5th AXIS®

VOLUME 6

PRODUCT CATALOG



WORKHOLDING | ZERO-POINT | AUTOMATION

52mm RockLock Overview

Maximum efficiency with 52mm

ROCKLOCK™ QUICK CHANGE SYSTEM

- Reduce Setup and Changeover Times
- Simple Modular Design
- Solutions Available for 3, 4, & 5 Axis Machines



READY TO ROCK SETUP

Example shown for Haas VF-2/VF-3
[GI54 Work Coordinates]



1. Starting with an empty machine table, install 5th Axis 3613S plates for your specific table. Thread bolts into t-nuts, but do not torque bolts.

2. Space plates 3” (76.2mm) apart from each other. Use a mallet to initially align and straighten plates.

3. Install master pallet (RL96-MP) in center position (P89, P92, P95, P98) to indicate straight. Once aligned and indicated straight, torque mounting bolts to torque specifications.

4. For every position, install master pallet and set X and Y axes with touch probe or indicator for each work offset position.

5. Set Z zero on the top mounting surface of the RockLock 3613S base for all work offsets.

6. R2R system is ready to use.

52mm Top Tooling

Double Station Vises

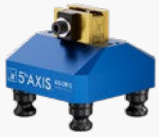
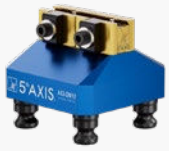
Part Number	DV75150X-J1	DV75150X-J2	DV75150X-J3
			
Fixture Size	75mm x 150mm x 56mm	75mm x 150mm x 64mm	75mm x 150mm x 64mm
Fixture Size``	75mm x 150mm x 56mm	75mm x 150mm x 64mm	75mm x 150mm x 64mm
Jaw Width	75mm	75mm	75mm
Jaw Set	Hard Jaws (2" Fixed Center Jaw)	Machinable Aluminum Jaws	Machinable Steel Jaws
Vise Type	Double Station	Double Station	Double Station
Compatible Pull Studs	4x PS16F (Sold separately)	4x PS16F (Sold separately)	4x PS16F (Sold separately)
Additional Vise Specs	See Pages 60 & 62	See Pages 61-62	See Pages 61-62

Self-Centering Vises and Round Bar Fixture

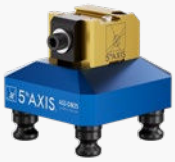
Part Number	V75100X	V75150X	A52-CERX-32	A52-CERX-40
				
Size	75mm x 100mm x 56mm	75mm x 150mm x 56mm	75mm x 75mm x 68mm	75mm x 75mm x 68mm
Jaw Width	75mm	75mm	Utilizes Standard ER32 Collet Nut	Utilizes Standard ER40 Collet Nut
Fixture	V75100X	V75150X	CER32	CER40
Overall Clamping Range	0 - 76.3mm	0 - 128.8mm	Accepts Only ER32 Size Collet	Accepts Only ER40 Size Collet
Vise Type	Self-Centering	Self-Centering	Round Bar Fixture	Round Bar Fixture
Compatible Pull Studs	4x PS16F (Sold separately)	4x PS16F (Sold separately)	4x PS16F (Included)	4x PS16F (Included)
Additional Vise Specs	See Pages 67-68	See Pages 67-68	See Page 83	See Page 83

CAD models available for download at 5thaxis.com/downloads

Metric Dovetail Fixtures

Part Number	A52-DM12	A52-2DM12	A52-P12DM12
			
Size	75mm x 75mm x 51mm	75mm x 75mm x 51mm	126mm x 126mm x 134mm
Fixture	DM12	2x DM12	12x DM12
Stock	12mm and Above	12mm and Above	12mm and Above
Compatible Pull Studs	4x PS16F (Included)	4x PS16F (Included)	4x PS16F (Included)
Additional Fixture Specs			See Page 81

Metric Dovetail Fixtures

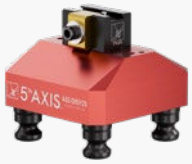
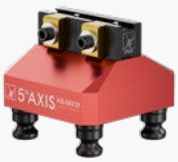
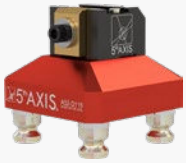
Part Number	A52-DM25	A52-P4DM25	A52-DM50
			
Size	75mm x 75mm x 55mm	Ø152mm x 65mm	75mm x 75mm x 63mm
Fixture	DM25	4x DM25	DM50
Stock	25mm and Above	25mm and Above	50mm and Above
Compatible Pull Studs	4x PS16F (Included)	4x PS16F (Included)	4x PS16F (Included)
Additional Fixture Specs		See Page 81	

To see the full product offering scan here:

CAD models available for download at 5thaxis.com/downloads

52mm Top Tooling

Inch Dovetail Fixtures

Part Number	A52-D05125	A52-2D05125	A52-P12D05125	A52-D115
				
Size	2.95” x 2.95” x 2”	2.95” x 2.95” x 2”	4.95” x 4.95” x 5.27”	2.95” x 2.95” x 2.175”
Fixture	D05125	2x D05125	12x D05125	D115
Stock	0.5” and Above	0.5” and Above	0.5” and Above	1” and Above
Compatible Pull Studs	4x PS16F	4x PS16F	4x PS20F	4x PS16F

Inch Dovetail Fixtures

Part Number	A52-P4D115	A52-D22
		
Size	A52-P4D115	2.95” x 2.95” x 2.5”
Fixture	4x D115	D22
Stock	1” and Above	2” and Above
Compatible Pull Studs	4x PS16F	4x PS16F

RockLock 52mm Double Station Vises

Part Number	A52-DV75150X-J1
	
Size	75mm x 150mm x 56mm
Vise	DV75150X-J1
Jaw Set	Hard Jaws (2” Fixed Center Jaw)
Compatible Pull Studs	4x PS16F
Vise Type	Double Station

RockLock 52mm Self-Centering Vises

Part Number	A52-V75100X	A52-V75150X
		
Size	75mm x 100mm x 56mm	75mm x 150mm x 56mm
Vise	V75100X	75150X
Jaw Set	UPDATE	UPDATE
Compatible Pull Studs	4x PS16F	4x PS16F
Vise Type	hSelf-Centering	Self-Centering

52mm RockLock Bases

Low Profile Adapters

Part Number	RL52A-4 RL52S-4	RL52A-4-12	RL52A-4-96 RL52S-4-96	RL52A-4-TRT100	RL52A-44 RL52S-44
					
Size	Ø116mm x 25mm	Ø116mm x 25mm	Ø116mm x 25mm	Ø116mm x 25mm	103.5mm x 103.5mm x 25mm
Subcat-egory	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter
Materials	Aluminum (RL52A-4) or Steel (RL52S-4)	Aluminum (RL52A-4)	Aluminum (RL52A-4-96) or Steel (RL52S-4-96)	Aluminum (RL52A-4-TRT100)	Aluminum (RL52A-44) or Steel (RL52S-44)
Mounting	Drill Your Own M10 @ 50mm-100mm	Drill your own mounting	2x M10 SHCS @ 96mm	HAAS TRT 100	2x SB1210 (Included) and 2x M12 or 1/2" @ Ø82mm 90°
Additional RockLock Specs	See Page 9	See Page 9	See Page 9	See Page 9	See Page 10

Low Profile Adapters and Integrated Tombstone

Part Number	RL52S-45	RL52A-4560 RL52S-4560	RL52A-A96	RL52A-T31
				
Size	Ø114mm x 25mm	122.0mm x 102.1mm x 25mm	124.0mm x 124.0mm x 25mm	Ø160mm x 167mm
Subcategory	Low Profile Adapter	Low Profile Adapter	96mm to 52mm Adapter	52mm Integrated Tombstone 96mm Base
Materials	Steel (RL52S-45)	Aluminum (RL52A-4560) or Steel (RL52S-4560)	Aluminum (RL52A-A96)	Aluminum (RL52A-T31)
Mounting	4x 1/2" at 2" × 4" Grid	4x M10 @ Ø116mm 60°	96mm Spacing and Includes 4x PS20F	96mm Spacing and Includes 4x PS20F
Additional RockLock Specs	See Page 10	See Page 10	See Page 10	See Page 11

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Low Profile Adapters

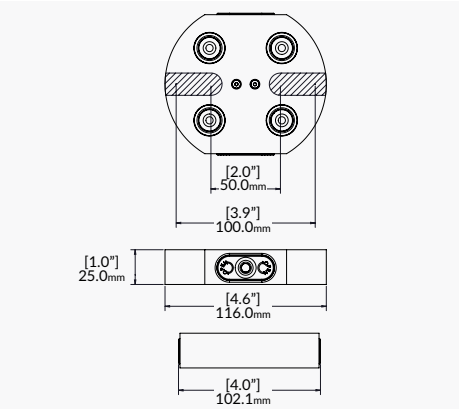
RL52A-4 / RL52S-4



Size: Ø116mm x 25mm
Bolt Pattern: Drill Your Own Custom M10 @ 50mm-100mm
Material Construction: Aluminum (RL52A-4) Steel (RL52S-4)

This circular **RockLock** adapter is built for small and medium sized rotaries and trunnions with 50mm to 100mm bolt circle.

Repeatability of +/- 8 µm.



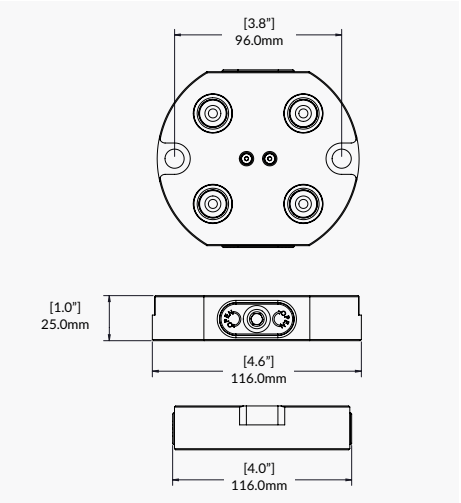
RL52A-4-96 / RL52S-4-96



Size: Ø116mm x 25mm
Bolt Pattern: 2x M10 SHCS @ 96mm
Material Construction: Aluminum (RL52A-4-96) Steel (RL52S-4-96)

This circular **RockLock** adapter is built for small and medium sized rotaries and trunnions with 96mm bolt circle.

Repeatability of +/- 8 µm.



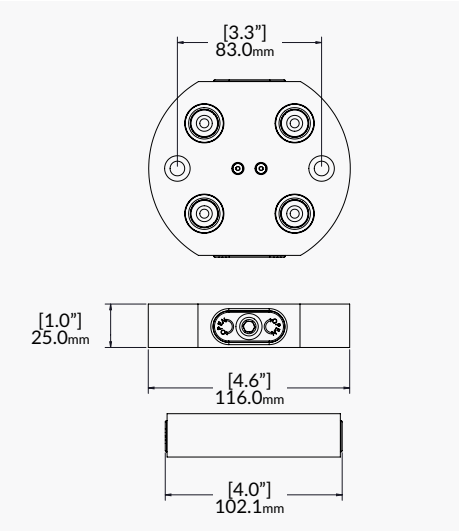
RL52A-4-TRT100



Size: Ø116mm x 25mm
Bolt Pattern: 2x 5/16" @ 82.98mm
Material Construction:
Aluminum (RL52A-4-TRT100)

This circular **RockLock** adapter is built for the Haas TRT100 trunnion.

Repeatability of +/- 8 µm.

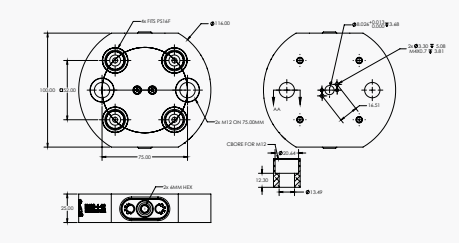


RL52A-4-12



Size: 116mm x 100mm x 25mm
Bolt Pattern: 2x M12 at 180° on 75mm PCD
Material Construction:
Aluminum (A)

This circular **RockLock** adapter is built for small and medium sized rotaries and trunnions with 75mm bolt circle.



Low Profile Adapters

RL52A-44 / RL52S-44

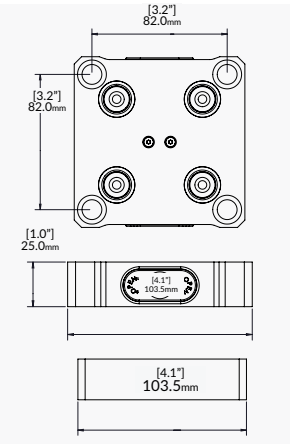


Size: 103.5mm x 103.5mm x 25mm
Mounting: 4x M10 at 90° on 116mm PCD
Material Construction: Aluminum (RL52A-44) / Steel (RL52S-44)

This square low profile adapter is built for custom tombstones.

Ships with 2x shoulder bolts (SB1210) for locating.

Repeatability of +/- 8 µm.

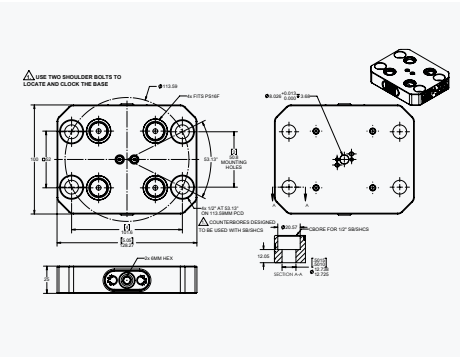


RL52S-45



Size: 128.27mm x 100mm x 25mm
Mounting: 4x 1/2" at 53.13° ON 113.59mm PCD
Material Construction: Steel (RL52S-45)

Repeatability of +/- 8 µm.



RL52A-4560 / RL52S-4560

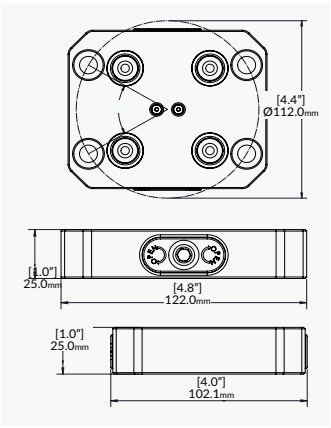


Size: 122.0mm x 102.1mm x 25.0mm
Mounting: 4x M10 at 60° ON 112mm PCD
Material Construction: Aluminum (RL52A-4560) / Steel (RL52S-4560)

This rectangular low profile adapter is built for small &medium sized rotaries with 60-degree T-slot spacing.

Ships with 2x rounded T-Slot nuts (14mm x M10) for maximum bolt circle capability.

Repeatability of +/- 8 µm.



RL52A-A96



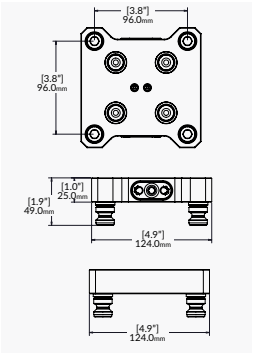
Size: 124.0mm x 124.0mm x 25.0mm
Mounting: 4x M10 at 90° on 135.76mm PCD
Material Construction: Aluminum (RL52A-A96)

The RL52A-A96 allows for the quick and easy conversion between the 96mm system and the 52mm system.

96mm spacing on the bottom of the unit and the integrated 52mm system on the top quickly adapts 52mm top tooling to the 96mm risers and adapters.

The unit includes 4x PS20F and 96mm **RockLock** pattern on the bottom for mounting to any RL96 base.

Repeatability of +/- 8 µm.



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Integrated Tombstones

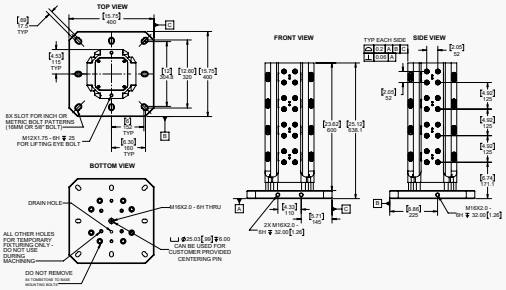
RL52S-4004U-638

RockLock™ Tombstone, 4 Face Cast Iron



Size: 400mm x 400mm x 638mm
Material Construction: Aluminum
Mounting: 80mm
# of Positions: 16 total, 4 per side
Weight: 400 lbs
Weight w/ Freight: 500 lbs

Enhance your machining efficiency with our robust four-sided 400mm **CNC** tombstone. Engineered to integrate seamlessly with the **RockLock™** 52mm quick change system, this tombstone ensures swift and precise workpiece setup, reducing downtime and increasing productivity.



RL52A-T31

Rocklock Tombstone, 3 Face Aluminum



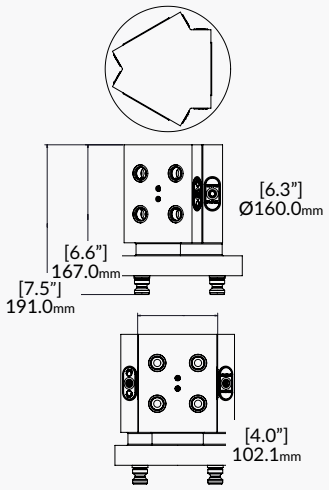
Size: Ø160mm X 167.0mm
Mounting: 96mm RockLock
Material Construction: Aluminum (RL52A-T31)

This 3-sided integrated **RockLock** tombstone can be mounted onto any RL96 base.

52mm spacing on the 3 faces of the tombstone. 96mm spacing on the bottom of the tombstone.

4x PS20F are included.

Repeatability of +/- 8 µm.



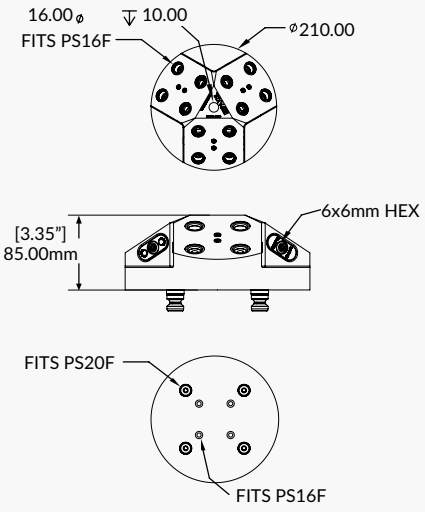
RL52A-P330

3-Sided Integrated RockLock Pyramid



Size: Ø210.00mm x 85mm
Mounting: 96mm RockLock
Material Construction: Aluminum (RL52A-P330)

The RL52A-P300 is a 3-sided (52mm quick change) pyramid ideal for increasing throughput on multi-axis machines. This pyramid was designed and optimized to work with 5 axis universal machines as well as robotic pallet changers.



CAD models available for download at 5thaxis.com/downloads

52mm Accessories



PS16F

PULL STUD

Size: 52mm Pull Studs
Material Construction: S7 Tool Steel

The **PS16F** is necessary to use any 5th Axis 52mm base. The 52mm spacing on 5th Axis vises and adapters allow for compatibility with other competitive systems.

*Please note that pull studs must stay with the corresponding company's base plate. If you are using a 5th Axis 52mm RockLock base plate you will need 5th Axis pull studs (PS16F). The spacing and thread allows the top tooling to be interchangeable between the competitive systems.



PS16F-PY

SINGLE PULL STUD WITH POKA-YOKE INSERT

Size: 52mm Pull Studs
Material Construction: S7 Tool Steel

Poka-yoke is a Japanese term that means "mistake-proofing" or "inadvertent error prevention". The **PS16F-PY** is a single modified pull stud with an aluminum ring. The ring is placed inside one of the locating holes in the RockLock base, allowing for only the single poka-yoke pull stud to fit inside the locating hole with the corresponding ring. This will prevent operators from changing the orientation and misloading a part.



PS16F-4PY

PULL STUDS WITH POKA-YOKE INSERT

Size: 52mm Pull Studs
Material Construction: S7 Tool Steel

3x Standard PS16F Pull Studs and one Poka-Yoke (PS16F-PY).



