Conventional Workholding

While the strengths of Makro·Grip stamping technology with its 5-Axis Vices are mainly seen in the processing of unmachined parts, clamping devices of the "Conventional Workholding" category offer multitude options for smooth clamping of round or shaped components. All "Conventional Workholding" vice components use the same base body as the Makro·Grip® 5-Axis Vice, are compatible and interchangeable. Different jaw types of "Conventional Workholding" are perfectly suited for the demanding machining of the 6th side and expand clamping possibilities in order to completely machine a workpiece.

→ Flexibility

One vice body for all jaw types

→ Versatility

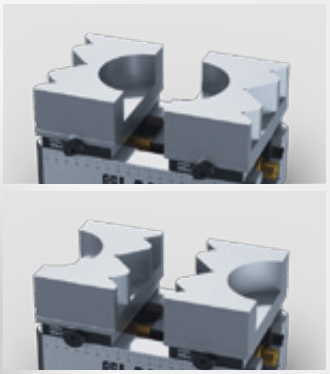
Suitable for almost any clamping task in milling

→ Setup Time Reduction

Fast jaw change over a variety of clamping configurations

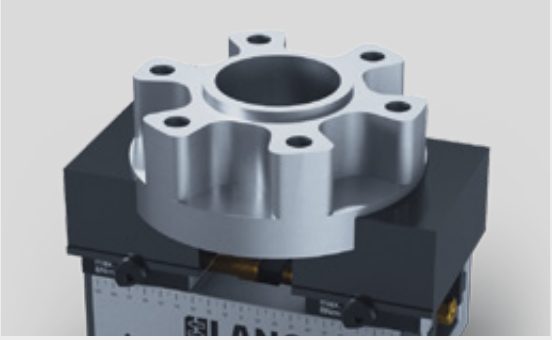
Avanti **Technology**

The universal vice with great handling characteristics and unbeatable add-on jaw prices!



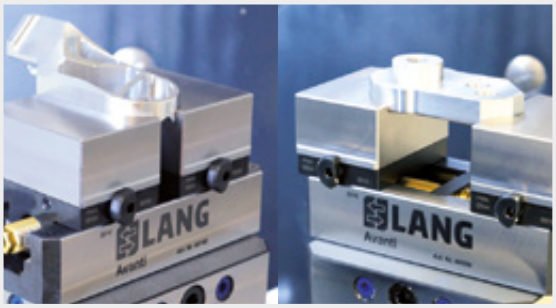
Large-volume steel or aluminium add-on jaw allows contours to be added on both sides of the jaws to use it for two different clamping applications.

1. Precise positioning of jaws thanks to patented clamping interface
2. Centring accuracy ± 0.02 mm
3. Double guided jaws
4. Integrated with clamping studs for precise clamping in the Quick·Point® zero-point clamping system
5. Add-on jaws available in steel or aluminium
6. Changing the jaws rapidly with only one screw (internal hexagon 5 mm)
7. Rigid and sturdy base – but still lightweight and handy



If the maximum clamping diameter (Ø 34 mm) of the Preci·Point Collet Chuck is not enough, the Avanti vice is a great choice to clamp round stock with a larger diameter. There is also a chance to customise add-on jaws with more height through our customising department (see page 136).

Avanti Quick Jaw Exchange System applications



Independent from the alignment of the workpiece a great variety of profiles can be clamped for best accessibility with the patented quick jaw exchange system. By adding contours on both sides of the jaws and through their maximum usable volume add-on jaws can be used twice.

How to prepare add-on jaws:
In order to get the best results when machining with the Avanti we recommend you simulate the future clamping setup as accurately as possible.

We suggest clamping a precision block at maximum torque between the top jaws while machining the workpiece contour into the add-on jaws.

Tip for your benefit:

Avanti adaptor jaw to use own clamping fixtures

As an interface for customised clamping fixtures such as prisms, a special Avanti adaptor jaw can be offered and manufactured upon request, making the system even more versatile.

