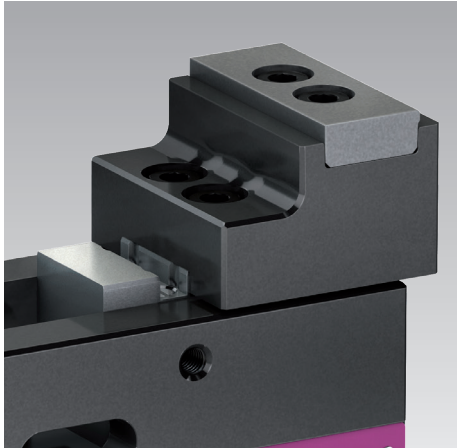


## Accessories for Workholding Systems MC-P

### Clamping jaws and jaw inserts, accessories for mounting, positioning and operation

#### Clamping jaws / jaw inserts

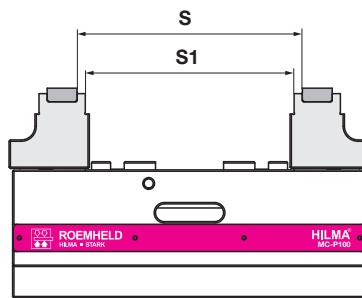
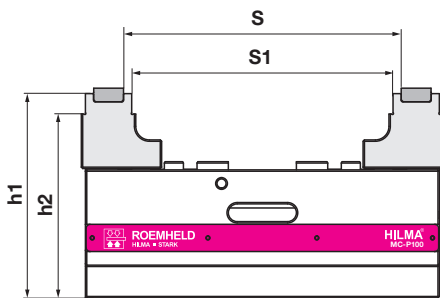


#### Scope of delivery - clamping jaws

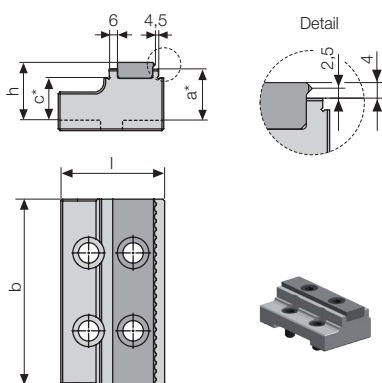
All clamping jaws are supplied with fixing screws.  
Reversible step jaws are always delivered without jaw inserts.  
They are to be ordered separately as accessories (see page 3).

#### Important notes

- By the use of clamping jaws with grip jaw inserts, the jaw opening is reduced by approx. 4 mm.
- Technical information and application recommendations for jaw inserts see page 3
- All MC-P workholding systems are delivered without clamping jaws.
  1. Selection: clamping jaws
  2. Selection: jaw inserts (see page 3)
- Reversible step jaws for jaw inserts can only be used in combination with the appropriate jaw inserts.

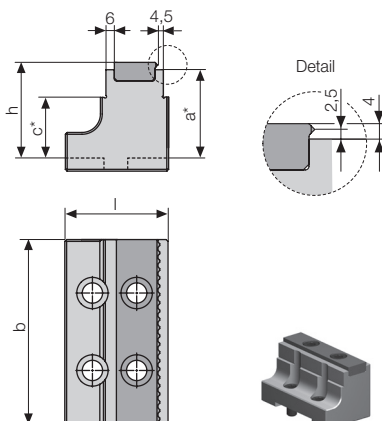


- S:** Clamping range  
step at the jaw insert
- S1:** Clamping range  
step at the jaw body
- h1:** Height of support  
step at the jaw insert
- h2:** Height of support  
step at the reversible step jaw



#### Reversible step jaws, flat for 1 jaw insert hardened and ground

Type	Part no.	Dimensions					Clamping range		Height of support	
		l	b	h	a	c	S	S1	h1	h2
MC-P 60	945836901	56	60	22	18	-	12-126	-	88	-
MC-P 60 ZH	945836901	56	60	22	18	-	12-126	-	98	-
MC-P 100	945856901	59	100	29	25	15	18-204	6-192	125	115
MC-P 125	945866901	91	125	34	30	20	18-400	6-388	160	150
MC-P 125 Compact	945866901	91	125	34	30	20	18-215	6-203	160	150

