

## *The sprinter among the NC quick-action vices*



**gripos**<sup>®</sup>

### **Record-setting rapid-action clamping**

*Unique and patented clamping-action with mechanical force amplification. Secure clamping with only one lever movement of max. 160°.*

### **In middle of the machine table**

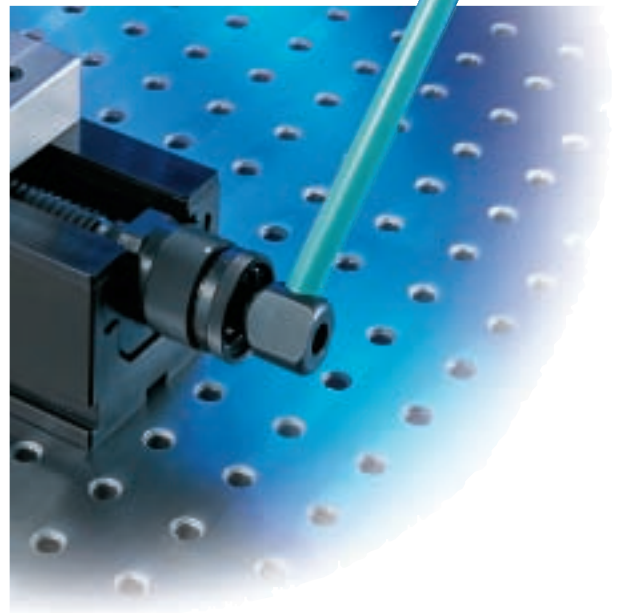
*Compact, no cranking, no bevel drive. Hence free positioning, even in the middle of the machine table.*

### **Quick dismantling**

*Only a few components. Quickly adjusted, positioned, dismantled and cleaned.*

### **Modular and flexible**

*The modularity of gripos<sup>®</sup> allows a conversion into various versions and solves almost every clamping task.*



# High-speed clamping ...

# **gripos®**

**gripos® holds almost everything**  
 Hard or soft, cubic or irregular shaped work pieces, series or single piece processing, fully automatic or manual.

**The trick with the lever**  
 Small angle of rotation, full clamping force at max. 160° lever movement, no cranking, no bevel drive, hence also in the middle of the machine table.



**Very few components, spindle assembly easy to remove**  
 and therefore easy to position, dismantle and clean.



**gripos® - the system kit**  
 Easy to convert, set-up and extend. Whether it is set up horizontally, vertically or laterally, individually or in groups, on a grid plate, slot table or zero point positioning system.

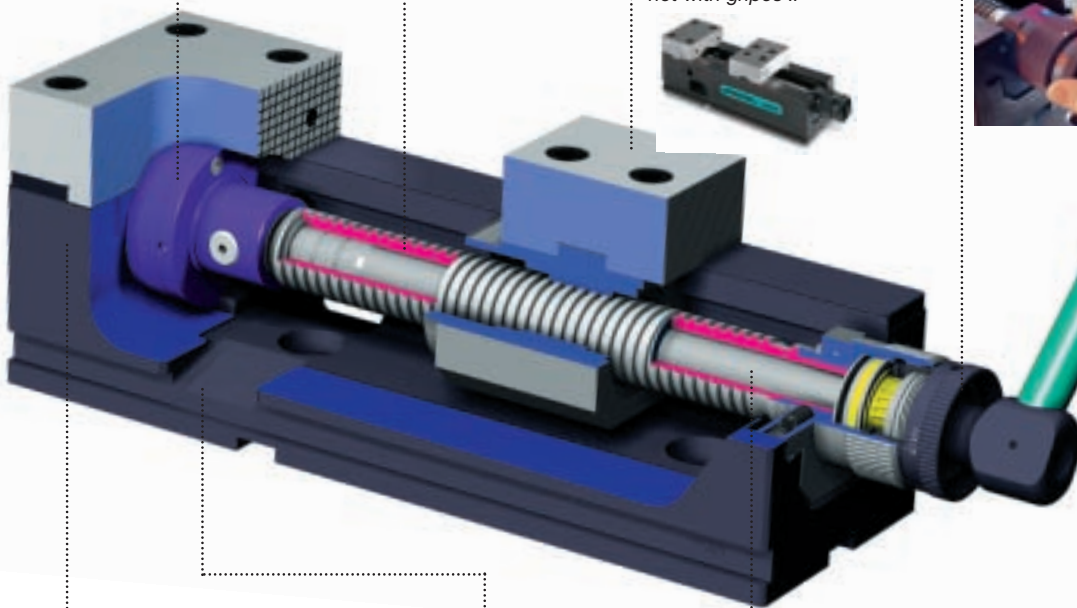
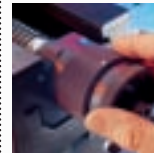


