

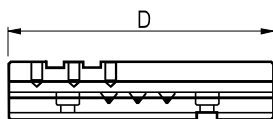
## ELEMENTI MODULARI BASE / Supplemento extra per ogni foro calibrato + € 76

### BASIC MODULAR UNITS / Extra supplement for each ground hole + € 76

Tipo (grandezza) morsa / Vise (type) size

#### Art. 44

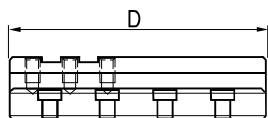
Slittone base per ganascia fissa  
Split base for fixed jaw



|      | 1          | 2          | 3          | 4          | 5          | 6          |
|------|------------|------------|------------|------------|------------|------------|
| D    | 140        | 160        | 230        | 240        | 300        | 350        |
| kg   | 1.8        | 3.3        | 6.9        | 8          | 14.5       | 21.8       |
| Cod. | 1.80.14140 | 1.80.24160 | 1.80.34230 | 1.80.44250 | 1.80.54300 | 1.80.64351 |

#### Art. 44A

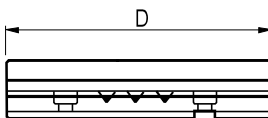
Slittone base a reticolo (Passo 50 mm, Ø 16 per blocco fisso)  
Split grid (50 mm) pitch, Ø 16 base for fixed section



|      | 1          | 2          | 3          | 4          | 5          | 6          |
|------|------------|------------|------------|------------|------------|------------|
| D    | 140        | 160        | 230        | 240        | 300        | 350        |
| kg   | 1.7        | 3.2        | 6.8        | 7.9        | 14.4       | 21.7       |
| Cod. | 3.44.A1000 | 3.44.A2000 | 3.44.A3000 | 3.44.A4000 | 3.44.A5000 | 3.44.A6000 |

#### Art. 51

Elemento di prolunga base  
per ganascia mobile  
Base extension for  
movable jaw



|      | 1          | 2          | 3          | 4          | 5          | 6          |
|------|------------|------------|------------|------------|------------|------------|
| D    | 140        | 160        | 230        | 240        | 300        | 350        |
| kg   | 2.1        | 3.4        | 8.2        | 11.5       | 20         | 30         |
| Cod. | 1.80.13140 | 1.80.23160 | 1.80.33230 | 1.80.43250 | 1.80.53300 | 1.80.63350 |

#### Art. 51A

Elemento di prolunga base a reticolo (Passo 50 mm, Ø 16)  
Grid (50 mm) pitch, Ø 16 base extension

|      | 1          | 2          | 3          | 4          | 5          | 6          |
|------|------------|------------|------------|------------|------------|------------|
| Cod. | 3.51.A1000 | 3.51.A2000 | 3.51.A3000 | 3.51.A4000 | 3.51.A5000 | 3.51.A6000 |

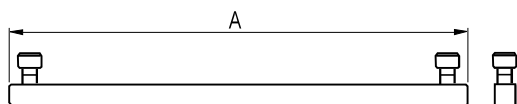
## ACCESSORI

### ACCESSORIES

Tipo (grandezza) morsa / Vise (type) size

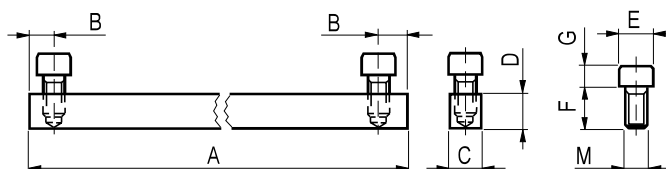
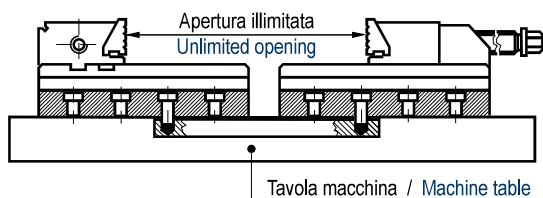
#### Art. 358

Barra di tensione / Tension bar



Accessori per Art. 51 e 102  
A richiesta altre larghezze senza variazione di prezzo  
Accessories for Art. 51 and 102  
Other widths available on request without price change

|      | 1          | 2          | 3          | 4          | 5          | 6          |
|------|------------|------------|------------|------------|------------|------------|
| A    | 320        | 320        | 400        | 400        | 500        | 500        |
| B    | 11         | 11         | 18         | 18         | 20         | 20         |
| C    | 10         | 10         | 15         | 15         | 20         | 20         |
| D    | 20         | 20         | 25         | 25         | 25         | 25         |
| M    | M6         | M8         | M12        | M12        | M16        | M16        |
| E    | 9          | 12         | 18         | 18         | 24         | 24         |
| F    | 15         | 15         | 20         | 20         | 30         | 30         |
| G    | 6          | 8          | 12         | 12         | 16         | 16         |
| kg   | 0.5        | 0.5        | 1.2        | 1.2        | 2          | 2          |
| Cod. | 3.35.81000 | 3.35.82000 | 3.35.83000 | 3.35.84000 | 3.35.85000 | 3.35.86000 |



# ELEMENTI MODULARI MODULAR ELEMENTS

Pagg. 3.2 - 3.14

Le morse **Gerardi** sono ormai considerate sinonimo di produzione ad alto livello tecnologico per l'accurata scelta dei materiali impiegati e per la precisione raggiunta anche nei minimi particolari.