A52-BLANK

Size: 52mm Pull Studs
Material Construction: 6061 Aluminum

Blank 6061 aluminum block with 4x PS16F pull studs included. Quickly build your own fixture / subplate with the A52-Blank.



A52-HTS

Size: 52mm Pull Studs
Material Construction: 6061 Aluminum

Quick change adapter for the Renishaw OTS Tool Setter. Accurately remove and relocate the tool probe when its not in use. The part number includes the adapter plate and 4x PS16F pull studs.

*Requires any 52mm RockLock base unit.
**Tool setter sold separately.



RL52-MP

52mm Master Pallet

Size: 52mm Pull Studs
Material Construction: 4140 Steel

Mount the RockLock base onto the machine, drop in the master pallet, dial in your setup, and torque your mounting bolts once you have reached the desired location. This is the fastest, most accurate way to set up the RockLock system. Use the bore to find center and the edge to set rotation.

See page 33 for more info.

96mm RockLock Overview

Maximum efficiency with 96mm

ROCKLOCK™ QUICK CHANGE SYSTEM

- Reduce Setup and Changeover Times
- Simple Modular Design
- Solutions Available for 3, 4, & 5 Axis Machines



96mm RockLock Overview

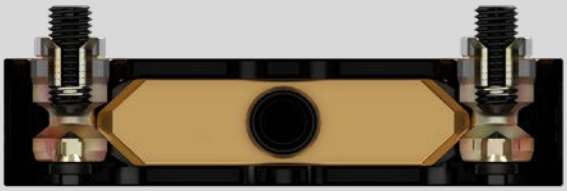
ROCKLOCK™ QUICK CHANGE SYSTEM

Maximum efficiency with 96mm

Repeatability less than 8 µm	Industry standard 96mm pull stud spacing	Steel or aluminum body construction



- 96mm Pull Stud Spacing
- Robust Single Actuation Screw
- Steel Locating Features



Patented free float design ensures equal force on all 4 pull studs. Compatible with other 96mm 4 pull stud systems. Simply change out the pull studs to ensure that the manufacturer's base plate and pull studs match.

96mm Top Tooling

RockLock 96mm Compatible Self-Centering Vises

Part Number	A96-V562X	A96-V510X	V562X	V510X
				
Size	126mm 152mm x 74mm	126mm x 254mm x 74mm	126mm x 152mm x 74mm	126mm x 254mm x 74mm
Vise	V562X	V510X	V562X	V510X
Vise Overall Clamping Range	0 - 153.6mm	0 - 254.8mm	0 - 153.6mm	0 - 254.8mm
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Sold separately)	4x PS20F (Sold separately)
Vise Type	Self-Centering	Self-Centering	Self-Centering	Self-Centering
Additional Vise Specs			See Pages 67-68	See Pages 67-68

RockLock 96mm Compatible Self-Centering Vises

Part Number	A96-V75100X	A96-2V75100X	A96-V75150X	A96-2V75150X	A96-V75100T4	A96-V75XT4
						
Size	125mm x 126mm x 88mm	150mm x 177mm x 78mm	126mm x 150mm x 88mm	150mm x 177mm x 78mm	126mm x 126mm x 267mm	126mm x 126mm x 200mm
Vise	V75100X	2x V75100X	V75150X	2x V75150X	Compatible with V75100X (Vises Sold Separately)	Compatible with V75100X, V75150X, & DV75150X (Vises Sold Separately)
Vise Overall Clamping Range	0 - 76.3mm	N/A	0 - 128.8mm	N/A	N/A	N/A
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)
Vise Type	Self-Centering	Self-Centering	Self-Centering	Self-Centering	Self-Centering	Self-Centering or Double Station
Additional Vise Specs					See Page 39	See Page 39

CAD models available for download at 5thaxis.com/downloads

RockLock 96mm Double Station Vises

Part Number	A96-DV75150X-J1	A96-2DV75150X-J1	A96-DV75150X-J2	A96-2DV75150X-J2	A96-DV75150X-J3	A96-2DV75150X-J3	A96-DV56-J1
							
Size	126mm x 150mm x 88mm	150mm x 177mm x 78mm	126mm x 151mhhx 88mm	150mm x 177mm x 78mm	126mm x 151mm x 88mm	150mm x 177mm x 78mm	126mm x 152mm x 74mm
Vise	DV75150X-J1	2x DV75150-J1	DV75150-J2	2x DV75150-J2	DV75150-J3	2x DV75150-J3	DV56-J1
Jaw Set	Hard Jaws (2" Fixed Center Jaw)	Hard Jaws (2" Fixed Center Jaw)	Machinable Aluminum Jaws	Machinable Aluminum Jaws	Machinable Steel Jaws	Machinable Steel Jaws	Hard Jaws (2" Fixed Center Jaw)
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)
Vise Type	Double Station	Double Station	Double Station	Double Station	Double Station	Double Station	Double Station

RockLock 96mm Double Station Vises

Part Number	DV56	DV56-J1	DV56-J2	DV56-J3	A96-DV510-J1	DV510	DV510-J1
							
Size	126mm x 152mm x 48mm	126mm x 152mm x 73mm	126mm x 152mm x 89mm	126mm x 152mm x 89mm	126mm x 152mm x 74mm	126mm x 254mm x 41mm	126mm x 258mm x 73mm
Vise	DV56	DV56-J1	DV56-J2	DV56-J3	DV56-J1	DV510	DV510-J1
Jaw Set		Hard Jaws (2" Fixed Center Jaw)	Machinable Aluminum Jaws	Machinable Steel Jaws	Hard Jaws (2" Fixed Center Jaw)		Hard Jaws (2" Fixed Center Jaw)
Compatible Pull Studs	4x PS20F (Sold separately)	4x PS20F (Sold separately)	4x PS20F (Sold separately)	4x PS20F (Sold separately)	4x PS20F (Included)	4x PS20F (Sold separately)	4x PS20F (Sold separately)
Vise Type	Double Station	Fixed Jaw / Double Station	Double Station	Double Station	Fixed Jaw / Double Station	Double Station	Fixed Jaw / Double Station
Additional Vise Specs		See Pages 60 & 63	See Pages 61 & 63	See Pages 61 & 63			Sees Page 60 & 64

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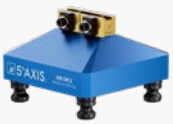
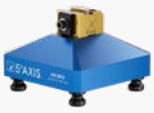
96mm RockLock Bases

RockLock 96mm Double Station Vises

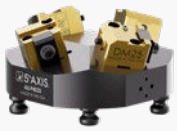
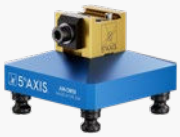
Part Number	DV510-J2	DV510-J3	R96-DV510-J4	DV510-J4
				
Size	126mm x 258mm x 89mm	126mm x 258mm x 89mm	126mm x 254mm x 74mm	126mm x 258mm x 73mm
Vise	DV510-J2	DV510-J3	DV510-J4	DV510-J4
Jaw Set	Machinable Aluminum Jaws	Machinable Steel Jaws	Hard Jaws (1" Fixed Center Jaw)	Hard Jaws (1" Fixed Center Jaw)
Compatible Pull Studs	4x PS20F (Sold separately)	4x PS20F (Sold separately)	4x PS20F (Sold separately	4x PS20F (Sold separately)
Vise Type	Double Station	Double Station	Double Station	Fixed Jaw / Double Station
Additional Vise Specs	See Pages 61 & 65	See Pages 61 & 65		See Pages 60 & 64

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Dovetail Fixtures Metric

Part Number	A96-DM12	A96-2DM12	A96-P12DM12	A96-DM25
				
Size	126mm x 126mm x 67mm	126mm x 126mm x 67mm	126mm x 126mm x 133mm	126mm x 126mm x 75mm
Fixture	DM12	2x DM12	12x DM12	DM25
Stock Size	12mm and Above	12mm and Above	12mm and Above	25mm and Above
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)
Additional Fixture Specs			See Page 81	

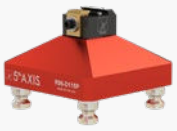
Dovetail Fixtures Metric

Part Number	A96-P4DM25	A96-DM50	A96-D115T41	A96-CERX-40
				
Size	Ø152mm x 65mm	126mm x 126mm x 76mm	126mm x 126mm x 107mm	126mm x 126mm x 81mm
Fixture	4x DM25	DM50	4x D115 *Fixtures sold separate*	CER40
Stock Size	25mm and Above	50mm and Above	25mm and Above	Utilizes Standard ER40 Collet Nut
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)
Additional Fixture Specs	See Page 81			See Page 83

CAD models available for download at 5thaxis.com/downloads

96mm RockLock Bases

Dovetail Fixtures Inch

Part Number	A96-D05125	A96-2D05125	A96-P12D05125	A96-D115	A96-D115P
					
Size	4.95” x 4.95” x 2.625”	4.92” x 4.92” x 2.625”	4.95” x 4.95” x 5.27”	4.95” x 4.95” x 3”	1.6” x 2.5” x 1.5”
Fixture	D05125	2x D05125	12x D05125	D115	D115P
Stock Size	0.5” and Above	0.5” and Above	0.5” and Above	1” and Above	1” and Above
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)

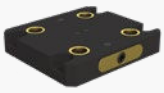
Dovetail Fixtures Inch

Part Number	A96-3D115	A96-3D115P	A96-P4D115	A96-D22	A96-D362
					
Size	4.95” x 4.95” x 3”	4.92” x 4.92” x 3”	Ø6” x 2.83”	4.92” x 4.92” x 3”	6” x 4.92” x 2.225”
Fixture	3x D115	3x D115	4x D115	D22	D362
Stock Size	1” and Above	1” and Above	1” and Above	2” and Above	3” and Above
Compatible Pull Studs	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)	4x PS20F (Included)

CAD models available for download at 5thaxis.com/downloads

96mm RockLock Bases

Low Profile Bases

Part Number	RL96A-56 RL96S-56	RL96A-66 RL96S-66	RL96A-67 RL96S-67	RL96S-67M	RL96S-68	RL96S-6695
						
Size	158mm x 126mm x 30mm	158mm x 150mm x 30mm	158mm x 176mm x 30mm	158mm x 176mm x 30mm	190mm x 156mm x 30mm	156mm x 150mm x 30mm
Subcategory	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter
Materials	Aluminum (RL96A-56) or Steel (RL96S-56)	Aluminum (RL96A-66) or Steel (RL96S-66)	Aluminum (RL96A-67) or Steel (RL96S-67)	Steel (RL96S-67M)	Steel (RL96S-68)	Steel (RL96S-6695)
Mounting	2x M12 on 101.6mm	Drill your own mounting holes	4x 1/2” at 4” x 6” grid	4x M12 at 100mm x 150mm grid	4x M10 at 60° on 190.5mm PCD	2x M12 on 96.14mm
Additional RockLock Specs	See Page 24	See Page 24	See Page 24	See Page 25	See Pages 25 & 32	See Pages 25 & 32

Low Profile Bases

Part Number	RL96A-6760 RL96S-6760	RL96A-6790 RL96S-6790	RL96SS-9590	RL96SS-9690	RL96A-60100 RL96S-60100	RL96S-DDR
						
Size	174mm x 158mm x 30mm	156mm x 158mm x 30mm	156mm x 148mm x 30mm	6.142” x 5.827” x 1.181”	158mm x 150mm x 30mm	150mm x 150mm x 35mm
Subcategory	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter	Low Profile Adapter
Materials	Aluminum (RL96A-6760) or Steel (RL96S-6760)	Aluminum (RL96A-6790) or Steel (RL96S-6790)	Stainless Steel (RL96SS-9590)	Stainless Steel (RL96SS-9690)	Aluminum (RL96A-60100) or Steel (RL96S-60100)	Steel (RL96S-DDR)
Mounting	4x M12 at 60° on 170.11mm PCD	4x M10 at 90° on 184.15mm PCD	4x M8 SHCS into E-Z LOK Inserts in M12 Pallet Threads, 95mm PCD	4x 5/16-18 SHCS into E-Z LOK Inserts in 1/2-13 Pallet Threads, 3.800” PCD	4x M10 at 60° on 100mm PCD	6x M8 at 45° on 74mm PCD
Additional RockLock Specs	See Page 26	See Page 26	See Page 26	See Page 27	See Page 27	See Page 27

CAD models available for download at 5thaxis.com/downloads

96mm RockLock Bases

Risers

Part Number	RL96A-38	RL96A-411	RL96A-3915	RL96A-4816
				
Size	Ø 201.9mm x 75.0mm	Ø 276mm x 100mm	381mm x 230mm x 80mm	400mm x 200mm x 100mm
Subcategory	Single Position Riser	Single Position Riser	Multi-Position Riser	Multi-Position Riser
Materials	Aluminum (RL96A-38)	Aluminum (RL96A-411)	Aluminum (RL96A-3915)	Aluminum (RL96A-4816)
Mounting	4x M12 at 90° on 178mm PCD or 3x M12 at 120° on 178mm PCD	3x M12 at 120° on 252mm PCD or 4x M12 at 90° on 252mm PCD	4x M16 on 200mm X 200mm grid	4x M12 @ 320mm x 160mm rectangle (80mm T-slots) or 4x M16 @ 360mm x 126mm rectangle (63mm T-slots)
Additional RockLock Specs	See Page 28	See Page 28	See Page 29	See Page 29

CAD models available for download at 5thaxis.com/downloads

Multi-Position Plates

Part Number	RL96A-3613S0	RL96A-3613S1	RL96A-3613S2	RL96A-3613S3
				
Size	156mm x 338mm x 30mm	158mm x 338mm x 30mm	158mm x 338mm x 30mm	158mm x 338mm x 30mm
Subcategory	Multi-Position Horizontal Plate	Multi-Position Horizontal Plate	Multi-Position Horizontal Plate	Multi-Position Horizontal Plate
Materials	Aluminum (RL96A-3613S0)	Aluminum (RL96A-3613S1)	Aluminum (RL96A-3613S2)	Aluminum (RL96A-3613S3)
Mounting	Drill your own mounting holes	2x M12 on 96mm apart or 2x M12 on 250mm apart	4x M12 on 80mm apart	4x M12 on 100mm apart
Additional RockLock Specs		See Page 30	See Page 30	See Page 30

Tombstones, Right Angle Plate, and Single Position Riser

Part Number	RL96A-4004U-638	RL96A-3002-400 RL96S-3002-400	RL96A-3003-400 RL96S-3003-400	RL96A-90DEG	RL96A-356 RL96S-356
					
Size	400mm x 400mm x 638mm	300mm x 300mm x 400mm	300mm x 300mm x 400mm	149.4mm x 158mm x 200mm	158mm x 126mm x 75mm
Subcategory	96mm Integrated Tombstone	96mm Integrated Tombstone	96mm Integrated Tombstone	Right Angle Plate	Single Position Riser
Materials	Aluminum	Aluminum (RL96A-3002-400) or 1018 Steel (RL96S-3002-400)	Aluminum (RL96A-3003) or 1018 Steel (RL96S-3003)	Aluminum (RL96A-90DEG)	Aluminum (RL96A-356) or Steel (RL96S-356)
Mounting	8x 160mm or 6” spacing	6x 100mm or 120mm spacing	6x 100mm or 120mm spacing	4x PS20F (Included) or 2x M12 SHCS @ 100mm - 101.6mm (4”)	96mm RockLock™
Additional RockLock Specs	See Page 37	See Page 36	See Page 36	See Page 40	See Page 40

*Submit table drawing upon inquiry.

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Low Profile Adapters

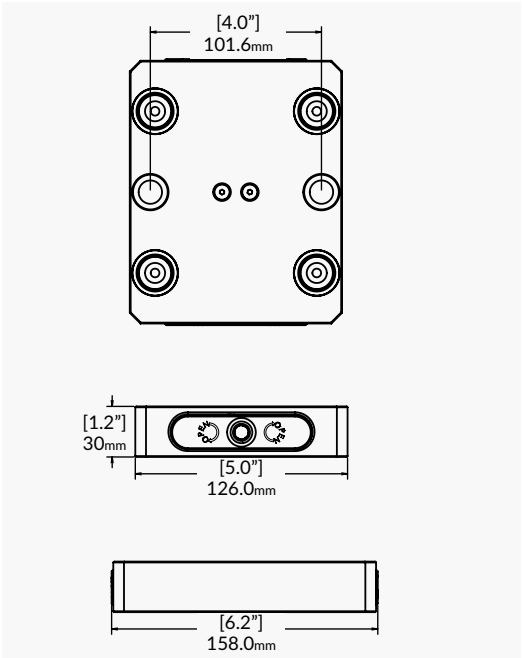
RL96A-56 / RL96S-56



Size: 158mm x 126mm x 30mm
Mounting: 2x M12 on 101.6mm
Material Construction:
Aluminum (RL96A-56)
Steel (RL96S-56)

The adapter has two enlarged counterbores to allow mounting from 100mm to 101.6mm for M12 or 1/2-13 **SHCS** for simple mounting to T-slots.

Repeatability of +/- 8 µm.

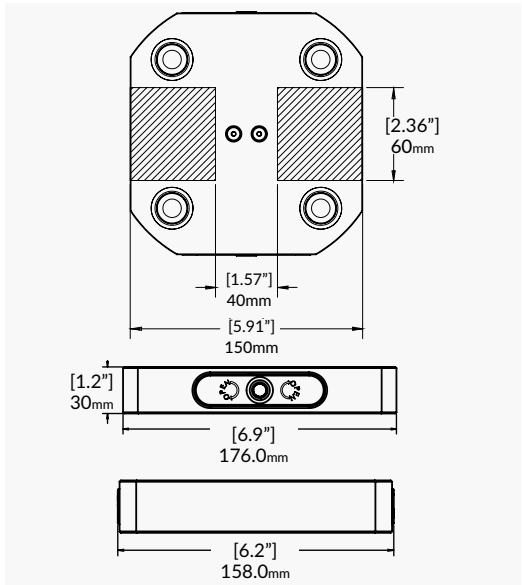


RL96A-66/ RL96S-66



Size: 158mm x 150mm x 30mm
Mounting: Drill your own mounting holes
Material Construction:
Aluminum (RL96A-66)
Steel (RL96S-66)

The **RL96-66** series quick change adapter was built to accommodate a variety of machines that are not part of our standard offering. The blank adapter allows for drilling your own mounting holes.



RL96A-67 / RL96S-67

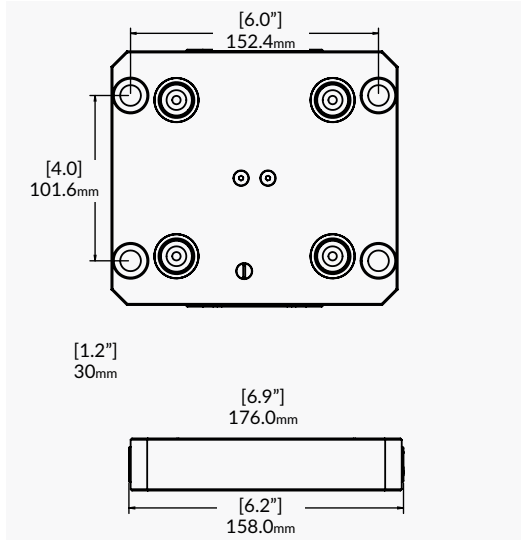


Size: 158.0mm x 176.0mm x 30mm
Mounting: 4x 1/2" at 4" x 6" grid
Material Construction:
Aluminum (RL96A-67)
Steel (RL96S-67)

The **RL96-67** was built specifically for horizontal machining centers.

Bolt pattern 6.0" x 4.0" allows for easy mounting to most standard tombstone grid pattern spacing.

Repeatability of +/- 8 µm.



