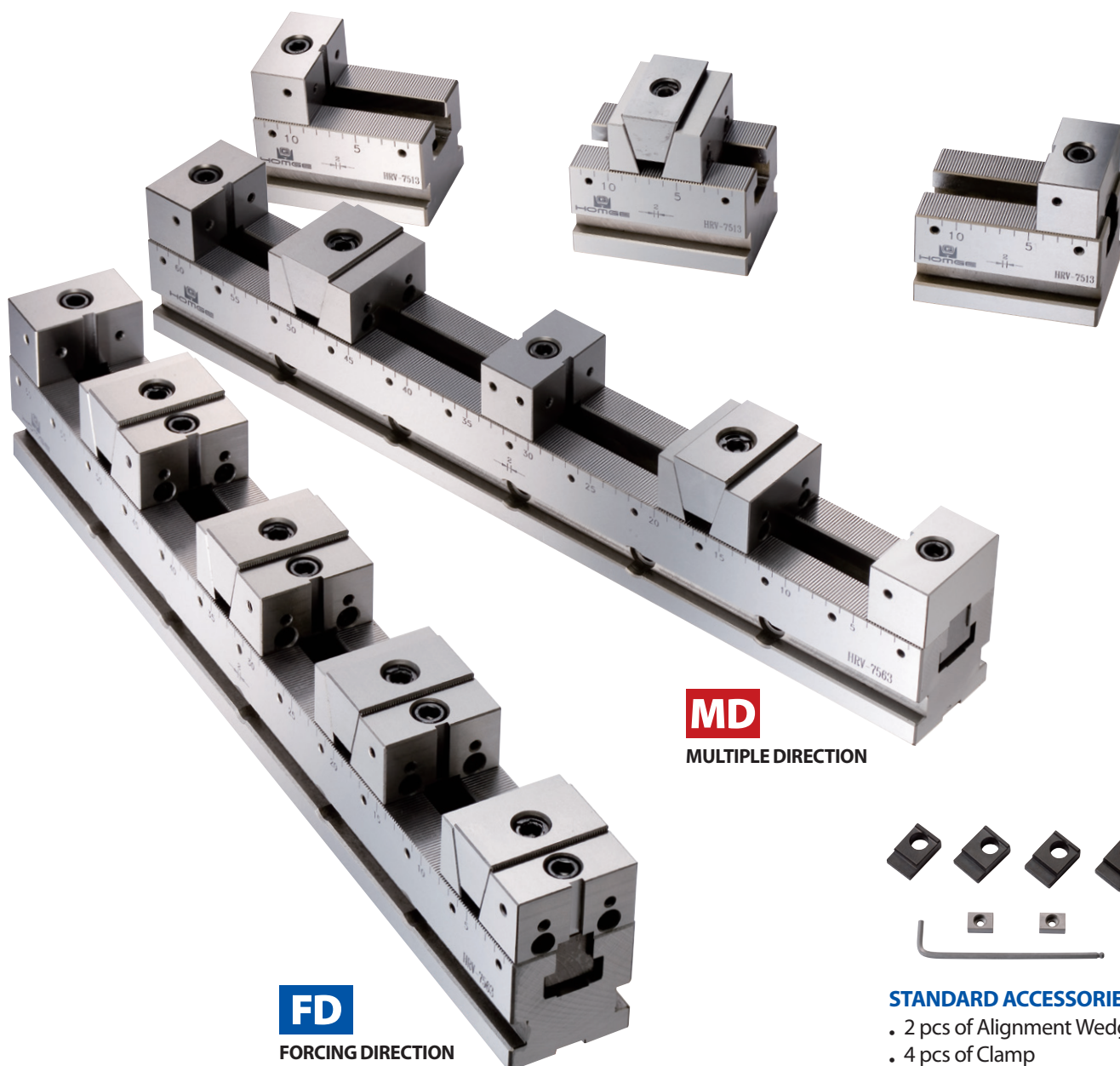
Model: HRV-50, 75, 100

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

Saves cost.

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

This vise is suitable for horizontal, vertical and 4-Axis CNC Machining Centers and Surface Grinder, ...etc.