**Accuratamente rettificate** in ogni loro particolare ed ampiamente collaudate, consentono:

- ✓ una capacità di **massimo rendimento** della macchina,
- ✓ un **forte carico di pressione**,
- ✓ una **maggior potenza di taglio**,
- ✓ **esclusione totale di vibrazioni**,
- ✓ **minor usura dell'utensile**
- ✓ una **più precisa lavorazione**.

La costruzione con un sistema di elementi componibili consente le più svariate possibilità di impiego e combinazioni in caso di necessità.

**Gerardi** vises are manufactured under rigid quality control. Only the most suitable materials are used, and the accuracy of even the smallest components is assured. As a result of the high standard construction Gerardi vises can maintain their accuracy under the most severe operating conditions.

**Hardened and Ground steel construction throughout allowing you maximum machine performance with:**

- ✓ **bigger clamping power**,
- ✓ **bigger cutting performances**,
- ✓ **total exclusion of vibrations**,
- ✓ **lower tool wear**;
- ✓ **higher precision during machinework**.

The modular design and the concept of interchangeability makes possible a wide variety of set up combination and solutions.

## RAPIDITA' DEI SERRAGGI

Grazie allo **scorrimento del gruppo di serraggio** nella guida della base (a cremagliera) fino in prossimità del pezzo da lavorare dove si adatterà automaticamente alla nicchia più vicina. L'operazione di serraggio si conclude agendo sulla vite di bloccaggio. Naturalmente anche con gli elementi modulari sono disponibili **4 ulteriori sistemi di serraggio** intercambiabili e indipendenti oltre a quello manuale meccanico illustrato nella foto:

- 1- Idraulici
- 2- Pneumatici
- 3- Idraulici manuali
- 4- Idraulici elettrici.

L'operazione è in termini di secondi.

## QUICK CLAMPING

Thanks to the **clamping device sliding in the vise base slide** (compact rack type) till the proximity of the workpiece. The clamping is completed with the main screw. Besides the manual mechanic system, **4 further interchangeable and independent clamping systems** are available:

- 1- Hydraulic
- 2- Pneumatic
- 3- Manual hydraulic
- 4- Electrical hydraulic.

The change needs only few seconds.

**Art. 102**

Gli **elementi modulari Gerardi** Vi permettono di ottimizzare i bloccaggi di pezzi particolarmente grandi, che richiedano le lavorazioni più gravose, sfruttando anche il piano della tavola della macchina come punto di appoggio.

Gli elementi modulari sono sicuramente l'esempio (vedere applicazioni alle pag. seg.) più lampante dell'estrema versatilità del **Sistema Modulare Gerardi**.

La disponibilità di una vastissima gamma di composizioni (modulari) permette di realizzare con soluzioni standard anche gli allestimenti che credevate speciali.

**Gerardi modular elements** allow You perfect clamping even of big workpieces which need the heaviest machining using the machine table as surface.

Modular elements are the best example of the extreme versatility of the **Gerardi Modular System**.

The availability of the broadest assortment program allows to build with standard solutions even the fixtures You thought special.

They are a solution for a lot of applications and, with the many reference points available, a perfect **complement or alternative to single or double vises**



**Gli Elementi Modulari altro non sono che delle morse STD sezionate in modo da ottenere la parte mobile e la parte fissa completamente indipendenti per una versatilità estrema**

**MODULAR ELEMENTS are simply standard vises sections, the movable section and the fixed one, which in this way result completely independent for an extreme versatility**

## CARATTERISTICHE E VANTAGGI

- USURA INESISTENTE
- RAPIDITA' DEI SERRAGGI
- MODULARITA' & VERSATILITA'
- PRECISIONI  $\pm 0,02$  mm
- RIGIDITA' & SICUREZZA
- DESIGN COMPATTO E MANEGGEVOLEZZA

*Si rimanda a quanto esposto a pag. 1.2 e 2.3 (morse serie STANDARD)*

## TECHNICAL FEATURES AND ADVANTAGES

- NO WEAR
- QUICK CLAMPING
- MODULARITY & VERSATILITY
- HIGHEST ACCURACIES  $\pm 0,02$  mm
- RIGIDITY & SAFETY
- SPACE SAVING DESIGN & HANDY