**Fully enclosed force transmission**  
 - protection against dust and liquids  
 - mechanical locking  
 - vibration proof

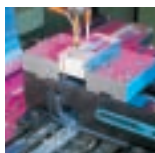
**Flawless clamping action**  
 - no spinning of the outer spindle  
 - no jamming of chips

**Reversible jaw with three-fold benefit\***  
 - smooth  
 - serrated  
 - M8 thread for attachment of a large range of jaws  
 \*not with gripos II

**Controlled clamping force**  
 - 10% to 100%  
 - continuously variable  
 - pre-adjustable  
 - no loss of clamping force



**Body with high torsional stability**  
 - wear resistant  
 - underside and guide-ways ground  
 - true-to-square laid on side



**Coolant drain-off**  
 - controlled drain-off of coolant liquid  
 - interruption-free operation

**Clamping force by traction rod**  
 - no bending of base body  
 - top machining precision

**Quick-action lever clamping**  
 - clamping < 1 second!  
 - no cranking  
 - no bevel drive  
 - reliably locked



## **GRESSEL clamping systems**

*By innovation and experience GRESSEL clamping systems have become the epitome of cleverness, precision and reliability. They enjoy worldwide appreciation, moreover for their high economy, durability and flexibility.*



### **gripes® NC-vices for processing centres**

GRESSEL gripes® are also available as multiple clamping units as 2V or 4V tower units for use in production and horizontal processing centres.

### **Extended clamping widths**

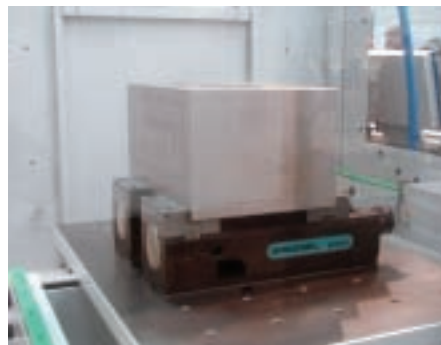
Two individual gripes® clamping units are connected with a traction rod to build one block for greater clamping widths. In addition, the NC-vice can be equipped with 160 mm jaws to expand the application range. The conversion is completed quickly, easily and without any great assembly effort.

### **Application with all conventional zero point clamping systems**

gripes® can be adjusted to fit practically all zero point clamping system by individually modifying the base body.

### **Plenty of accessories**

Work piece supports with a unique swivel-click bracket, quick-action adjustment, quick-change jaws in various designs, and much more.



### **Real 5-sided processing**

Limits are frequently encountered in 5-axis machining centers due to inaccessibility of the processing axis. GRESSEL offers a sophisticated assortment of high support jaws, which allow an excellent use of the full play of the axis.

The new support jaws are also available in version VS (expanded clamping width), meaning that the support jaws can be reversed very easily and quickly, resulting in an expansion of the clamping width by max. 88 mm.

The so-called PC (pseudo-centric) version offers additional possibilities. The stationary jaw can be moved closer into the centre of the vice with additional slots in the basic body. This provides the user with more freedom in the 5-axis processing.

The clamping force, which is reduced by approx. 40% with the high support jaws, is compensated by special variable grip jaws, which highly improve the clamping and holding of the work piece.

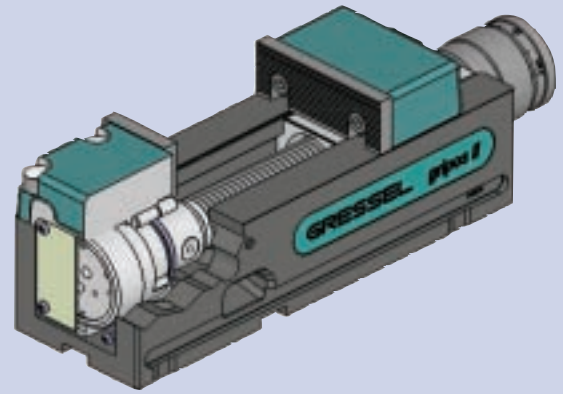


**... in production and automation.  
Modular structure for the greatest economy.**

# gripos II - cost effective clamping

Drawbar principle for an optimal distribution of the clamping forces on the work piece. The basic body is relieved from direct clamping forces and remains stable against distortions – even at extreme load.