MD

MULTIPLE DIRECTION

FD

FORCING DIRECTION

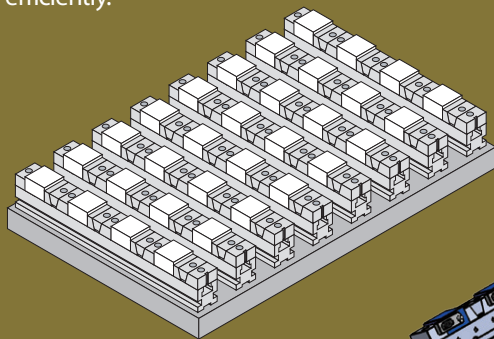


STANDARD ACCESSORIES:

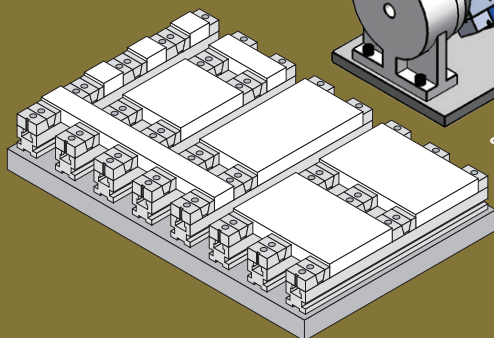
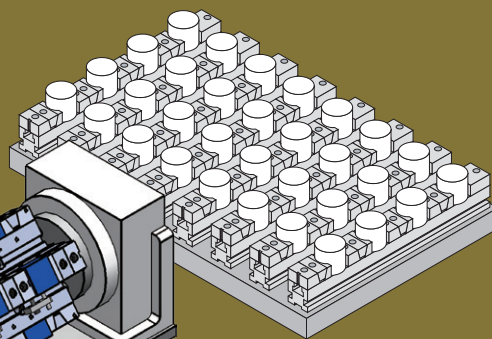
- 2 pcs of Alignment Wedge
- 4 pcs of Clamp
- 1 pc of Wrench

CLAMPING EXAMPLE

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

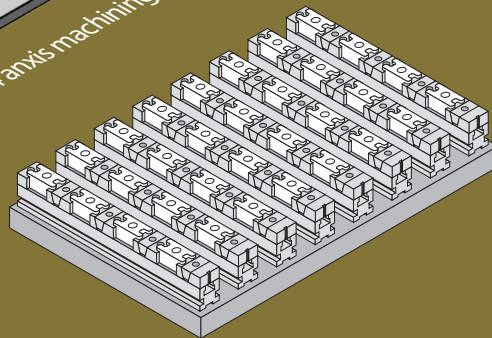


Cylindrical working pieces can be easily clamped by using optional accessory (V Jaw).