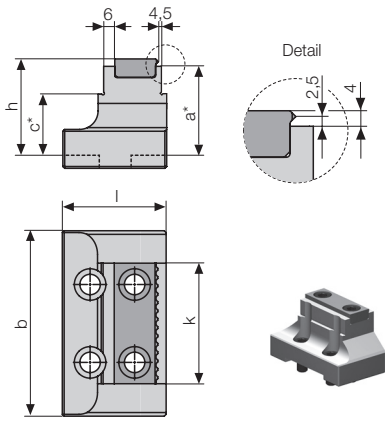


#### Reversible step jaws for 1 jaw insert hardened and ground

Type	Part no.	Dimensions					Clamping range		Height of support	
		l	b	h	a	c	S	S1	h1	h2
MC-P 60	945836902	56	60	34	30	-	12-126	-	100	-
MC-P 60 ZH	945836902	56	60	34	30	-	12-126	-	110	-
MC-P 100	945856902	59	100	54	50	35	18-204	6-192	150	135
MC-P 125	945866902	91	125	66	62	42	18-400	6-388	192	172
MC-P 125 Compact	945866902	91	125	66	62	42	18-215	6-203	192	172

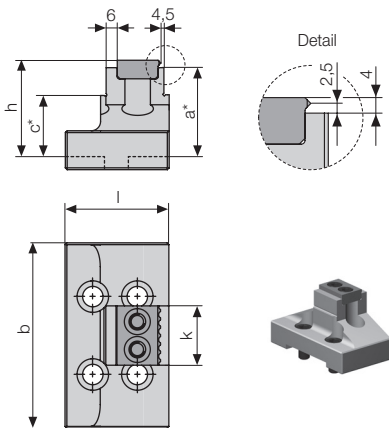
\* Tolerance ±0.01 mm  
All dimensions in [mm]

## Accessories Clamping jaws



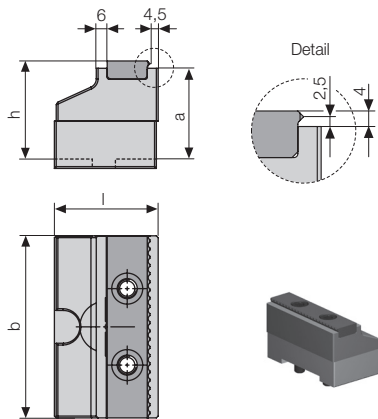
### Reversible step jaws for 1 jaw insert hardened and ground, various widths

Type	Part no.	Dimensions						Clamping range		Height of support	
		l	b	h	a	c	k	S	S1	h1	h2
<b>MC-P 60</b>	<b>945836903</b>	56	60	34	30	-	35	12-126	-	100	-
<b>MC-P 60 ZH</b>	<b>945836903</b>	56	60	34	30	-	35	12-126	-	110	-
<b>MC-P 100</b>	<b>945856903</b>	59	100	54	50	35	65	18-204	6-192	150	135
<b>MC-P 125</b>	<b>945866903</b>	91	125	66	62	42	80	18-400	6-388	192	172
<b>MC-P 125 Kompakt</b>	<b>945866903</b>	91	125	66	62	42	80	18-215	6-203	192	172



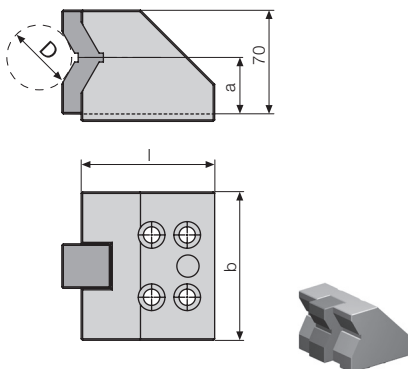
### Reversible step jaw for 1 jaw insert hardened and ground, various widths

Type	Part no.	Dimensions						Clamping range		Height of support	
		l	b	h	a	c	k	S	S1	h1	h2
<b>MC-P 100</b>	<b>945856904</b>	59	100	54	50	35	32	18-204	6-192	150	135



### Pendulum jaws for 1 jaw insert hardened and ground

Type	Part no.	Dimensions				Clamping range S	Height of support h1
		l	b	h	a		
<b>MC-P 100</b>	<b>945856905</b>	56	100	54	50	12-204	150
<b>MC-P 125</b>	<b>945866905</b>	88	125	66	62	12-400	192
<b>MC-P 125 Compact</b>	<b>945866905</b>	88	125	66	62	12-215	192



