

# CIVI SinterGrip

6.1

## Multiple clamping system



### CIVI-S 60 CIVI-S 90

#### Jaw

- Self-centering
- Double Clamping
- Fixed

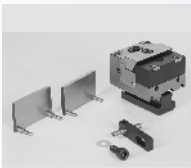
Page 6.1.2



### CIVI SINTERGRIP

- Parallels

Page 6.1.5



### CIVI SINTERGRIP

- Movable jaw set
- Fixed jaw set

Page 6.1.3



### Accessories

Page 6.1.6



# CIVI-S 60 CIVI-S 90

## Multiple clamping system

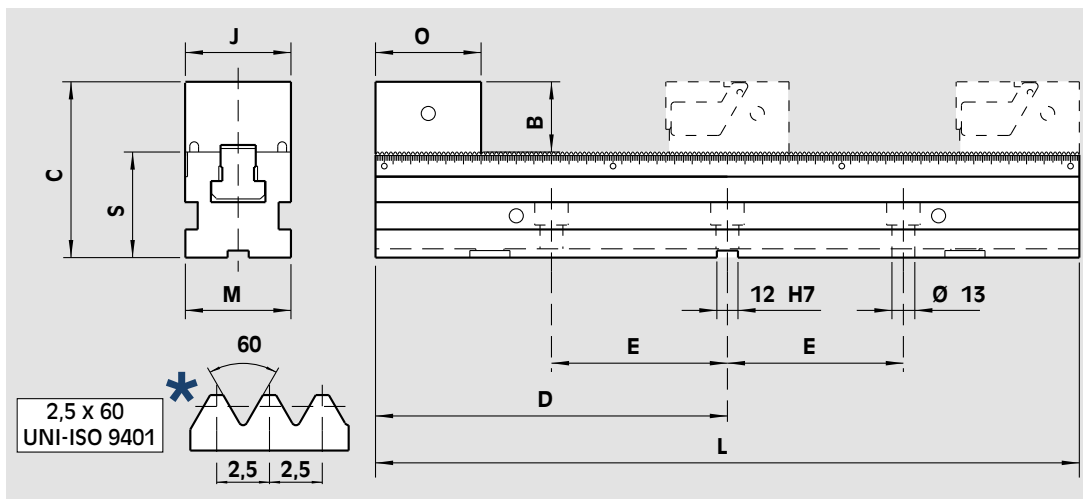
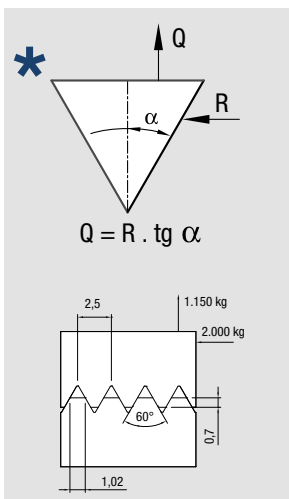


CIVI-S is a new interesting modular Multi-Clamping system that reduces downtime and maximizes machine tool productivity

### Complete base set with:

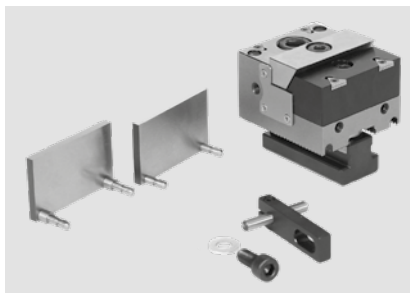
1 base (length optional), 1 fixed support, n. 2 (CIVI-S 60) or n. 3 (CIVI-S 90) SinterGrip inserts STD for steel\*, 1 pair of positioning keys, 1 t-wrench

\* On request inserts for ALU or HRC

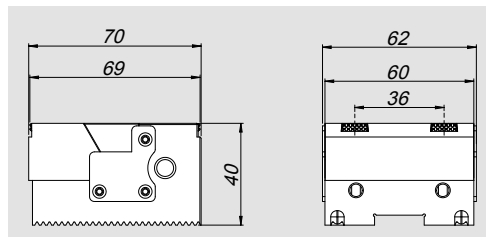


For type	Id. No.	B mm	C mm	D mm	E mm	J mm	L mm	M mm	O mm	S ±0.01 mm	Weight kg
CV-S 60-250	77584664	40	100	125	100	60	250	60	60	60	6.5
CV-S 60-400	77584661			200	100		400				9.5
CV-S 60-500	77584662			250	150		500				11.5
CV-S 60-630	77584663			315	200		630				13.5
CV-S 90-250	77584694	45	115	125	100	90	250	90	70	70	11
CV-S 90-400	77584691			200	100		400				16
CV-S 90-500	77584692			250	150		500				19.5
CV-S 90-630	77584693			315	200		630				23.5

