

Centering vise

model **CVH**

model CVH08

model CVH06

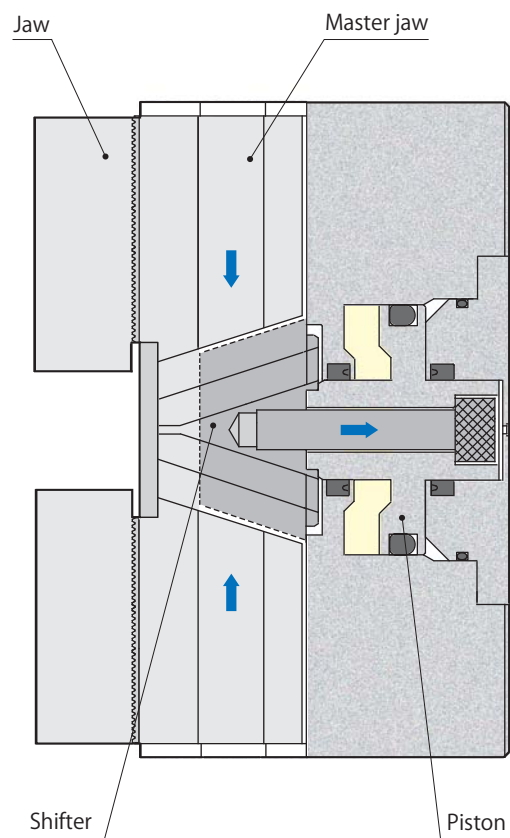


model CVH04

model CVH□□



Best suited for milling after lathe turning



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Specifications

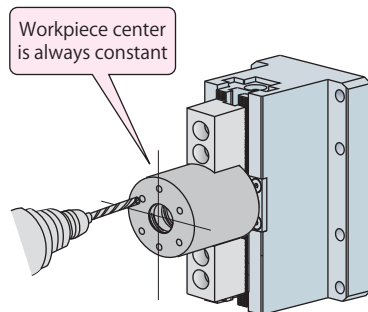
Size	Piping method	
CVH 04	G : Manifold piping	(Nil) : Standard
06	S : Rc thread piping	J : Long stroke
08		

Refer to **page →200** for long stroke.

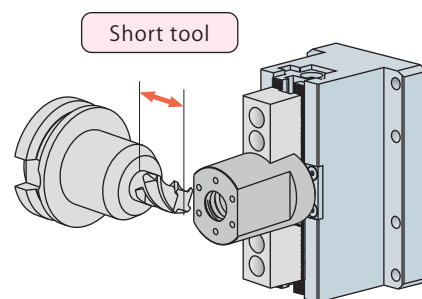
■ indicates made to order.

Model		CVH04 (4 inch)	CVH06 (6 inch)	CVH08 (8 inch)
Clamping force (hydraulic pressure 7MPa)	kN	10	20	30
Jaw stroke (diameter)	mm	5.6	5.8	6.0
Max. grip outer diameter	mm	100	145	190
Max. grip inner diameter	mm	125	170	220
Cylinder capacity	Grip outer diameter	cm ³	23.7	34.6
	Grip inner diameter	cm ³	11.6	11.6
Mass	kg	4.6	8.3	15.3
Recommended tightening torque of mounting screws*	N·m	12	29	57
Recommended tightening torque of jaw mounting screws*	N·m	29	57	77
Recommended positioning pin		∅6 (m6) × 18	∅8 (m6) × 24	∅10 (m6) × 30

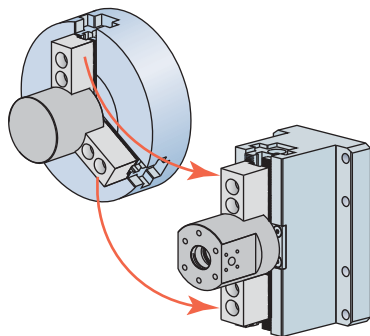
- Pressure range: 1–7 MPa
- Proof pressure: 10.5 MPa
- Operating temperature: 0–70 °C
- Fluid used: General mineral based hydraulic oil (ISO-VG32 equivalent) * : ISO R898 class 12.9



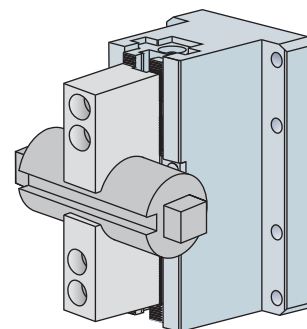
- Since both jaws stroke with centering vise, center datum processing is possible even when external shape of workpiece is variable.