Low Profile Adapters

RL96S-67M

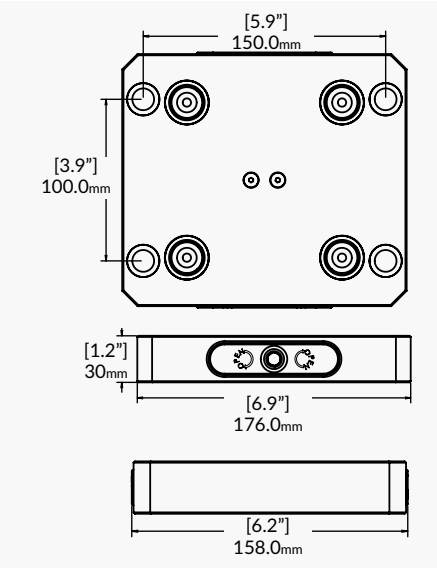


Size: 158.0mm x 176.0mm x 30mm
Mounting: 4x M12 at 100mm x 150mm grid
Material Construction:
Steel (RL96S-67)

The **RL96-67M** was built specifically for tombstones on horizontal machining centers.

Bolt pattern 150mm x 100mm allows for easy mounting to most standard tombstone grid pattern spacing.

Repeatability of +/- 8 µm.

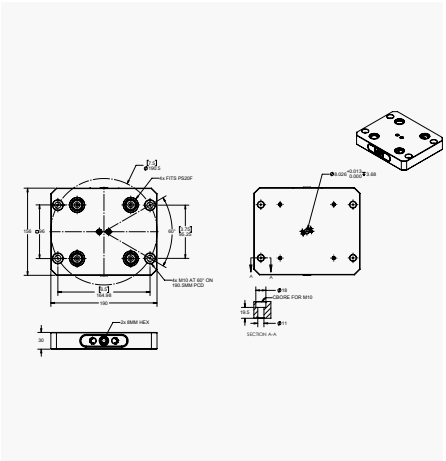


RL96S-68



Size: 190mm x 156mm x 30mm
Mounting: 4x M10 at 60° on 190.5mm PCD
Material Construction:
Steel (RL96S-68)

The **RL96S-68** embodies the perfect blend of versatility and robust durability. 96mm pull stud spacing ensures a seamless fit into your machining setup, reducing unnecessary bulk while maximizing workspace efficiency.



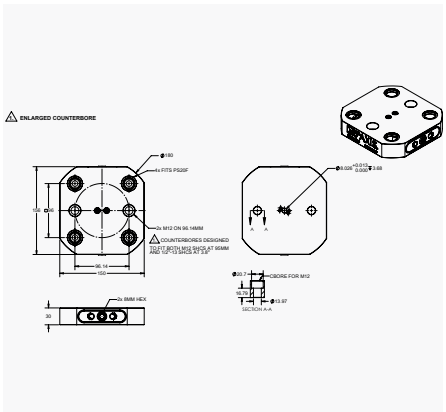
RL96S-6695



Size: 156mm x 150mm x 30mm
Mounting: 2x M12 on 96.14mm
Material Construction:
Aluminum (RL96A-6695)
Steel (RL96S-6695)

The **RL96-66** series quick change adapter was built specifically for the MAM pallet on the Matsuura MAM-72 series machines.

Repeatability of +/- 8 µm.



Low Profile Adapters

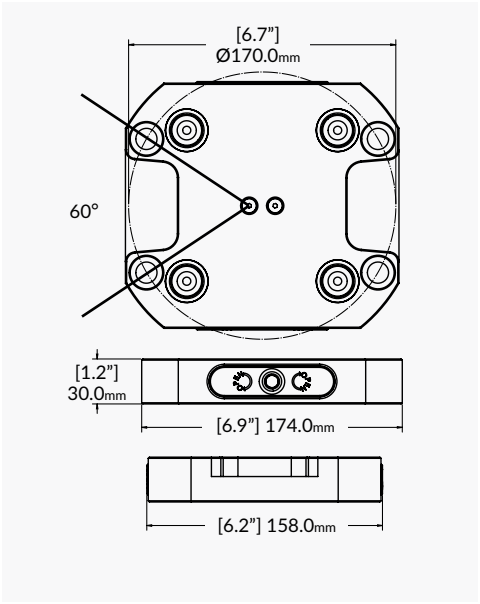
RL96A-6760 / RL96S-6760



Size: 174mm x 158mm x 30mm
Mounting: 4x M12 at 60° on 170.11mm PCD
Material Construction:
Aluminum (RL96A-6760)
Steel (RL96S-6760)

The **RL96-6760** series quick change adapter was built for the Haas TR-210 series rotaries, Hurco VMX30 series rotaries, and any other rotary with 60 degree radial T-slots.

A quick turn of the wrench actuates the cam mechanism to lock and release your fixtures and vises for fast changeover.



RL96A-6790 / RL96S-6790

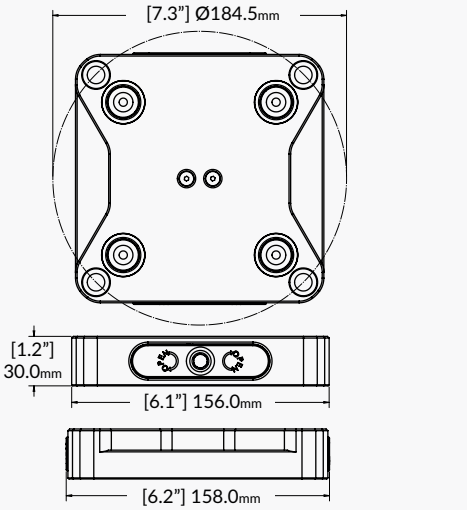


Size: 156mm x 158mm x 30mm
Mounting: 4x M10 at 90° on 184.15mm PCD
Material Construction:
Aluminum (RL96A-6790)
Steel (RL96S-6790)

The **RL96-6790** quick change adapter was built for any rotary with 90 degree radial T-slots.

A quick turn of the wrench actuates the cam mechanism to lock and release your fixtures and vises for fast changeover.

Repeatability of +/- 8 µm.



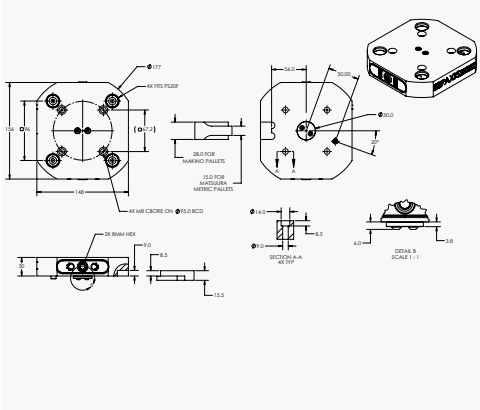
RL96SS-9590



Size: 156mm x 148mm x 30mm
Mounting: 4x M8 SHCS into E-Z LOK Inserts in M12 Pallet Threads, 95mm PCD
Material Construction:
Stainless Steel (RL96SS-9590)

Built for compatible Matsuura models and the Makino DA300 machine, this **RockLock**™ base is designed to improve repeatability, simplify changeovers, and maintain precision in high-mix production.

Repeatability of +/- 8 µm.



Low Profile Adapters

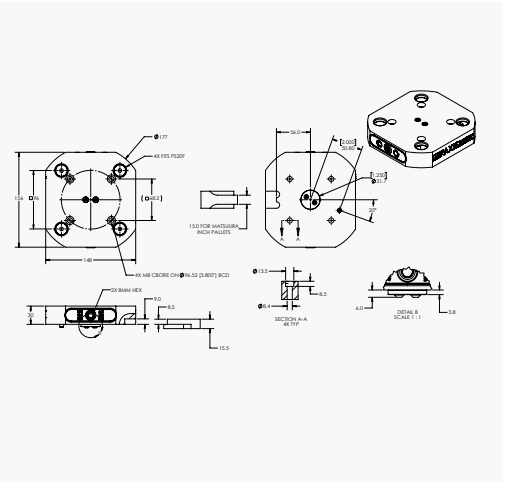
RL96SS-9690



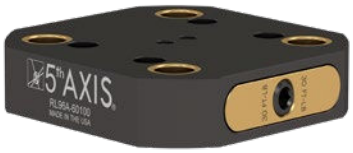
Size: 6.142” x 5.827” x 1.181”
Mounting: 4x 5/16-18 SHCS into E-Z LOK Inserts in 1/2-13 Pallet Threads, 3.800” PCD
Material Construction:
Stainless Steel (RL96SS-9690)

Built for compatible Matsuura models, this **RockLock**™ base is designed to improve repeatability, simplify changeovers, and maintain precision in high-mix production.

Repeatability of +/- 8 µm.

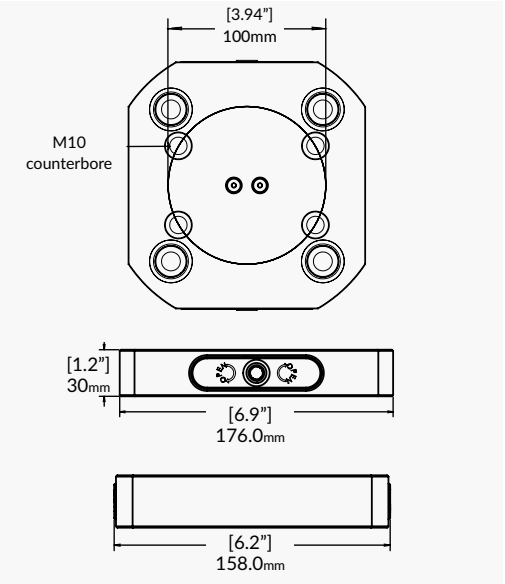


RL96A-60100 / RL96S-60100



Size: 158mm x 150mm x 30mm
Mounting: 4x M10 at 60° on 100mm PCD
Material Construction:
Aluminum (RL96A-60100)
Steel (RL96S-60100)

The **RL96-60100** series quick change adapter was built with 4x counterbores with 100mm spacing. Fitments include the new Haas TRT160 and many others.

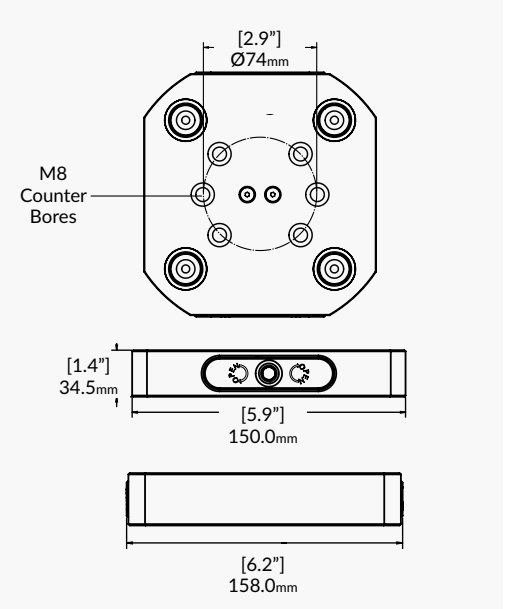


RL96A-DDR / RL96S-DDR



Size: 150mm x 158mm x 34.5mm
Mounting: 6x M8 at 45° on 74mm PCD
Material Construction:
Aluminum (RL96A-DDR)
Steel (RL96S-DDR)

The **RL96-DDR** was built for the Fanuc DDR rotary table.



Single Position Risers

RL96A-38



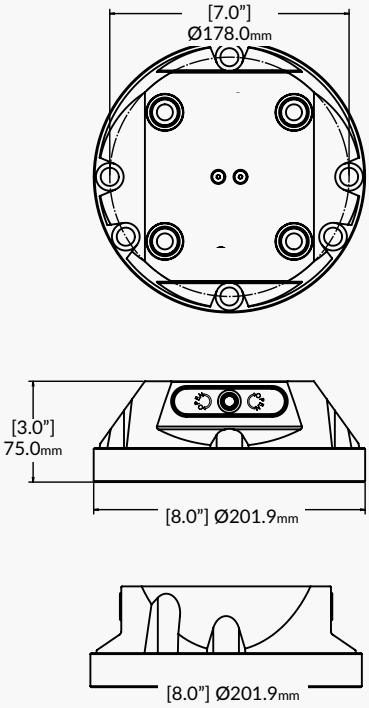
Size: Ø 201.9mm x 75.0mm
Mounting: 4x M12 at 90° on 178mm PCD or 3x M12 at 120° on 178mm PCD
Material Construction: Aluminum (RL96A-38)

The **RL96A-38** series quick change adapter was built for medium sized rotaries and smaller 5 axis machines (~300mm range).

With bolt patterns at 60 degrees and 90 degrees this adapter is flexible and fits on a majority of the most popular rotaries and 5 axis tables on the market.

The 3" overall height makes it ideal for smaller parts that you want to raise above the table.

Repeatability of +/- 8 µm.



RL96A-411

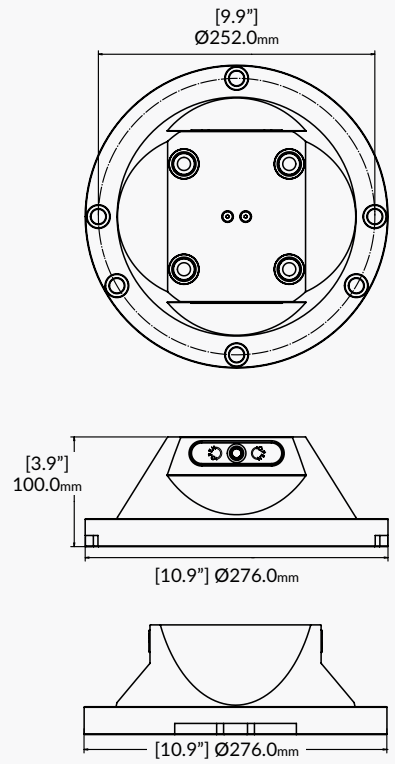


Size: Ø 276mm x 100mm
Mounting: 3x M12 at 120° on 252mm PCD or 4x M12 at 90° on 252mm PCD
Material Construction: Aluminum (RL96A-411)

The **RL96A-411** is an integrated RockLock riser built into one of our most popular adapters.

The 11" diameter adapter x 4" overall height is ideal for medium to large 5 axis machines like the DMG Mori DMU50 and DMU60 as well as the Haas UMC-750 and UMC-750SS.

Repeatability of +/- 8 µm.



Multi-Position Risers

RL96A-3915

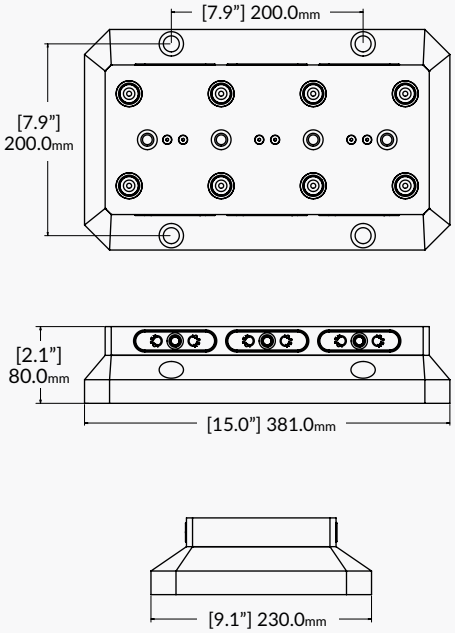


Size: 381mm x 230mm x 80mm
Mounting: 4x M16 on 200mm X 200mm grid
Material Construction: Aluminum (RL96A-3915)

The **RL96A-3915** was built with larger machines in mind (400mm-500mm tables).

Utilize one singular large vise or accommodate two smaller workholding units to maximize machine efficiency and reduce changeover time.

Repeatability of +/- 8 µm.



RL96A-4816

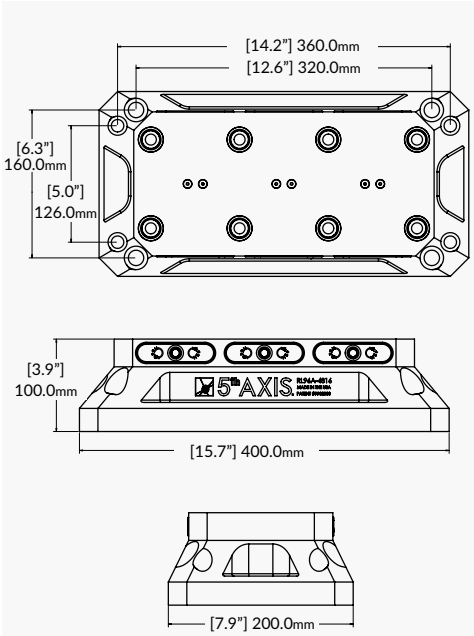


Size: 400mm x 200mm x 100mm
Mounting:: 4x M12 @ 320mm x 160mm rectangle (80mm T-slots) or 4x M16 @ 360mm x 126mm rectangle (63mm T-slots)
Material Construction: Aluminum (RL96A-4816)

The **RL96A-4816** is an integrated multi-position RockLock riser built into one of the largest adapters in the product line.

Utilize one large vise or accommodate two smaller vises with this riser.

Repeatability of +/- 8 µm.



Multi-Position Horizontal Plates

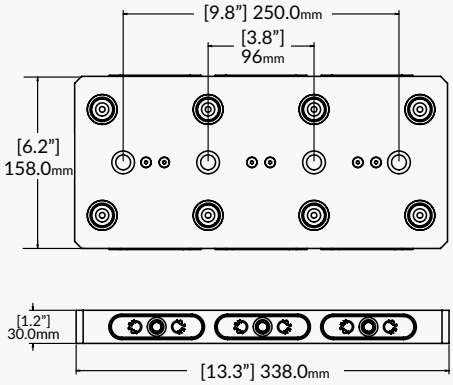
RL96A-3613S1



Size: 158mm x 338mm x 30mm
Mounting: 2x M12 on 96mm apart or 2x M12 on 250mm apart
Material Construction:
Aluminum (RL96A-3613S1)

The **RL96A-3613S1** is a multi-position RockLock plate built for maximum efficiency on small to medium vertical mills. The nested RockLock 96mm pattern allows for the operator to utilize one single large vise or two smaller vises. 125mm T-slot spacing for 3 axis mills.

Repeatability of +/- 8 µm.



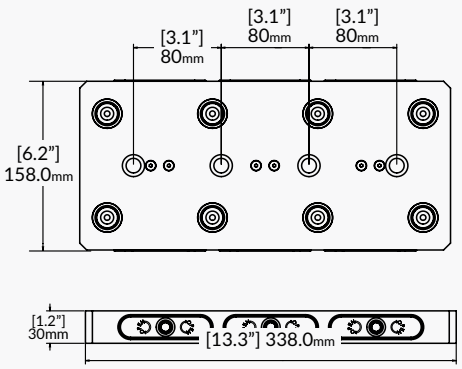
RL96A-3613S2



Size: 158mm x 338mm x 30mm
Mounting: 4x M12 on 80mm apart
Material Construction:
Aluminum (RL96A-3613S2)

The **RL96A-3613S2** is a multi-position RockLock plate built for maximum efficiency on small to medium vertical mills. The nested RockLock 96mm pattern allows for the operator to utilize one single large vise or two smaller vises. 80mm T-slot spacing for 3 axis mills.

Repeatability of +/- 8 µm.



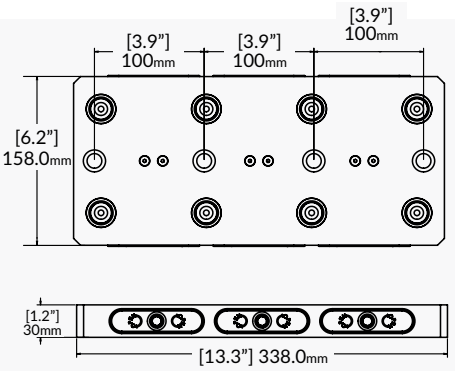
RL96A-3613S3



Size: 158mm x 338mm x 30mm
Mounting: 4x M12 on 100mm apart
Material Construction:
Aluminum (RL96A-3613S3)

The **RL96A-3613S3** is a multi-position RockLock plate built for maximum efficiency on small to medium vertical mills. The nested RockLock 96mm pattern allows for the operator to utilize one single large vise or two smaller vises. 100mm T-slot spacing for 3 axis mills.

