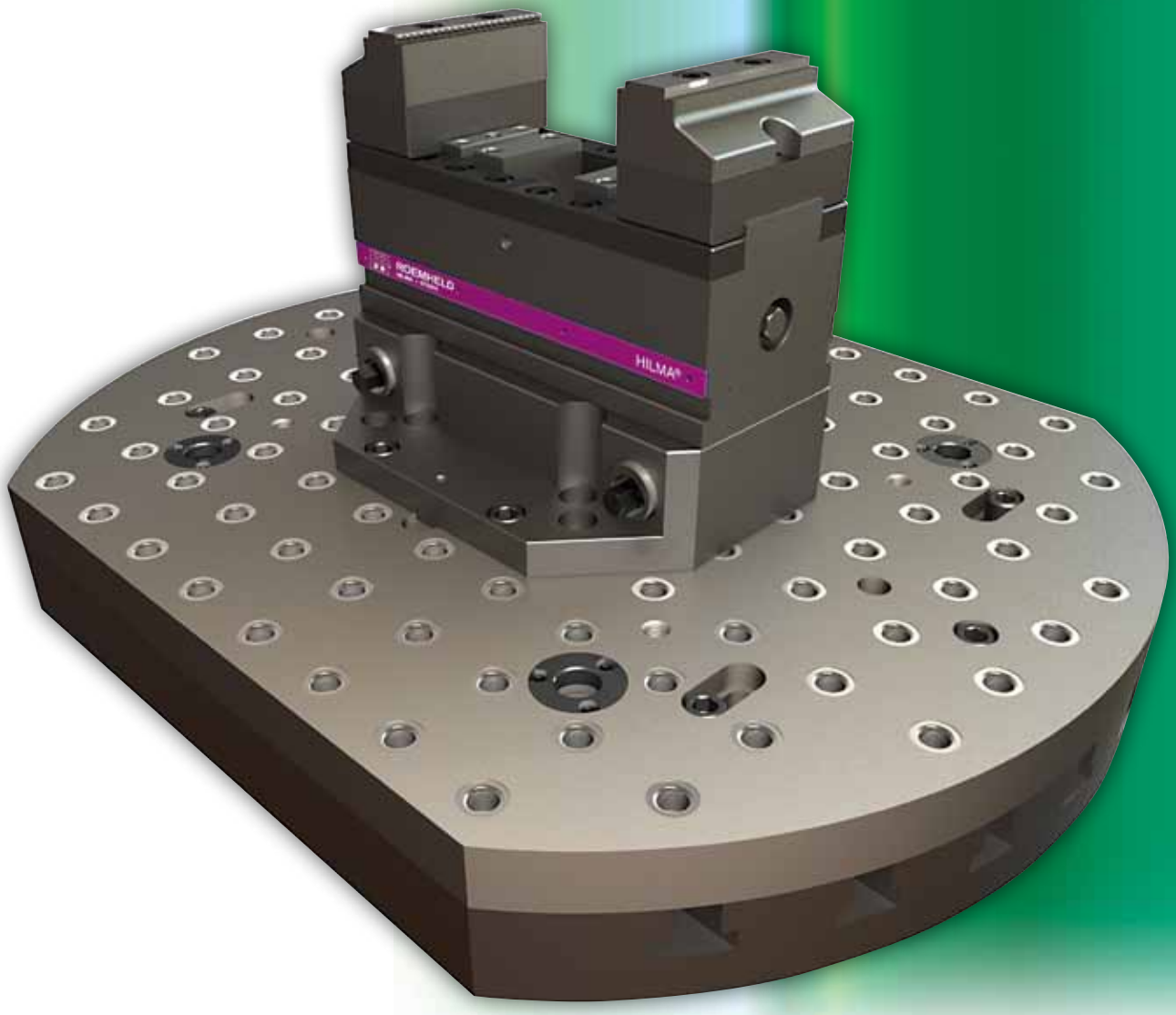
CL5™

QUICK-CHANGE 5-AXIS WORKHOLDING



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MANUFACTURING CO.
4200 Carr Lane Ct., P.O. Box 191970 • St. Louis, Missouri 63119-7970 USA
Phone: 314/647-6200 • Fax: 314/647-5736 • Web Site: www.carrlane.com

