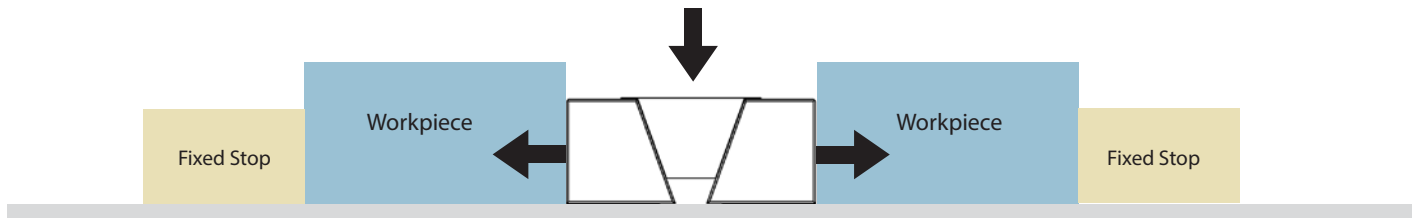


VISE FORCE[®]
WORKHOLDING CLAMPS

WORKHOLDING WEDGE CLAMPS

For Automated or Manual Clamping

WISE FORCE LOW PROFILE WEDGE CLAMPS



The clamps are constructed to expand evenly and apply balanced workholding pressure to the work piece. Our low profile clamps improve your machining process by eliminating movement, vibration, and chatter.

Vise Force® wedge clamps from PAWS Workholding® offer several unique advantages, including:

- Internal return springs
- Through hardened (28-32 Rc)
- A variety of clamp models to suit your application
- Holding forces of up to 14,500 lbs
- One bolt tightening operation
- Low profile design