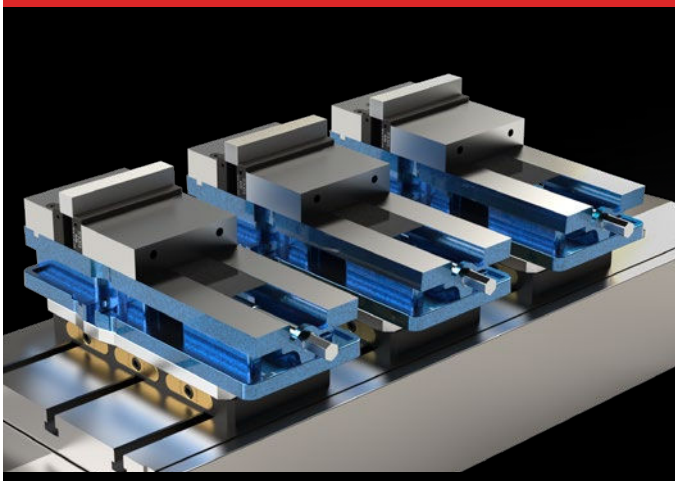
Repeatability of +/- 8 µm.



More Parts Per Cycle = More Profit

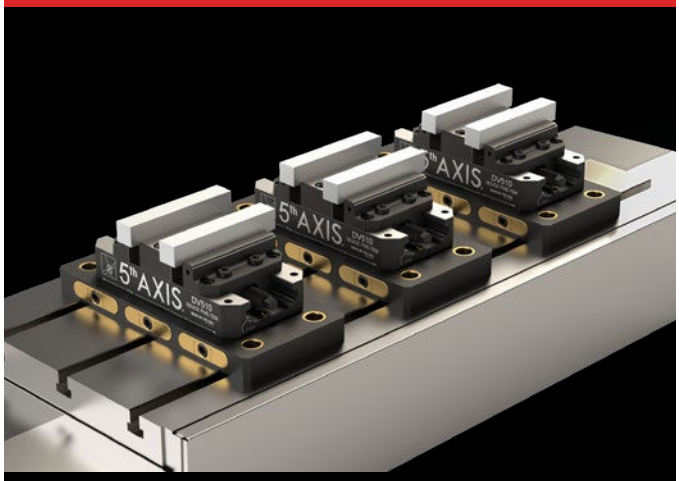
Profitability Through Efficiency

3 Parts Per Cycle



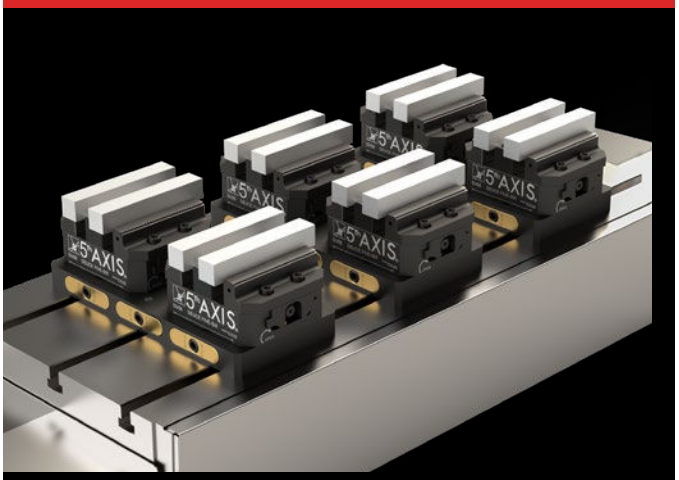
Old school setup with 3 clunky old vises

6 Parts Per Cycle



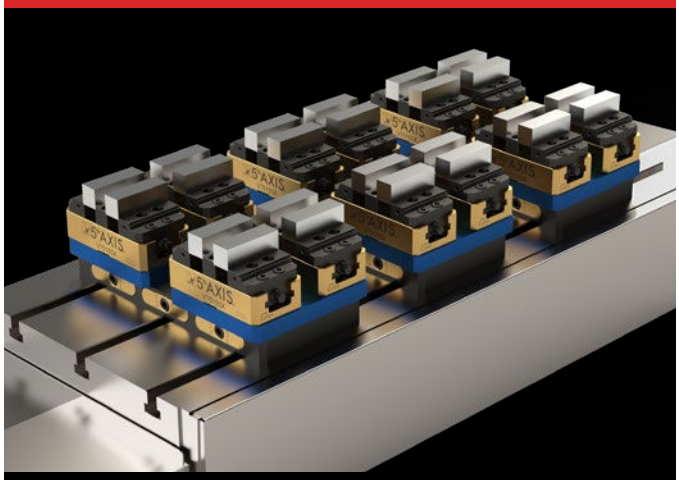
3x DV510 double vise setup

12 Parts Per Cycle



6x DV56 double vise setup

24 Parts Per Cycle



12x DV75150X double vise setup

Multi-Position Horizontal Plates

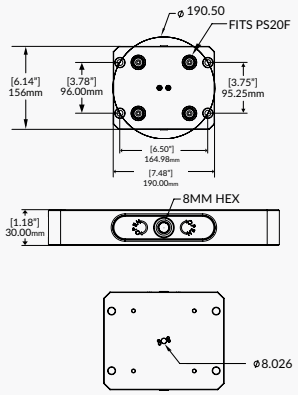
RL96S-68 / RL96A-68

96mm Low Profile Base



Size: 190mm x 156mm x 30mm
Mounting: 4x M10 at 60° on 190.5mm PCD
Material Construction:
Steel (RL96S-68)
Aluminum (RL96A-68)

The **RL96-68** is a 6” x 8” low profile 96mm quick change adapter plate. Designed for the new Haas TRT-210



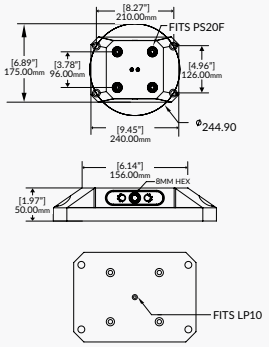
RL96A-2710

96mm Riser



Size: 175mm x 240mm x 50mm
Mounting: 4x M12 on 126mm x 210mm grid
Material Construction:
Aluminum (A)

The **RL96A-2710** is a single position riser built for the new Haas UMC500.
The RL96A-2710 integrates with the RockLock system for maximum changeout efficiency.



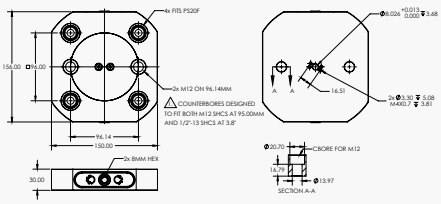
RL96S-6695

96mm Low Profile Base



Size: 156mm x 150mm x 30mm
Mounting: 2x M12 on 96.14mm
Material: Steel (S)
Weight: 9 lbs.

The **RL96-66** series quick change adapter was built specifically for the MAM pallet on the Matsuura MAM-72 series machines.



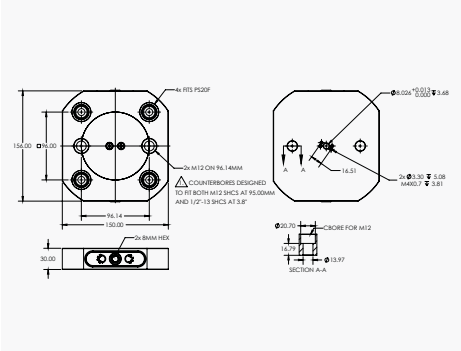
Multi-Position Horizontal Plates

RL96A-6695
96mm Low Profile Base



Size: 156mm x 150mm x 30mm
Mounting: 2x M12 on 96.14mm
Material: Aluminum (A)

The **RL96-66** series quick change adapter was built specifically for the MAM pallet on the Matsuura MAM-72 series machines.

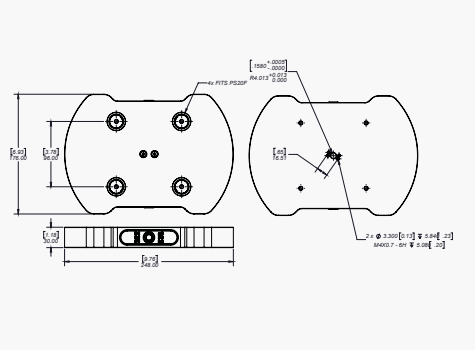


RL96A-10
96mm Low Profile Base



Size: Ø248mm x 30mm
Mounting: DIY Ø248mm
Material: Aluminum (A)
Weight: 6 lbs.

The **RL96-66** series quick change adapter was built as a DIY mounting base for medium to large rotary tables.



Multi-Position 3 Axis Plates

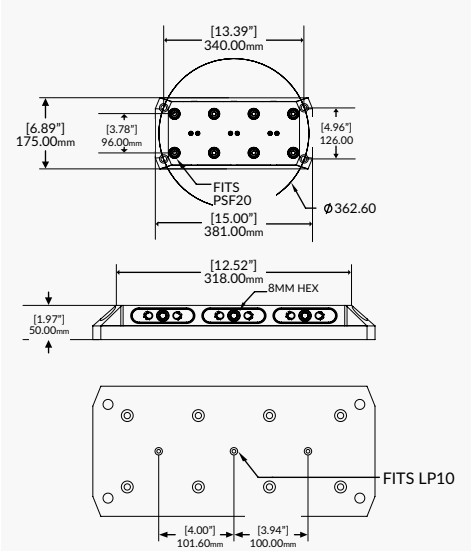
RL96A-2715
96mm Riser



Size: 175mm x 240mm x 50mm
Mounting: 4x M12 on 340mm X 126mm grid
Material Construction: Aluminum (A)

The **RL96A-2715** is a multi-position riser built for the new Haas UMC-500.

The RL96A-2715 provides maximum changeout efficiency with the RockLock system.

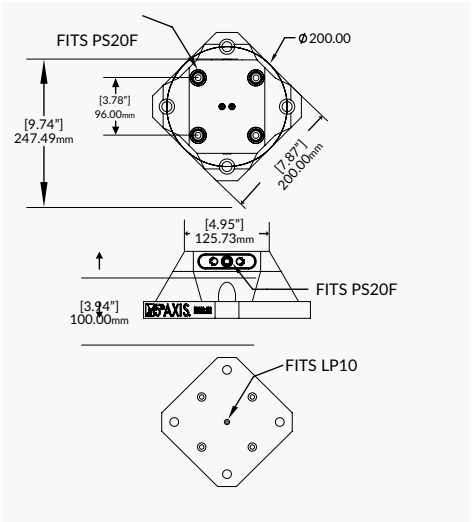


RL96A-488
Riser Adapter



Size: 200mm x 200mm x 100mm
Mounting: 4x M16 at 90° on 200mm PCD
Material Construction: Aluminum (A)

The **RL96A-488** riser adapter provides multiple mounting options to meet various application needs and functions with the RockLock system to reduce setup time.



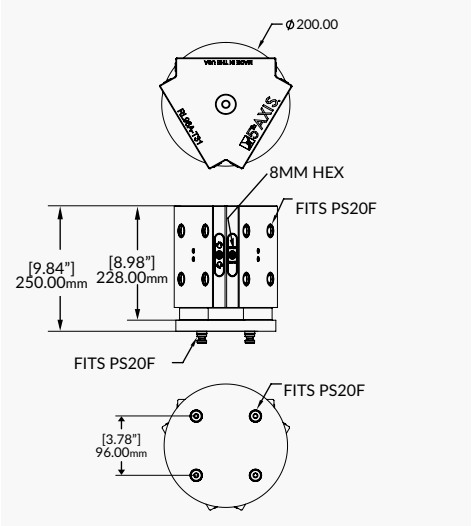
RL96A-T31

3-Sided Integrated RockLock Tombstone



Size: Ø200mm x 250mm
Mounting: 96mm RockLock™
Material Construction: Aluminum (A)

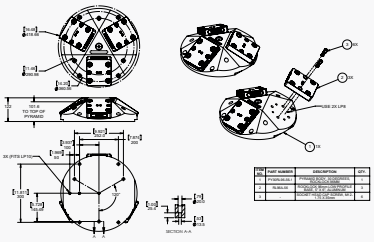
Ideal for automated systems, the **RL96A-T31** tombstone provides three mounting sides for part manufacturing. The RL96A-T31 can be mounted onto any 96mm RockLock base.



PY30RL96-56
3-Sided RockLock™ Pyramid



Size: Ø418.66 x 122mm
Material Construction:
Aluminum (PY30RL96-56)
Mounting: 4x M12 on 200mm x 300mm rectangle or 3x M12 at 120° on 290.95mm PCD



RL96A-3RP20
Dynafix- System 3R Pyramid



Size: Ø381mm x 106mm
Material Construction:
Aluminum (RL96A-3RP20)
Mounting: 96mm RockLock™

RL96A-P320
Integrated RockLock™ Pyramid (96mm)



Size: Ø393mm x 101.6mm
Material Construction:
Aluminum (RL96A-P320)
Mounting: 96mm RockLock™

Tombstones

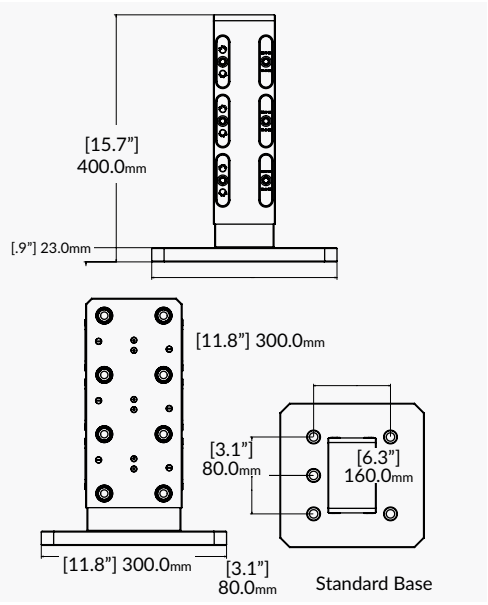
RL96A-3002-400
RL96S-3002-400

300mm RockLock™ Tombstone, 2 Face Aluminum / Steel



Size: 300mm x 300mm x 400mm
Mounting: 6x 100mm or 120mm spacing
Material Construction:
Aluminum (RL96A-3002-400)
Steel (RL96S-3002-400)

This two sided 300mm tombstone integrates the **RockLock** 96mm quick change system. This tombstone is perfect for mid-sized 5 axis machines. It is also a perfect fit for 300mm horizontal machining centers offered by Kitamura and Kitagawa. All units feature hardened steel internals and locating features. All tombstones are built to order, and the base plate is customized to your machine table or pallet specs. This will mount on a 100mm or 120mm grid platter/table. Repeatability of +/- 8 µm.



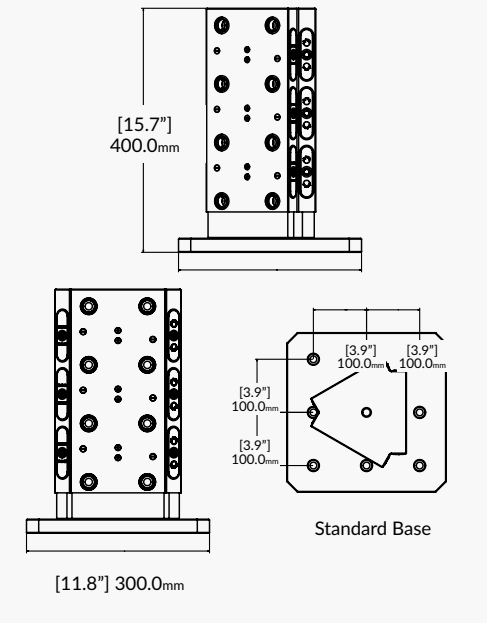
RL96A-3003-400
RL96S-3003-400

300mm RockLock™ Tombstone, 3 Face Aluminum / Steel



Size: 300mm x 300mm x 400mm
Mounting: 6x 100mm or 120mm spacing
Material Construction:
Aluminum (RL96A-3003-400)
Steel (RL96S-3003-400)

This three sided 300mm tombstone integrates the **RockLock** 96mm quick change system. This tombstone is perfect for mid sized 5 axis machines. It is also a perfect fit for 300mm horizontal machining centers. All units feature hardened steel internals and locating features. All tombstones are built to order, and the base plate is customized to your machine table or pallet specs. This will mount on a 100mm or 120mm grid platter/table. Repeatability of +/- 8 µm.

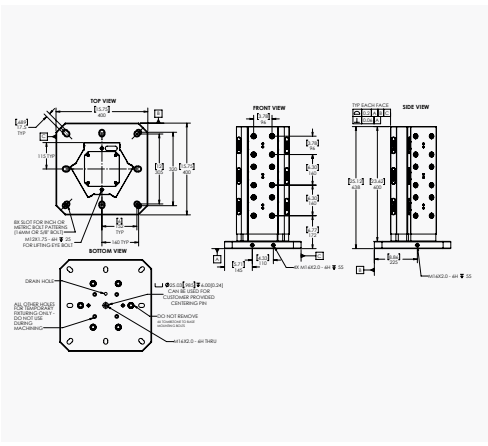


RL96A-4003U-638

400mm RockLock™ Tombstone, 3 Face Aluminum



Size: 400mm x 400mm x 638mm
Mounting: 160mm or 6" spacing
Material Construction: Aluminum (RL96A-4003U-638)
This lightweight three-sided 400mm tombstone integrates the **RockLock** 96mm quick change system. This tombstone is perfect for pallet exchange systems with low weight restrictions. All units feature hardened steel internals and locating features. This will mount on a 80mm or 3" grid platter/table. Repeatability of +/- 8 µm.



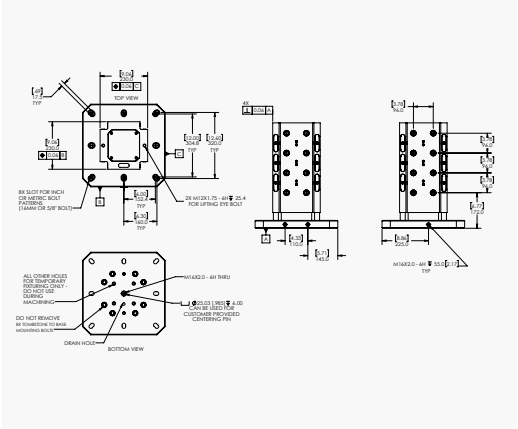
RL96A-4004U -510

400mm RockLock™ Tombstone, 4 Face Aluminum



Size: 400mm x 400mm x 510mm
Mounting: 8x 160mm or 6” spacing
Material Construction:
Aluminum (RL96A-4004U-510)

This lightweight four-sided 400mm tombstone integrates the RockLock 96mm quick change system. This tombstone is perfect for pallet exchange systems with low weight restrictions. All units feature hardened steel internals and locating features. This tombstone will mount on a 80mm or 3” spaced grid platter/table. Repeatability of +/- 8 µm.



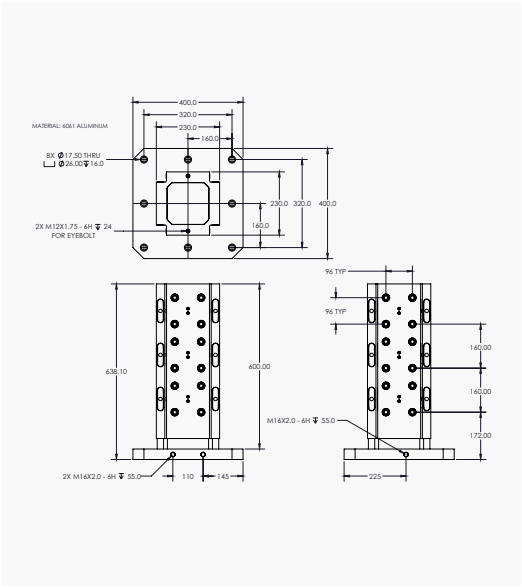
RL96A-4004U -638

400mm RockLock™ Tombstone, 4 Face Aluminum



Size: 400mm x 400mm x 638mm
Material Construction:
Aluminum (RL96A-4004U-638)
Mounting: 8x 160mm or 6” spacing
# of Positions: 12 total, 3 per side
Weight: 175lb
Weight w/ Freight: 218lb

This lightweight four-sided 400mm tombstone integrates the RockLock 96mm quick change system. This tombstone is perfect for pallet exchange systems with low weight restrictions. All units feature hardened steel internals and locating features. This tombstone will mount on a 80mm or 3” spaced grid platter/table. Repeatability of +/- 8 µm.