- Centering vise minimizes tool interference and facilitates stable cutting process with comfortable tool length.

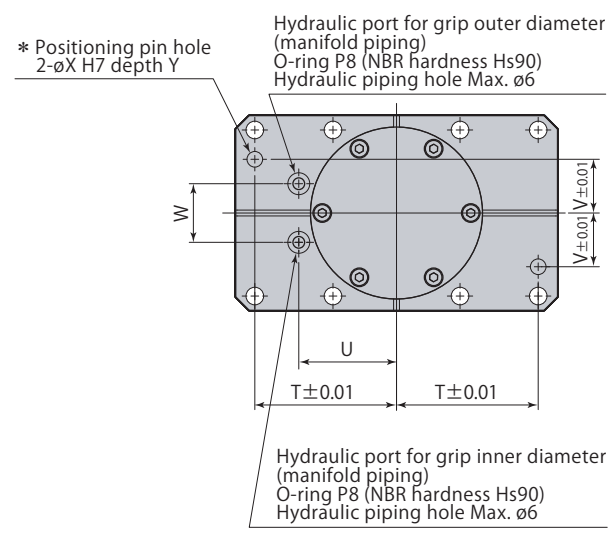
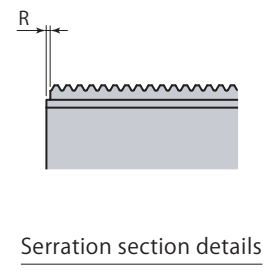
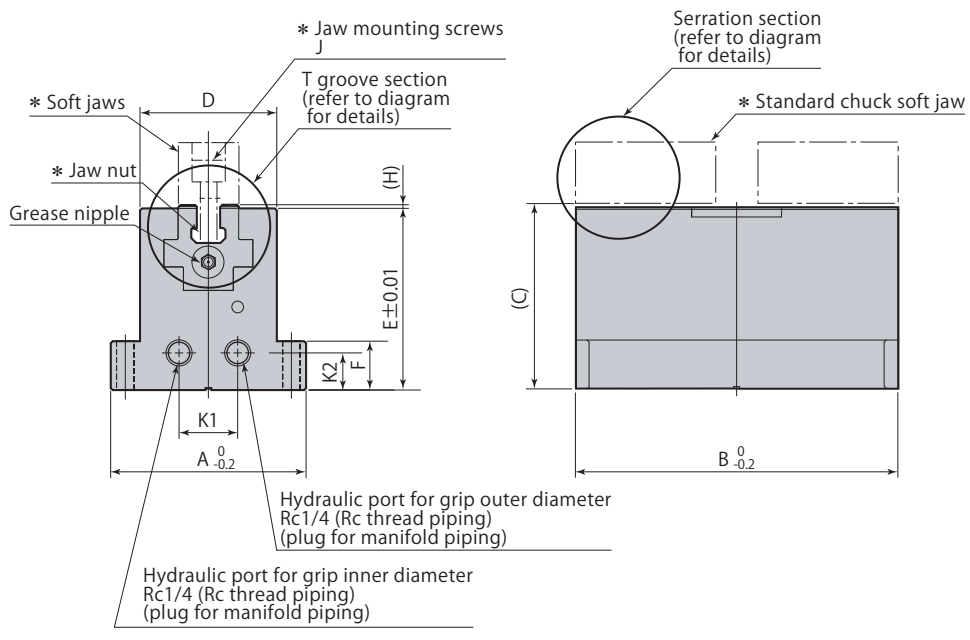
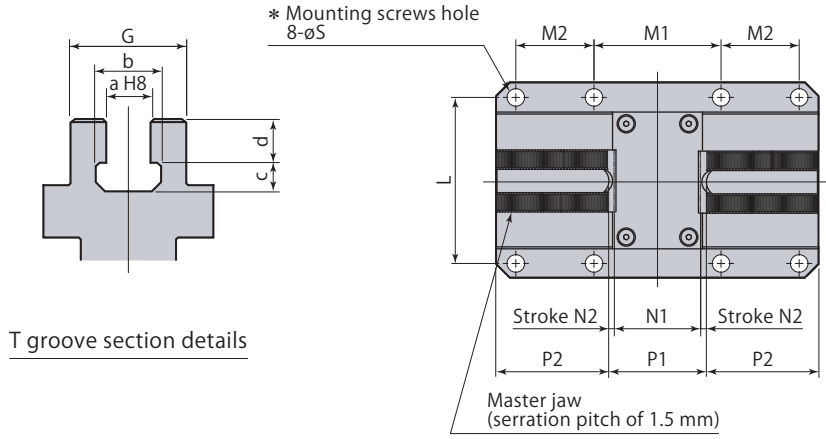