VF0 SMOOTH JAW

2030-VF0-S-CP



VF0 +4MM MACHINABLE JAW

2030-VF0+4-CP



VF1 SMOOTH JAW

2030-VF1-S-CP



VF1 +3MM MACHINABLE JAW

2030-VF1+3-CP



VF1 +8MM MACHINABLE JAW

2030-VF1+8-CP



VF1 SERRATED JAW

2030-VF1-SER-CP



WISE FORCE LOW PROFILE WEDGE CLAMPS

VF1 SIDE LOAD

2030-VF1-SW-CP



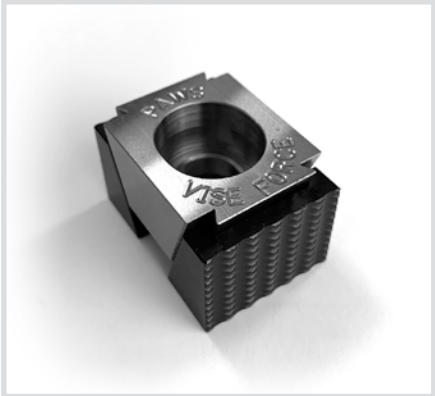
VF13 SMOOTH JAW

2030-VF13-S-CP



VF13 SERRATED JAW

2030-VF13-SER-CP



VF2 SMOOTH JAW

2030-VF2-S-CP



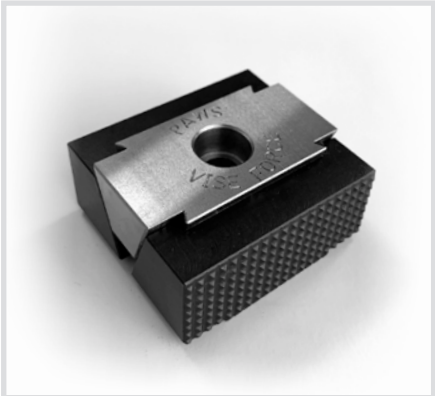
VF2 +8MM MACHINABLE JAW

2030-VF2+8-CP



VF2 SERRATED JAW

2030-VF2-SER-CP



VF2 TAPPED JAW

2030-VF2-TP-CP



VF2 SIDE LOAD

2030-VF2-SW-CP

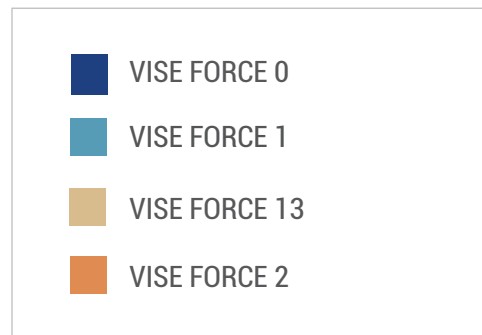
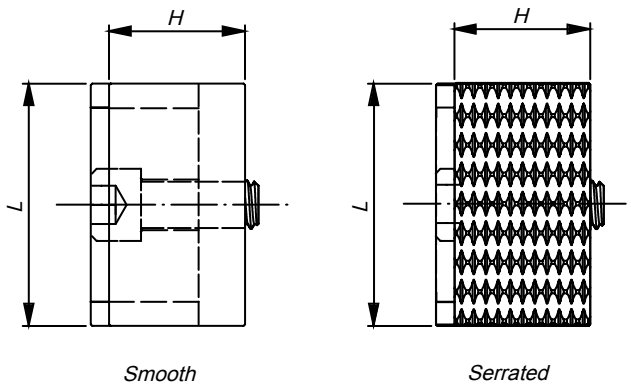
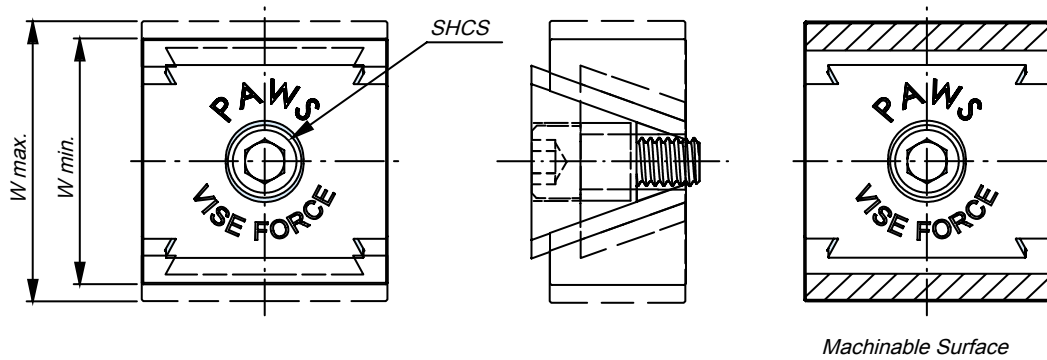