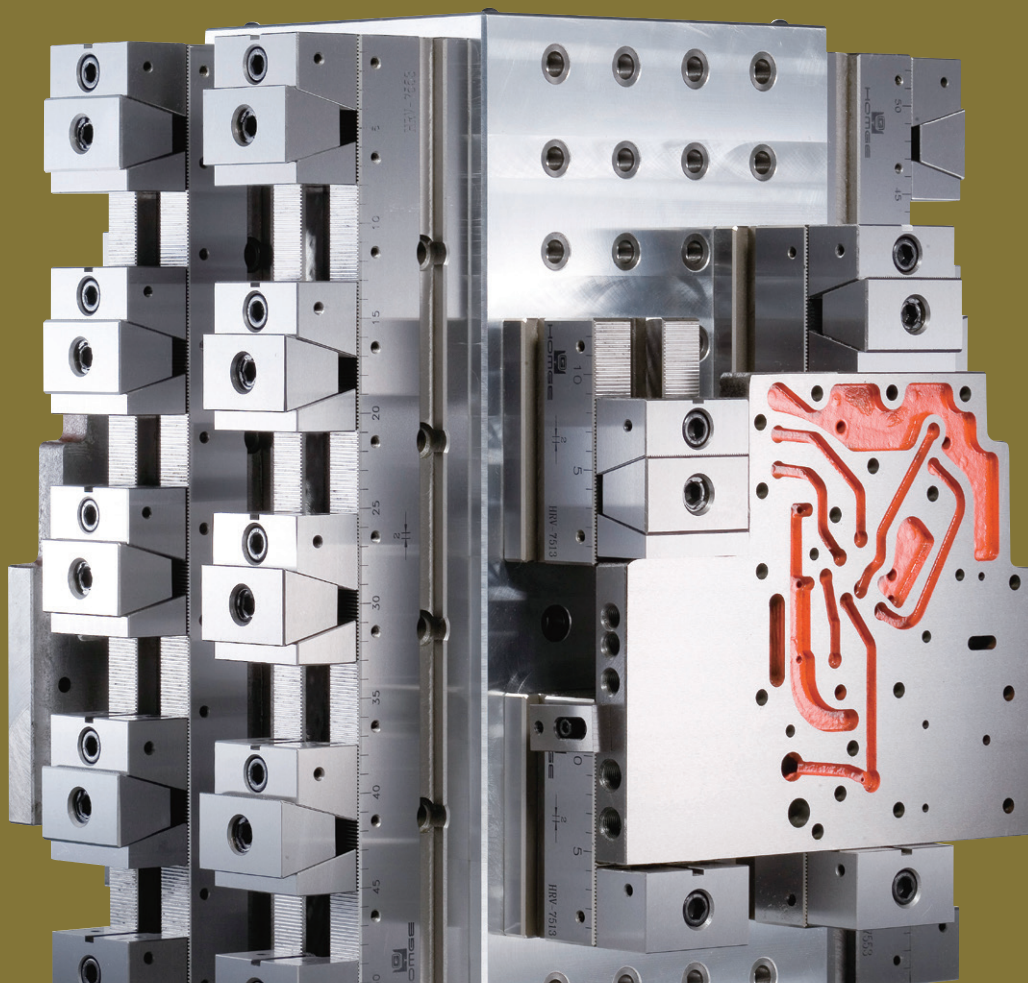


One or couple larger working pieces can be clamped flexibly at the same time.

Suitable for 4 axis machining centers.

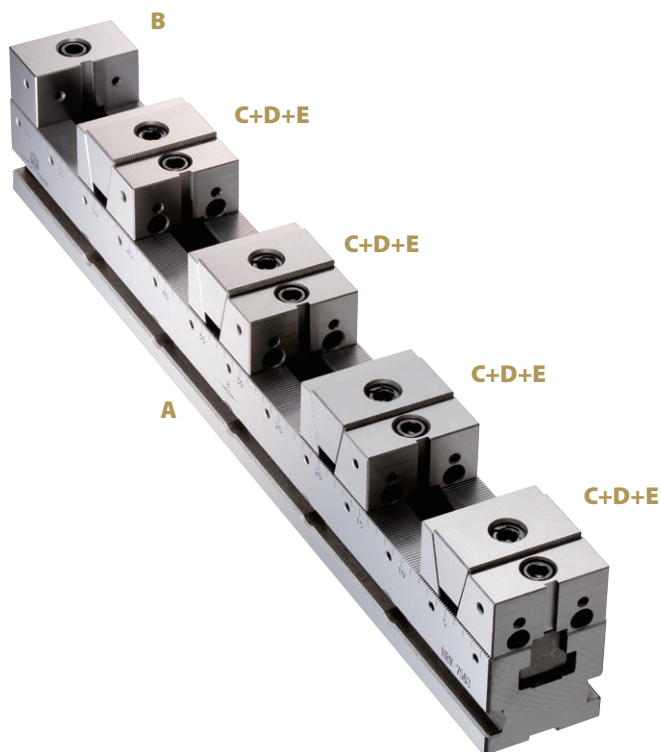


Irregular shape of working pieces can be clamped by using optional jaw (Soft Jaw) which can be special tailored to meet the clamping requirement of the working pieces.