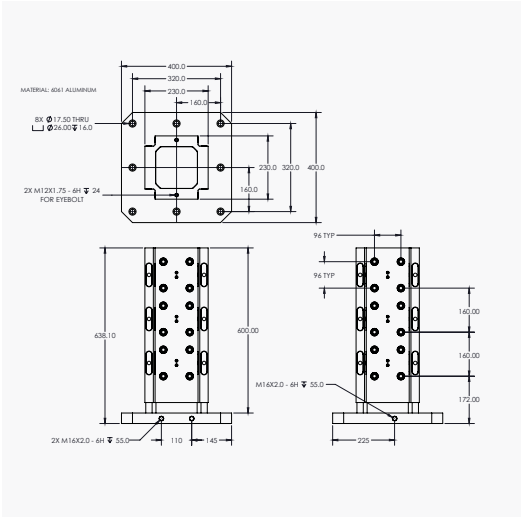


RL96S-4004U -638

400mm RockLock™ Tombstone, 4 Face Cast Iron



Size: 400mm x 400mm x 638mm
Material Construction:
Cast Iron
Mounting: 8x 160mm or 6” spacing
# of Positions: 12 total, 3 per side
Weight: 400lb
Weight w/ Freight: 510lb
Enhance your machining efficiency with our robust four-sided 400mm CNC tombstone.Crafted from high-quality cast-iron, this tombstone is designed to withstand the rigors of intensive machining operations. All units feature hardened steel internals and locating features. This tombstone will mount on a 80mm or 3” spaced grid platter/table. Repeatability of +/- 8 µm.



Tombstones

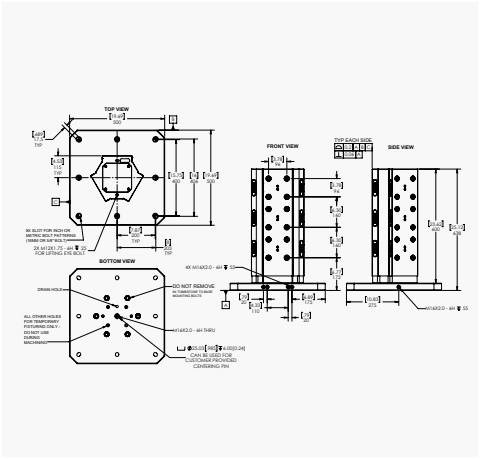
RL96A-5003U -638

500mm RockLock™ Tombstone, 3 Face Aluminum



Size: 500mm x 500mm x 638mm
Mounting: 8x 200mm or 8” spacing
Material Construction:
Aluminum (RL96A-5003U-638)

This lightweight three-sided 500mm tombstone features the integrated **RockLock** 96mm quick change system. This tombstone is perfect for pallet exchange systems with low weight restrictions. All units feature hardened steel internals and locating features. This tombstone will mount on a 100mm or 4” grid platter/table. Repeatability of +/- 8 µm.



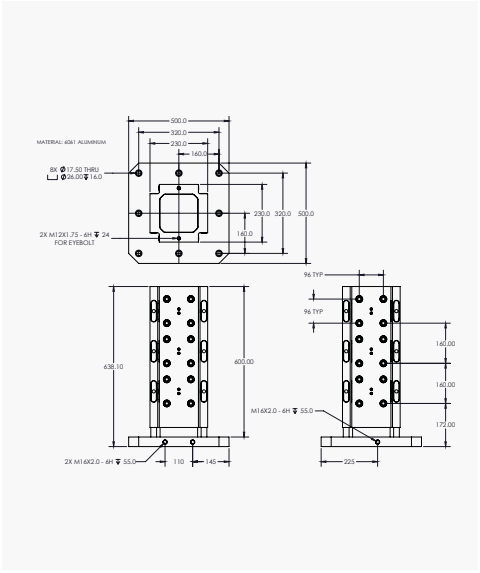
RL96A-5004U -638

500mm RockLock™ Tombstone, 4 Face Aluminum



Size: 500mm x 500mm x 638mm
Material Construction:
Aluminum
Mounting: 8x 200mm or 8” spacing
# of Positions: 12 total, 3 per side
Weight: 195lb
Weight w/ Freight: 200lb

This lightweight four-sided 500mm tombstone features the integrated **RockLock** 96mm quick change system. This tombstone is perfect for pallet exchangea systems with low weight restrictions. All units feature hardened steel internals and locating features. This tombstone will mount on a 100mm or 4” grid platter/table. Repeatability of +/- 8 µm.



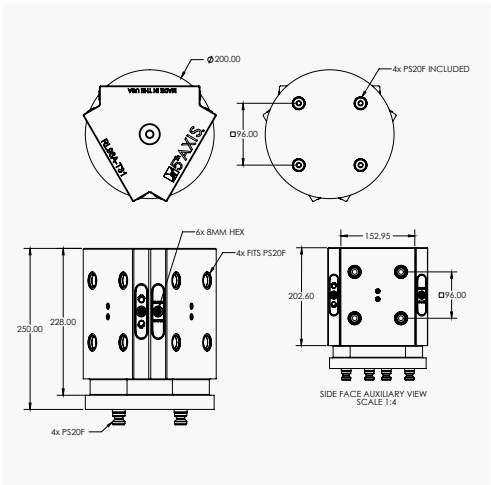
RL96A-T31

Rocklock™ Tombstone, 3 Face Aluminum



Size: Ø 200mm x 250mm
Material Construction:
Aluminum
Mounting: 96mm RockLock™
# of Positions: 3 total, 1 per side
Weight: 37lbs

Constructed with aerospace-grade aluminum, the **RockLock** base embodies the perfect blend of versatility and robust durability. Its industry standard 96mm pull stud spacing ensures a seamless fit into your machining setup, reducing unnecessary bulk while maximizing workspace efficiency workspace efficiency.



96mm Top Tooling Tombstones

A96-V75100T4

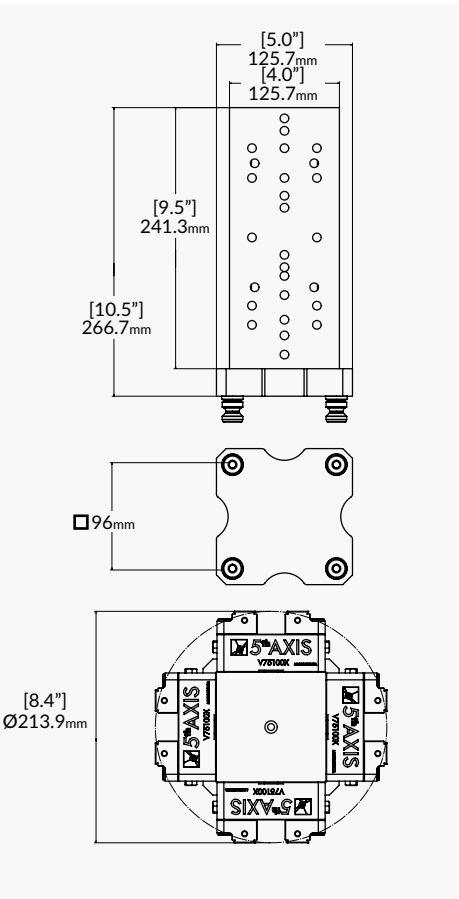
Tombstone, 4 Face Aluminum



*Vises sold separately

Size: 125.7mm x 125.7mm x 266.7mm
Mounting: 96mm RockLock™
Material Construction:
Aluminum (RL96A-V75100T4)

The **A96-V75100T4** is an ultra compact mini tombstone designed to work with smaller 4 and 5 Axis machines. The goal was to create a 4 sided tombstone to increase productivity while maintaining a compact footprint. The tombstone is built for the V75100X self-centering vise (see page 45). The nested bolt pattern allows for the vises to be mounted vertically or rotated horizontally. The entire tombstone will quick change onto any 96mm RockLock base plates. With a maximum of 12 vises on the tombstone, the machine can run unattended. This minimizes tool changes and frees operators up to run multiple machines. Includes 4x PS20F. Repeatability of +/- 8 µm.



A96-V75XT4

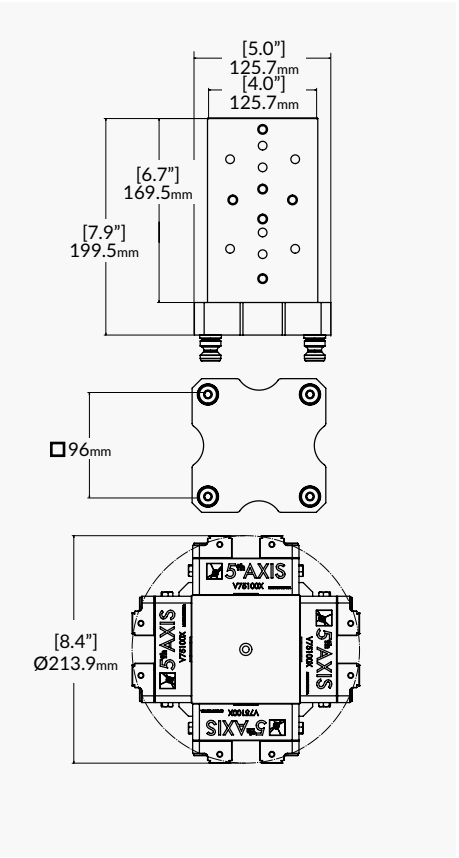
Tombstone, 4 Face Aluminum



*Vises sold separately

Size: 125.7mm x 125.7mm x 200mm
Mounting: 96mm RockLock™
Material Construction:
Aluminum (RL96A-V75XT4)

The **R96-V75XT4** is a mini tombstone designed to work with smaller 4 and 5 Axis machines. The goal was to create a 4 sided tombstone to increase productivity while maintaining a compact footprint. This tombstone can accommodate the following self-centering vises: V75100X and V75150X (see page 45). It will also fit the DV75150X double station vise (see page 39). The entire tombstone will quick change on any 96mm RockLock base plates. With a maximum of 8 vises on the tombstone, the machine can run unattended. This minimizes tool changes and frees operators up to run multiple machines. Includes 4x PS20F. Repeatability of +/- 8 µm.



Adapters

RL96A-90DEG



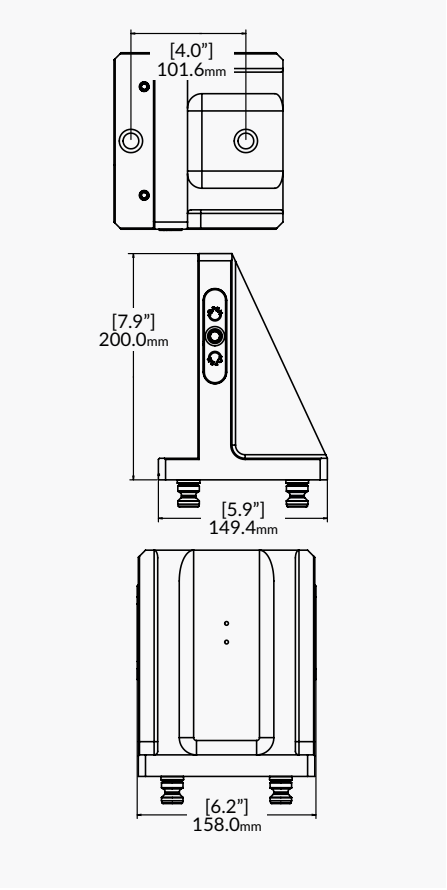


Size: 149.4mm x 158mm x 200mm
Mounting: RockLock PS20F or 2x M12 SHCS @ 100mm - 101.6mm
Material Construction: Aluminum (RL96A-90DEG)

The 90° right angle **RockLock** plate is the perfect low cost solution for multi-side machining. Machine 5 sides of a part without a 5 axis machine. The unit features pull studs on the bottom so that it can be mounted onto any 96mm RockLock plate. It also has 2 counter bores for traditional mounting to machine T-slots at 4" or 100mm.

Simply machine your material, unlock the system, rotate the material, lock the system and continue machining.

Includes 4x PS20F.
Repeatability of +/- 8 µm..



RL96A-356 / RL96S-356



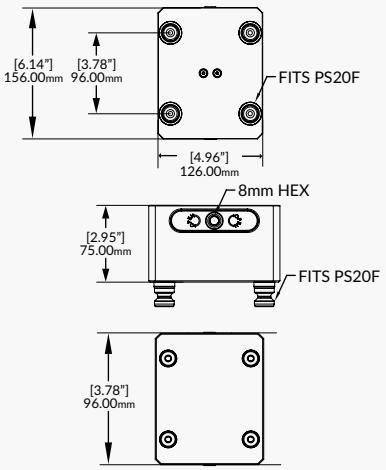
Size: 158mm x 126mm x 75mm
Mounting: 96mm RockLock™
Material Construction: Aluminum (RL96A-356) Steel (RL96S-356)

Built to give extra rise from any **RockLock** bases.

The small profile was created to reduce any interference.

Includes 4x PS20F.

Repeatability of +/- 8 µm.



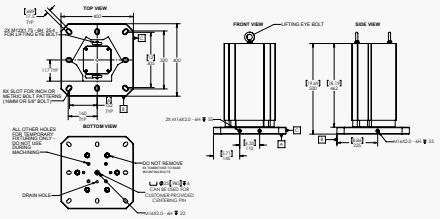
MTA-4003U-500

Machinable Tombstone,
3 Face Aluminum



Size: 400mm x 400mm x 500mm
Material Construction: Aluminum
Mounting: 8x 160mm or 6” spacing
Weight: 121.16 lbs
Weight w/ Freight: 258 lbs

MTA-4003U-500 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 80mm or 3” spaced grid platter/table.



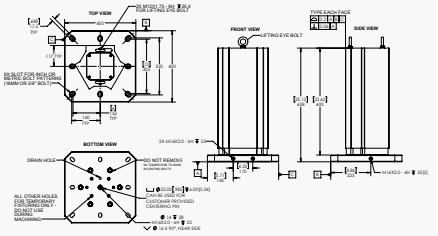
MTA-4003U-638

Machinable Tombstone,
3 Face Aluminum



Size: 400mm x 400mm x 638mm
Material Construction: Aluminum
Mounting: 8x 160mm or 6” spacing
Weight: 155 lbs
Weight w/ Freight: 255 lbs

MTA-4003U-638 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 80mm or 3” spaced grid platter/table.



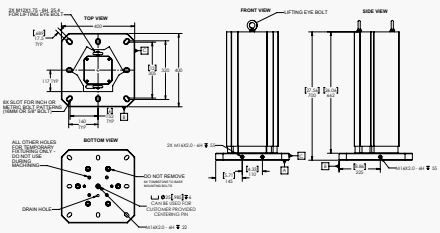
MTA-4003U-700

Machinable Tombstone,
3 Face Aluminum



Size: 400mm x 400mm x 800mm
Material Construction: Aluminum
Mounting: 8x 160mm or 6” spacing
Weight: 158.84 lbs
Weight w/ Freight: 258 lbs

MT-4003U-700 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 80mm or 3” spaced grid platter/table.



Tombstones

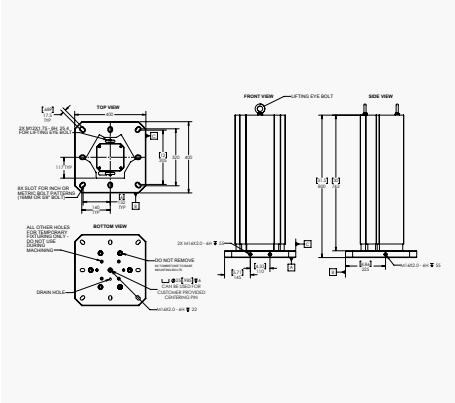
MTA-4003U-800

Machinable Tombstone,
3 Face Aluminum



Size: 400mm x 400mm x 800mm
Material Construction: Aluminum
Mounting: 8x 160mm or 6” spacing
Weight: 177.69 lbs
Weight w/ Freight: 277 lbs

MTA-4003U-800 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 80mm or 3” spaced grid platter/table.



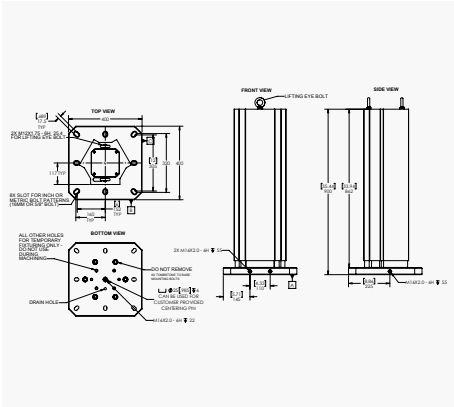
MTA-4003U-900

Machinable Tombstone,
3 Face Aluminum



Size: 400mm x 400mm x 900mm
Material Construction: Aluminum
Mounting: 8x 160mm or 6” spacing
Weight: 196.54 lbs
Weight w/ Freight: 296 lbs

MTA-4003U-900 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 80mm or 3” spaced grid platter/table.



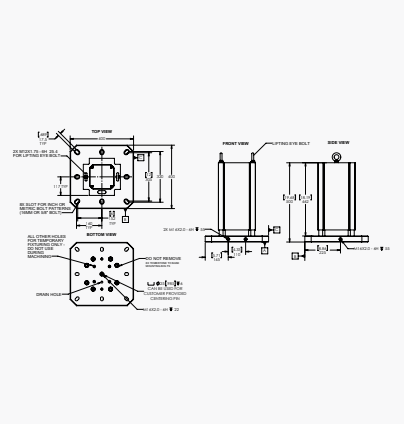
MTA-4004U-500

Machinable Tombstone,
4 Face Aluminum



Size: 400mm x 400mm x 500mm
Material Construction: Aluminum
Mounting: 8x 160mm or 6” spacing
Weight: 124.42 lbs
Weight w/ Freight: 244 lbs

MTA-4004U-500 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 80mm or 3” spaced grid platter/table.



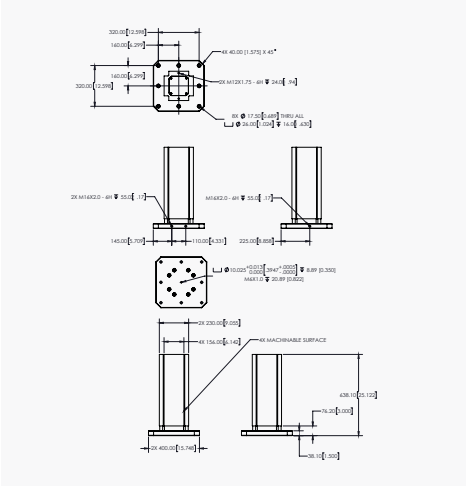
MTA-4004U-638

Machinable Tombstone,
4 Face Aluminum



Size: 400mm x 400mm x 638mm
Material Construction: Aluminum
Mounting: 8x 160mm or 6” spacing
Weight: 155 lbs
Weight w/ Freight: 255 lbs

MTA-4004U-638 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 80mm or 3” spaced grid platter/table.