The force amplification cassette is directly integrated in the T-shaped fixed jaw and therefore has a direct counter-pull. gripos II is designed as a cost-effective version in the gripos® quality, and only a little less modular.



# gripos® - modular construction

## Drive

gripos® allows a conversion from the mechanical force transmission into a hydraulic or pneumatic drive system without any great assembly.

A simple acting hydraulic cylinder can be used or a pneumatically powered clamping cassette can be attached instead of the standard mechanical force cassette.

### Versions:

#### mechanical force amplification

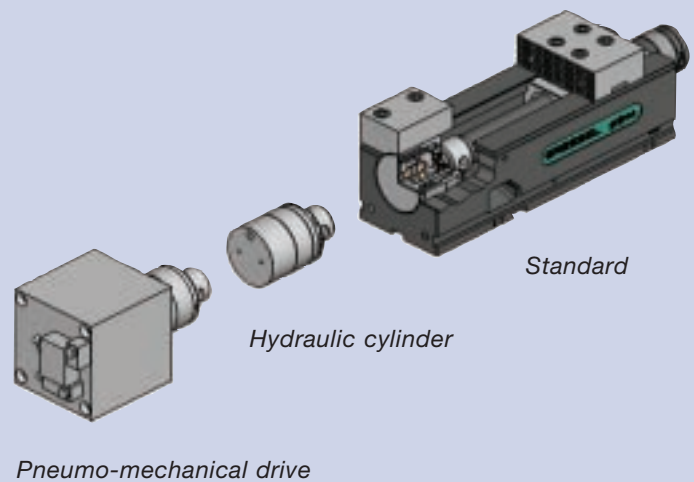
- for models 100 and 125

#### hydraulically powered

- for models 125 and 160

#### pneumo-mechanical

- for models 100 and 125



## Jaws

An important constituent of the modular structure of gripos® is the option to easily replace the most diverse support jaws.