Movable jaw set J60



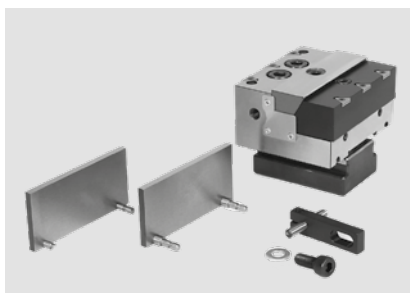
Complete with 1 work stop, n. 4 SinterGrip inserts STD for steel\*, n. 1 pair of parallels H37.



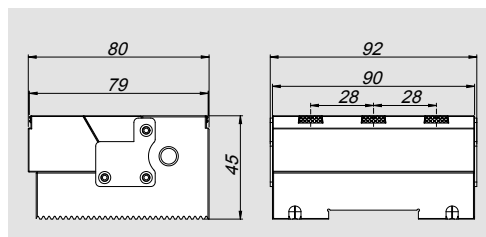
\* On request for ALU or HRC

Id. No.	For type	Weight
77 58 46 60	CIVI-S / 60 x ...	Kg 1,4

Movable jaw set J90



Complete with 1 work stop, n. 6 SinterGrip inserts STD for steel\*, n. 1 pair of parallels H42.



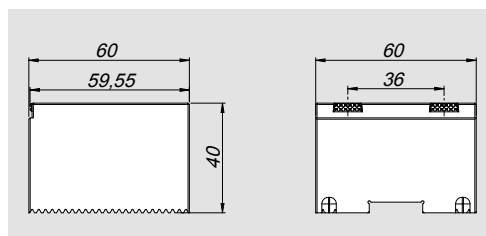
\* On request for ALU or HRC

Id. No.	For type	Weight
77 58 46 90	CIVI-S / 90 x ...	Kg 2,9

Fixed jaw set J60



Complete with 1 work stop, n. 2 SinterGrip inserts STD for steel\*.