ROEMHELD
HILMA ■ STARK

THE 5-AXIS WORKHOLDING SOLUTION

Top Tooling

- Connect directly to the Quintus Quick-Change Riser



Blank Fixture Plate



5-Axis Vise



Multifunction Fixture Plate

Quintus Quick-Change Riser

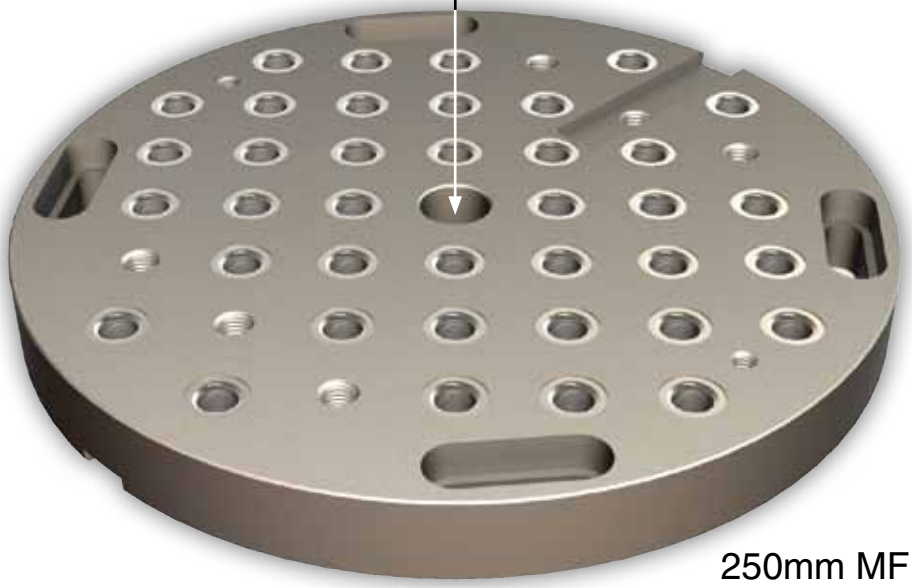
- No extra adaptors required
- Connects to any subplate



Quintus Riser

Subplate

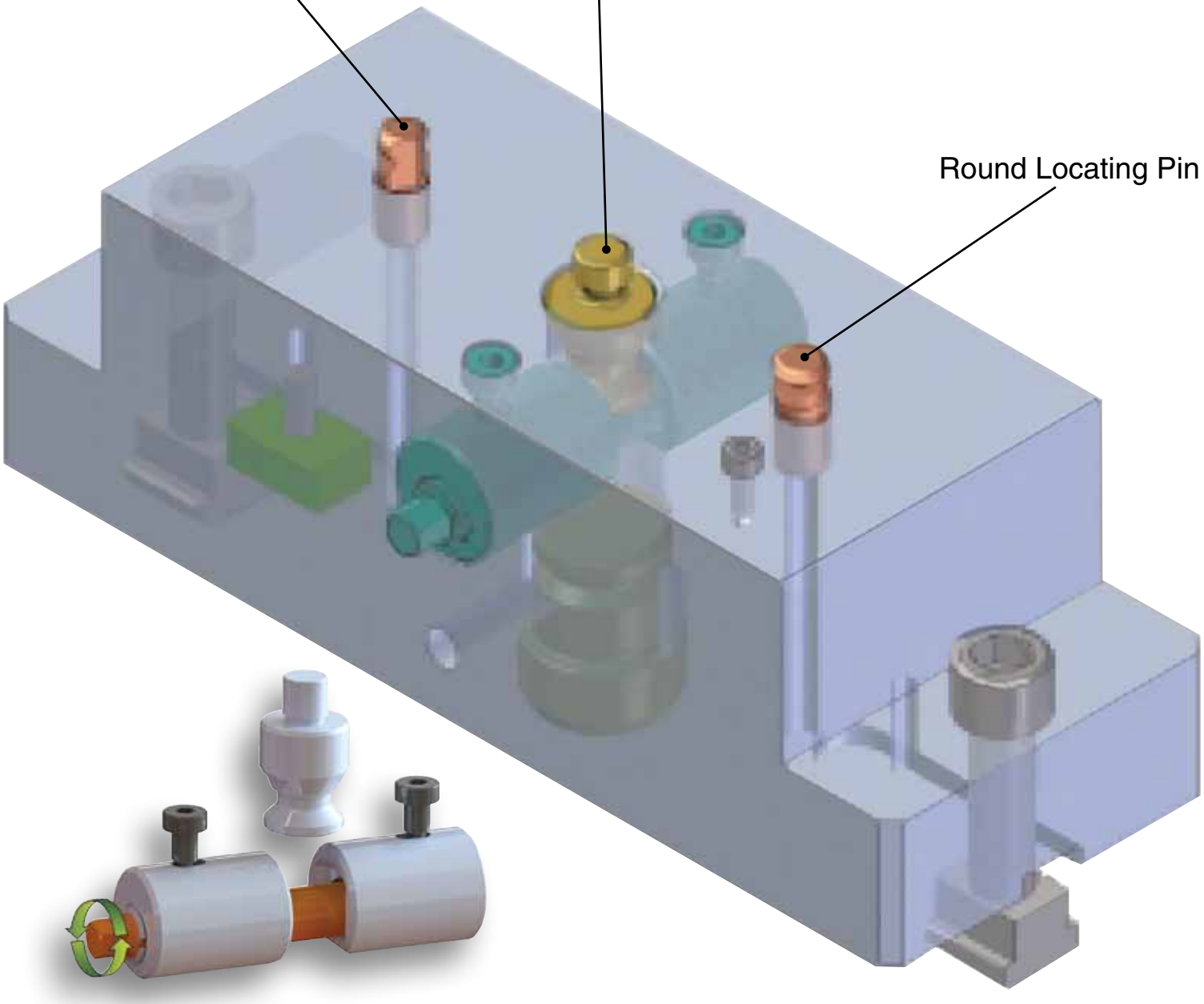
- 7 standard sizes
- Custom plates available
- Use alone or with risers and plates