### Vee jaws with horizontal prism with interchangeable insert, hardened

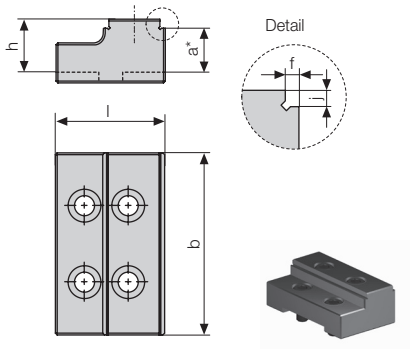
Type	Part no.	Dimensions			Clamping range D	Clamping centre h1
		l	b	a		
<b>MC-P 60</b>	<b>945836921</b>	60	60	40	D 10-76	110
<b>MC-P 60 ZH</b>	<b>945836921</b>	60	60	40	D 10-76	120
<b>MC-P 100</b>	<b>945856921</b>	90	100	38	D 12-80	138

### Vee jaws with vertical prism on request

\* Tolerance  $\pm 0.01$  mm  
All dimensions in [mm]

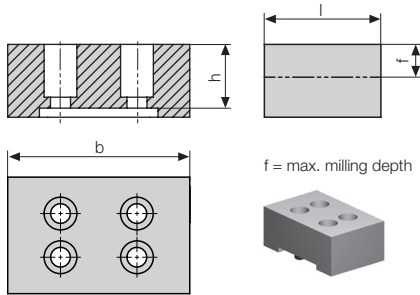
## Accessories

### Clamping jaws / jaw inserts



#### Reversible jaws with step hardened

Type	Part no.	Dimensions						Clamping range S	Height of support h1
		l	b	h	a	f	j		
<b>MC-P 40</b>	<b>94581 6931</b>	36	40	15	12	3	3	6-79	64
<b>MC-P 60</b>	<b>94583 6931</b>	49	60	23	18	3	5	6-150	88
<b>MC-P 60 ZH</b>	<b>94583 6931</b>	49	60	23	18	3	5	6-150	98
<b>MC-P 100</b>	<b>94585 6931</b>	60	100	30	25	3	5	6-204	125
<b>MC-P 125</b>	<b>94586 6931</b>	80	125	35	30	5	5	6-400	160
<b>MC-P 125 Compact</b>	<b>94586 6931</b>	80	125	35	30	5	5	6-215	160



#### Block jaws, soft for milling workpiece contours

Type	Part no.	Dimensions			
		l	b	h	f
<b>MC-P 40</b>	<b>94581 6932</b>	36	40	16	6
<b>MC-P 60</b>	<b>94583 6932</b>	42	60	25	8
<b>MC-P 100</b>	<b>94585 6932</b>	64	100	35	18
<b>MC-P 125</b>	<b>94586 6932</b>	88	125	55	32
<b>MC-P 125 Compact</b>	<b>94586 6932</b>	88	125	55	32

\* Tolerance ±0.01 mm  
All dimensions in [mm]

## Interchangeable jaw inserts

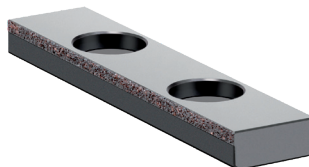
see also: data sheet WS 12-SE Technical information "Jaw inserts for clamping jaws"

#### Jaw inserts grip serrated



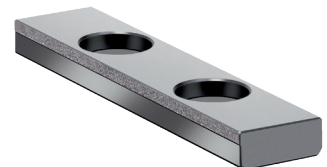
**Grip/smooth**

#### Jaw inserts with coatings



**Grip round**

**Hard metal coarse/smooth**  
Hardness 58 HRC  
Grain size 0.3 – 0.5 mm



**TUC/smooth**  
Hardness 80 HRC  
Coarseness RA 10

#### Recommendation for jaw inserts to increase the retention forces

Workpiece material	Workpiece surface	Workpiece surface					
		rolled / cast / forged	drawn	sawn	milled	ground	
Steel, e.g. C45, 20MnCr5, 31CrMoV9		HM coarse, Grip	TUC	HM coarse, Grip	TUC	TUC	
Heat-treated steel e.g. C45 induction-hardened, 20 Mn Cr 5 case-hardened, 31 Cr Mo V9 nitrided					TUC	TUC	
Cast e.g. GG, red bronze		HM coarse, Grip			TUC	TUC	
Titanium			TUC		TUC	TUC	
Aluminium		HM coarse, Grip		Grip		TUC	
Non-ferrous metals				Grip		TUC	