FD FORCING DIRECTION

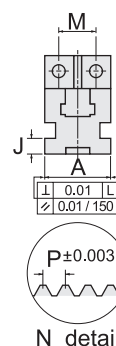
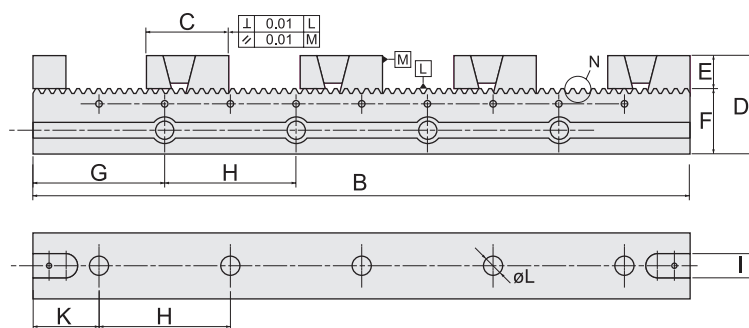
Model: HRV-50, 75, 100 (FD)



STANDARD ACCESSORIES:

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

DIMENSIONS



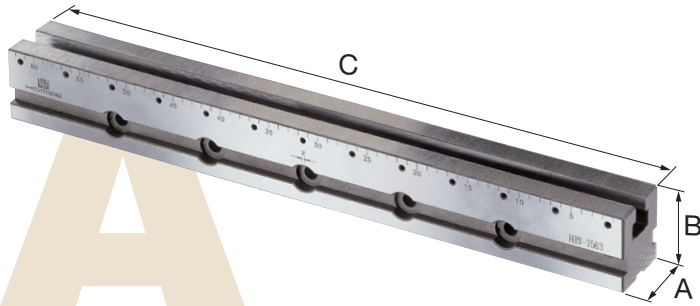
N detail

SPECIFICATIONS (Material: Tool Steel. Hardness: HRC 56°~60°)

Unit: mm

Model	A	B	C	D	E	F	G	H	I	J	K	L	M	P	Weight (kg)
HRV-5030-FD	50	300	66	75	25	50 ±0.01	70	80/100	18	10	30	14	24	1.5	7
HRV-5040-FD		400					80				40				9
HRV-5050-FD		500					90				50				10
HRV-5060-FD		600					100				60				11
HRV-5070-FD		700					110				70				12
HRV-7543-FD	75	430	84	115	40	75 ±0.01	115	100	18	17	65	14	40	2	20
HRV-7553-FD		530					115				65				25.5
HRV-7563-FD		630					115				65				31
HRV-7573-FD		730					65				115				33.5
HRV-10055-FD	100	550	106	125	50	75 ±0.01	75	100	18	17	125	14	60	2.5	40
HRV-10065-FD		650					125				75				51
HRV-10075-FD		750					125				75				55

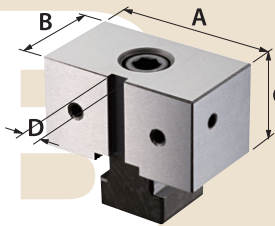
Forcing Direction Assembled Parts:



MAIN BODY

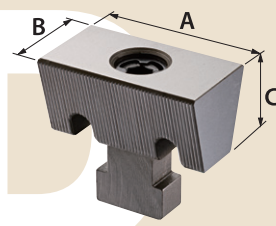
Unit: mm

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



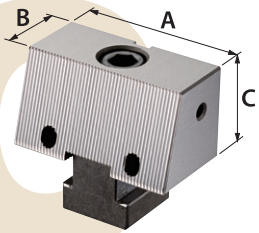
FIXED MOUTHPIECE SET

Model	A	B	C	D
HRV-50B	48	35	25	8
HRV-75B	73	42	40	8
HRV-100B	98	60	50	8



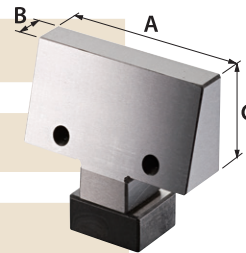
WEDGE SET

Model	A	B	C
HRV-50D	48	26	21
HRV-75D	72	42	36
HRV-100D	98	50	45



SINGLE BEVEL FIXED MOUTHPIECE SET

Model	A	B	C
HRV-50C	48	27	25
HRV-75C	72	30	40
HRV-100C	98	35	50



SINGLE BEVEL MOVEABLE MOUTHPIECE SET

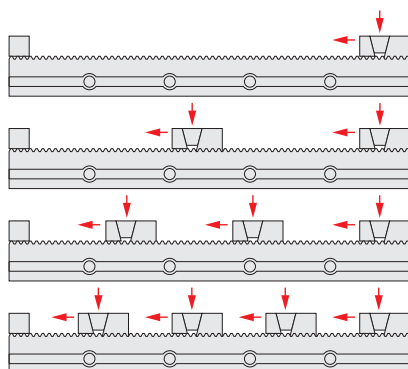
Model	A	B	C
HRV-50E	48	13	25
HRV-75E	73	12	40
HRV-100E	98	21	50

*** Note ***

HRV-5030-FD / HRV-7543-FD / HRV-10055-FD
Can clamp 3 workpieces only

FORCING DIRECTION

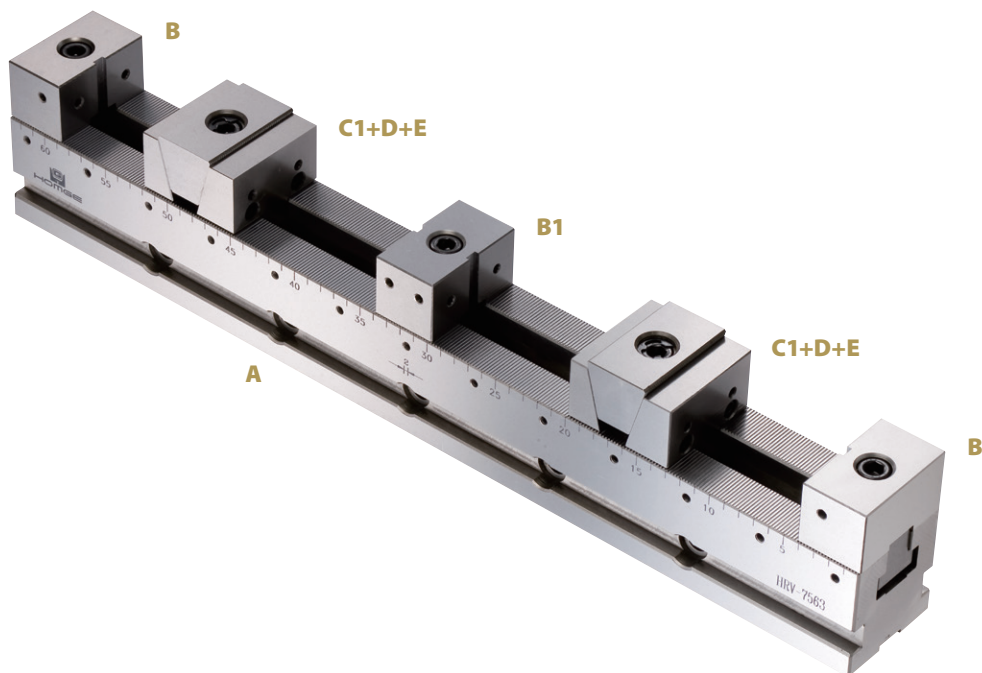
Maximum range of the working pieces to be clamped



Model				
HRV-5030-FD	199	66	22	—
HRV-5040-FD	299	116	55	25
HRV-5050-FD	399	166	89	50
HRV-5060-FD	499	216	122	75
HRV-5070-FD	599	266	155	100
HRV-7543-FD	304	110	45	—
HRV-7553-FD	404	160	78	36
HRV-7563-FD	504	210	112	60
HRV-7573-FD	604	260	145	88
HRV-10055-FD	384	139	57	—
HRV-10065-FD	484	189	91	41
HRV-10075-FD	584	239	124	66

