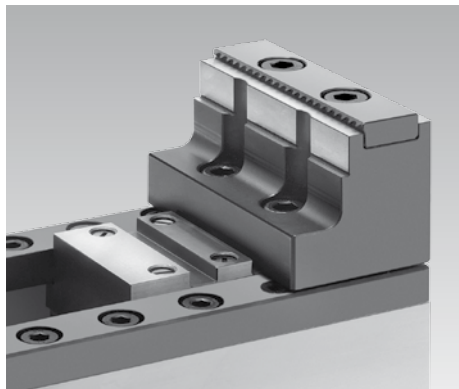




## Jaw Inserts for Clamping Jaws Technical Information



Stable workholding systems with flexible base jaws for the location of various jaw inserts are the basis. Raw and finished parts are clamped in the same workholding system without additional set-up effort.

The use of jaw inserts significantly reduces the required investment in clamping devices. In many applications, the additional “punching” operation is no longer required.

Jaw inserts grip serrated	Design	Damage to the workpiece surface	Compensation of angular misalignment
<p>Particularly suited to first clamping of raw parts. Used on saw cuts or casting surfaces with major angular misalignments (0.3 mm)</p> <p>The “round” jaw inserts are particularly suited to clamping non-cubic workpieces or forgings and castings.</p> <p>In combination with pendulum jaws, angular misalignments of up to several millimetres can be accommodated.</p>	<p><b>Grip</b></p>	high	large
<p><b>Jaw inserts with coatings</b></p> <p>Suitable for first clamping of drawn materials or saw cuts with minor angular misalignments (0.1 mm). The type and coarseness of the coating enables a specific selection in accordance with the machining task and material. Retention forces can be increased by a factor of 2.</p> <p>The inserts can also be used without any problems for clamping (2nd clamping) on machined surfaces. TUC coatings can also be applied subsequently to contour jaws or the existing clamping jaws.</p> <p>Jaw inserts with coating can also be used without hesitation on clamping systems with power amplifier.</p>	<p><b>TUC</b> Hardness 80 HRC Coarseness RA 10</p> <p><b>HM Fine</b> Hardness 58 HRC Grain size 0.1 – 0.3 mm</p> <p><b>HM Coarse</b> Hardness 58 HRC Grain size 0.3 – 0.5 mm</p>	<p>very low</p> <p>little</p> <p>medium</p>	<p>very low</p> <p>little</p> <p>medium</p>

### Recommendation for jaw inserts to increase the retention forces

Workpiece material	Workpiece surface	Workpiece surface				
		rolled / cast / forged	drawn	sawn	milled	ground
Steel, e.g. C45, 20MnCr5, 31 CrMo4V9		HM coarse, Grip	HM fine, TUC	HM coarse, Grip	HM fine, TUC	TUC
Heat-treated steel e.g. C45 induction-hardened, 20 MnCr5 case-hardened, 31 CrMoV9 nitrided					HM fine, TUC	TUC
Cast e.g. GG, red bronze		HM coarse, Grip			HM fine, TUC	TUC
Titanium		HM fine	HM fine, TUC	HM fine	HM fine, TUC	HM fine, TUC
Aluminium		HM coarse, Grip		HM fine, Grip	HM fine	TUC
Non-ferrous metals				HM fine, Grip	HM fine	TUC