### Versions:

#### Standard reversible jaws for triple use

- smooth, serrated or with attachment jaws

#### Soft jaws for positive fitting clamping

#### Combination reversible jaws for more clamping width

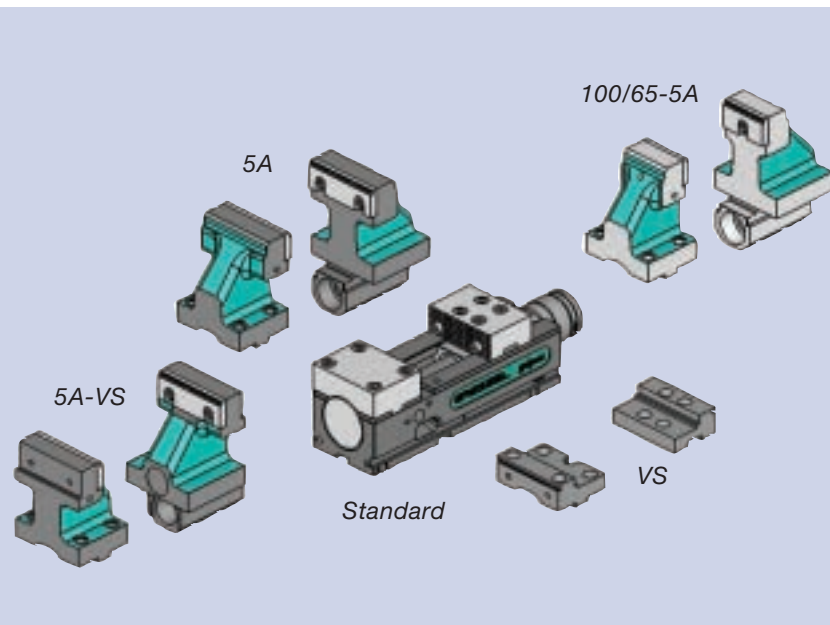
- VS jaw set 100, 125 and 160 mm

#### High support 5A jaws for 5-sided processing

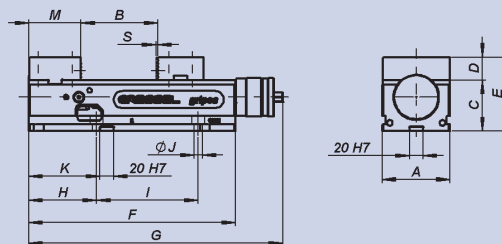
- Standard set of 5A jaws

- reversible 5A-VS jaw set for expanded clamping widths

- 100/65 5A jaw set with a reduced jaw width of 65 mm



# gripos® standard version

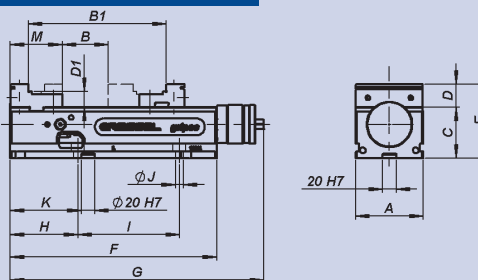


Model	Measurement [mm]												
	A	B	C	D	E	F	G	H	I	J	K	M	S
<b>gripos 100</b>	100	0-156	75	34	109	305	374	100	150	12	105	77	2.5
<b>gripos 125</b>	125	0-214	100	39	139	390	458	120	200	16	125	89	3

Model	Description	Jaw width [mm]	Clamping force [kN]	Weight [kg]	Order No.
<b>gripos 100</b>	NC quick-action vice	100	4-30	19,5	GPS.100.200.01
<b>gripos 125</b>	NC quick-action vice	125	4-40	35	GPS.125.200.01

**Scope:** Contents **gripos** including 1 clamping lever, 4 springs and cover plates

# gripos-VS expanded clamping widths

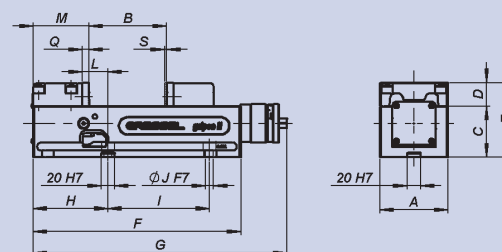


Model	Measurement [mm]														
	A	B	B1	C	D	D1	E	F	G	H	I	J	K	M	S
<b>gripos 100-VS</b>	100	0-156	89-245	75	34	23	109	305	374	100	150	12	105	77	2.5
<b>gripos 125-VS</b>	125	0-214	95-309	100	39	25	139	390	458	120	200	16	125	89	3

Model	Description	Jaw width [mm]	Clamping force [kN]	Weight [kg]	Order No.
<b>gripos 100-VS</b>	NC quick-action vice with expanded clamping width	100	4-30	19	GPS.100.200.02
<b>gripos 125-VS</b>	NC quick-action vice with expanded clamping width	125	4-40	34	GPS.125.200.02

**Scope:** Contents **gripos VS** including 1 clamping lever, 4 springs and cover plates

# gripos II quick-action vice

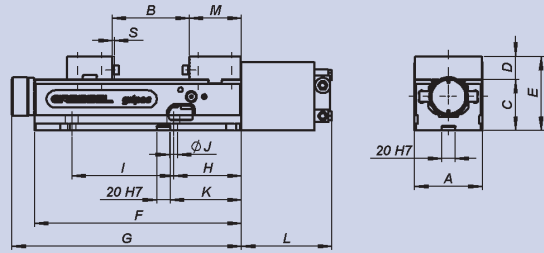


Model	Measurement [mm]													
	A	B	C	D	E	F	G	H	I	J	L	M	Q	S
<b>gripos II 100</b>	100	0-153	75	35	110	307	375	110.5	120/150	12	38	82.5	10	2.5
<b>gripos II 125</b>	125	0-205	100	40	140	392	460	134	200	16	46	99.5	11.5	3

Model	Description	Jaw width [mm]	Clamping force [kN]	Weight [kg]	Order No.
<b>gripos II 100</b>	NC quick-action vice, standard version	100	4-30	19	GTS.100.000.01
<b>gripos II 125</b>	NC quick-action vice, standard version	125	4-40	34	GTS.125.000.01