#### Part numbers

Type	Part no.	Part no.	Part no.
<b>MC-P 60</b>	<b>Jaw width 60</b>	<b>Jaw width 35</b>	
Jaw inserts Grip/smooth	550500543	550500545	
Jaw inserts HM coarse/smooth	550500635	550500740	
Jaw inserts TUC/smooth	550500743	550500744	
<b>MC-P 100</b>	<b>Jaw width 100</b>	<b>Jaw width 65</b>	<b>Jaw width 32</b>
Jaw inserts Grip/smooth	550500542	550500471	550500470
Jaw inserts HM coarse/smooth	550500523	550500723	550500741
Jaw inserts TUC/smooth	550500586	550500745	550500746
Jaw inserts Grip round with fixing screw	932856001		
<b>MC-P 125</b>	<b>Jaw width 125</b>	<b>Jaw width 80</b>	
Jaw inserts Grip/smooth	550500509	550500547	
Jaw inserts HM coarse/smooth	550500660	550500742	
Jaw inserts TUC/smooth	550500747	550500748	
Jaw inserts Grip round with fixing screw	932856003		

## Accessories for mounting, positioning and operation

### Mounting and positioning

#### Centring bolts

for hub centring on machine table



Type	Part no.	Ø [mm]	L [mm]
<b>Quintus 1/2/3</b>	<b>961535001</b>	D30 g6	15/38
	<b>961535002</b>	D32 g6	15/38
	<b>961535003</b>	D50 g6	25/48
	<b>961535009</b>	D50 g6	18/41

#### Retractable nipples

for mounting at the clamping system



Type	Part no.	Quantity
<b>Quintus 1 / MC-P 60</b>	<b>939200201</b>	1 off
<b>Quintus 2 / MC-P 100</b>	<b>939200202</b>	1 set = 2 off
<b>Quintus 3 / MC-P 125</b>	<b>939200203</b>	1 set = 3 off

#### Positioning pins

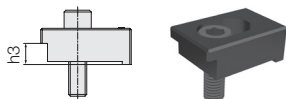
stepped for grid plate, set of 2 off



Type	Part no.	Ø [mm]
<b>MC-P 60</b>	<b>939200101</b>	10/12
<b>MC-P 100 / MC-P 125</b>	<b>939200103</b>	25/12

#### Clamping claws

1 set = 4 off, incl. screws



Type	Part no.	Thread	h3 [mm]
<b>MC-P 40</b>	<b>937772021</b>	M8	9
<b>MC-P 60</b>	<b>937772031</b>	M10	12
<b>MC-P 60</b>	<b>937772041</b>	M12	12
<b>MC-P 100</b>	<b>937772011</b>	M12	24
<b>MC-P 100 ZH</b>	<b>937772061</b>	M12	14
<b>MC-P 125</b>	<b>937773011</b>	M12	27
<b>MC-P 125</b>	<b>937773021</b>	M16	27

#### Key block

with screw for Quintus 1,2,3



Part no.		Slot [mm]
<b>961535004</b>	DIN 6322, 1 off	14

#### T-nut

with screw for Quintus 1,2,3



Part no.		Slot [mm]
<b>961535005</b>	DIN 508, 4 off	14

### Operation

#### Torque wrenches



Type	Part no.	Torque [Nm]
<b>MC-P 40 / MC-P 60</b>	<b>937926600</b>	5 – 60
<b>MC-P 100</b>	<b>937926610</b>	20 – 120
<b>MC-P 125</b>	<b>937926620</b>	40 – 200

#### Sockets

for torque wrenches



Type	Part no.	SW
<b>MC-P 40</b>	<b>131240114</b>	7
<b>MC-P 60</b>	<b>131240021</b>	12
<b>MC-P 100</b>	<b>131240020</b>	14
<b>MC-P 125</b>	<b>131240017</b>	17

#### Allen wrenches

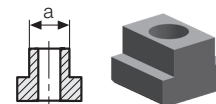
for fixing screws and jaw inserts



Type	Part no.	SW
<b>MC-P 40</b>	<b>169110101</b>	4
<b>MC-P 60</b>	<b>169110002</b>	6
<b>MC-P 100</b>	<b>169110003</b>	8
<b>MC-P 125</b>	<b>169110005</b>	10

#### T-nuts

DIN 508, 1 set = 4 off

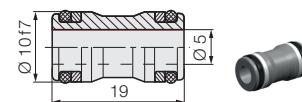


Type	Part no.	Thread	Width a
<b>MC-P 40</b>	<b>937773001</b>	M8	10
<b>MC-P 60</b>	<b>937773002</b>	M10	12
<b>MC-P 60</b>	<b>937773003</b>	M10	14
<b>MC-P 60/MC-P 100</b>	<b>937773004</b>	M12	18
<b>MC-P 125</b>	<b>937773231</b>	M12	18
<b>MC-P 125</b>	<b>937773311</b>	M16	18

### Hydraulic connection

#### Plug-in connector

for hydraulic connection from below including seals, 1 off



Part no.	for bore hole
<b>805300023</b>	Ø 10 H7 x 10 mm deep