- Soft jaw used for lathe turning process can be mounted on centering vise, thereby eliminating fabrication of soft jaw at machining center.



- One chuck machining for diverse shapes of workpiece using self-cut soft jaw.

Dimensions



* : Soft jaws, jaw nuts, mounting screws and positioning pins are not included.

Centering vise

CVH Standard

CVH □□	Centering vise Standard	7MPa	Double acting
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Model	CVH04□	CVH06□	CVH08□
A	90	100	125
B	120	165	210
C	84.85	94.85	109.85
D	60	70	85
E	83	93	108
F	20	25	30
G	27	31	35
H	1.85	1.85	1.85
J	M8	M10	M12
K1	30	30	35
K2	17	19	19
L	75	85	105
M1	45	65	60
M2	30	40	60
N1	38.6	44.2	64.9
N2	2.8	2.9	3
P1	44.2	50	70.9
P2	37.5	57	69
R	0.4	0.5	0.55
øS	6.8	9	11
T	52.5	72.5	90
U	42.5	50	75
V	27.5	27.5	35
W	30	30	35
øX	6 ^{+0.012} ₀	8 ^{+0.015} ₀	10 ^{+0.015} ₀
Y	9	12	15
a	10 ^{+0.022} ₀	12 ^{+0.027} ₀	14 ^{+0.027} ₀
b	15.5	18.5	21.5
c	6	8	10
d	10	12	13

- The diagram shown on the left indicates the jaw strokes out when gripping inner diameter.
- The mounting surface finish must be no rougher than Rz6.3 (ISO4287:1997).