**Scope:** Contents **gripos II** incl. 2 jaws with profiled surface, 1 clamping lever, 4 springs

# gripos® hydraulic/pneumatic



Model	Measurement [mm]														
	A	B	C	D	E	F	G	H	I	J	K	L	M	S	
<b>gripos 125-H *</b>	125	0-214	100	39	139	390	458	120	200	16	125			89	3
<b>gripos 160-H *</b>	160	0-302	115	49	164	470	531	140	180	16				82	6
<b>gripos 100-P**</b>	100	0-156	75	34	109	305	339	100	150	12	105	133	77	2.5	
<b>gripos 125-P**</b>	125	0-214	100	39	139	390	428	120	200	16	125	155	89	3	

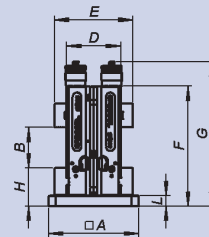
\* A simple acting hydraulic cylinder is attached instead of the mechanical cassette

\*\*A pneumo-mechanical drive is attached instead of the mechanical cassette

Model	Description	Jaw width [mm]	Clamping force [kN]	Max. pressure [bar]	Weight [kg]	Order No.
<b>gripos 125-H *</b>	NC quick-action vice, hydraulic	125	bis 40	170	33	GPH.125.200.01
<b>gripos 160-H *</b>	NC quick-action vice, hydraulic	160	bis 70	250	71	GPH.160.000.01
<b>gripos 100-P**</b>	NC quick-action vice, pneumo-mechanical	100	5-30	8	21	GPP.100.200.01
<b>gripos 125-P**</b>	NC quick-action vice, pneumo-mechanical	125	6-40	8	38	GPP.125.200.01

**Scope:** Contents **gripos hydraulic / pneumatic** \*hydraulic connection / \*\*pneumatic connection

## gripos-2V vertical unit

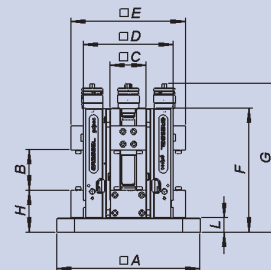


**Vertical unit attached on a base plate with 2 NC quick-action vices**, for pallets according to DIN 55201 and JIS 6337-1980

Model	Measurement [mm]									Weight [kg]	Order No.	
	A	B	C	D	E	F	G	H	L			
<b>gripos 100-2V</b>	250	0-156		150	218	335	404	107	30		56	GPS.100.202.01
<b>gripos 125-2V</b>	250	0-214		200	278	430	498	129	40		92	GPS.125.202.01

**Scope:** Contents **gripos 2V** including 1 clamping lever, cover plates and 2 springs

## gripos-4V vertical unit

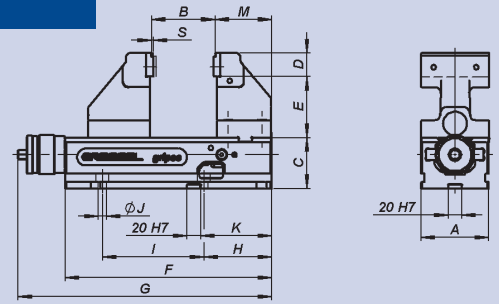


**Vertical unit attached on a base plate with 4 NC quick-action vices**, for pallets according to DIN 55201 and JIS 6337-1980

Model	Measurement [mm]									Weight [kg]	Order No.	
	A	B	C	D	E	F	G	H	L			
<b>gripos 100-4V / 400</b>	400	0-156	101	251	319	345	414	117	40		148	GPS.100.204.04
<b>gripos 125-4V / 400</b>	400	0-214	126	326	404	430	498	129	40		224	GPS.125.204.04
<b>gripos 125-4V / 500</b>	500	0-214	126	326	404	430	498	129	40		252	GPS.125.204.05

**Scope:** Contents **gripos 4V** including 1 clamping lever, cover plates and 1 lifting ring

## gripos-5A 5 axis

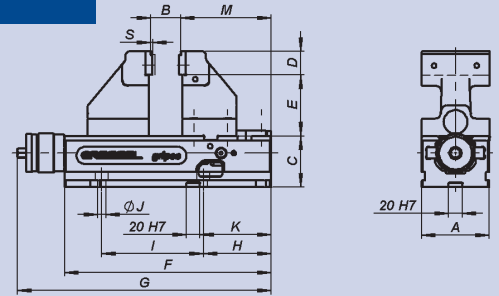
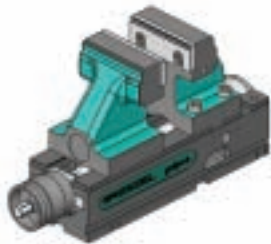


