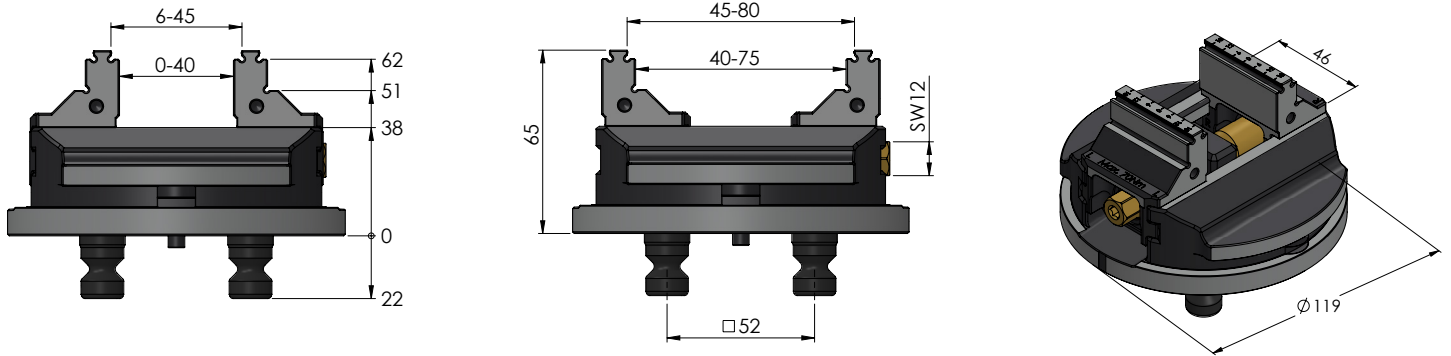
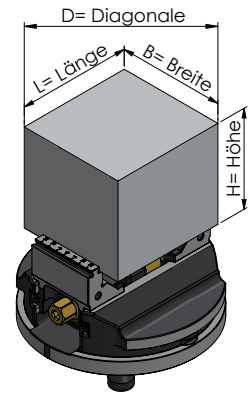


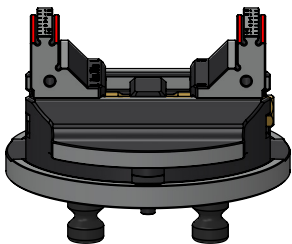
Dimensioning of the Makro·Grip® HAUBEX 5-Axis Vice:

Permitted workpiece dimensions:

Due to the taper of the workholding hood, the maximum permissible diagonal (D) of the workpiece blank varies depending on its height and contact face in the 5-Axis Vice.

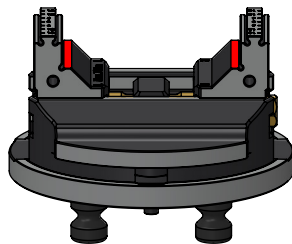
Based on the contact face used (marked red in the following models) and the height of the workpiece blank (H), the permissible diagonal (D) can be determined, which in turn is decisive for the permissible workpiece width.


contact face X

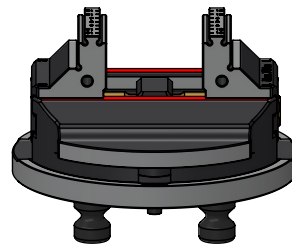
workpiece length: 6 - 80 mm
workpiece height: max. 70 mm


contact face Y

workpiece length: 40 - 75 mm
workpiece height: max. 81 mm


contact face Z

workpiece length: 0 - 40 mm
workpiece height: max. 94 mm



workpiece height at contact face X (mm)	workpiece height at contact face Y (mm)	workpiece height at contact face Z (mm)	permissible diagonal (mm)
0 - 25	0 - 36	0 - 49	113
> 25 - 40	> 36 - 51	> 49 - 64	112
> 40 - 55	> 51 - 66	> 64 - 79	111
> 55 - 70	> 66 - 81	> 79 - 94	110

Example calculation:

$$W = \sqrt{D^2 - L^2}$$

Workpiece length specified with **70 mm**

Selected contact face Y with specified workpiece height of **60 mm**

= the permissible diagonal taken from the table is **111 mm**

$$W = \sqrt{111^2 - 70^2} = 86,1$$

The workpiece width (W) must not be greater than 86.1 mm in this calculation example.

Note: For workpiece blanks with maximum permissible dimensions, the workpiece must be clamped exactly centrally, otherwise the workholding hood could collide with the workpiece edges. Please check this before pre-stamping several workpiece blanks.