250mm MF Subplate

WITH QUICK-CHANGE AT ITS CORE!

The Quintus Quick-Change Riser



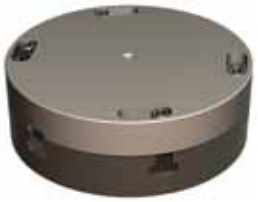
Quintus Mechanism

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CL5™ PLATES

Plates Available Fall 2013

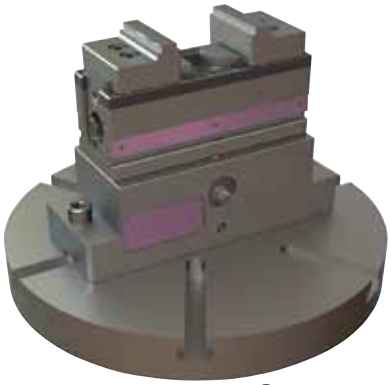


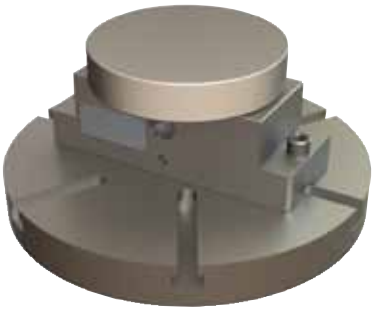


Method 1

Fixture Plate Mounted on Rotary Table

- Ideal for small rotary tables up to 210mm diameter.
- Fixture plates are accurately located and fastened directly to the rotary table.

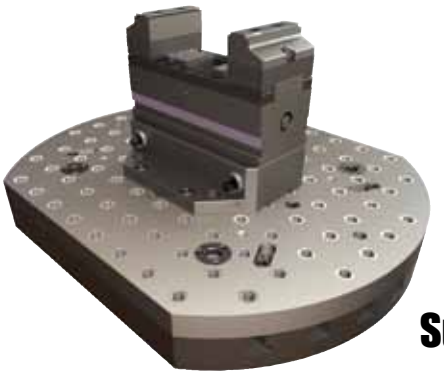
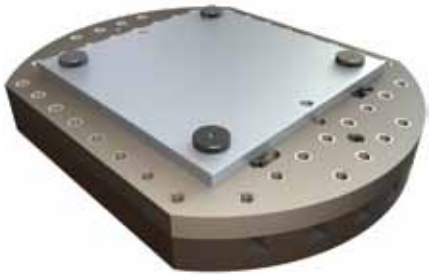
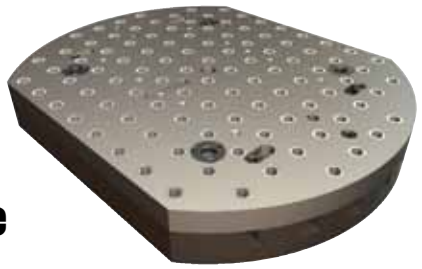




Method 2

Quintus Quick-Change Riser Mounted on Rotary Table

- Quintus Quick-Change Riser provides additional height for spindle clearance
- Can be quickly and accurately mounted directly on rotary tables 250mm diameter and larger.