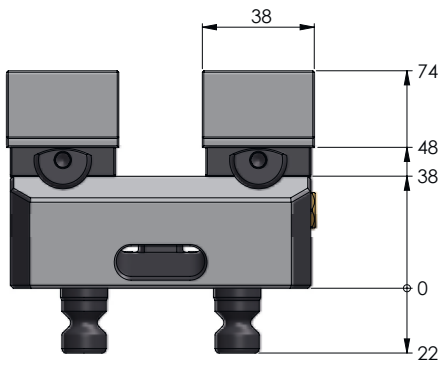
An individual borehole pattern (e.g. tapped holes or fittings) enables the simple assembly of your clamping fixture. Combine the benefits of the Avanti quick jaw exchange system with your own fixtures!

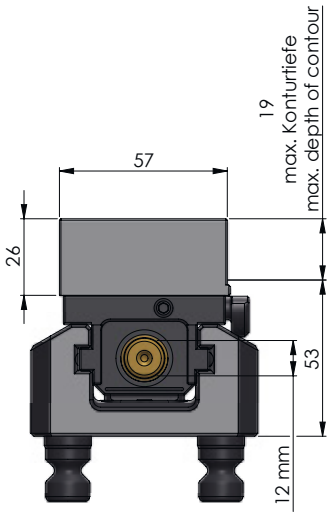
Avanti **77**

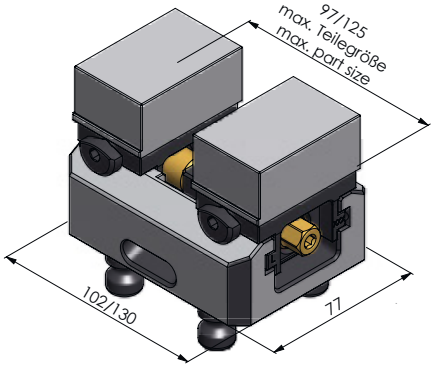
AVANTI 77, JAW WIDTH 46 MM

ITEM NO.	BASE LENGTH	MAX. CLAMPING RANGE	WEIGHT	PRICE	COMPARABLE PREVIOUS VERSION
44085-46	102 mm	97 mm	2.2 kg		44065
44120-46*	130 mm	125 mm	2.6 kg		44105

*automatable



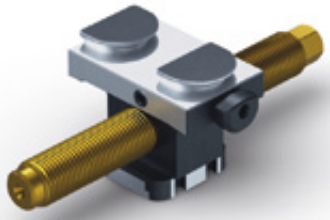


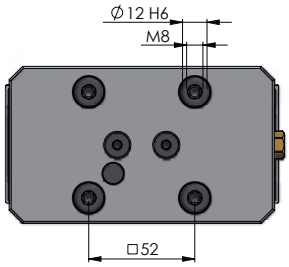


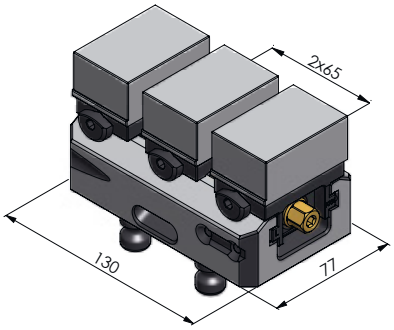
AVANTI 77 BASE JAWS, JAW WIDTH 46 MM

ITEM NO.	DIMENSIONS	WEIGHT	UNIT	PRICE	COMPARABLE PREVIOUS VERSION
44771-46	55 × 36 mm	0.6 kg	1 pair		44461

NEW







CENTRE BASE JAW + SPINDLE FOR AVANTI 77, JAW WIDTH 46 MM

ITEM NO.	SPINDLE LENGTH (+Ø)	FOR AVANTI	WEIGHT	PRICE
44120-TG46	135 mm (Ø 16 mm)	44120-46	0.5 kg	

AVANTI 46 ADD-ON JAWS, SOFT

ITEM NO.	MATERIAL	DIMENSIONS	WEIGHT	UNIT	PRICE
44468-26	Steel (16MnCr5)	57 × 38 × 26 mm	0.6 kg	1 pc.	
44469-26	Aluminium (F50)	57 × 38 × 26 mm	0.2 kg	1 pc.	

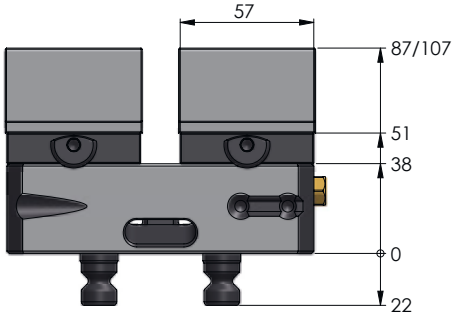
Add-on jaws fit the new base jaw version and also the previous one.