PART LOCATORS

2041-SPRINGL-RND/SQ-CP

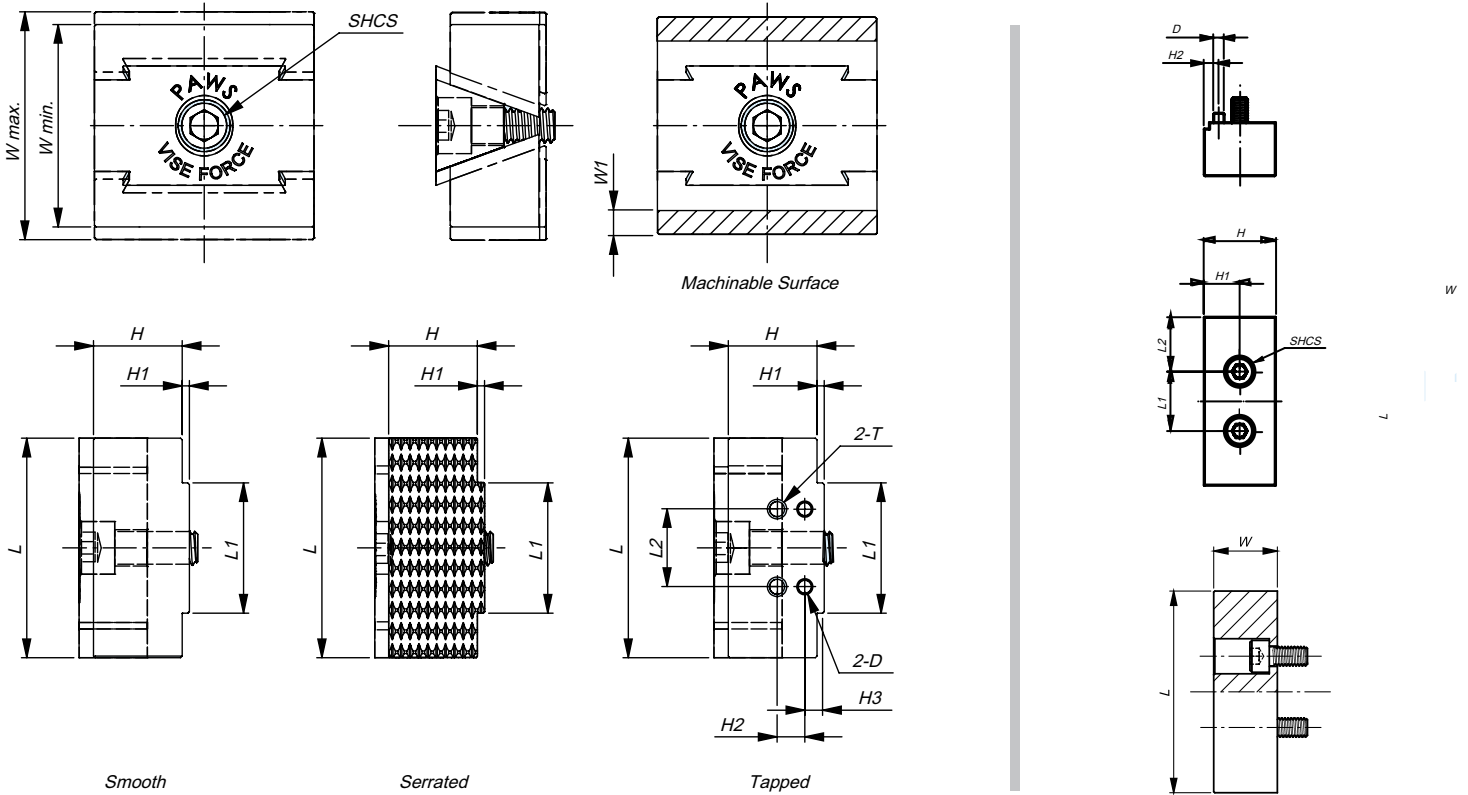


WISE FORCE CLAMP DATA



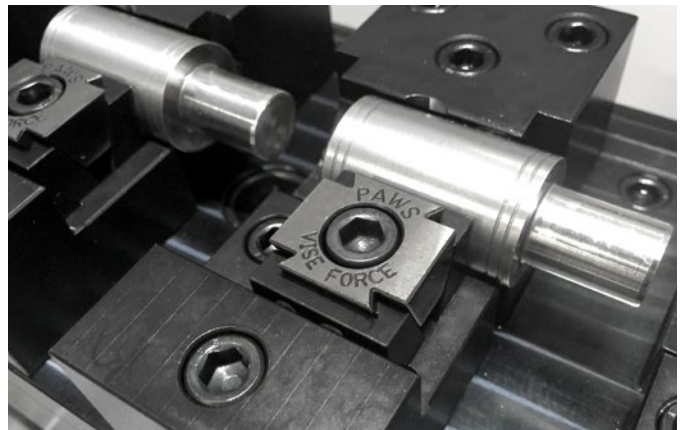
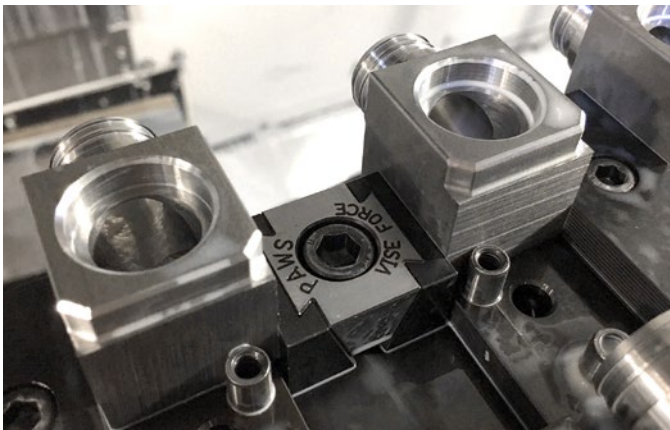
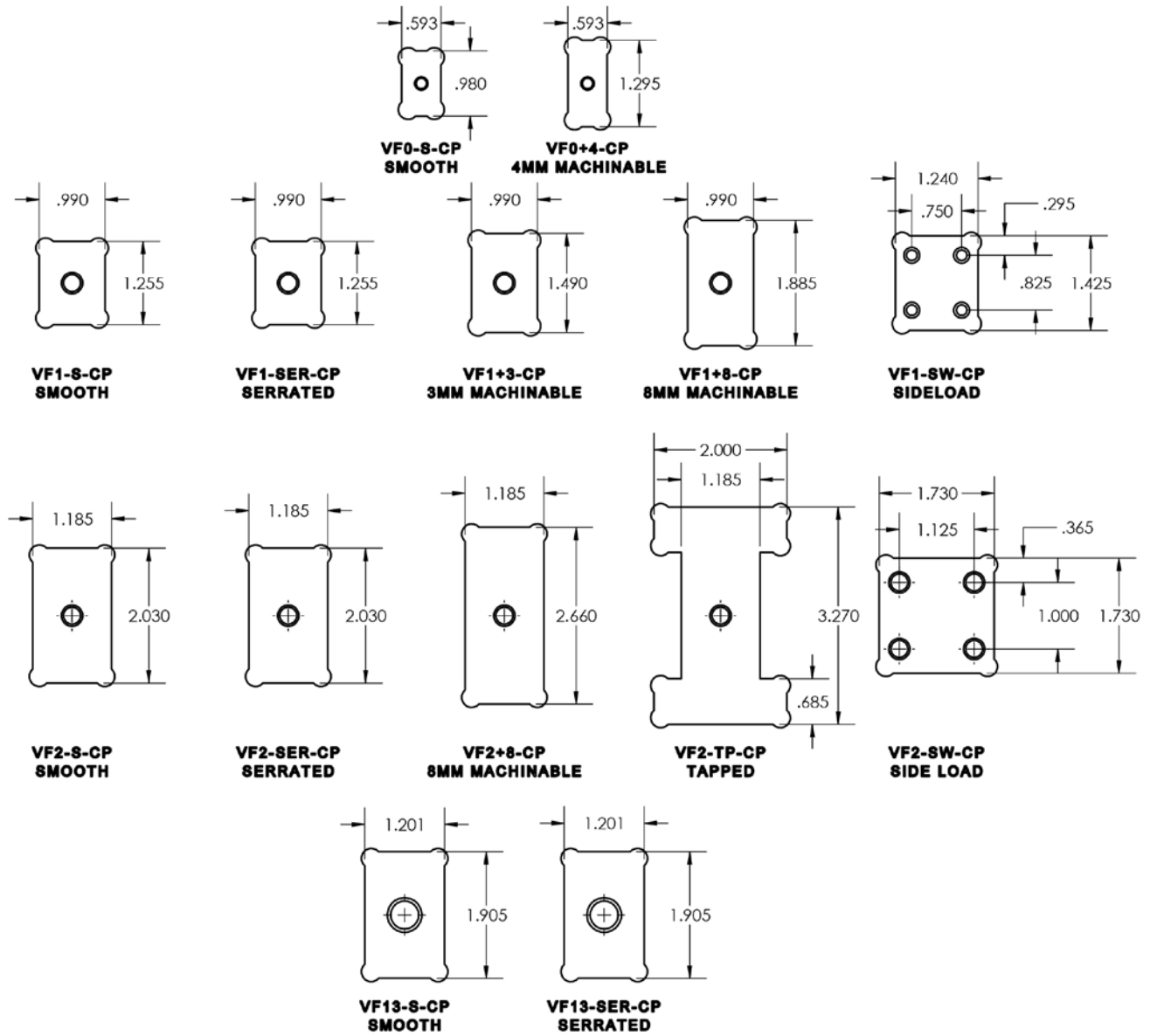
Part Number	Jaw Type	(W) Min.	(W) Opt.	(W) Max.	(T) Thread	(D)	(L)	(L1)
2030-VF0-S-CP	Smooth	.840	.905	.950	-	-	.583	-
2030-VF0+4-CP	Machinable (+4mm)	1.155	1.220	1.265	-	-	.583	-
2030-VF1-S-CP	Smooth	1.090	1.150	1.225	-	-	.980	-
2030-VF1-SER-CP	Serrated	1.090	1.150	1.225	-	-	.980	-
2030-VF1+3-CP	Machinable (+3mm)	1.330	1.385	1.460	-	-	.980	-
2030-VF1+8-CP	Machinable (+8mm)	1.720	1.780	1.855	-	-	.980	-
2030-VF1-SW-CP	Side Load	0.090	0.100	0.115	-	-	1.230	-
2030-VF13-S-CP	Smooth	1.670	1.775	1.875	-	-	1.181	-
2030-VF13-SER-CP	Serrated	1.670	1.775	1.875	-	-	1.181	-
2030-VF2-S-CP	Smooth	1.850	1.920	2.000	-	-	1.980	1.175
2030-VF2-SER-CP	Serrated	1.850	1.920	2.000	-	-	1.980	1.175
2030-VF2+8-CP	Machinable (+8mm)	2.480	2.550	2.630	-	-	1.980	1.175
2030-VF2-TP-CP	Tapped	1.850	1.920	2.000	10-32	.127	1.980	1.175
2030-VF2-TP-SJ-200-CP	Machinable	-	-	-	-	.125	1.980	.700
2030-VF2-SW-CP	Side Load	.040	.060	.070	-	-	1.720	-