Method 3

Subplate Mounted on Rotary Table

- Appropriate for all machines.
- May be used by itself as Modular Fixturing, or a Quintus Riser or Carr Lock™ plate may be mounted on the subplate to allow quick exchange of fixtures.

See compatibility chart on back cover.

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MC Z Series
Concentric
Mechanical

Jaw Widths 40 • 60 • 100 • 125 (mm)

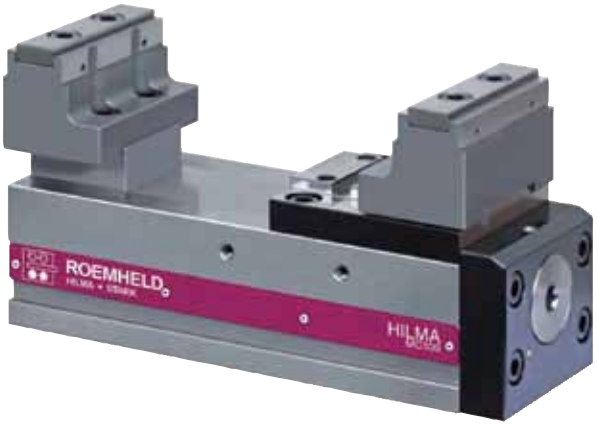
- Two moving jaws that provide exact centering of the workpiece
- Allows unrestricted tool access for 5-sided machining



MC Series
Fixed Jaw
Mechanical

Jaw Widths 40 • 60 • 100 (mm)

- Conventional vise style with 1 fixed and 1 moving jaw
- Allows unrestricted tool access for 5-sided machining



SCS Series
Fixed Jaw
Mechanical

Jaw Widths 80 • 120 (mm)

- Most economical choice for larger workpieces
- Conventional vise style with 1 fixed and 1 moving jaw
- Allows unrestricted tool access for 5-sided machining



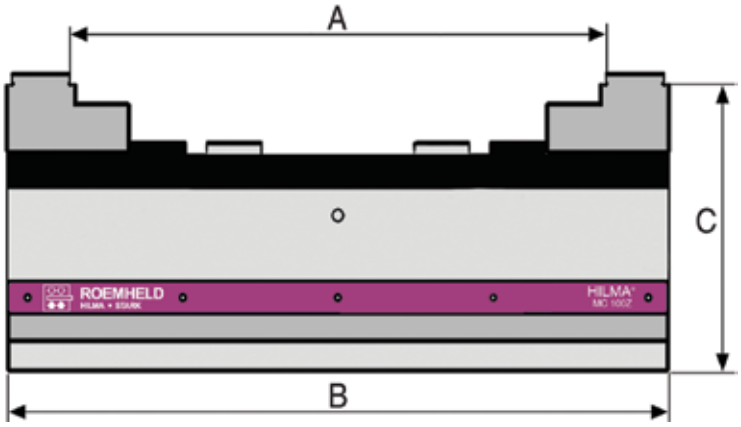
MC CONCENTRIC VISE



MC-Z

MC-Z Series - Concentric

Operation	Manual	Manual	Manual	Manual
Jaw Width (mm)	MC 40Z	MC 60Z	MC 100Z	MC 125Z
	40	60	100	125
Max. clamping force (lbs)	1700	3400	5600	7800
Max. clamping torque required (ft-lbs)	17	37	59	148
Clamping stroke (mm)	20	30	73	75
A (mm-max)	79	91	204	400
B (mm) (mm)	110	170	260	465
C	64	88	154	160
Weight without jaws (lbs)	3.1	8.4	39.3	108
Part No., Vise	**CLRH-9-3581-0302-VS**	**CLRH-9-3583-0301-VS**	**CLRH-9-3585-0303-VS**	**CLRH-9-3586-0304-VS**



Concentric (MC 40 Z, MC 60 Z, MC 100 Z, and MC 125 Z)

- Know where the center of your workpiece is every time
- Designed specifically for 5-Axis machining
- Free access to the workpiece which allows the use of shorter standard tools
- Simple and robust construction, smooth surfaces, easy cleaning
- One-piece machined steel base
- Highest precision
- Also suitable for standard machining
- Comprehensive jaw program (see page 11)

See compatibility chart on back cover.