*See pag. 1.2 and 1.3 (STANDARD series vises)*

**Art. 104**

Le ganasce fisse hanno la possibilità di essere posizionate sia con piastrine all'interno della base (come nelle foto), sia con piastrine che fuoriescono dalla base in modo da poter serrare anche particolari posizionati sul piano della tavola della macchina

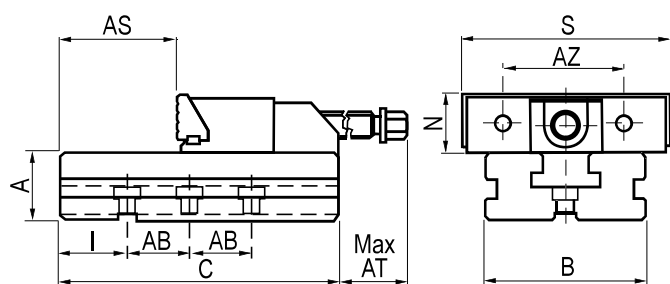
Fixed jaws have the possibility to be positioned both with jaw plates inside the vise base (as shown in the picture) and with jaw plates externally from the vise base in order to be able to clamp even workpieces positioned on the machine table directly

**Art. 103**

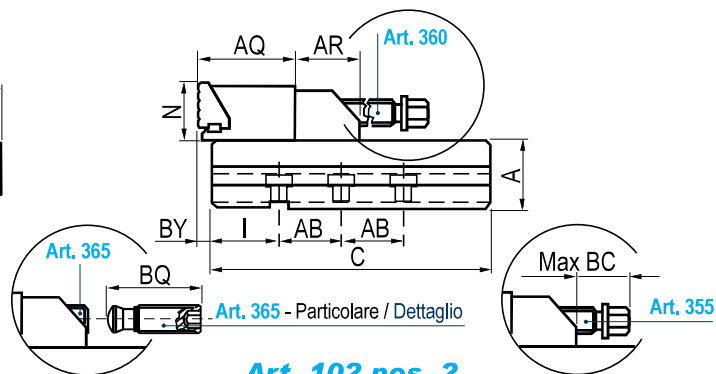
Slittone base (per Art. 103 e 104) o elemento di prolunga (per Art. 102) sempre previsti con chiavette di posizionamento longitudinali e trasversali per allineamento agli assi della macchina. Inoltre per le ganasce fisse sono sempre previsti 2 differenti posizionamenti per permettere alle stesse anche la possibilità di serrare pezzi direttamente appoggiati sul piano / tavola della macchina (vedi immagini a pag. 3.4, 3.5).

Vise bases (for Art. 102 and 104) or base extensions (for Art. 102) are always built with longitudinal and cross keyways in order to be aligned with the machine axis. Furthermore fixed jaws have always 2 different positions in order to be able to clamp even workpieces positioned on the machine table directly (see images on pages 3.4, 3.5).