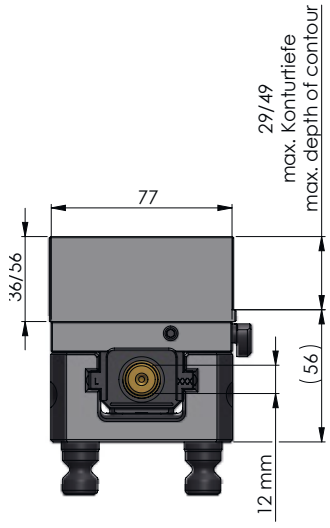
Avanti **77**

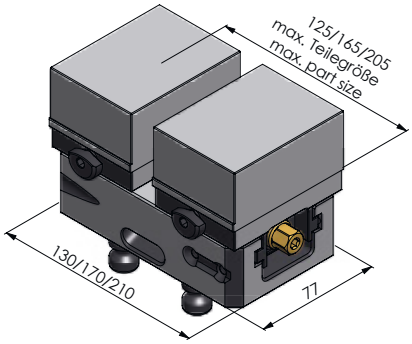
AVANTI 77, JAW WIDTH 77 MM

ITEM NO.	BASE LENGTH	MAX. CLAMPING RANGE	WEIGHT	PRICE	COMPARABLE PREVIOUS VERSION
44120-77*	130 mm	125 mm	3.5 kg		44120
44160-77	170 mm	165 mm	4.2 kg		44160
44200-77	210 mm	205 mm	4.8 kg		44200

*automatable



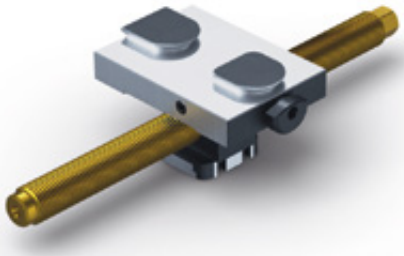


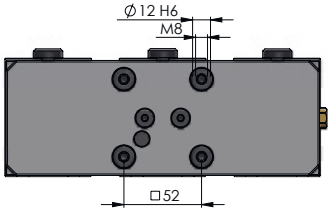


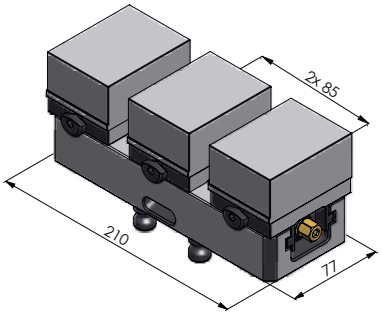
AVANTI 77 BASE JAWS, JAW WIDTH 77 MM

ITEM NO.	DIMENSIONS	WEIGHT	UNIT	PRICE	COMPARABLE PREVIOUS VERSION
44771-77	77 × 57 mm	1.4 kg	1 pair		44771

NEW







CENTRE BASE JAW + SPINDLE FOR AVANTI 77, JAW WIDTH 77 MM

ITEM NO.	SPINDLE LENGTH (+Ø)	FOR AVANTI	WEIGHT	PRICE
44200-TG77	215 mm (Ø 16 mm)	44200-77	0.9 kg	

AVANTI 77 ADD-ON JAWS, SOFT

ITEM NO.	MATERIAL	DIMENSIONS	WEIGHT	UNIT	PRICE
44778-36	Steel (16MnCr5)	78 × 58 × 36 mm	0.6 kg	1 pc.	
44779-36	Aluminium (F50)	78 × 58 × 36 mm	0.2 kg	1 pc.	
44778-56	Steel (16MnCr5)	78 × 58 × 56 mm	0.9 kg	1 pc.	
44779-56	Aluminium (F50)	78 × 58 × 56 mm	0.3 kg	1 pc.	

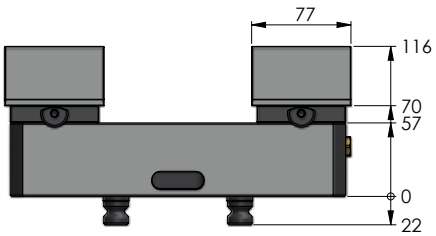
Add-on jaws fit the new base jaw version and also the previous one.