Model	Measurement [mm]												
	A	B	C	D	E	F	G	H	I	J	K	M	S
<b>gripos 100-5A</b>	100	5-127	75	35	90	305	375	100	150	12	105	83.5	2.5
<b>gripos 125-5A</b>	125	5-179	100	40	110	390	458	120	200	16	125	100	3

Model	Description	Jaw width [mm]	* Clamping force [kN]	Weight [kg]	Order No.
<b>gripos 100-5A</b>	NC quick-action vice with high support jaws	100	4-30	25	GPS.100.200.05
<b>gripos 125-5A</b>	NC quick-action vice with high support jaws	125	4-40	43	GPS.125.200.05

**Scope:** Contents **gripos-5A** incl. 2 stepped jaws grip 5mm, 1 clamping lever, 4 springs, cover plates

## gripos-5A-PC 5 axis

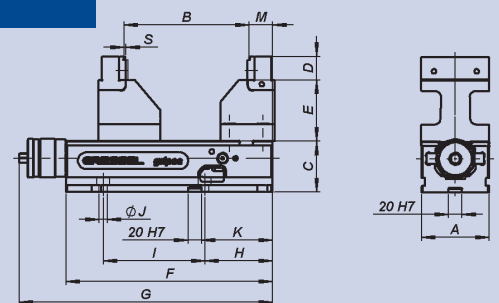
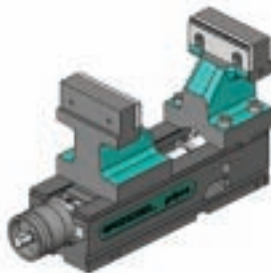


Model	Measurement [mm]												
	A	B	C	D	E	F	G	H	I	J	K	M	S
<b>gripos 100-5A-PC</b>	100	5-77	75	35	90	305	375	100	150	12	105	133.5	2.5
<b>gripos 125-5A-PC</b>	125	5-124	100	40	110	390	458	120	200	16	125	155	3

Model	Description	Jaw width [mm]	* Clamping force [kN]	Weight [kg]	Order No.
<b>gripos 100-5A-PC</b>	NC quick-action vice with high support jaws	100	4-30	25	GPS.100.200.07
<b>gripos 125-5A-PC</b>	NC quick-action vice with high support jaws	125	4-40	43	GPS.125.200.07

**Scope:** Contents **gripos-5A-PC** incl. 2 stepped jaws grip 5mm, 1 clamping lever, 4 springs, cover plates

## gripos-5A-VS expanded clamping widths

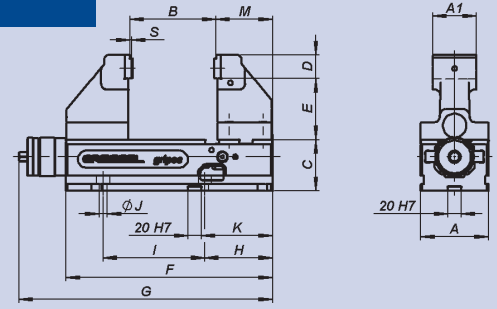
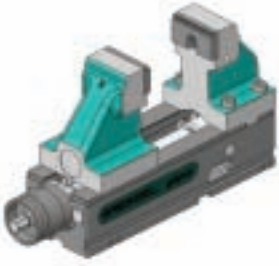


Model	Measurement [mm]												
	A	B	C	D	E	F	G	H	I	J	K	M	S
<b>gripos 100-5A-VS</b>	100	98-198	75	35	90	305	375	100	150	12	105	34.5	2.5
<b>gripos 125-5A-VS</b>	125	119-267	100	40	110	390	458	120	200	16	125	36	3

Model	Description	Jaw width [mm]	* Clamping force [kN]	Weight [kg]	Order No.
<b>gripos 100-5A-VS</b>	NC quick-action vice with high support jaws	100	4-30	25	GPS.100.200.06
<b>gripos 125-5A-VS</b>	NC quick-action vice with high support jaws	125	4-40	43	GPS.125.200.06

**Scope:** Contents **gripos-5A-VS** incl. 2 stepped jaws grip 5mm, 1 clamping lever, 4 springs, cover plates

# gripos-5A 5 axis – jaws 65



Model	Measurement [mm]													
	A	A1	B	C	D	E	F	G	H	I	J	K	M	S
<b>gripos 100/65-5A</b>	100	65	5-127	75	35	90	305	375	100	150	12	105	83.5	2.5