## Art. 102

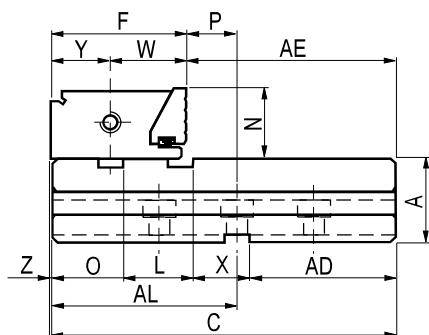


**Art. 102 pos. 1**

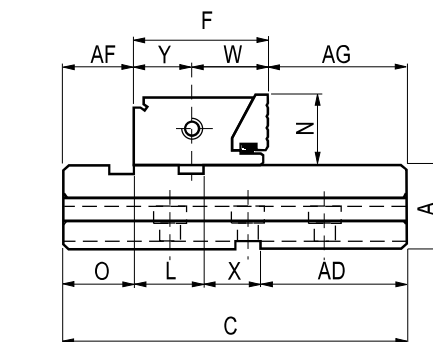


**Art. 102 pos. 2**

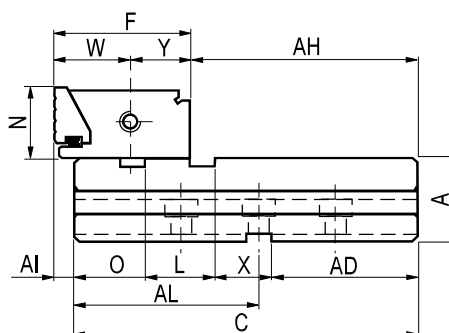
## Art. 103



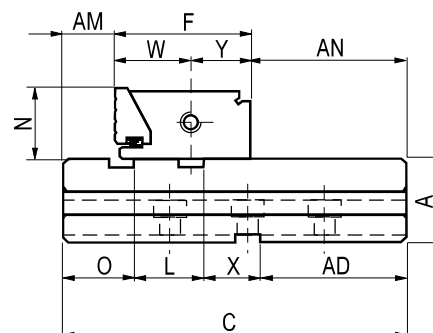
**Art. 103 pos. 1**



**Art. 103 pos. 2**

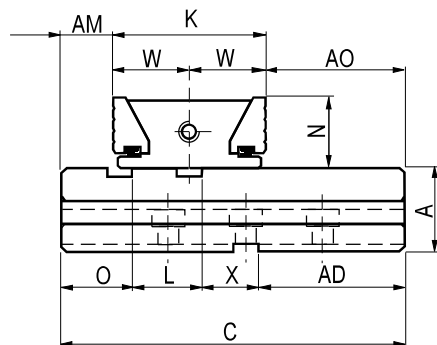


**Art. 103 pos. 3**

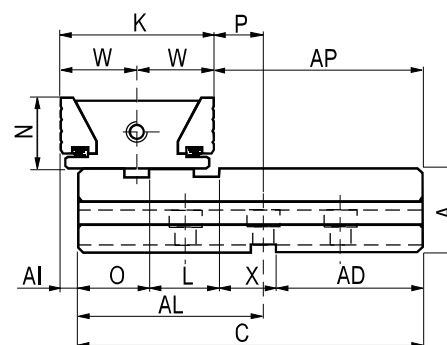


**Art. 103 pos. 4**

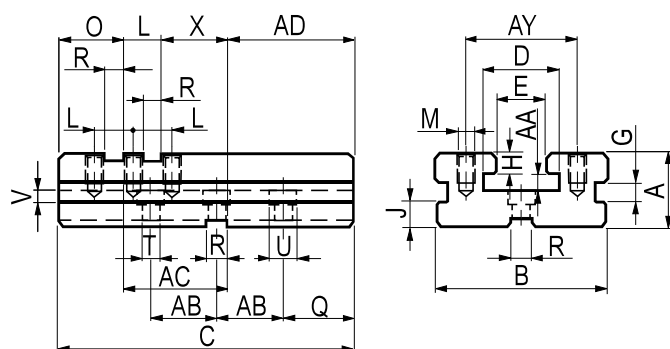
## Art. 104



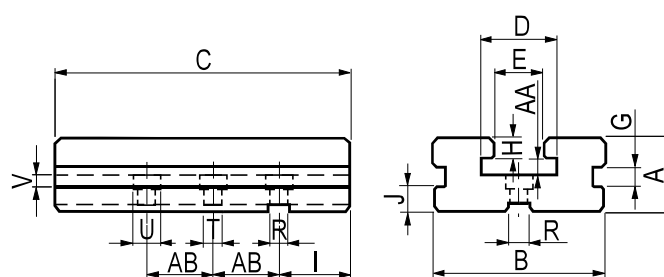
**Art. 104 pos. 1**



**Art. 104 pos. 2**

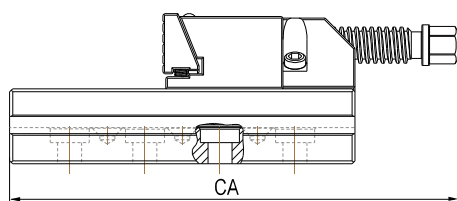


**Art. 44**



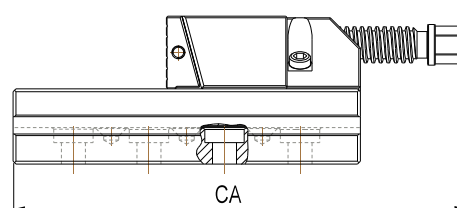
**Art. 51**

## Art. 102A



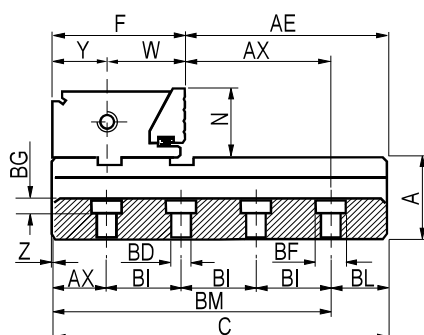
Art. 102A pos. 1

## Art. 102Ai

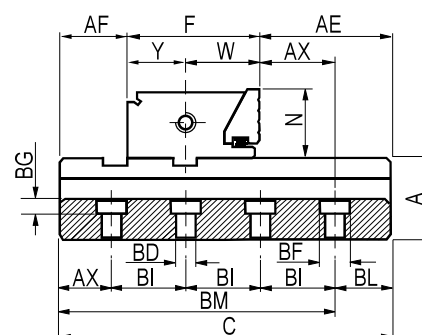


Art. 102Ai pos. 1

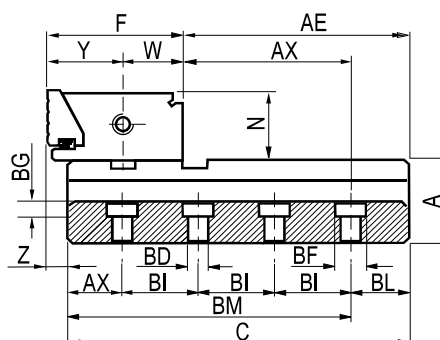
## Art. 103A



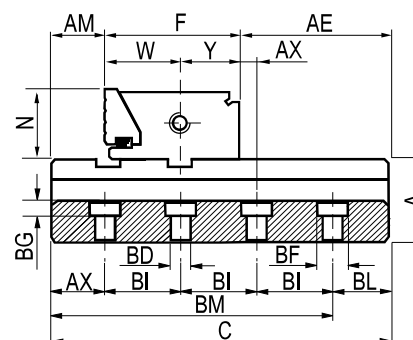
Art. 103A pos. 1



Art. 103A pos. 2

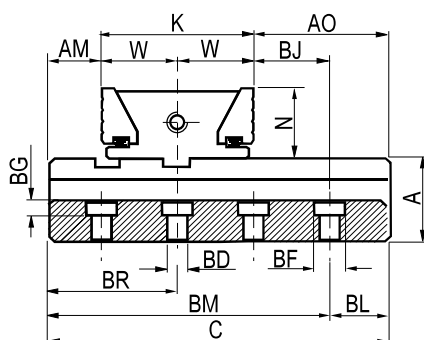


Art. 103A pos. 3

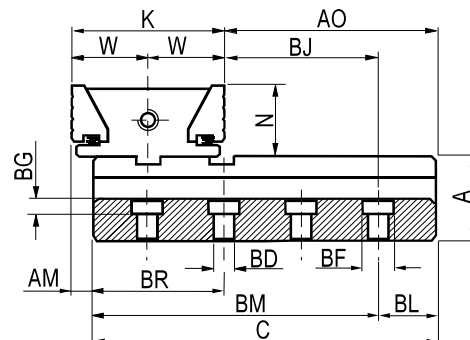


Art. 103A pos. 4

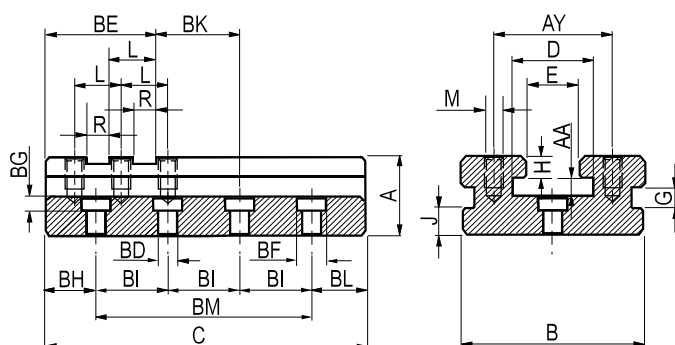
## Art. 104A



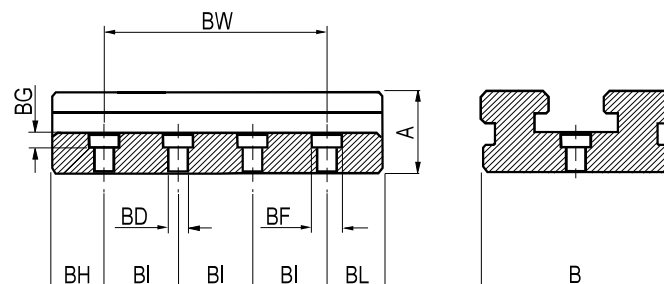
Art. 104A pos. 1



Art. 104A pos. 2



Art. 44A



Art. 51A

| Tipo (grandezza) morsa / Vise (type) size |         |         |         |         |         |         |                         | Tipo (grandezza) morsa / Vise (type) size |         |         |         |        |         |         |                         |
|-------------------------------------------|---------|---------|---------|---------|---------|---------|-------------------------|-------------------------------------------|---------|---------|---------|--------|---------|---------|-------------------------|
| mm                                        | 1       | 2       | 3       | 4       | 5       | 6       | Tolleranza<br>Tolerance | mm                                        | 1       | 2       | 3       | 4      | 5       | 6       | Tolleranza<br>Tolerance |
| A                                         | 35      | 40      | 50      | 58      | 70      | 78      | - 0.02                  | AV                                        | 29      | 49      | 107.5   | 111    | 155     | 198     |                         |
| B                                         | 75      | 95      | 125     | 145     | 170     | 195     | - 0.02                  | AW                                        | 111     | 111     | 122.5   | 129    | 145     | 152     |                         |
| C                                         | 140     | 160     | 230     | 240     | 300     | 350     |                         | AX                                        | 33.6    | 33.6    | 33.6    | 33.6   | 33.6    | 33.6    | ± 0.02                  |
| D                                         | 31      | 41      | 57      | 70      | 80      | 90      |                         | AY                                        | 50      | 62      | 88      | 100    | 120     | 133     |                         |
| E                                         | 21      | 28      | 41      | 51      | 61      | 71      | + 0.02                  | AZ                                        | 62      | 80      | 90      | 116    | 138     | 184     |                         |
| F                                         | 77.9    | 77.9    | 89.4    | 96.9    | 113.4   | 120.4   | - 0.04                  | BA                                        |         |         |         |        |         |         |                         |
| G                                         | 9.5     | 9.5     | 11.5    | 11.5    | 17.5    | 17.5    |                         | BB                                        | 20      | 32      | 50      | 50     | 76      | 90      |                         |
| H                                         | 10      | 10      | 13      | 15      | 20      | 20      | - 0.02                  | BC                                        | 45      | 38      | 47      | 32     | 52      | 55      |                         |
| I                                         | 31      | 41      | 40      | 57.5    | 31      | 67      |                         | BD                                        | 16      | 16      | 16      | 16     | 16      | 16      | F7                      |
| J                                         | 15      | 15      | 20      | 20      | 26      | 26      |                         | BE                                        | 75      | 75      | 82      | 84     | 97      | 97      |                         |
| K                                         | 84.8    | 84.8    | 101.8   | 101.8   | 132.8   | 146.8   | - 0.04                  | BF                                        | 20.5    | 25      | 25      | 25     | 25      | 25      |                         |