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MC STANDARD VISE

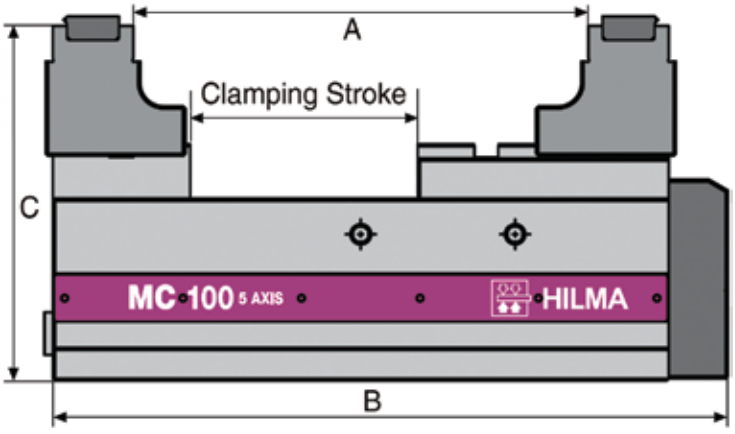


MC

MC Series

Operation	Manual	Manual	Manual
Jaw Width (mm)	MC 40	MC 60	MC 100
	40	60	100
Max. clamping force (lbs)	1800	3400	5620
Max. clamping torque required (ft-lbs)	11	19	45
Clamping stroke (mm)	30	44	96
A (mm-max)	79	150	204
B (mm)	110	187	285
C (mm)	64	88	154
Weight without jaws (lbs)	4	7.3	44
Part No., Vise	**CLRH-9-3581-0102-VS**	**CLRH-9-3583-0112-VS**	**CLRH-9-3585-0113-VS**

- For multi-face machining with a single clamping operation
- Simple and robust constuction, smooth surfaces, easy cleaning
- Maximum clamping force 5620 lbs.
- Allows unrestricted tool access for multiple-side machining
- One-piece machined steel base



See compatibility chart on back cover.

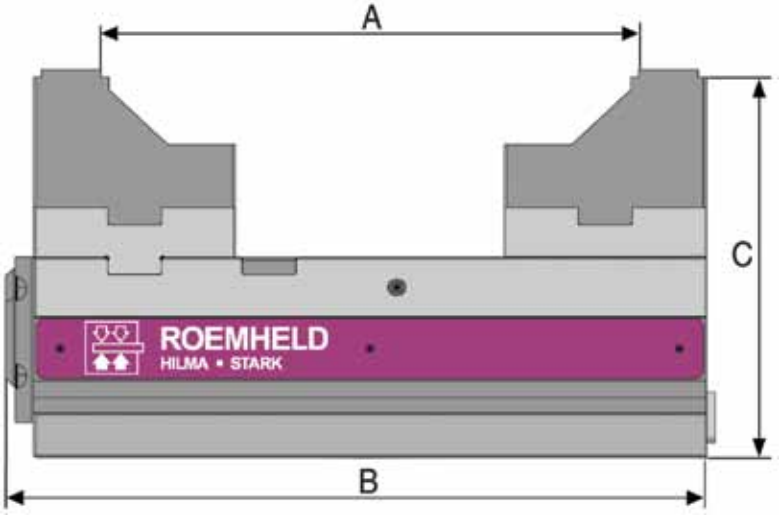
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SCS STANDARD VISE



TYPE	PART NO.	CLAMPING FORCE (lb)	WEIGHT (lb)	JAW TRAVEL	mm		
					A	B	C
SCS 80M	CLRH-9-3672-0121-VS	5600	19	80	155	206	145
SCS 120M	CLRH-9-3673-0121-VS	9000	40	100	200	260	152

- For multi-face machining with a single clamping operation
- Reversible jaws yield clamping ranges from 6mm to 155mm or 8mm to 200mm
- Maximum clamping force 5600 or 9000 lbs.
- Allows unrestricted tool access for multiple-side machining
- One-piece machined cast-iron base



See compatibility chart on back cover.