Model	Description	Jaw width [mm]	* Clamping force [kN]	Weight [kg]	Order No.
<b>gripos 100/65-5A</b>	NC quick-action vice	65	4-30	25	GPS.100.201.05

**Scope:** Contents **gripos 100/65-5A** 65 incl. 2 stepped jaws grip 5mm, 1 clamping lever, 4 springs, cover plates

\* **Clamping force:** corresponds with the clamping force value adjustable at the spindle when using standard jaws.  
 They reduce by approx. 40% with high support jaws.  
 The clamping force loss, however, is generally compensated by using the standard grip stepped jaws.

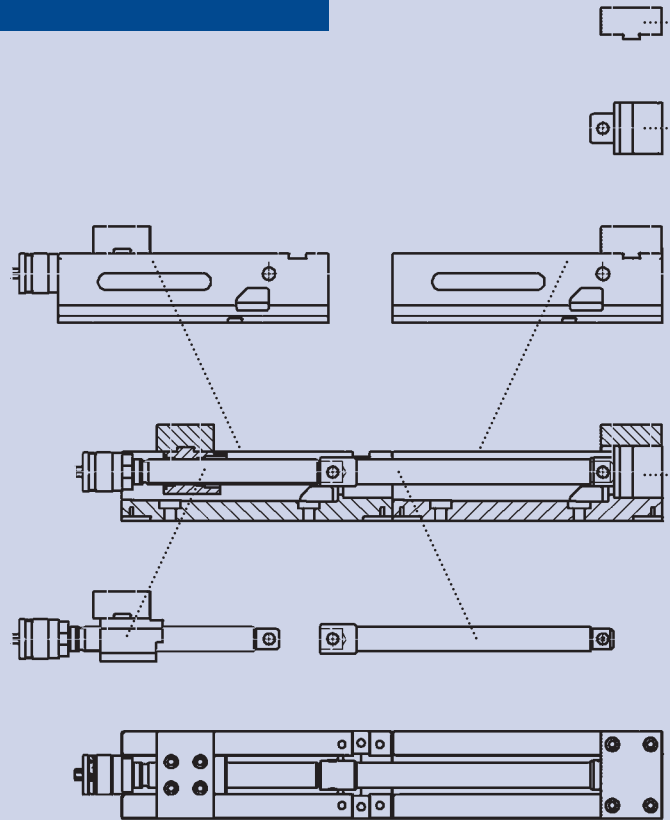
## gripos® for enlarged jaw opening

### Clamping width expansion by sequentially arranging 2 gripos with traction rod extensions

Two single devices are combined into one unit with a traction rod extension. Quick conversion due to a modular structure. At least one basic body and a traction rod are also required.

### Zero point clamping systems

gripos® can be individually manufactured to suit most conventional zero point clamping systems. Holes with the appropriate key dimensions can be incorporated upon request.



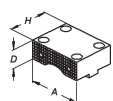
## Sales

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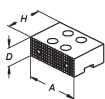
[info@gressel.ch](mailto:info@gressel.ch)

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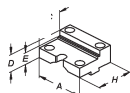




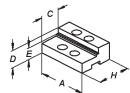
Model	Jaw width [mm]						Order No.
	A	B	C	D	E	H	
Reversible jaw, fixed	100	-	-	34	-	76	GPA.100.040.01
Reversible jaw, fixed	125	-	-	39	-	88	GPA.125.040.01



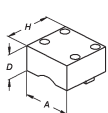
Reversible jaw, mobile	100	-	-	34	-	67	GPA.100.041.01
Reversible jaw, mobile	125	-	-	39	-	82	GPA.125.041.01



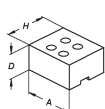
Combination reversible jaw, fixed	100	-	50	34	23	76	GPA.100.042.01
Combination reversible jaw, fixed	125	-	50	39	25	88	GPA.125.042.01



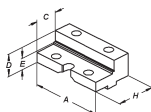
Combination reversible jaw, mobile	100	-	40	34	23	67	GPA.100.043.01
Combination reversible jaw, mobile	125	-	45	39	25	82	GPA.125.043.01



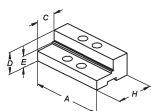
Soft jaw, fixed	100	-	-	50	-	95	GPA.100.003.01
Soft jaw, fixed	125	-	-	50	-	110	GPA.125.003.01