| L                                         | 32      | 32      | 36      | 36      | 44      | 44      | - 0.02                  | BG                                        | 8       | 8       | 10      | 10     | 10      | 10      |                         |
| M                                         | M10     | M12     | M14     | M16     | M20     | M20     |                         | BH                                        | 36      | 21      | 40      | 32.5   | 31      | 67      |                         |
| N                                         | 30      | 40      | 50      | 60      | 65      | 80      | ± 0.02                  | BI                                        | 50      | 50      | 50      | 50     | 50      | 50      | ± 0.01                  |
| O                                         | 43      | 43      | 46      | 48      | 53      | 53      |                         | BJ                                        | 33.6    | 33.6    | 33.6    | 33.6   | 33.6    | 33.6    | ± 0.02                  |
| P                                         | 33.6    | 33.6    | 33.6    | 33.6    | 33.6    | 33.6    | ± 0.02                  | BK                                        | 36      | 36      | 40.5    | 45     | 48      | 55      | ± 0.01                  |
| Q                                         | 29      | 49      | 157.5   | 61      | 55      | 98      |                         | BL                                        | 29      | 39      | 40      | 57.5   | 69      | 83      |                         |
| R                                         | 16      | 16      | 16      | 16      | 16      | 16      | H7                      | BM                                        | 111     | 121     | 190     | 182.5  | 231     | 267     |                         |
| S                                         | 100     | 125     | 150     | 175     | 200     | 300     |                         | BN                                        | 320     | 320     | 400     | 400    | 500     | 500     |                         |
| T                                         | 6.5     | 8.5     | 13      | 13      | 17      | 17      |                         | BO                                        | 11      | 11      | 18      | 18     | 20      | 20      |                         |
| U                                         | 10.5    | 13.5    | 19      | 19      | 26      | 26      |                         | BP                                        | 24.6    | 24.6    | 23.1    | 20.6   | 22.6    | 15.6    |                         |
| V                                         | 4.5     | 5.5     | 8.5     | 8.5     | 17      | 17      |                         | BQ                                        | 35      | 35      | 38      | 40     | 45      | 45      |                         |
| W                                         | 42.4    | 42.4    | 50.9    | 55.4    | 66.4    | 73.4    | ± 0.02                  | BR                                        | 67      | 67      | 74      | 76     | 89      | 89      |                         |
| X                                         | 44      | 44      | 48.5    | 53      | 56      | 63      | ± 0.02                  | BS                                        | 12      | 12      | 12      | 12     | 12      | 12      | F7                      |
| Y                                         | 35.5    | 35.5    | 35.5    | 41.5    | 47      | 47      | ± 0.02                  | BT                                        | 20      | 20      | 20      | 20     | 20      | 20      |                         |
| Z                                         | 0.5     | 0.5     | 0.5     | 1.5     | 2       | 2       |                         | BU                                        | 8       | 8       | 8       | 8      | 8       | 8       |                         |
| AA                                        | 10      | 10      | 12      | 18      | 18      | 18      | + 0.04                  | BV                                        | 31      | 31      | 42.5    | 49     | 65      | 72      |                         |
| AB                                        | 40      | 40      | 50      | 50      | 100     | 100     |                         | BW                                        | 100     | 100     | 150     | 150    | 200     | 200     | ± 0.01                  |
| AC                                        | 76      | 76      | 84.5    | 89      | 100     | 107     | - 0.02                  |                                           | 3 x Ø16 | 3 x Ø16 | 4 x Ø16 | 4x Ø16 | 3 x Ø16 | 3 x Ø16 |                         |