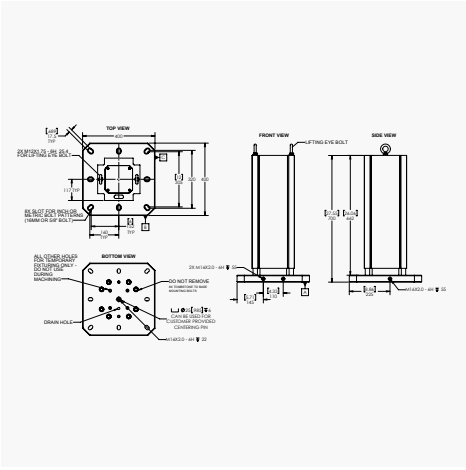
MTA-4004U-700

Machinable Tombstone,
4 Face Aluminum



Size: 400mm x 400mm x 700mm
Material Construction: Aluminum
Mounting: 8x 160mm or 6” spacing
Weight: 163.64 lbs
Weight w/ Freight: 263 lbs

MT-4004U-700 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 80mm or 3” spaced grid platter/table.



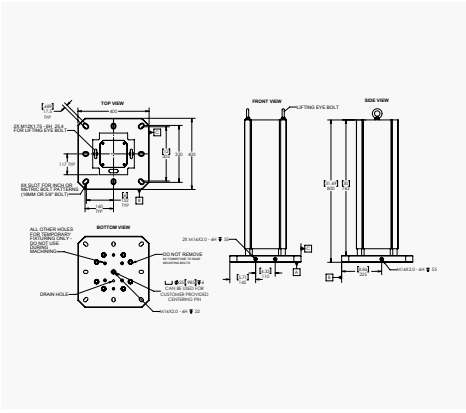
MTA-4004U-800

Machinable Tombstone,
4 Face Aluminum



Size: 400mm x 400mm x 800mm
Material Construction: Aluminum
Mounting: 8x 160mm or 6” spacing
Weight: 183.2 lbs
Weight w/ Freight: 283 lbs

MTA-4004U-800 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 80mm or 3” spaced grid platter/table.



Tombstones

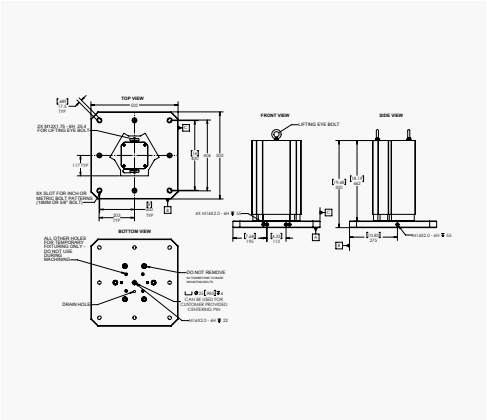
MTA-5003U-500

Machinable Tombstone,
3 Face Aluminum



Size: 500mm x 500mm x 500mm
Material Construction: Aluminum
Mounting: 8x 200mm or 8” spacing
Weight: 141.64 lbs.
Weight w/ Freight: 241 lbs

MTA-5003U-500 is designed to be one of the most robust and competitively priced 500mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 100mm or 4” grid platter/table.



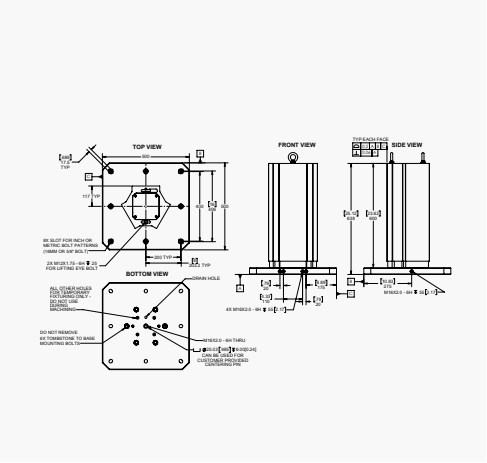
MTA-5003U-638

Machinable Tombstone,
3 Face Aluminum



Size: 500mm x 500mm x 638mm
Material Construction: Aluminum
Mounting: 8x 200mm or 8” spacing
Weight: 155 lbs
Weight w/ Freight: 218 lbs

MTA-5003U-638 is designed to be one of the most robust and competitively priced 500mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 100mm or 4” grid platter/table.



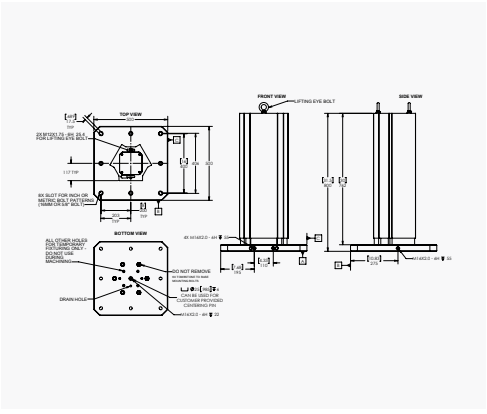
MTA-5003U-800

Machinable Tombstone,
3 Face Aluminum



Size: 500mm x 500mm x 800mm
Material Construction: Aluminum
Mounting: 8x 200mm or 8” spacing
Weight: 198.17 lbs
Weight w/ Freight: 298 lbs

MTA-5003U-800 is designed to be one of the most robust and competitively priced 500mm machinable aluminum tombstones in the world.This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 100mm or 4” grid platter/table.



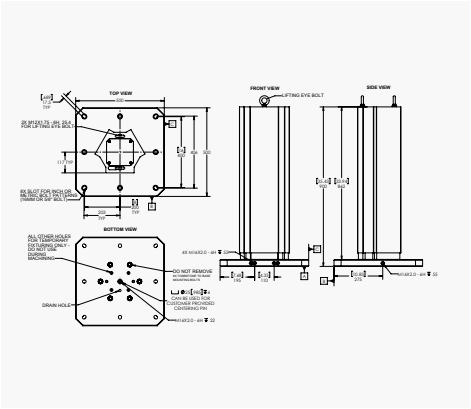
MTA-5003U-900

Machinable Tombstone,
3 Face Aluminum



Size: 500mm x 500mm x 900mm
Material Construction: Aluminum
Mounting: 8x 200mm or 8” spacing
Weight: 98.43 lbs
Weight w/ Freight: 198 lbs

MTA-5003U-900 is designed to be one of the most robust and competitively priced 500mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 100mm or 4” grid platter/table.



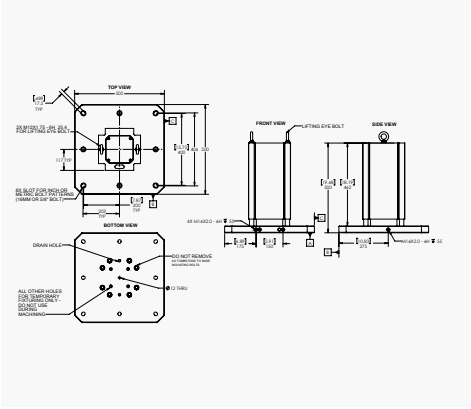
MTA-5004U-500

Machinable Tombstone,
4 Face Aluminum



Size: 500mm x 500mm x 500mm
Material Construction: Aluminum
Mounting: 8x 200mm or 8” spacing
Weight: 144.95 lbs
Weight w/ Freight: 244 lbs

MTA-5004U-500 is designed to be one of the most robust and competitively priced 500mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 100mm or 4” grid platter/table.



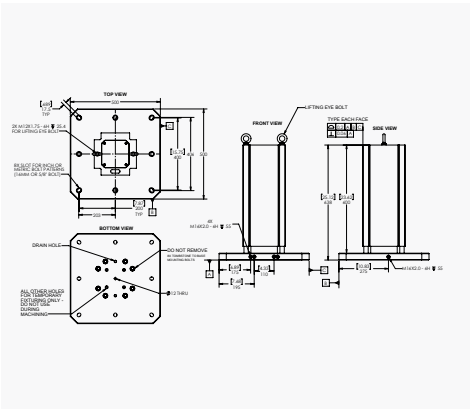
MTA-5004U-638

Machinable Tombstone,
4 Face Aluminum



Size: 500mm x 500mm x 638mm
Material Construction: Aluminum
Mounting: 8x 200mm or 8” spacing
Weight: 175 lbs
Weight w/ Freight: 275 lbs

MTA-5004U-638 is designed to be one of the most robust and competitively priced 500mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 100mm or 4” grid platter/table.



Tombstones

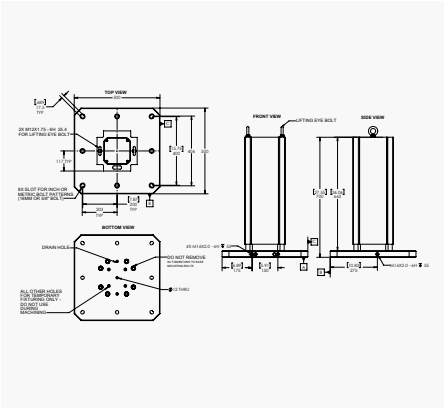
MTA-5004U-700

Machinable Tombstone,
4 Face Aluminum



Size: 500mm x 500mm x 700mm
Material Construction: Aluminum
Mounting: 8x 200mm or 8” spacing
Weight: 184.17 lbs
Weight w/ Freight: 284 lbs

MTA-4004U-700 is designed to be one of the most robust and competitively priced 400mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 100mm or 4” grid platter/table.



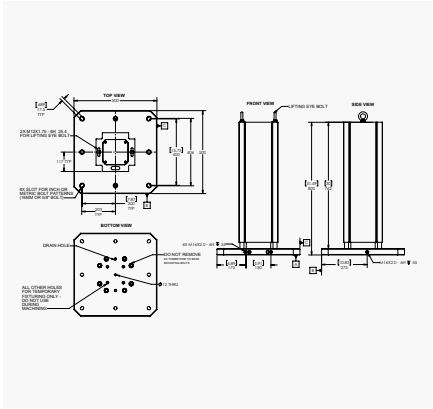
MTA-5004U-800

Machinable Tombstone,
4 Face Aluminum



Size: 500mm x 500mm x 800mm
Material Construction: Aluminum
Mounting: 8x 200mm or 8” spacing
Weight: 203.79 lbs
Weight w/ Freight: 303 lbs

MTA-5004U-800 is designed to be one of the most robust and competitively priced 500mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 100mm or 4” grid



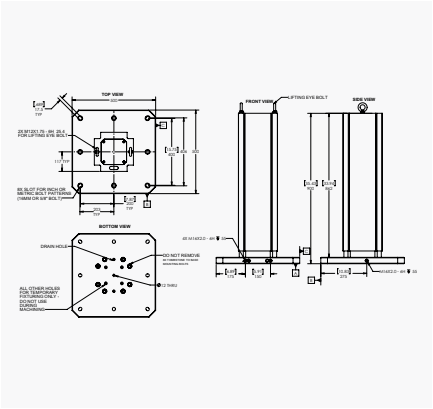
MTA-5004U-900

Machinable Tombstone,
4 Face Aluminum



Size: 500mm x 500mm x 900mm
Material Construction: Aluminum
Mounting: 8x 200mm or 8” spacing
Weight: 223.39 lbs
Weight w/ Freight: 323 lbs

MTA-5004U-900 is designed to be one of the most robust and competitively priced 500mm machinable aluminum tombstones in the world. This tombstone provides a sturdy and cost-effective solution for your machining needs. This tombstone will mount on a 100mm or 4” grid platter/table.



R96-D115T41

Dovetail Mini Tombstone Top Tooling

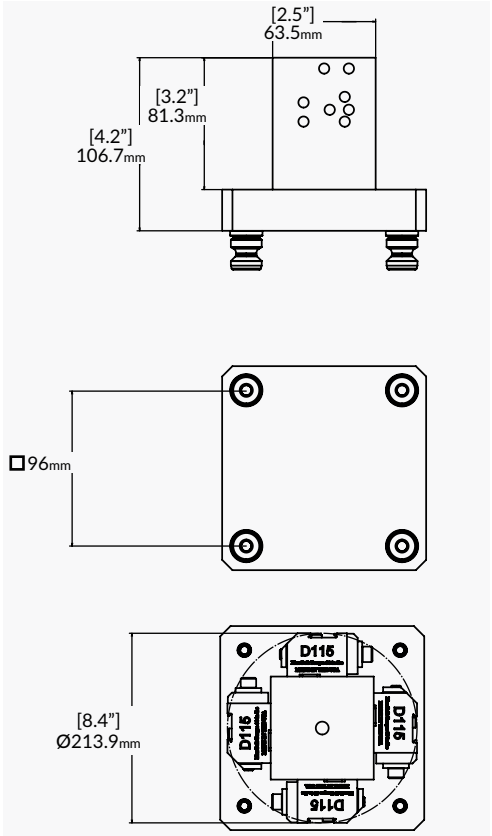


Size: 125mm x 125mm x 106.7mm
Mounting: 96mm RockLock™
Built for small or medium rotaries. Able to utilize quantity **4 D115** dovetail fixtures in order to maximize part density allowing minimal interference. Quantity 4 PS20F Pull studs are included.

Repeatability of +/- 8 µm.





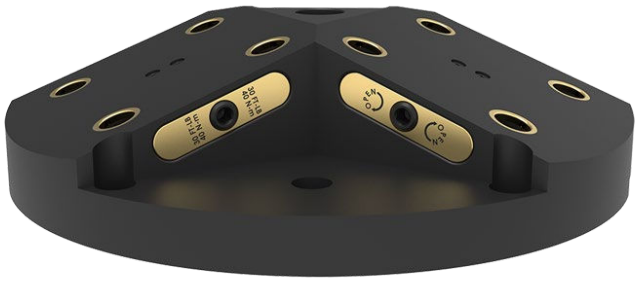


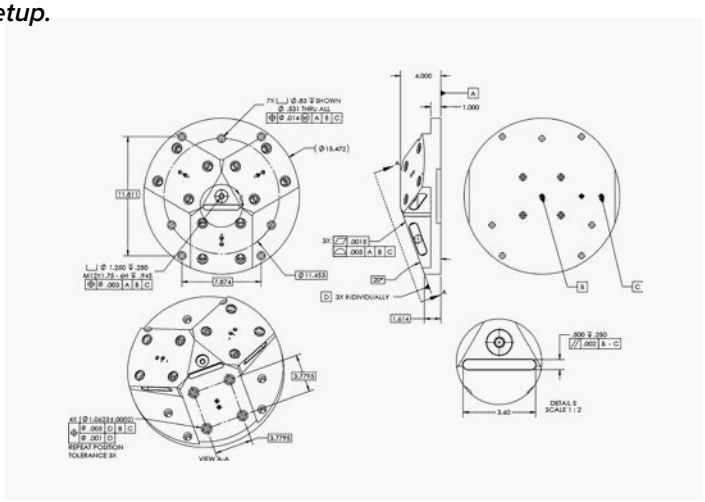
*Fixtures sold separately

RL96A-P320

Integrated RockLock Pyramid
Size: 15" diameter x 4" overall height
Mounting: 96mm RockLock™
Weight: 47 lbs

RL96A-P320 Pyramids – a cutting-edge solution designed for seamless compatibility with 96mm RockLock top tooling, elevating the versatility of your machining setup.





96mm Accessories



PS20F

PULL STUD

Size: 96mm Pull Studs
Material Construction: S7 Tool Steel

The PS20F is required to use any 5th Axis 96mm base. The 96mm spacing allows for compatibility with other systems.

*Please note that pull studs must stay with the corresponding company's base plate. If you are using a **5th Axis 96mm RockLock** base plate you will need 5th Axis pull studs (PS20F). The spacing and thread allows for the top tooling to be interchangeable between the different systems.



PS20F-PY

SINGLE PULL STUD WITH POKA-YOKE INSERT

Size: 96mm Pull Studs
Material Construction: S7 Tool Steel

Poka-yoke is a Japanese term that means "mistake-proofing". The **PS20F-PY** is a single modified pull stud with an aluminum ring. The ring is placed inside one of the locating holes in the RockLock base, allowing for only the single poka-yoke pull stud to fit inside the locating hole with the corresponding ring. This will prevent operators from changing the orientation and misloading a part.



PS20F-4PY

PULL STUDS WITH POKA-YOKE INSERT

Size: 96mm Pull Studs
Material Construction: S7 Tool Steel

3x Standard **PS20F** Pull Studs and one Poka-Yoke (PS20F-PY).



PS20D

DUMMY PULL STUDS

Size: 96mm Pull Studs
Material Construction: S7 Tool Steel



A96-BLANK

Size: 96mm Pull Studs
Material Construction: 6061 Aluminum

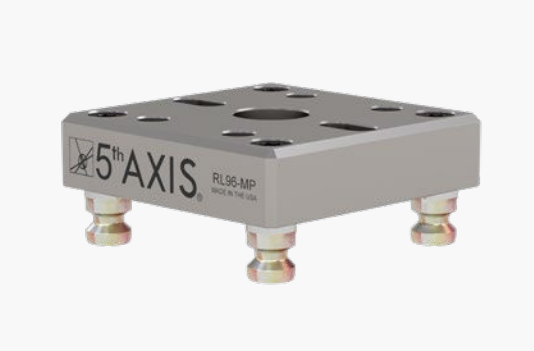
Blank 6061 aluminum block with quantity **4 PS20F** pull studs included. Quickly build your own fixture or subplate with the R96-Blank.



A96-BR

Size: 96mm Pull Studs
Material Construction: 6061 Aluminum

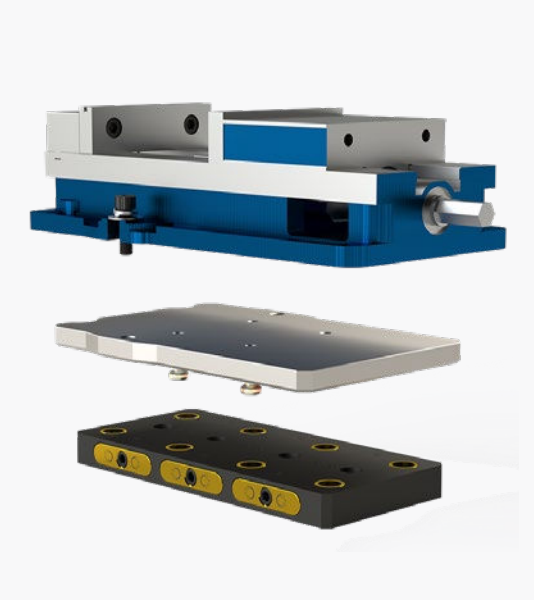
Blank 6061 aluminum cylinder with quantity **4 PS20F** pull studs included. Quickly build your own fixture or subplate with the R96-BR.



RL96-MP

Size: 96mm Pull Studs
Material Construction: Steel

Mount the **RockLock** base onto the machine, drop in the master pallet, dial in your setup, and torque your mounting bolts once you have reached the desired location. This is the fastest, most accurate way to set up the RockLock system.
See page 33 for more info.



RL96-KD688 / RL96-KDX6*

Size: RL96-KD688: 13” x 8.25” x .78”
RL96-KDX6: 13” x 6.92” x .78”
Material Construction:
Aluminum (RL96-KD688)
Aluminum (RL96-KDX6)

The **RL96-KD688** is built to upgrade your Kurt D-series 6 vise to the RockLock quick-change system. Never indicate your Kurt vise in again! Simply bolt your Kurt vise onto the adapter and you will be off and running. Part number includes adapter + 4x PS20F pull studs.

The **RL96-KDX6** is built for the newer style DX6 crossover vise. Upgrade your new Kurt DX6 to RockLock quick-change system from 5th Axis. Part number includes adapter quantity 4 PS20F pull studs.

*Vise and RockLock base sold separately

Pallets

Pallet Solutions



5th Axis Workholding products are designed to adapt to automated systems increasing throughput. Create profitability through efficiency.

EROWA system solutions

SOLUTIONS



148mm



320mm



400mm

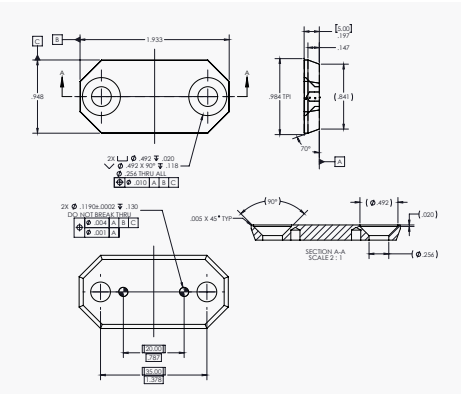


AS-96

96mm Custom Gripper

Automation Solutions, Gripper Assembly, 96mm

industrial robot automation.