MD MULTIPLE DIRECTION

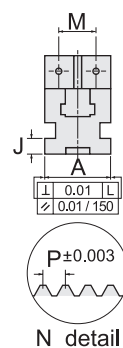
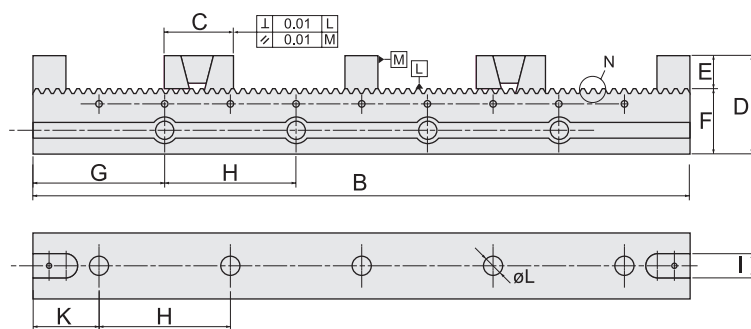
Model: HRV-50, 75, 100 (MD)



STANDARD ACCESSORIES:

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

DIMENSIONS

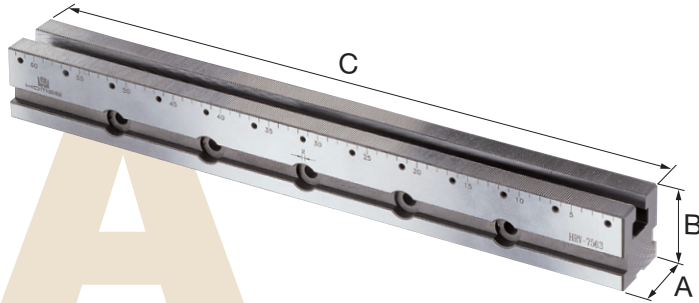


SPECIFICATIONS (Material: Tool steel. Hardness: HRC 56°~60°)

Unit: mm

Model	A	B	C	D	E	F	G	H	I	J	K	L	M	P	Weight (kg)
HRV-5030-MD	50	300	59	75	25	50 ±0.01	70	80/100	18	10	30	14	24	1.5	5.3
HRV-5040-MD		400					80				40				6.1
HRV-5050-MD		500					90				50				7.1
HRV-5060-MD		600					100				60				8.1
HRV-5070-MD		700					110				70				9.1
HRV-7543-MD	75	430	73	115	40	75 ±0.01	115	100	18	17	65	14	40	2	21
HRV-7553-MD		530					115				65				23.3
HRV-7563-MD		630					115				65				26.3
HRV-7573-MD		730					65				115				29.3
HRV-10055-MD	100	550	99	125	50	75 ±0.01	75	100	18	17	125	14	60	2.5	40
HRV-10065-MD		650					125				75				44.6
HRV-10075-MD		750					125				75				49.6

Multiple Direction Assembled Parts:

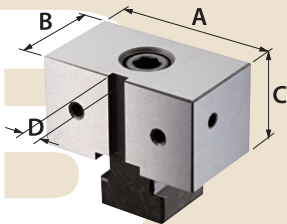


MAIN BODY

Unit: mm

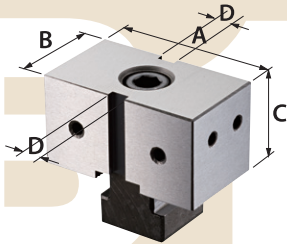
Model	A	B	C
HRV-50A30	50	50	300
HRV-50A40	50	50	400
HRV-50A50	50	50	500
HRV-50A60	50	50	600
HRV-50A70	50	50	700
HRV-75A43	75	75	430
HRV-75A53	75	75	530
HRV-75A63	75	75	630
HRV-75A73	75	75	730
HRV-100A55	100	75	550
HRV-100A65	100	75	650
HRV-100A75	100	75	750

FIXED MOUTHPIECE SET



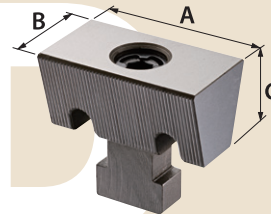
Model	A	B	C	D
HRV-50B	48	35	25	8
HRV-75B	73	42	40	8
HRV-100B	98	60	50	8