| AD                                        | 21      | 41      | 99.5    | 103     | 147     | 190     |                         | BX                                        | 10      | 10      | 15      | 15     | 20      | 20      |                         |
| AE                                        | 62.6    | 82.6    | 141.6   | 144.6   | 188.6   | 231.6   |                         | BY                                        | 10      | 10      | 15      | 20     | 25      | 30      |                         |
| AF                                        | 31.5    | 31.5    | 35.5    | 35.5    | 42      | 42      |                         | BZ                                        | 40      | 40      | 40      | 40     | 40      | 40      | ± 0.01                  |
| AG                                        | 30.6    | 50.6    | 105.1   | 108.6   | 144.6   | 187.6   |                         | CA                                        | 195     | 228     | 312     | 302    | 392     | 420     |                         |
| AH                                        | 69.5    | 89.5    | 153.5   | 158.5   | 208     | 258     |                         | CB                                        |         |         |         |        |         |         |                         |
| AI                                        | 7.4     | 7.4     | 12.9    | 15.4    | 21.4    | 28.4    |                         | CC                                        | 20      | 20      | 25      | 25     | 25      | 25      |                         |
| AJ                                        | 36      | 36      | 40.5    | 45      | 48      | 55      | ± 0.1                   | CD                                        | M6      | M8      | M12     | M12    | M16     | M16     |                         |
| AK                                        | 80      | 80      | 120     | 120     | 160     | 240     | ± 0.01                  | CE                                        | 9       | 12      | 18      | 18     | 24      | 24      |                         |
|                                           | 3 x Ø12 | 3 x Ø12 | 4 x Ø12 | 4 x Ø12 | 3 x Ø12 | 4 x Ø12 |                         | CF                                        | 15      | 15      | 20      | 20     | 30      | 30      |                         |
| AL                                        | 111     | 111     | 122.5   | 129     | 145     | 152     |                         | CG                                        | 4       | 5       | 12      | 12     | 16      | 16      |                         |
| AM                                        | 24.6    | 24.6    | 23.6    | 20.6    | 22.6    | 15.6    |                         |                                           |         |         |         |        |         |         |                         |
| AN                                        | 37.5    | 57.5    | 117.5   | 122.5   | 164.    | 214     |                         |                                           |         |         |         |        |         |         |                         |
| AO                                        | 30.6    | 50.6    | 105.1   | 108.6   | 144.6   | 187.6   |                         |                                           |         |         |         |        |         |         |                         |
| AP                                        | 62.6    | 82.6    | 141.6   | 144.6   | 188.6   | 231.6   |                         |                                           |         |         |         |        |         |         |                         |
| AQ                                        | 50      | 60      | 80      | 90      | 100     | 120     |                         |                                           |         |         |         |        |         |         |                         |
| AR                                        | 32      | 51      | 48      | 68      | 78      | 94      |                         |                                           |         |         |         |        |         |         |                         |
| AS                                        | 28      | 49      | 102     | 82      | 122     | 136     |                         |                                           |         |         |         |        |         |         |                         |
| AT                                        | 55      | 68      | 82      | 62      | 92      | 70      |                         |                                           |         |         |         |        |         |         |                         |
| AU                                        | 45      | 38      | 47      | 27      | 52      | 45      |                         |                                           |         |         |         |        |         |         |                         |