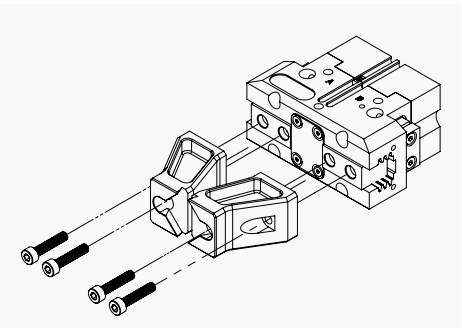


AG-12

52mm Custom Gripper

Automation Solutions, Gripper Assembly, 52mm

industrial robot automation.



Automation Solutions

Available in 52mm and 96mm Pull Stud Spacing

Clamp / Unclamp Confirmation

Steel Locating Features

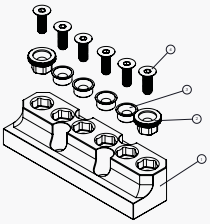




V562X-5RG

Round Stock Gripper Jaw
(For V562X & V510X)

5□ wide, X-Series compatible hard jaws to support round raw stock

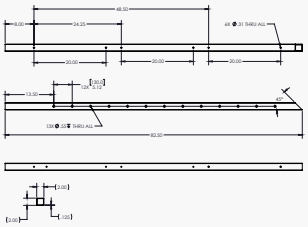




AS-RS

Automation Rack Shelf

Single Shelf for Automation Racks.

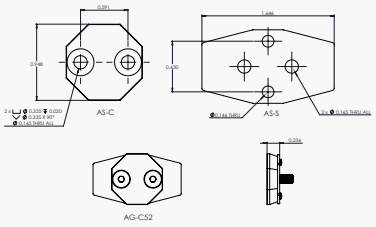




AG-C

52mm Low Profile Cleat

Our innovative cleat design simplifies and secures the movement of tooling using robotic systems.

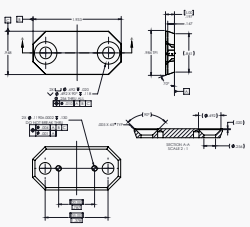




AS-C96

96mm Low Profile Cleat

Our innovative cleat design simplifies and secures the movement of tooling using robotic systems.

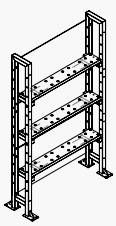




AS-R3

Single Rack & Shelf Kit

Single Rack & Shelf Kit with 3-shelf assembly.



Visit 5thaxis.com/automation to see the full line of automation products.

Automation

RL52P-66B

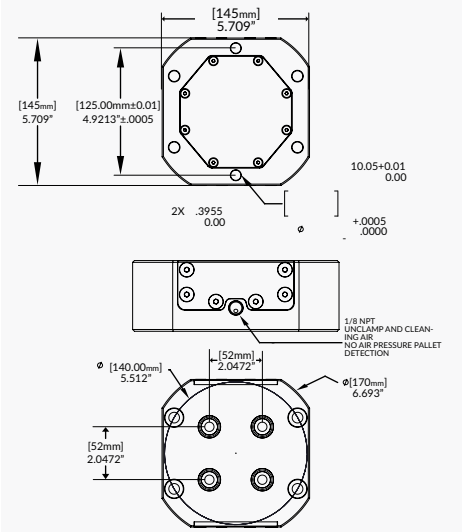


The **RL52P-66B** is a 52mm pneumatic RockLock unit.

Working pressure range:
80 PSI (.55 MPa) MIN /
120 PSI (.83 MPa) MAX

Side-Port

- 52mm pull stud spacing
- Air to open / spring to close
- Built for manual operation
- 1 port for clamp / unclamp
- No cleaning air / clamp confirmation



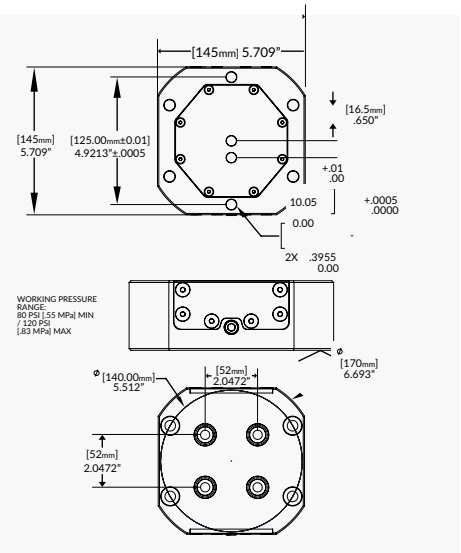
RL52P-66A
Bottom-Port



The **RL52P-66A** is a 52mm pneumatic RockLock unit that uses air to open and spring to close.

Working pressure range:
80 PSI (.55 MPa) MIN /
120 PSI (.83 MPa) MAX

- 52mm pull stud spacing
- Air to open / spring to close
- Built for automation applications
- 1 port for clamp / unclamp
- 1 port for cleaning / clamp confirmation



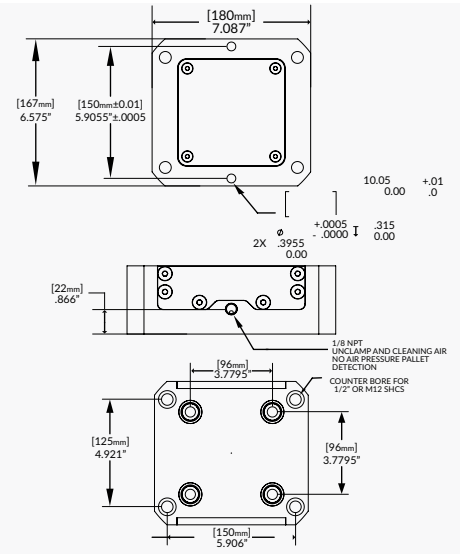
RL96P-67B
Side-Port



The **RL96P-67B** is a 96mm pneumatic RockLock unit.

Working pressure range:
80 PSI (.55 MPa) MIN /
130 PSI (.86 MPa) MAX

- 96mm pull stud spacing
- Air to open / spring to close
- Built for manual operation
- 1 port for clamp / unclamp
- No cleaning air / clamp confirmation



RL96P-67A

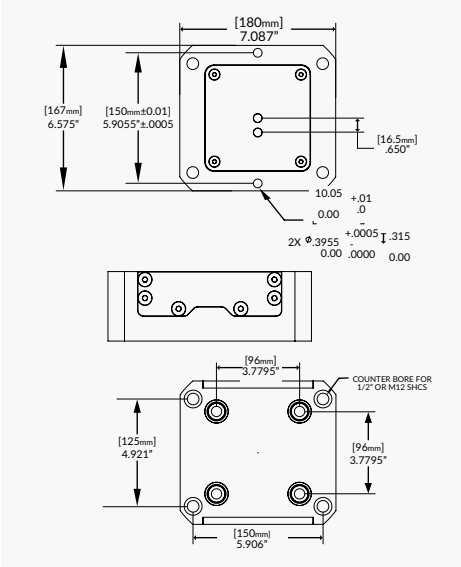


The **RL96P-67A** is a 96mm pneumatic RockLock unit that uses air to open and spring to close.

Working pressure range:
80 PSI (.55 MPa) MIN /
130 PSI (.86 MPa) MAX

Bottom Port

- 96mm pull stud spacing
- Air to open / spring to close
- Built for automation applications
- 1 port for clamp / unclamp
- 1 port for cleaning / clamp confirmation



RL52E-66

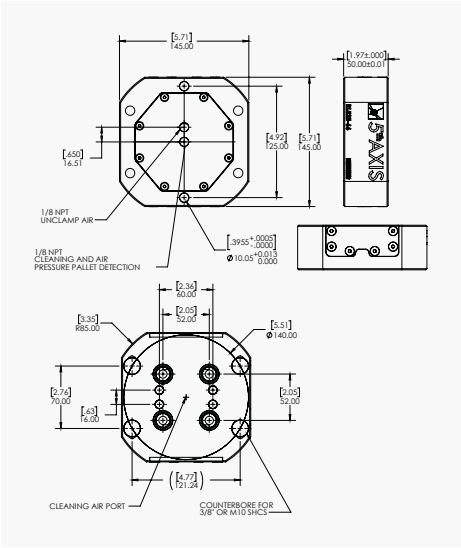


The **RL52E-66** is a 52mm pneumatic RockLock unit that uses air to open and spring to close.

Working pressure range:
80 PSI (.55 MPa) MIN /
130 PSI (.86 MPa) MAX

Bottom Port

- 52mm pull stud spacing
- Air to open / spring to close
- Built for automation applications
- 1 port for clamp / unclamp
- 1 port for cleaning / clamp confirmation



RL96E-67

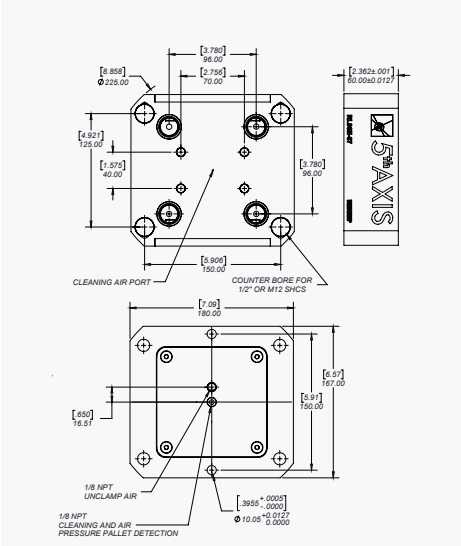


The **RL96E-67** is a 96mm pneumatic Chuck with Ejectors RockLock™ unit that uses air to open and spring to close.

Working pressure range:
80 PSI (.55 MPa) MIN /
130 PSI (.86 MPa) MAX

Bottom Port

- 96mm pull stud spacing
- Air to open / spring to close
- Built for automation applications
- 1 port for clamp / unclamp
- 1 port for cleaning / clamp confirmation



* Visit 5thaxis.com/automation for updates

Pneumatic Vises

Short Travel Pneumatic Vise

APV-160-A

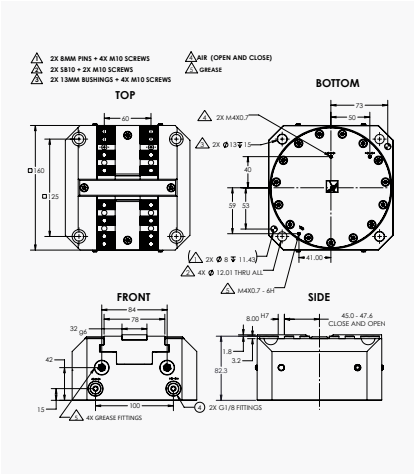


Short Stroke / High Clamping Force

42 kN clamping force — enough headroom for aggressive roughing cuts and heavier stock
without adding a second clamping station.

2.6mm travel per jaw keeps the stroke tight and the cycle fast. Runs on the same 30–130 PSI shop air as every other 5th Axis pneumatic product — no dedicated regulator required.

See Additional Vise Specks on page 55



Long Travel Pneumatic Vise

APV-160-B

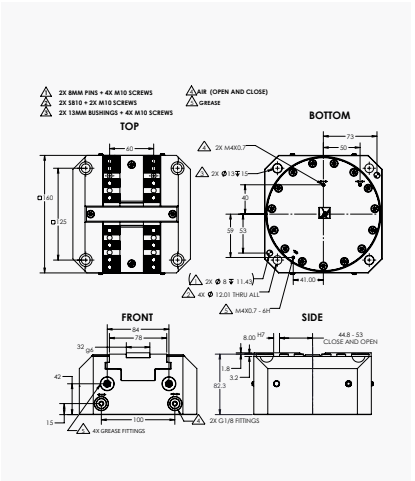


Long Stroke / Low Clamping Force

9 kN clamping force with a longer, more forgiving stroke for general production work, where stock varies slightly from part to part.

8.2mm travel per jaw, the same 30–130 PSI supply, and the same base pattern as the -A — mix force tiers by station without changing footprint.

See Additional Vise Specks on page 55



VAJ-APV-160

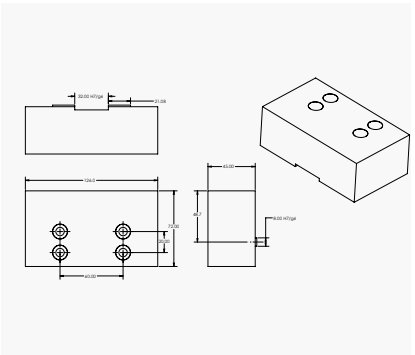
Pneumatic Vise Aluminum Soft Jaw Kit



Compatible with both APV-160-A and APV-160-B Pneumatic Vises, these jaws provide a versatile workholding solution for a range of machining applications. Machined from billet aluminum, these machinable jaws provide the strength and durability required for demanding machining and manufacturing environments.

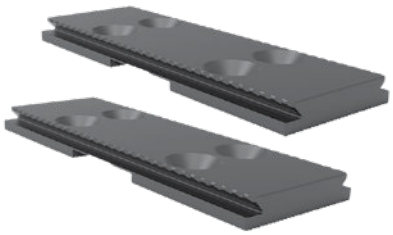
The machinable surface can be customized to match specific part requirements, providing precise and repeatable workholding for custom parts and different setups.

Size: 126mm × 72mm × 45mm
Mounting: Slots + 4X SHCS
Sold as a set (Mounting hardware included).



VSJ-APV-160

Pneumatic Vise Steel Low-Profile Master Jaw Set



The VSJ-APV-160 Low-Profile Master Jaw Set is engineered for use with the APV-160-A and APV-160-B Pneumatic Vises.

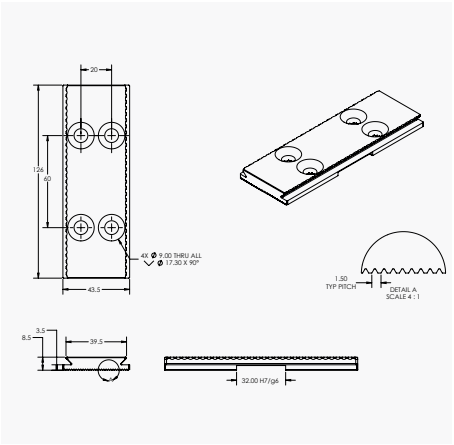
Serrated gripping teeth provide secure workholding for materials under 25 HRC.

Materials above 25 HRC are recommended to be dovetail-prepped.

The low-profile design provides greater access around the workpiece and supports compatible LiteVise™ accessory jaws.

VGA-VA5 and VAJ-VA5 accessory jaws mount directly to the master jaws, allowing the same LiteVise™ jaws to be used with both APV-160 models.

Sold as a set (Mounting hardware included).

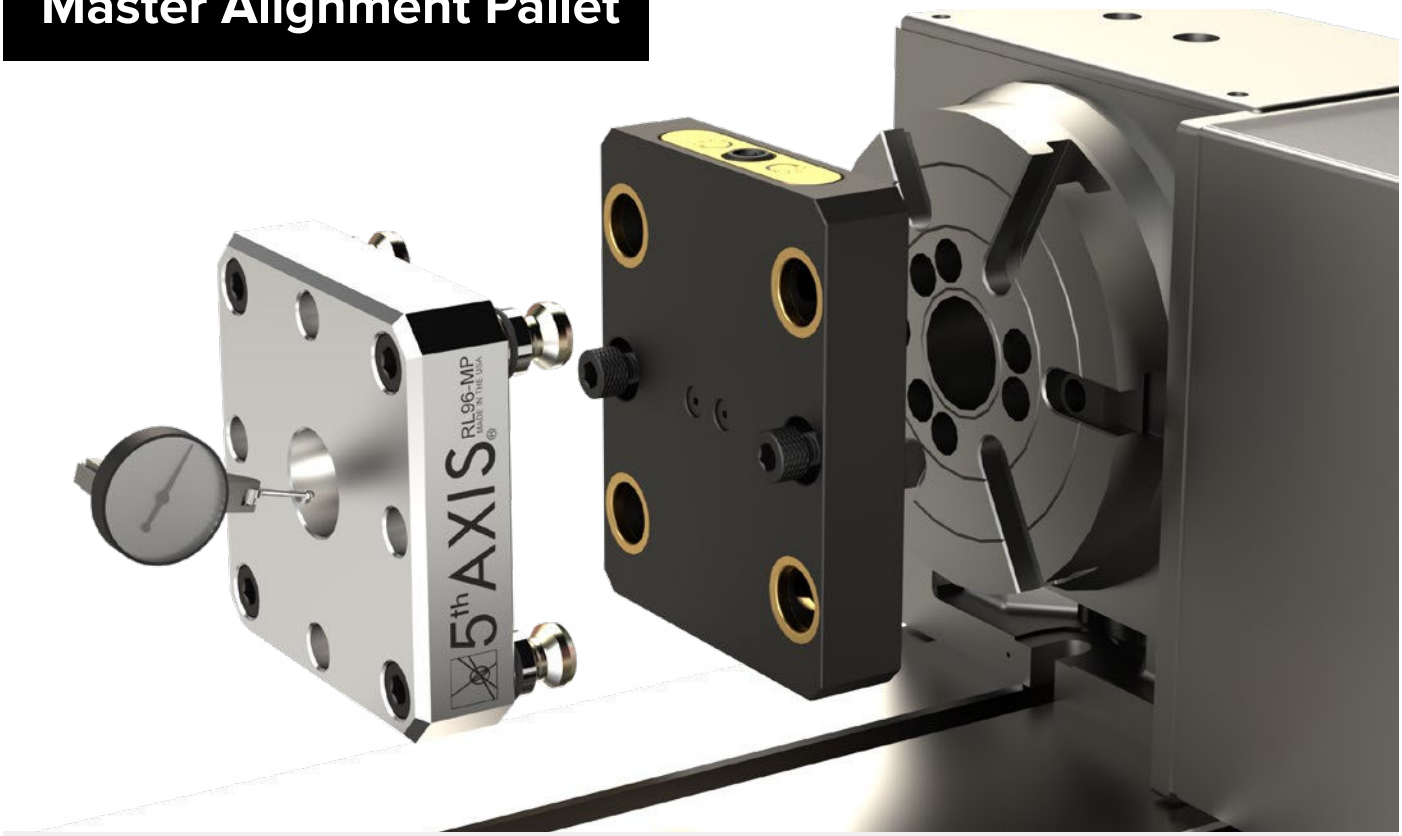


Pneumatic Vises | APV Series

Part Number	APV-160-A	APV-160-B
		
Size	160 mm × 160 mm × 82 mm	160 mm × 160 mm × 82 mm
Max Clamping Force	42 kN (9,400 lbf)	9 kN (2,000 lbf)
Travel Per Jaw	2.6mm (0.10”)	8.2mm (0.32”)
Operating Pressure	30–130 PSI (2–9 bar)	30–130 PSI (2–9 bar)
Air Ports	2x G1/8 side, 2x M4 bottom plugs	2x G1/8 side, 2x M4 bottom plugs
Grease Points	4x side fittings, 1x bottom plug	4x side fittings, 1x bottom plug
Mounting Options	3 (pins, SB10, or 13mm bushings)	3 (pins, SB10, or 13mm bushings)
Jaw Kits	VSJ-APV-160, VAJ-APV-160	VSJ-APV-160, VAJ-APV-160

Master Pallet

Master Alignment Pallet



Available in 96mm and 52mm

Ensures RockLock repeatability less than 8 µm

Precision milled and press fit pull studs*

One Master Pallet for all your RockLock systems

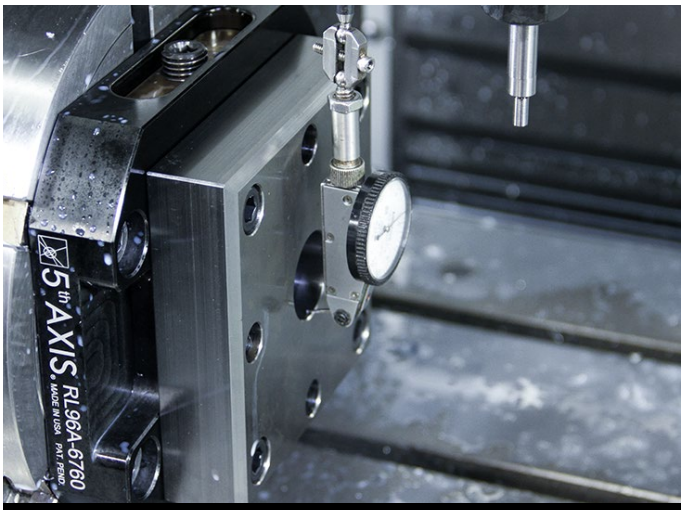
Guarantees accuracy of the RockLock system. The Master Pallets are used to set up 52mm and 96mm RockLock systems.