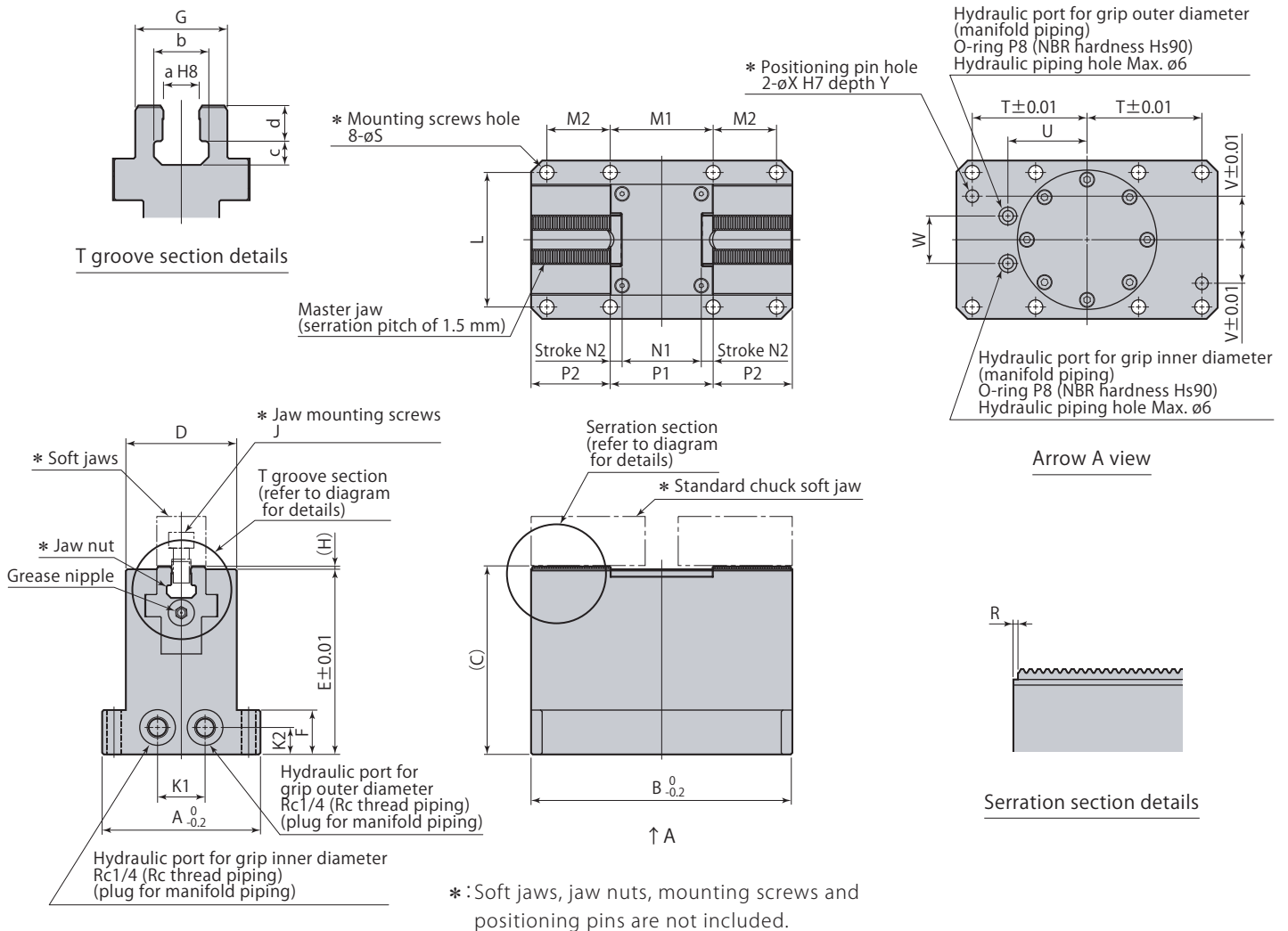
Centering vise
CVH Standard

Specifications

Model		CVH04□-J (4 inch)	CVH06□-J (6 inch)	CVH08□-J (8 inch)
Clamping force	Outer diameter (hydraulic pressure 7MPa)	kN 10	20	30
	Inner diameter (hydraulic pressure 5MPa)	kN 9	17	25
Jaw stroke (diameter)	mm	12.1	13	13
Max. grip outer diameter	mm	100	145	190
Max. grip inner diameter	mm	125	170	220
Cylinder capacity	Grip outer diameter	cm ³ 24.7	52.5	74.2
	Grip inner diameter	cm ³ 29.5	62.3	88.4
Mass	kg	5.8	10	17.9
Recommended tightening torque of mounting screws*	N·m	12	29	57
Recommended tightening torque of jaw mounting screws*	N·m	29	57	77
Recommended positioning pin		ø6 (m6) × 18	ø8 (m6) × 24	ø10 (m6) × 30

- Pressure range: 1–7 MPa (grip outer diameter), 1–5 MPa (grip inner diameter)
- Proof pressure: 10.5 MPa (grip outer diameter), 7.5 MPa (grip inner diameter)
- Operating temperature: 0–70 °C
- Fluid used: General mineral based hydraulic oil (ISO-VG32 equivalent) * : ISO R898 class 12.9

Dimensions



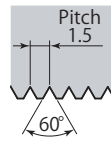
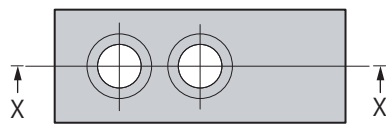
Centering vise
CVH
Long stroke