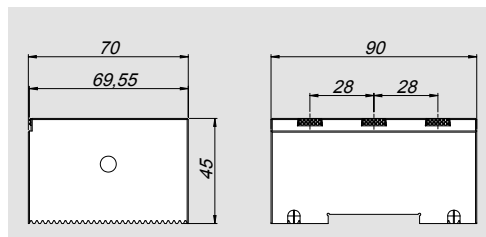
\* On request for ALU or HRC

Id. No.	For type	Weight
58 46 72 60	CIVI-S / 60 x ...	Kg 1,4

Fixed jaw set J90



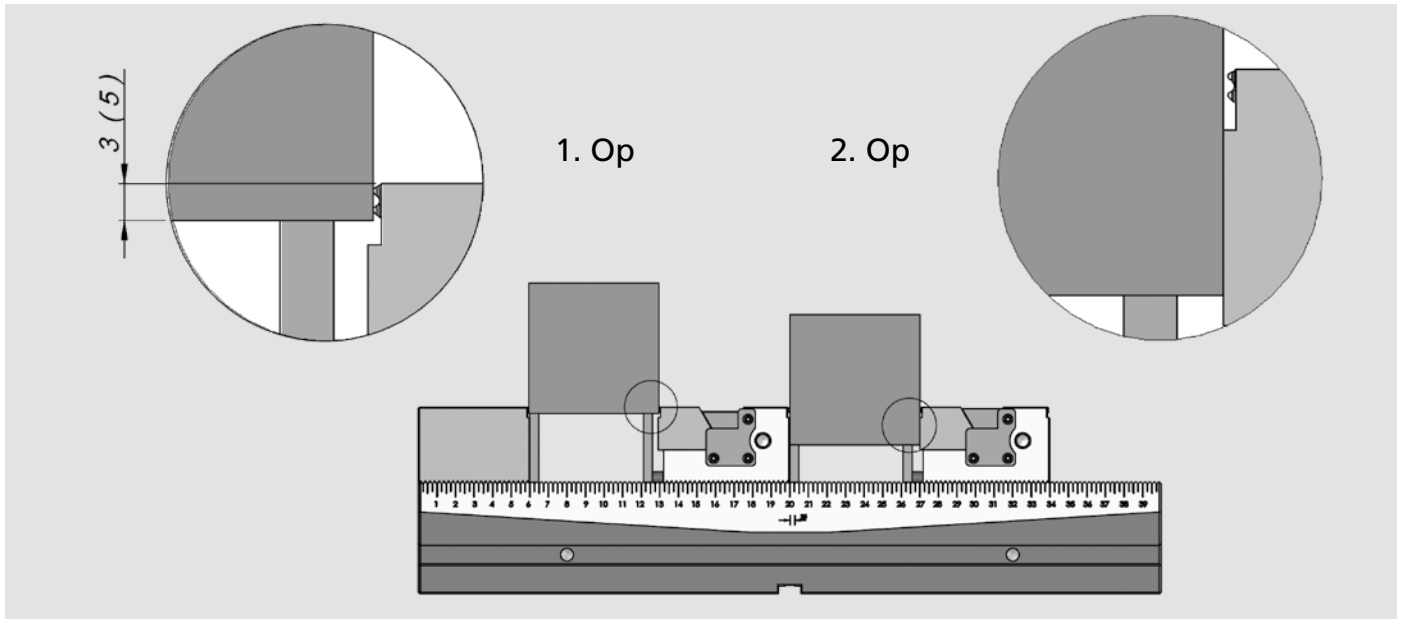
Complete with 1 work stop, n. 3 SinterGrip inserts STD for steel\*.



\* On request for ALU or HRC

Id. No.	For type	Weight
58 46 72 90	CIVI-S / 90 x ...	Kg 2,9

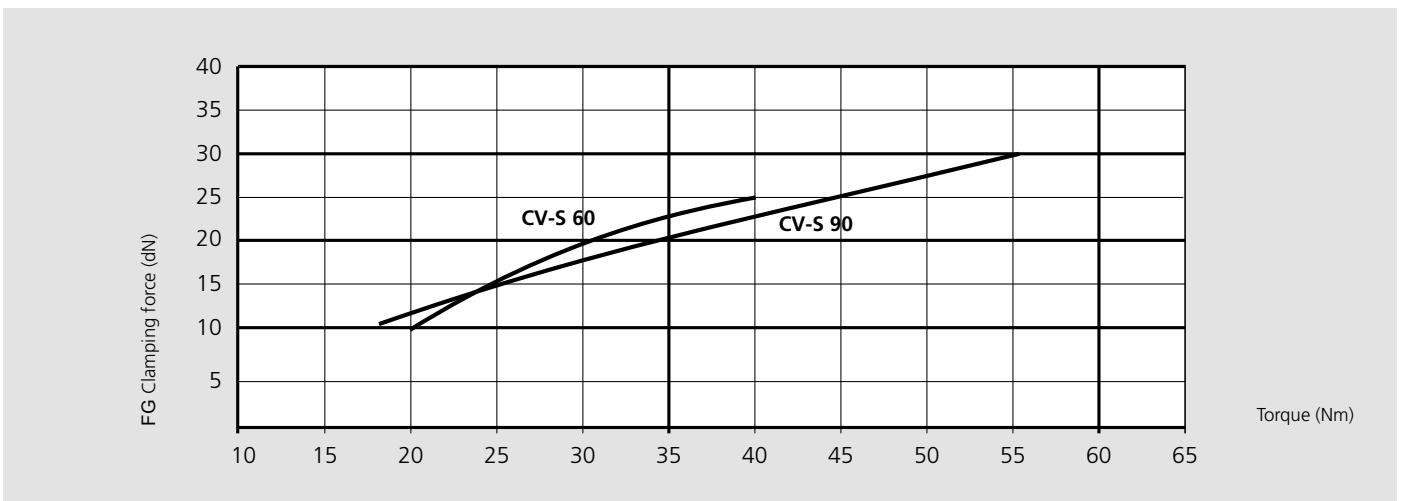
### Working example



### Clamping capacity

	A max. mm			
CV-S 60-250	120	25	-	-
CV-S 60-400	270	100	43	15
CV-S 60-500	370	150	76	40
CV-S 60-630	500	215	120	73
CV-S 90-250	99	-	-	-
CV-S 90-400	249	84	29	-
CV-S 90-500	349	134	62	26
CV-S 90-630	479	199	106	59