WISE FORCE CLAMP DATA



(L2)	(H)	(H1)	(H2)	(H3)	Clamp SHCS	Jaw Hardness	Torque (ft/lbs)	Lateral Pressing Force (lbs)
-	.435	-	-	-	10-32	28-32 Rc	8	2,100
-	.435	-	-	-	10-32	28-32 Rc	8	2,100
-	.580	-	-	-	5/16-18	28-32 Rc	30	5,500
-	.580	-	-	-	5/16-18	28-32 Rc	30	5,500
-	.580	-	-	-	5/16-18	28-32 Rc	30	5,500
-	.580	-	-	-	5/16-18	28-32 Rc	30	5,500
-	.970	-	-	-	1/4-20	28-32 Rc	14	3,100
-	.866	-	-	-	1/2-13	28-32 Rc	110	14,500
-	.866	-	-	-	1/2-13	28-32 Rc	110	14,500
-	.800	.065	-	-	5/16-18	28-32 Rc	30	5,500
-	.800	.065	-	-	5/16-18	28-32 Rc	30	5,500
-	.800	.065	-	-	5/16-18	28-32 Rc	30	5,500
.700	.800	.065	.250	.175	5/16-18	28-32 Rc	30	5,500
.640	.845	.415	.175	-	10-32 x 3/8	28-32 Rc	(Use With Clamp 2030-VF2-TP-CP)	
-	1.185	-	-	-	5/16-18	28-32 Rc	30	5,500

WISE FORCE CLAMP POCKET DATA



WISE FORCE SPRING LOCATORS

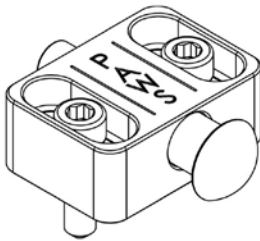


Adjustable Part Crowder

The Vise Force adjustable part crowders are spring loaded to provide clamp force as well as part retention on your workholding fixtures. The part crowders come in two standard styles with custom locators available upon request.

Style A Spring Locator

2041-SPRINGL-RND-CP

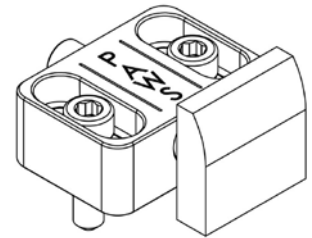


Specifications

Stroke	0.195
Hardness	HRC50
Spring Rate	4.1 FT/LBS
Material	Steel
Hardware	6-32 X .500 SHCS