CVH□□-J	Centering vise Long stroke	7MPa	Double acting
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Model	CVH04□-J	CVH06□-J	CVH08□-J
A	90	100	125
B	130	165	210
C	100.85	118.85	133.85
D	60	70	85
E	99	117	132
F	20	28	30
G	27	31	35
H	1.85	1.85	1.85
J	M8	M10	M12
K1	30	30	35
K2	17	17	19
L	75	85	105
M1	45	65	60
M2	30	40	60
N1	41.9	51.4	63.7
N2	6.05	6.5	6.5
P1	54	64.4	76.7
P2	37.5	49.5	66
R	0.5	0.8	0.6
øS	6.8	9	11
T	52.5	72.5	90
U	42.5	50	75
V	27.5	27.5	35
W	30	30	35
øX	6 ^{+0.012} ₀	8 ^{+0.015} ₀	10 ^{+0.015} ₀
Y	9	12	15
a	10 ^{+0.022} ₀	12 ^{+0.027} ₀	14 ^{+0.027} ₀
b	15.5	18.5	21.5
c	6	8	10
d	10	12	13

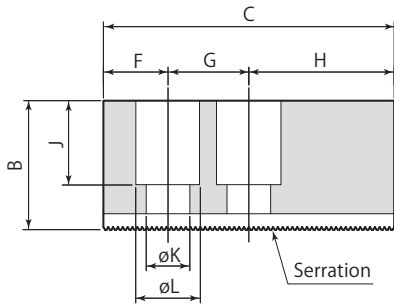
- The diagram shown on the left indicates the jaw strokes out when gripping inner diameter.
- The mounting surface finish must be no rougher than Rz6.3 (ISO4287:1997).

Centering vise
CVH
Long stroke

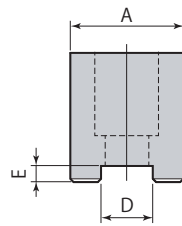
Jaw (option)

Material : S50C

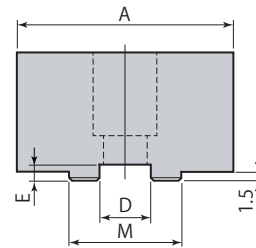
Serration section details



X-X



Standard jaw & tall jaw



Wide jaw

- Jaw (soft jaw) is supplied in sets of two. Specify number of sets when ordering. (Example : CVJ06-N×1 set)

Model	Soft jaw shape	A	B	C	D	E	F	G	H	J	øK	øL	M
CVJ04-N	Standard jaw	23	25	55	10	4	13	14	28	16	8.5	13.5	-
CVJ04-H	Tall jaw	23	48							39			-
CVJ04-W	Wide jaw	60	25							16			23

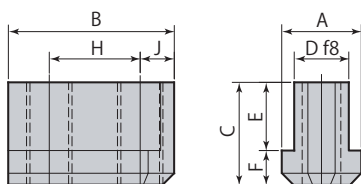
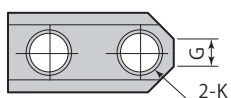
- CVJ04 mounting screw size : M8×22L (not included)

Model	Soft jaw shape	A	B	C	D	E	F	G	H	J	øK	øL	M
CVJ06-N	Standard jaw	31	32	72	12	5	15	20	37	20	11	17	-
CVJ06-H	Tall jaw	31	66							54			-
CVJ06-W	Wide jaw	70	32							20			31

- CVJ06 mounting screw size : M10×30L (not included)

Model	Soft jaw shape	A	B	C	D	E	F	G	H	J	øK	øL	M
CVJ08-N	Standard jaw	35	38	95	14	5	24	25	46	23	13	19	-
CVJ08-H	Tall jaw	35	76							61			-
CVJ08-W	Wide jaw	85	38							23			35

- CVJ08 mounting screw size : M12×35L (not included)

Jaw nut (option)

- Jaw nut is supplied in sets of two. Specify number of sets when ordering. (Example : CVJ06-T×1 set)

Model	A	B	C	D	E	F	G	H	J	K
CVJ04-T	14.5	26	18	10	12.5	5.5	5	14	6	M8×1.25
CVJ06-T	17	36.5	22.5	12	15	7.5	8	20	7.5	M10×1.5
CVJ08-T	20	48	25.5	14	16	9.5	8	25	11	M12×1.75