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QUINTUS



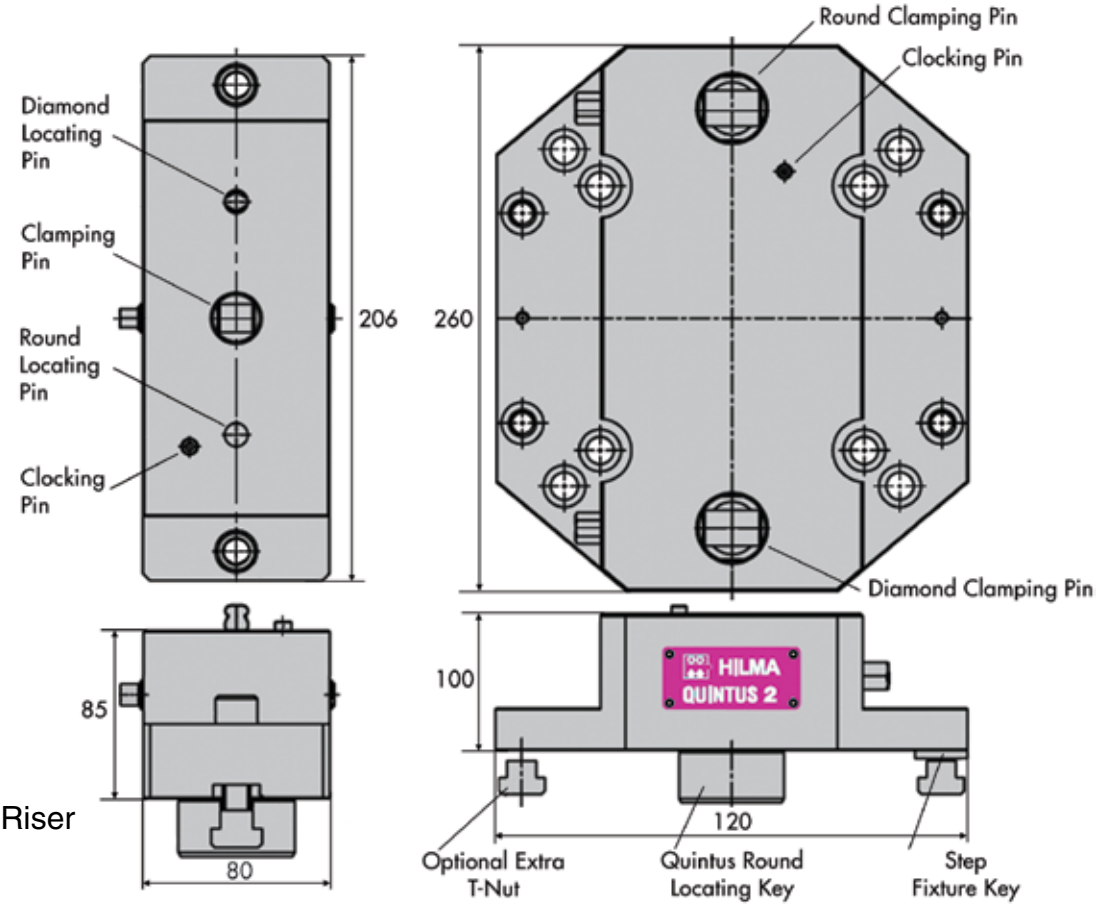
Quick Change Riser:

QUINTUS 1



Quick Change Riser:

QUINTUS 2



- Vises and fixture plates mount directly onto the Quintus Quick-Change Riser
- Two sizes
- Extremely accurate

QUINTUS 1

CLRH-9-6153-0101-VSA

2700 Lb Retention Force Per Clamping Pin

QUINTUS 2

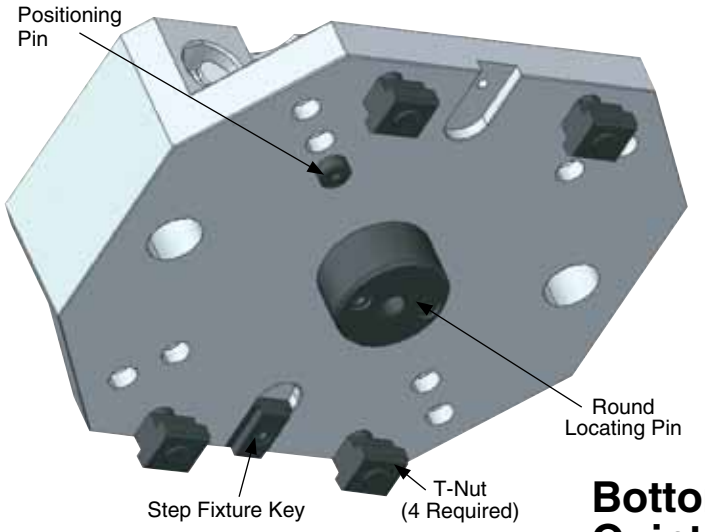
CLRH-9-6155-0102-VSA

4500 Lb Retention Force Per Clamping Pin

See compatibility chart on back cover.