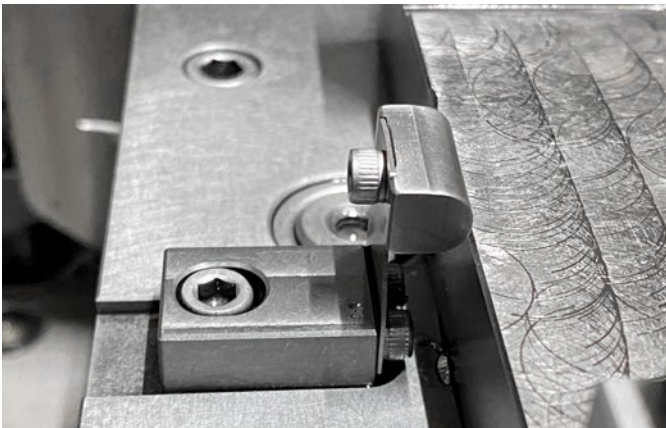
Style B Spring Locator

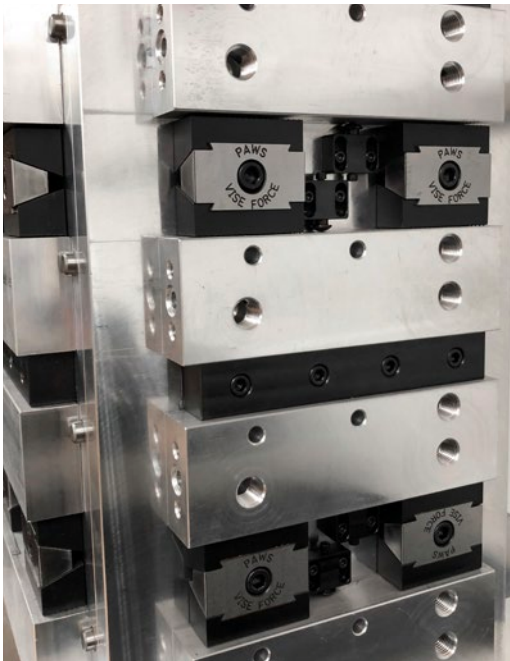
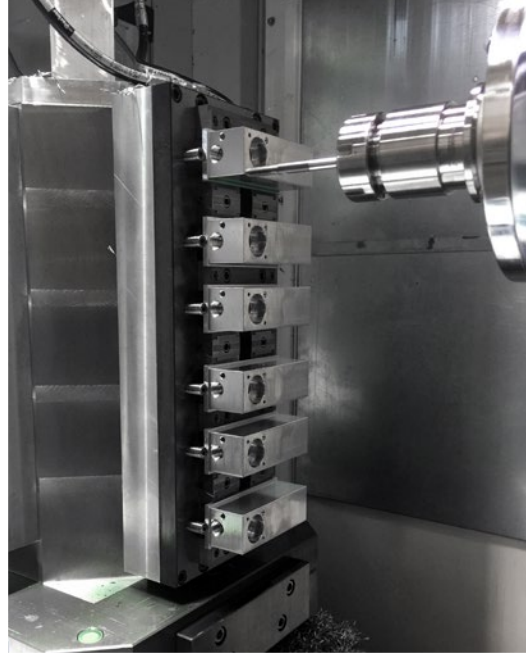
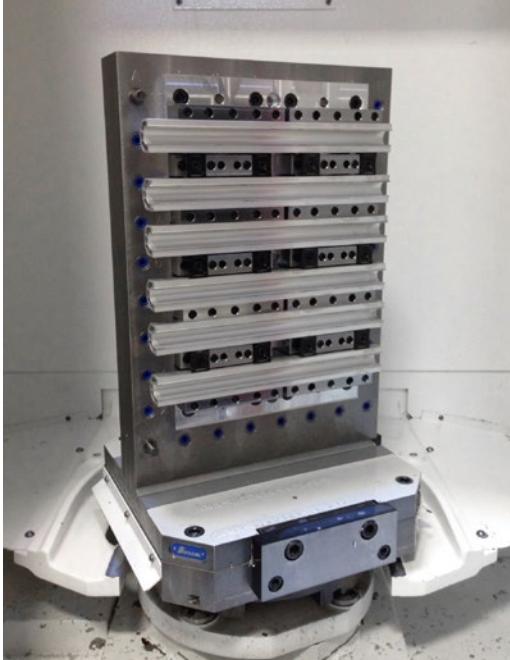
2041-SPRINGL-SQ-CP



Custom Part Keepers **Made For Your Fixture**

Not all projects are equal and many parts require special part retention. Our engineers will work with you on creating part keepers unique to your part and fixturing. With more than 20 years experience, our team can help solve your most challenging workholding problems.





PAWS  **WORKHOLDING**

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