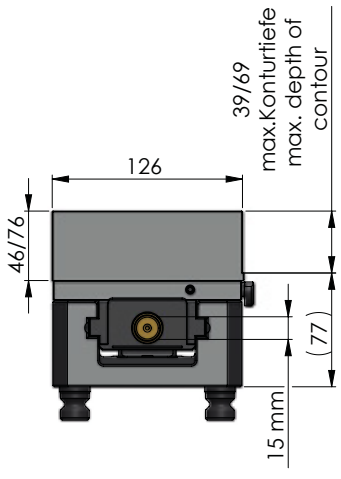
Avanti **125**

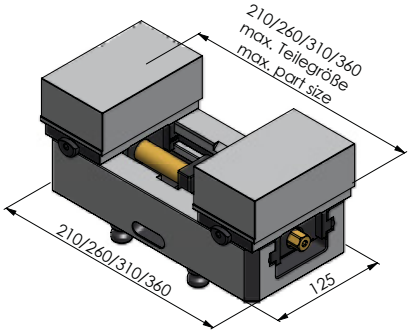
AVANTI 125, JAW WIDTH 125 MM

ITEM NO.	BASE LENGTH	MAX. CLAMPING RANGE	WEIGHT	PRICE	COMPARABLE PREVIOUS VERSION
44205-125*	210 mm	210 mm	11.3 kg		44205
44255-125	260 mm	260 mm	13.2 kg		44255
44305-125	310 mm	310 mm	15.1 kg		44305
44355-125	360 mm	360 mm	16.9 kg		44355

*automatable



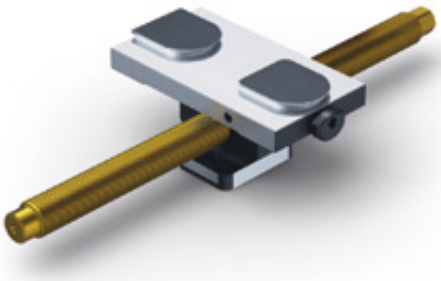


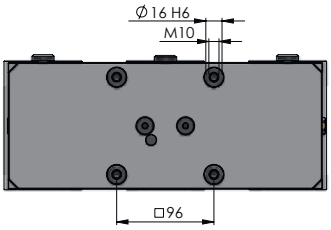


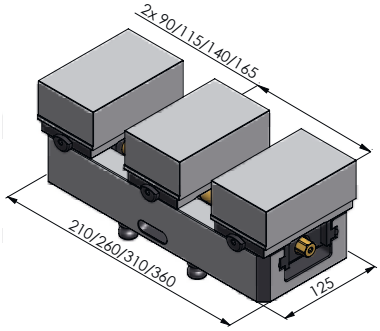
AVANTI 125 BASE JAWS

ITEM NO.	DIMENSIONS	WEIGHT	UNIT	PRICE	COMPARABLE PREVIOUS VERSION
44251-125	125 × 69 mm	3.7 kg	1 pair		44251

NEW







CENTRE BASE JAW + SPINDLE FOR AVANTI 125

ITEM NO.	SPINDLE LENGTH (+Ø)	FOR AVANTI	WEIGHT	PRICE
44255-TG125	264 mm (Ø 20 mm)	44255-125	2.1 kg	
44305-TG125	314 mm (Ø 20 mm)	44305-125	2.2 kg	
44355-TG125	364 mm (Ø 20 mm)	44355-125	2.3 kg	

AVANTI 77 ADD-ON JAWS, SOFT

ITEM NO.	MATERIAL	DIMENSIONS	WEIGHT	UNIT	PRICE
44258-46	Steel (16MnCr5)	126 × 77 × 46 mm	3.3 kg	1 pc.	
44259-46	Aluminium (F50)	126 × 77 × 46 mm	1.1 kg	1 pc.	
44258-76	Steel (16MnCr5)	126 × 77 × 76 mm	5.5 kg	1 pc.	
44259-76	Aluminium (F50)	126 × 77 × 76 mm	1.8 kg	1 pc.	

Add-on jaws fit the new base jaw version and also the previous one.