### Clamping forces diagram



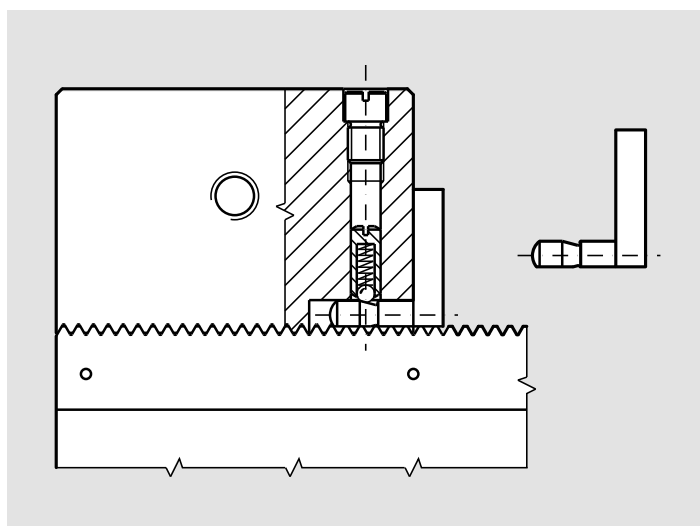
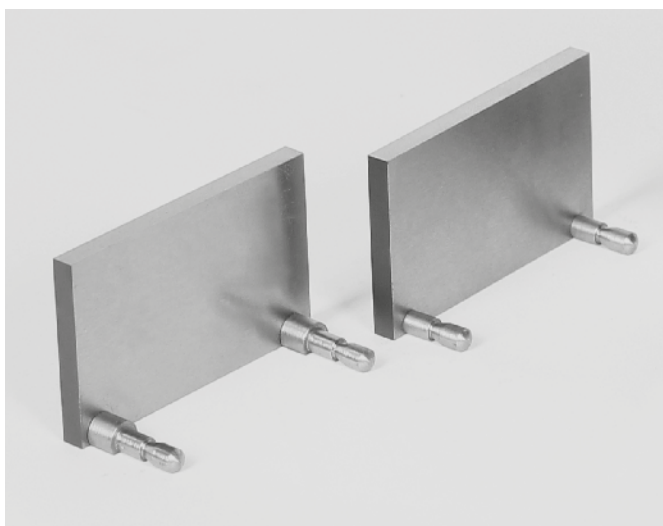
**Parallels for CIVI-S**

The exclusive and proven CLAK SYSTEM, for the quick replacement of parallels and jaws has been applied for use with the CIVI 2000 equipment with a new patent.

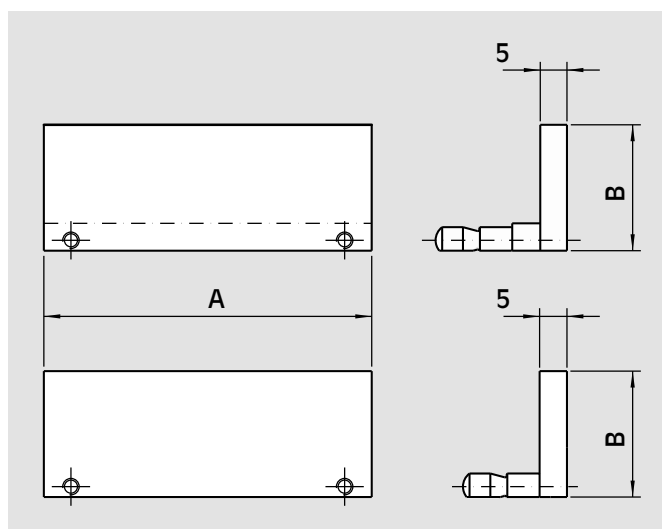
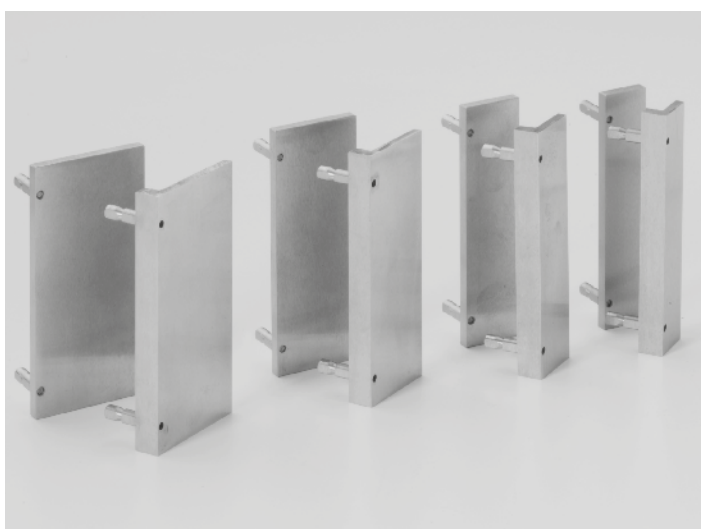
This equipment offers:

- a) The quick replacement of parallels and jaws
- b) The elimination of clamps and locks thanks to the patented selflocking system
- c) The increase in accuracy

All components are heat treated and precision ground.



**Set of 4 pair of parallels CLAK SYSTEM**

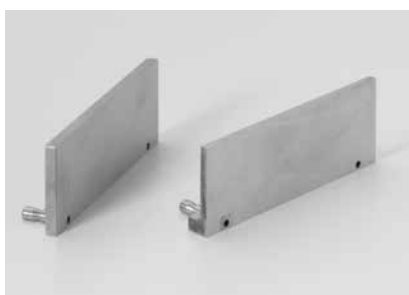


Id. No	For type	A		B			Weight Kg
		mm	mm	mm	mm	mm	
58 46 92 64	CIVI-S / 60 x ...	60	18	23	28	35	0,49
58 46 92 94	CIVI-S / 90 x ...	90	18	23	33	40	0,77



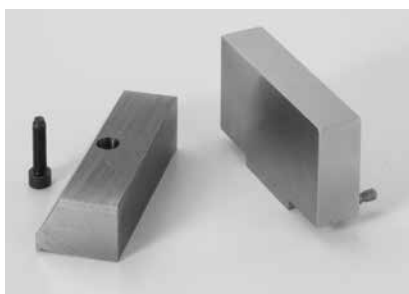
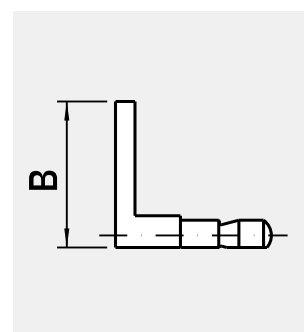
### Sintergrip jaws

Id. No.	For type
58 46 04 69	CIVI-S / 60 x ...
58 46 04 99	CIVI-S / 90 x ...



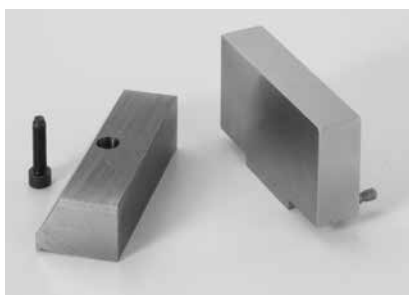
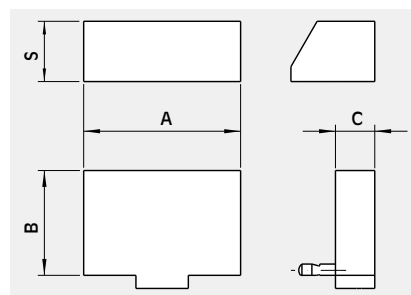
### Pair of parallels CLAK SYSTEM

Id. No.	For type	B
		mm
58 41 35 18	CIVI-S / 60 x ...	18
58 41 35 23	CIVI-S / 60 x ...	23
58 41 35 28	CIVI-S / 60 x ...	28
58 41 35 35	CIVI-S / 60 x ...	35
58 42 35 18	CIVI-S / 90 x ...	18
58 42 35 23	CIVI-S / 90 x ...	23
58 42 35 33	CIVI-S / 90 x ...	33
58 42 35 40	CIVI-S / 90 x ...	40