Soft jaw, mobile	100	-	-	50	-	85	GPA.100.004.01
Soft jaw, mobile	125	-	-	50	-	100	GPA.125.004.01



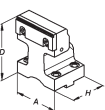
Jaw VS, fixed 125/160	160	-	50	49	25	88	GPZ.125.072.11
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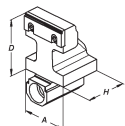
Jaw VS, mobile 125/160	160	-	45	49	25	82	GPZ.125.073.02
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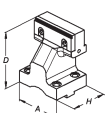
Spindle nut for the mobile jaw	100						GPA.100.007.11
Spindle nut for the mobile jaw	125						GPA.125.007.11



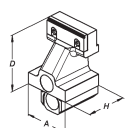
High support jaw, fixed	100	-	-	125	-	80	GPA.100.046.01
High support jaw, fixed	125	-	-	150	-	95	GPA.125.046.01



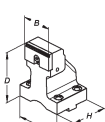
High support jaw, mobile	100	-	-	125	-	91	GPA.100.047.01
High support jaw, mobile	125	-	-	150	-	105	GPA.125.047.01



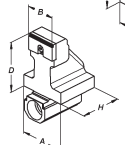
VS support jaw, high, fixed	100	-	-	125	-	80	GPA.100.048.01
VS support jaw, high, fixed	125	-	-	150	-	95	GPA.125.048.01



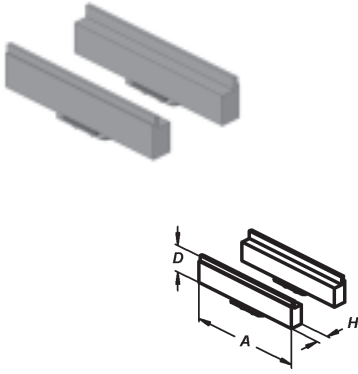
VS support jaw, high, mobile	100	-	-	125	-	91	GPA.100.049.01
VS support jaw, high, mobile	125	-	-	150	-	105	GPA.125.049.01



Support jaw, high, fixed 100/65	100	65	-	125	-	80	GPA.100.056.01
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Support jaw, high, mobile 100/65	100	65	-	125	-	91	GPA.100.057.01
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### Work piece supports, hardened and milled, with swivel-click bracket. (2 units per set)

Model	Jaw width [mm]	Measurement [mm]		Order No.
	A	D	H	
Work piece supports	100	11	10.5	GPA.100.033.01
Work piece supports	100	16	10.5	GPA.100.030.01
Work piece supports	100	23	10.5	GPA.100.036.01
Work piece supports	100	25.5	10.5	GPA.100.031.01
Work piece supports	100	29.5	10.5	GPA.100.032.01
Work piece supports	125	11	10.5	GPA.125.211.01
Work piece supports	125	16	10.5	GPA.125.216.01
Work piece supports	125	21	10.5	GPA.125.221.01
Work piece supports	125	25	10.5	GPA.125.225.01
Work piece supports	125	26	10.5	GPA.125.226.01
Work piece supports	125	29	10.5	GPA.125.229.01
Work piece supports	125	32.5	10.5	GPA.125.232.01
Work piece supports	125	36	10.5	GPA.125.236.01



### Quick-action device for gripos and gripos II

Model	Description	Order No.
Quick-action device	for fast jaw opening adjustment (unit)	GPA.000.032.01



### Handle for gripos

Model	Description	Order No.
Handle for gripos	for easy handling of the vices	GPA.000.029.01



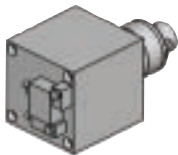
### Traction rod extension for gripos

Model	Description	Order No.
Traction rod extension	for gripos 100	GPA.100.026.01
Traction rod extension	for gripos 125	GPA.125.026.01



### Hydraulic cylinder for gripos

Model	Description	Order No.
Hydraulic cylinder	for gripos 125	GPH.125.062.01



### Pneumo-mechanical drive for gripos

Model	Description	Order No.
pneumo-mechanical drive	for gripos 100	GPP.100.062.01
pneumo-mechanical drive	for gripos 125	GPP.125.062.01



### Material stop for gripos and gripos II

Model	Description	Order No.
Material stop	for gripos and gripos II	MSA.000.275.01