**SERRAGGIO MECCANICO CON CHIAVE DINAMOMETRICA**

**MECHANICAL CLAMPING WITH TORQUE WRENCH**

**GRUPPI DI SERRAGGIO MECCANICI (Art. 258 e similari)**

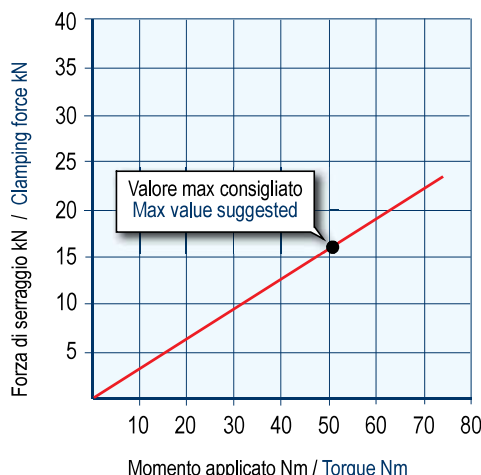
I diagrammi seguenti consentono di determinare le forze di serraggio ottenibili con le morse di varia grandezza (da 1 a 6), in funzione del momento applicato

**MECHANICAL CLAMPING DEVICES (Art. 258 and similar)**

The following diagrams give the clamping force that can be obtained with each vise type (size 1 to 6) as a function of the torque