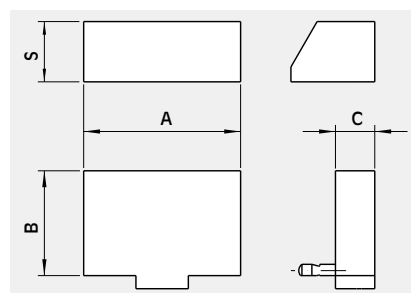
### Pair of soft aluminium jaws CLAK SYSTEM

Id. No.	For type	A	B	C	S	Weight
		mm	mm	mm	mm	Kg
58 41 95 49	CIVI-S / 60 x ...	60	40	15	23	0,19
58 42 95 49	CIVI-S / 90 x ...	90	45	20	25	0,40



### Pair of soft steel jaws CLAK SYSTEM

Id. No.	For type	A	B	C	S	Weight
		mm	mm	mm	mm	Kg
58 41 96 49	CIVI-S / 60 x ...	60	40	15	23	0,58
58 42 96 49	CIVI-S / 90 x ...	90	45	20	25	1,20



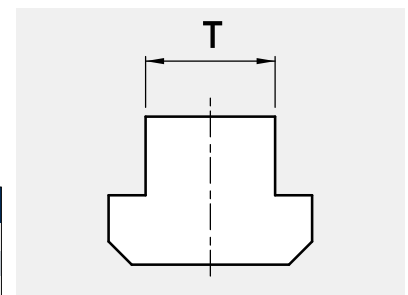


Work stop

Id. No.	Fot type	
58 31 50 10	CIVI-S / 60 x ...	for fixed support
58 32 50 10	CIVI-S / 90 x ...	for fixed support
58 31 50 20	CIVI-S / 60/90 x ...	for movable support



Pair of clamps complete with screw and T-nuts

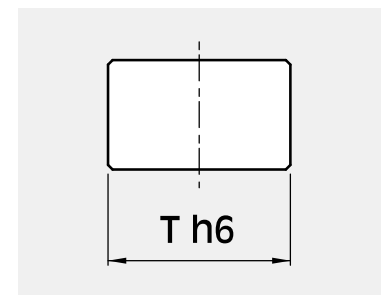


For type	Id. No.					
	mm 12	mm 14	mm 16	mm 18	mm 20	mm 22
CIVI-S / 60 x ...	58 01 27 92	58 01 27 93	58 01 27 94	58 01 27 95	58 01 27 96	58 01 27 97
CIVI-S / 90 x ...	58 02 27 92	58 02 27 93	58 02 27 94	58 02 27 95	58 02 27 96	58 02 27 97



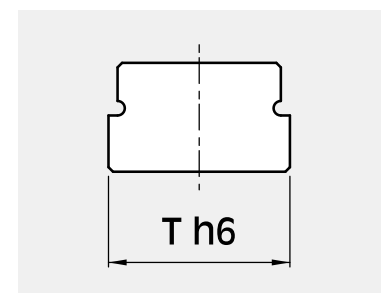
Pair of standard positioning keys

Id. No.	For type	T h6 mm
58 01 15 92	CIVI-S / 60 x ...	12
58 01 15 92	CIVI-S / 90 x ...	12



Pair of special positioning keys

For type	Id. No.					
	mm 12 - h6	mm 14 - h6	mm 16 - h6	mm 18 - h6	mm 20 - h6	mm 22 - h6
CIVI-S / 60 x ...	-	58 01 15 93	58 01 15 94	58 01 15 95	58 01 15 96	58 01 15 97
CIVI-S / 90 x ...	-	58 01 15 93	58 01 15 94	58 01 15 95	58 01 15 96	58 01 15 97



### SINTERGRIP

	Id. No.	Description
	58 45 01 19	Set of 10 SinterGrip inserts <b>STD</b> for steel
	58 45 01 29	set of 10 SinterGrip inserts <b>HRC</b> for hardened steel / titanium until 50-54 HRC
	58 45 01 39	Set of 10 SinterGrip inserts for <b>ALU</b>
	58 45 02 19	Kit 10VTx30 for inserts SINTERGRIP
	58 45 05 19	Kit 10 protection inserts in aluminum



*Find out more*