FIXED MOUTHPIECE SET



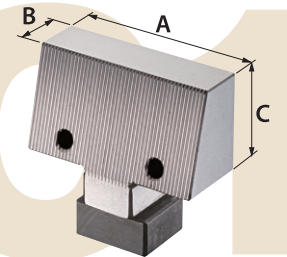
Model	A	B	C	D
HRV-50B1	48	35	25	8
HRV-75B1	73	42	40	8
HRV-100B1	98	60	50	8

WEDGE SET



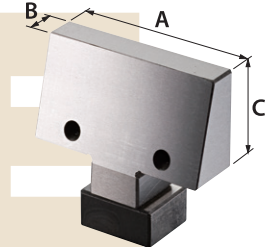
Model	A	B	C
HRV-50D	48	26	21
HRV-75D	72	42	36
HRV-100D	98	50	45

SINGLE BEVEL FIXED MOUTHPIECE SET



Model	A	B	C
HRV-50C1	48	20	25
HRV-75C1	72	19	40
HRV-100C1	98	28	50

SINGLE BEVEL MOVEABLE MOUTHPIECE SET



Model	A	B	C
HRV-50E	48	13	25
HRV-75E	73	12	40
HRV-100E	98	21	50

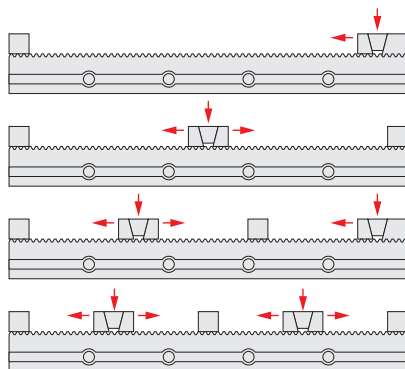
*** Note ***

HRV-5030-MD

Can clamp 3 workpieces only

MULTIPLE DIRECTION

Maximum range of the working pieces to be clamped

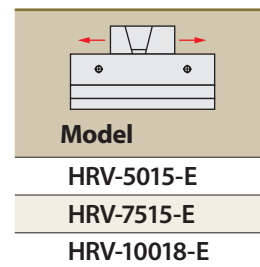
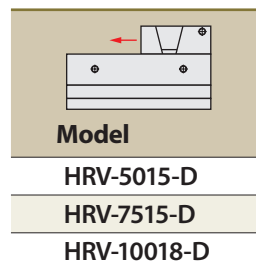
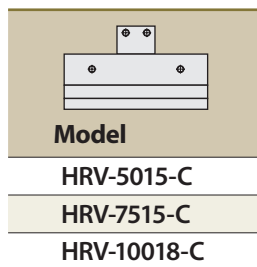
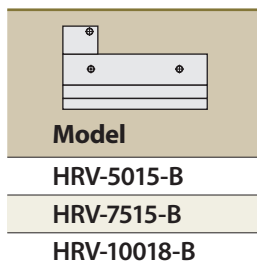
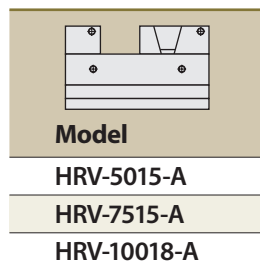


Model				
HRV-5030-MD	199	85	35	—
HRV-5040-MD	299	135	68	44
HRV-5050-MD	399	185	101	69
HRV-5060-MD	499	235	134	94
HRV-5070-MD	599	285	167	119
HRV-7543-MD	304	136	62	39
HRV-7553-MD	404	186	95	64
HRV-7563-MD	504	236	128	89
HRV-7573-MD	604	286	161	114
HRV-10055-MD	384	165	75	43
HRV-10065-MD	484	215	108	68
HRV-10075-MD	584	265	141	93

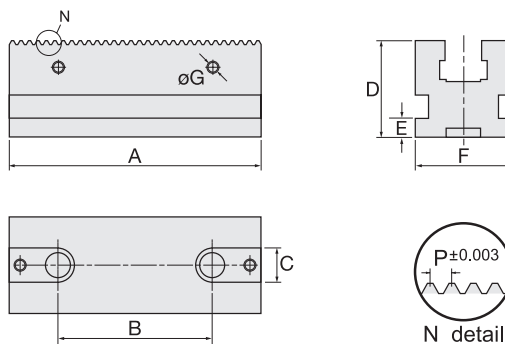
HRV ADJUSTABLE VERSIONS

Various combinations for Multiple usages

Model: HRV-5015 (A,B,C,D,E)
 HRV-7515 (A,B,C,D,E)
 HRV-10018 (A,B,C,D,E)