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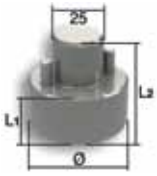
QUINTUS PINS & ACCESSORIES



Bottom View of Quintus 2

Round Locating Key

for Quintus 1, 2, 3



PART NO.	Ømm	L_1 / L_2
CLRH-9-6153-5001-VSA	D 30 g6	15/38
CLRH-9-6153-5002-VSA	D 32 g6	15/38
CLRH-9-6153-5003-VSA	D 50 g6	25/48
CLRH-9-6153-5009-VSA	D 50 g6	18/41

Step Fixture Key

CLM-6x16-SHCS screw required



PART NO.	FIXTURE SLOT	TABLE SLOT
CLRH-9-6153-5004-VSA	20mm	14mm
CL-20-SFK-16	20mm	16mm
CL-20-SFK-18	20mm	18mm
CLM-20-FK	20mm	20mm



Quintus Pin Sets

PART NO.	INCLUDES
CLRH-9-3920-0201-VSA	QUINTUS 1 - w/o Centering
CLRH-9-3920-0202-VSA	QUINTUS 2 - Round & Diamond Pin
CLRH-9-3920-0203-VSA	QUINTUS 3

Positioning Pin

for Quintus 2. 1 piece



PART NO.	Ømm
CLRH-9-3920-0102-VSA	10/14 h6

T-Nut

with screw (set of 4)



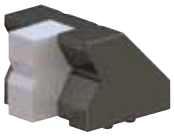
PART NO.		T-SLOT (mm)
CLRH-9-6153-5005-VSA	M12x30mm	14

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VISE JAWS

Please add “CLRH-” before, and “-VSA” after each part number.

Example: CLRH-9-3XXX-XXXX-VSA

				MC40	MC40Z	MC60	MC60Z	SCS80	MC100	MC100Z	SCS120	MC125Z
	Soft Jaw	Machinable soft jaw	Movable Jaw	9-3581-6902	9-3583-6902	9-3583-6902	9-3583-6902	9-3972-1201	9-3585-6902	9-3585-6902	9-3973-1201	9-3586-6902
			Fixed jaw	9-3581-6902	—	9-3583-6902	—	—	9-3585-6902	—	—	—
			Aluminum	—		—		9-3972-1202	—		9-3973-1202	
	Step Jaw	Reversible step jaw, 2 steps, hardened	Movable Jaw	9-3581-6901	9-3581-6901	9-3583-6901	9-3583-6901	—	9-3585-6901	9-3585-6901	—	9-3586-6901
			Fixed jaw	9-3581-6901	—	9-3583-6901	—		9-3585-6901	—		—
	Vee Jaw	Vee jaw with removable insert for increased part range	—	—	—	—	9-3583-6905	—	—	9-3585-6905	—	—
	Step Jaw w/Insert	Interchangable standard insert, one side serrated, one side smooth- May be replaced with custom inserts	Wide	—	—	9-3583-6906	9-3583-6906	—	9-3585-6906	9-3585-6906	—	9-3586-6906
			Medium			9-3583-6907	9-3583-6907		9-3585-6907	9-3585-6907		9-3586-6907
			Narrow (pictured)			—	—		9-3585-6908	9-3585-6908		—
	Pendulum Jaw	With Insert, for compensating non-parallel clamping surfaces	—	—	—	—	—	—	—	9-3585-6904	—	9-3586-6904
	Step Jaw Solid	Reversible step jaw, 2 steps, hardened, smooth grip edge	Narrow	—	—	—	—	9-3972-1001	—	—	9-3973-1001	—
			Medium					9-3972-1002			9-3973-1002	
			Wide					9-3972-1003			9-3973-1003	
	High Grip Jaw	Special grip reversible step jaw, hardened, serrated grip edge	Narrow	—	—	—	—	9-3972-1101	—	—	9-3973-1101	—
			Medium					9-3972-1102			9-3973-1102	
			Wide					9-3972-1103			9-3973-1103	

For dimensions and details please visit www.carrlane.com/featured.