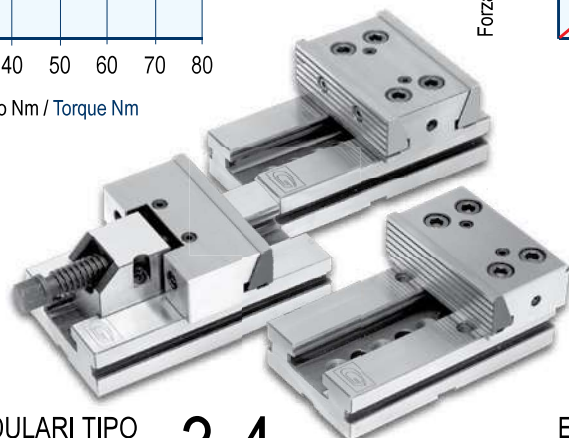
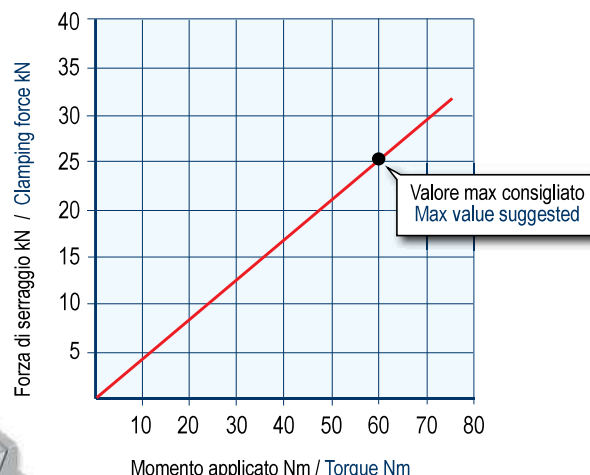
**ELEMENTI MODULARI TIPO 1**  
**MODULAR ELEMENTS TYPE 1**

Vite Ø 14 - Passo 4 mm  
 Screw Ø 14 - Pitch 4 mm



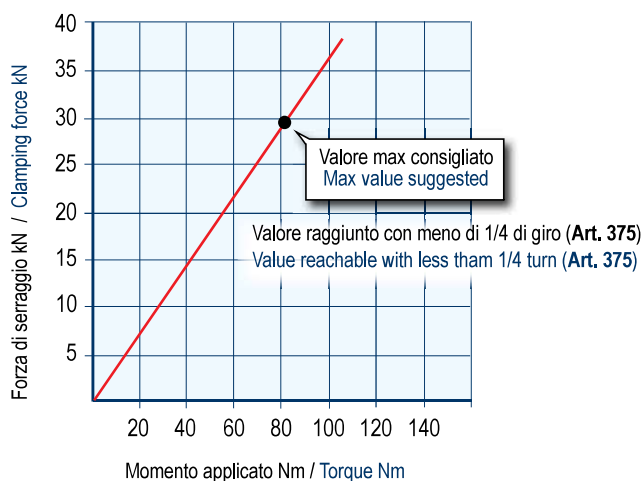
**ELEMENTI MODULARI TIPO 2**  
**MODULAR ELEMENTS TYPE 2**

Vite Ø 18 - Passo 4 mm  
 Screw Ø 18 - Pitch 4 mm



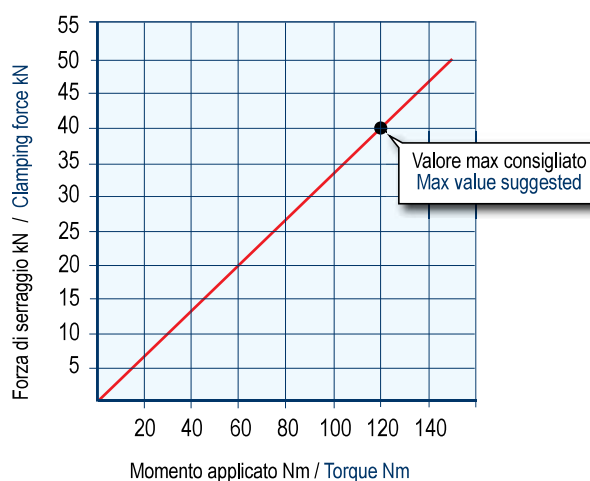
**ELEMENTI MODULARI TIPO 3-4**  
**MODULAR ELEMENTS TYPE 3-4**

Vite Ø 24 - Passo 5 mm  
 Screw Ø 24 - Pitch 5 mm



**ELEMENTI MODULARI TIPO 5-6**  
**MODULAR ELEMENTS TYPE 5-6**

Vite Ø 30 - Passo 5 mm  
 Screw Ø 30 - Pitch 5 mm



NB: Alcuni fattori, come la lubrificazione, lo staffaggio, gli attriti ed altro, possono modificare i valori indicati fino a  $\pm 10\%$ .  
 Per un corretto utilizzo non superare i valori indicati nel grafico

Some factor as lubrication, clamping on the machine table, frictions and more can modify above values within a  $\pm 10\%$  range. For optimum operation do not exceed chart values.