DIMENSIONS



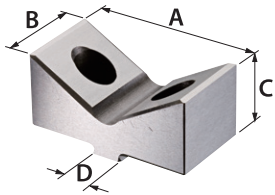
SPECIFICATIONS (Material: Tool Steel. Hardness: HRC 56°~60°)

Unit: mm

Model	A	B	C	D	E	F	G	P	Weight (kg)
HRV-5015	150	100	18	50±0.01	10	50	M6	1.5	2
HRV-7515	150	100	18	75±0.01	17	75	M6	2	4
HRV-10018	180	100	18	75±0.01	17	100	M6	2.5	7

OPTIONAL ACCESSORIES:

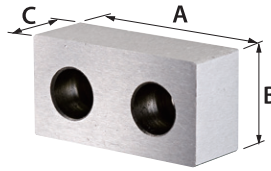
V JAW (For Fixed jaw)



Unit: mm

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

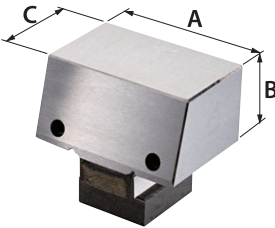
FIXED SOFT JAW (For moveable jaw)



Unit: mm

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

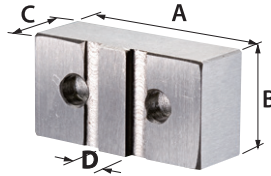
MOVEABLE SOFT JAW



Unit: mm

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

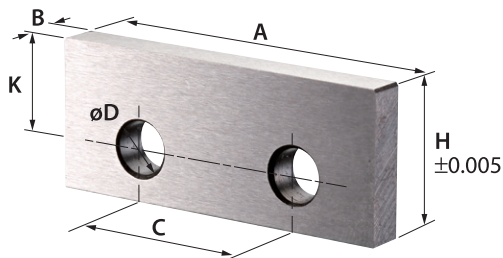
FIXED SOFT JAW (For Fixed jaw)



Unit: mm

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

SUPPORTING BLOCK

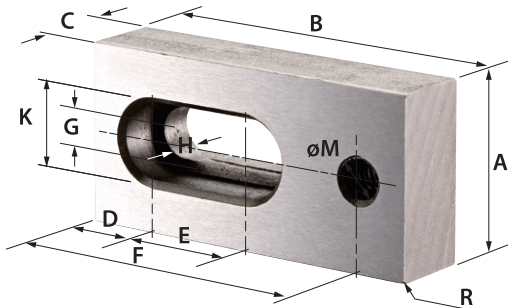


Unit: mm

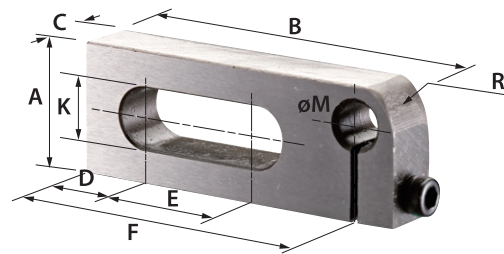
Model	A	B	C	D	H	K
SB-50A	47.5	3	24	7	17	13
SB-50B		5			20	
SB-50C		5			22	
SB-75A	72	3	40	7	25	20
SB-75B		5			30	
SB-75C		5			35	
SB-75D		5			37	
SB-100A	97.5	5	60	7	35	25
SB-100B		5			40	
SB-100C		5			45	
SB-100D		5			47	

DATUM PLATE (For HRV-50, 75, 100)

Model: DP-A



Model: DP-B



Unit: mm

Model	A	B	C	D	E	F	G	H	K	M	R
DP-A	25	50	12	10	15	43	6.5	7	11	M6	1
DP-B	19	50	9	10	15	43	—	—	8	M6	5