See compatibility chart on back cover.

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COMPATIBILITY CHART

Base	Additional Riser	Workholder	Size	Table Diameter															
				110mm	130mm	160mm	200mm	210mm	250mm	260mm	300mm	310mm	320mm	400mm	450mm	500mm	500 x 400mm	600mm	630 x 500mm
Vise Adaptor Plate		5-Axis Vise	MC40	●	●	●	●	●	●	●									
			MC60			●	●	●	●	●	●	●	●	●					
			MC60Z Concentric			●	●	●	●	●	●	●	●	●					
			SCS80			●	●	●	●	●	●	●	●	●					
			MC100Z Concentric								●	●	●	●					
			MC100								●	●	●	●					
			SCS120								●	●	●	●					
Modular Fixture Plate	Riser Block		130mm Round	●	●														
			160mm Round			●													
			210mm Round				●	●											
			250mm Round						●	●									
			310mm Round								●	●	●	●					
Blank Fixture Plate			130mm Round	●	●														
			160mm Round			●													
			210mm Round				●	●											
			250mm Round						●	●									
			310mm Round								●	●	●	●					
Quintus 1		5-Axis Vise	MC40						●	●	●	●	●	●	●	●	●	●	●
			MC60						●	●	●	●	●	●	●	●	●	●	●
			MC60Z Concentric						●	●	●	●	●	●	●	●	●	●	●
			SCS80						●	●	●	●	●	●	●	●	●	●	●
		Modular Fixture Plate	130mm Round						●	●	●	●	●	●	●	●	●	●	●
			160mm Round						●	●	●	●	●	●	●	●	●	●	●
			100 x 250mm Rectangular						●	●	●	●	●	●	●	●	●	●	●
			150 x 250mm Rectangular						●	●	●	●	●	●	●	●	●	●	●
		Blank Fixture Plate	130mm Round						●	●	●	●	●	●	●	●	●	●	●
			160mm Round						●	●	●	●	●	●	●	●	●	●	●
			100 x 250mm Rectangular						●	●	●	●	●	●	●	●	●	●	●
			150 x 250mm Rectangular						●	●	●	●	●	●	●	●	●	●	●
Quintus 2		5-Axis Vise	MC100Z Concentric								●	●	●	●	●	●	●	●	●
			MC100								●	●	●	●	●	●	●	●	●
			SCS120								●	●	●	●	●	●	●	●	●
		Modular Fixture Plate	250mm Round								●	●	●	●	●	●	●	●	●
		Blank Fixture Plate	250mm Round								●	●	●	●	●	●	●	●	●
Quintus 3		5-Axis Vise	MC125Z Concentric												●	●	●	●	●
Subplate	Quintus 1	5-Axis Vise	MC40						●	●	●	●	●	●				●	●
			MC60						●	●	●	●	●	●				●	●
			MC60Z Concentric						●	●	●	●	●	●				●	●
			SCS80						●	●	●	●	●	●				●	●
		Modular Fixture Plate	130mm Round						●	●	●	●	●	●				●	●
			160mm Round						●	●	●	●	●	●				●	●
			100 x 250mm Rectangular						●	●	●	●	●	●				●	●
			150 x 250mm Rectangular						●	●	●	●	●	●				●	●
		Blank Fixture Plate	130mm Round						●	●	●	●	●	●				●	●
			160mm Round						●	●	●	●	●	●				●	●
			100 x 250mm Rectangular						●	●	●	●	●	●				●	●
			150 x 250mm Rectangular						●	●	●	●	●	●				●	●
Subplate	Quintus 2	5-Axis Vise	MC100Z Concentric								●	●	●	●				●	●
			MC100								●	●	●	●				●	●
			SCS120								●	●	●	●				●	●
		Modular Fixture Plate	250mm Round								●	●	●	●				●	●
		Blank Fixture Plate	250mm Round								●	●	●	●				●	●
Subplate	Quintus 3	5-Axis Vise	MC125Z Concentric															●	●
Subplate		Carr Lock Fixture Plate	14 x 14 Square															●	●
			400 x 400mm Square															●	●

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