Mount the RockLock base onto the machine, drop in the Master Pallet, dial in your setup, and torque your mounting bolts once you have reached the desired location.

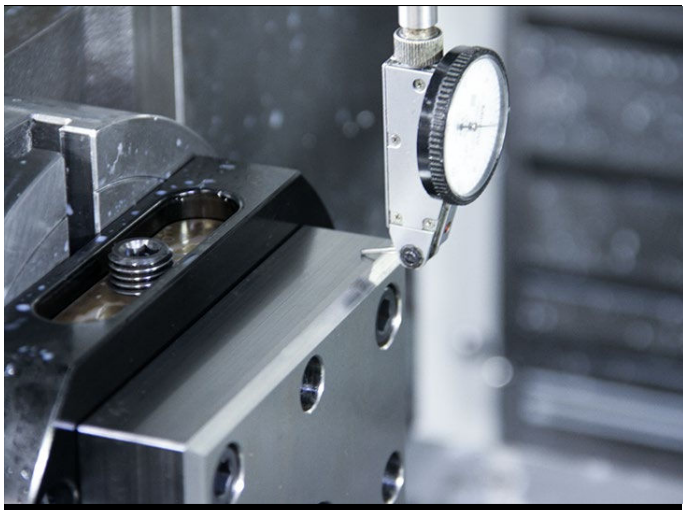
Master Pallet will only be used on the initial setup or if you move the setup from one machine to another. This is the fastest, most accurate way to set up the RockLock system.

*Do not remove pull studs.
**Instructional video provided on our website.
***CMM report provided with purchase of Master Pallet.

Master Pallet



Precision center bore allows for indication of rotation.



Precision milled sides allow for indication of center line.

Master Pallets

Part Number	RL52-MP	RL96-MP
		
Size	75mm x 75mm x 25.4mm	125.73mm x 125.73mm x 30.48mm
Mounting	RockLock PS16F Pull Studs Included	RockLock PS20F Pull Studs Included
Materials	Steel	Steel

CAD models available for download at 5thaxis.com/downloads

Double Station Vises

BUILT FOR 3-AXIS



Convert from double station to single position fixed jaw*

Quickly change jaws / convert to soft jaws

Compact footprint maximizes table space

Not a self-centering vise



Double Station



Single Station Fixed Jaw



Machinable Jaws

*Only applies to DV56 and DV510

Quickly Convert From Double To Single Fixed Station*



Double Station
This configuration utilizes the center portion as the fixed position.



Independent Movement
Each jaw moves independently. This allows for stock of different sizes and ensures proper clamping.



Reversible Jaw
Jaws can quickly and easily be reversed for increased clamping range.



Removing Center Jaw
The center jaw is bolted through the base and held in position with precision bushings.

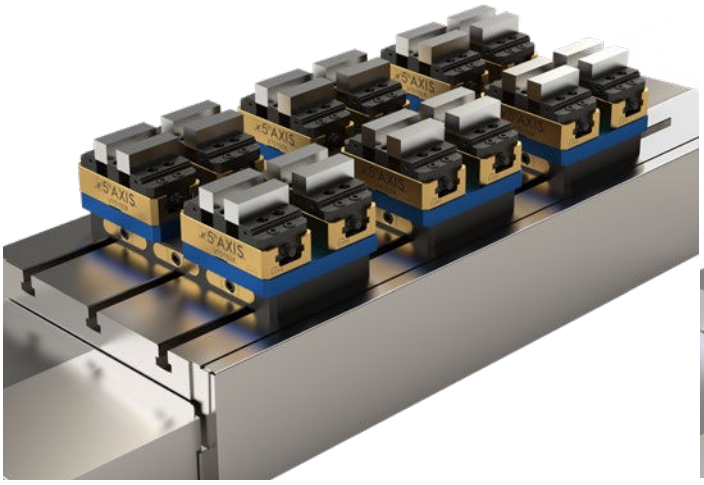


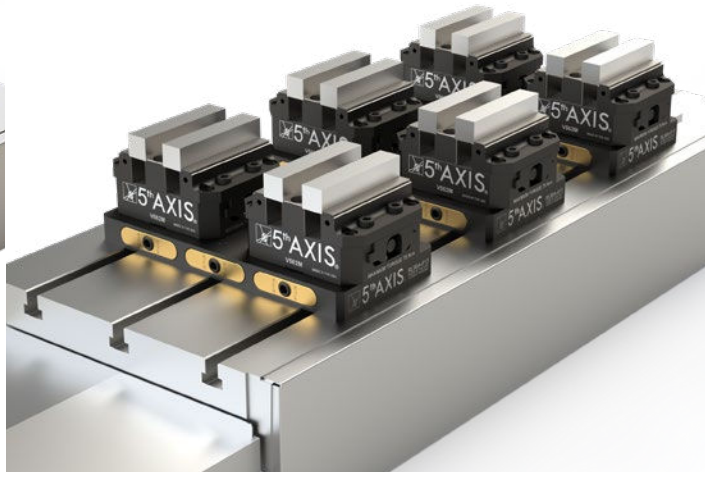
Shoulder Bolts Lock Back Jaw
The vise base has two precision bores that allow for shoulder bolts to lock the back jaw when switching to a single station.



Fixed Jaw*
In this configuration the vise operates like any traditional machine vise.
*DV56 and DV510 only

Maximize Your Table Space





*Only applies to DV56 and DV510

Double Station Vises

Master Hard Jaws

Part Number	DV75150X-J1	DV56-J1	DV510-J1	DV510-J4
				
Size	75mm x 150mm x 56mm	125.7mm x 152.4mm x 72.9mm	125.7mm x 258.3mm x 73.4mm	125.7mm x 258.3mm x 73.4mm
Jaw Type	Hard Jaws (2" Fixed Center Jaw)	Hard Jaws (2" Fixed Center Jaw)	Hard Jaws (2" Fixed Center Jaw)	Hard Jaws (1" Fixed Center Jaw)
Jaw Width	75mm	125.7mm	125.7mm	125.7mm
Clamping Force	13.5 kN @ 60 Nm	20.0 kN @ 75 Nm	20.0 kN @ 75 Nm	20.0 kN @ 75 Nm
Max Torque	60 Nm	75 Nm	75 Nm	75 Nm
Forward Clamping Range	0 - 37.02mm	0 - 28.5mm	0 - 66.7mm	0 - 79.4mm
Reverse Clamping Range	17.26mm - 55.02mm	31.0mm - 64.2mm	30.9mm - 102.3mm	30.9mm - 115mm
Single Station Forward Clamping Range	N/A	0 - 75.9mm	0 - 177.5mm	0 - 177.5mm
Single Station Reverse Clamping Range	N/A	56.8mm - 147.3mm	56.8mm - 248.7mm	56.8mm - 248.7mm



DV75150X-J1 shown on the RL96A-3613S1 base plate

CAD models available for download at 5thaxis.com/downloads

Aluminum Jaws

Part Number	DV75150X-J2	DV56-J2	DV510-J2
			
Size	75mm x 150mm x 64.1mm	125.7mm x 152.4mm x 89mm	125.7mm x 258.3mm x 88.5mm
Jaw Type	Machinable Aluminum Jaws	Machinable Aluminum Jaws	Machinable Aluminum Jaws
Jaw Width	75mm	125.7mm	125.7mm
Clamping Force	13.5 kN @ 60 Nm	20.0 kN @ 75 Nm	20.0 kN @ 75 Nm
Max Torque	60 Nm	75 Nm	75 Nm

Steel Jaws

Part Number	DV75150X-J3	DV56-J3	DV510-J3
			
Size	75mm x 150mm x 64.1mm	125.7mm x 152.4mm x 89mm	125.7mm x 258.3mm x 88.5mm
Jaw Type	Machinable Steel Jaws	Machinable Steel Jaws	Machinable Steel Jaws
Jaw Width	75mm	125.7mm	125.7mm
Clamping Force	13.5 kN @ 60 Nm	20.0 kN @ 75 Nm	20.0 kN @ 75 Nm
Max Torque	60 Nm	75 Nm	75 Nm

CAD models available for download at 5thaxis.com/downloads

Double Station Vises

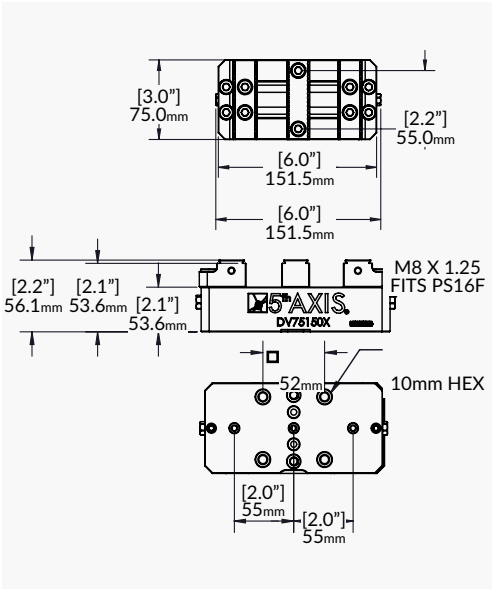
DV75150X-J1
Hard Jaws (2” Fixed Center Jaw)



Size: 75mm x 150mm x 56.1mm
Jaw Set: Hard Jaws (2” Fixed Center Jaw)
Jaw Set Material: Hardened Steel
Jaw Width: 75mm
Clamping Force: 13.5 kN @ 60 Nm
Max Torque: 60 Nm
Forward Clamping Range: 0-37.02mm
Reverse Clamping Range: 17.23 - 55.02mm

Double station vise with serrated and dovetail master jaws. Perfect for making parts that are less than 55mm x 75mm.

Cannot be used in single station configuration



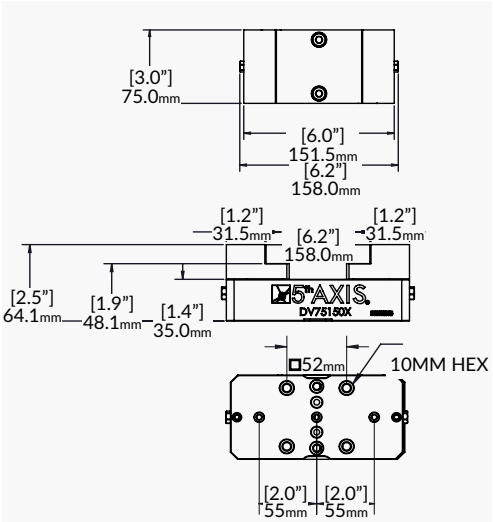
DV75150X-J2
Machinable Aluminum Jaws



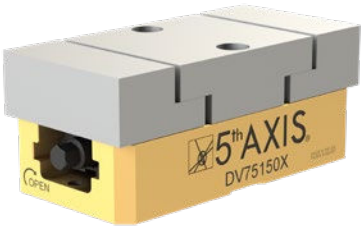
Size: 75mm x 150mm x 56.1mm
Jaw Set: Machinable Aluminum Jaws
Jaw Set Material: 6061 Aluminum
Clamping Force: 13.5 kN @ 60 Nm
Max Torque: 60 Nm

Double station vise with 6061 aluminum machinable jaws. Perfect for secondary operation work.

Cannot be used in single station configuration



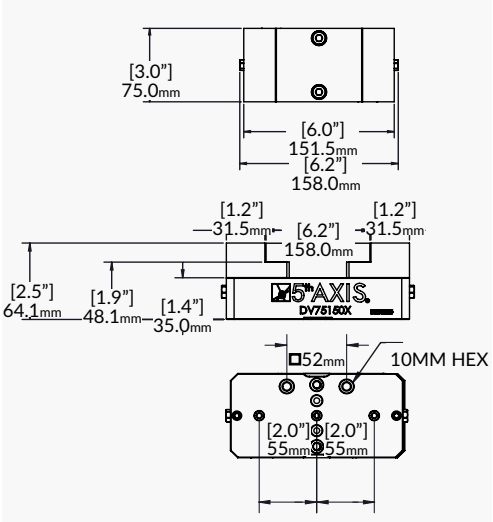
DV75150X-J3
Machinable Steel Jaws



Size: 75mm x 150mm x 56.1mm
Jaw Set: Machinable Steel Jaws
Jaw Set Material: 1018 Steel
Jaw Width: 75mm
Clamping Force: 13.5 kN @ 60 Nm
Max Torque: 60 Nm

Double station vise with 1018 steel machinable jaws. Perfect for secondary operation work.

Cannot be used in single station configuration

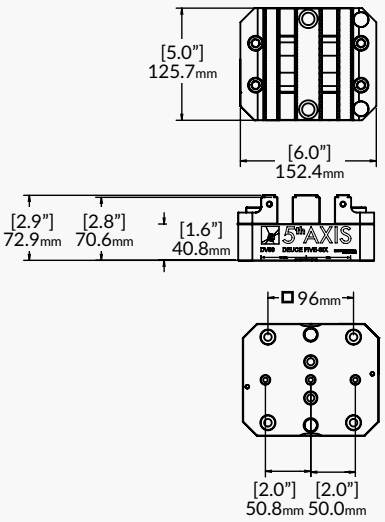


DV56-J1
Hard Jaws (2” Fixed Center Jaw)



Size: 125.7mm x 152.4mm x 72.9mm
Jaw Set: Hard Jaws (2” Fixed Center Jaw)
Jaw Set Material: Hardened Steel
Jaw Width: 75mm
Max Torque: 75 Nm
Forward Clamping Range:
0 - 28.5mm
Reverse Clamping Range:
31mm - 64.2mm
Fixed Jaw Forward Clamping Range:
0 - 75.9mm
Fixed Jaw Reverse Clamping Range:
56.8 - 147.3mm

Quickly convert the **DV56-J1** from a double station to a fixed single jaw vise. Perfect for parts smaller than 64.2mm x 125.7mm.

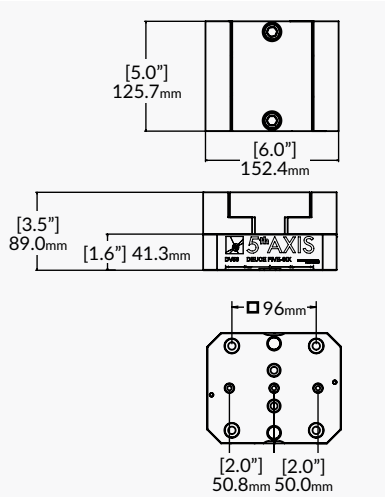


DV56-J2
Machinable Aluminum Jaws



Size: 125.7mm x 152.4mm x 89mm
Jaw Set: Machinable Aluminum Jaws
Jaw Set Material: 6061 Aluminum
Jaw Width: 75mm
Max Torque: 75 Nm

Double station vise with 6061 aluminum machinable jaws. Perfect for secondary operation work.

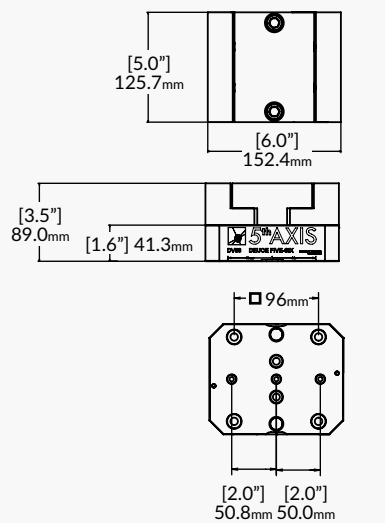


DV56-J3
Machinable Steel Jaws



Size: 125.7mm x 152.4mm x 89mm
Jaw Set: Machinable Steel Jaws
Jaw Set Material: 1018 Steel
Jaw Width: 75mm
Max Torque: 75 Nm

Double station vise with 1018 steel machinable jaws. Perfect for secondary operation work.



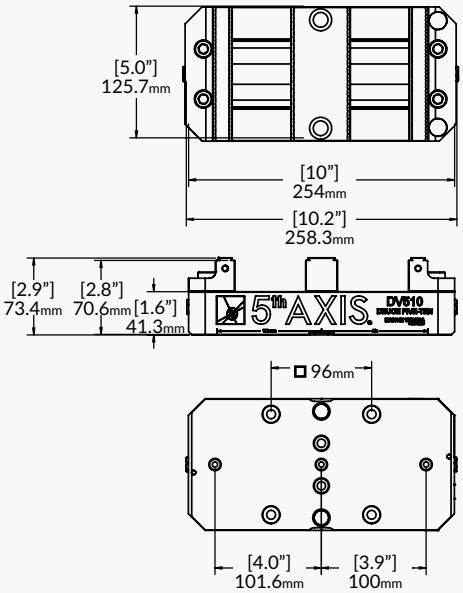
Double Station Vises

DV510-J1
Hard Jaws (2” Fixed Center Jaw)



Size: 125.7mm x 258.3mm x 73.4mm
Jaw Set: Hard Jaws (2” Fixed Center Jaw)
Jaw Set Material: Hardened Steel
Jaw Width: 125.7mm
Max Torque: 75 Nm
Forward Clamping Range: 0 - 66.7mm
Reverse Clamping Range: 30.9mm - 102.3mm
Fixed Jaw Forward Clamping Range: 0 - 177.5mm
Fixed Jaw Reverse Clamping Range: 56.8mm - 248.7mm

Double station vise that converts to a fixed jaw vise. 3 piece hard jaw set with a 2” center, serrations, and 45° dovetail master jaw.

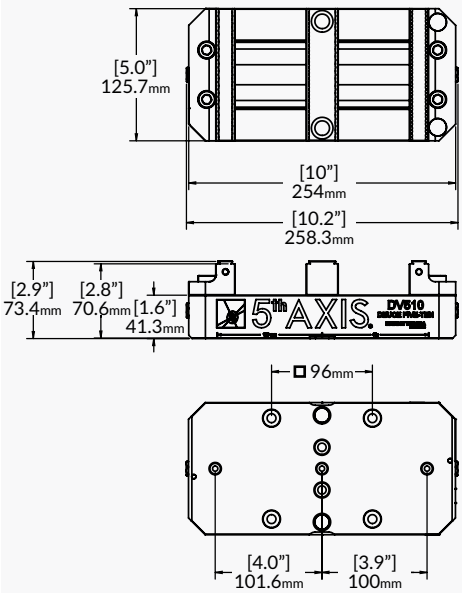


DV510-J4
Hard Jaws (1” Fixed Center Jaw)



Size: 125.7mm x 258.3mm x 73.4mm
Jaw Set: Hard Jaws (1” Fixed Center Jaw)
Jaw Set Material: Hardened Steel
Jaw Width: 125.7mm
Max Torque: 75 Nm
Forward Clamping Range: 0 - 79.4mm
Reverse Clamping Range: 30.9mm - 115mm
Fixed Jaw Forward Clamping Range: 0 - 177.5mm
Fixed Jaw Reverse Clamping Range: 56.8mm - 248.7mm

Double station vise that converts to a fixed jaw vise. 3 piece hard jaw set with a 1” center, serrations, and 45° dovetail master jaw.

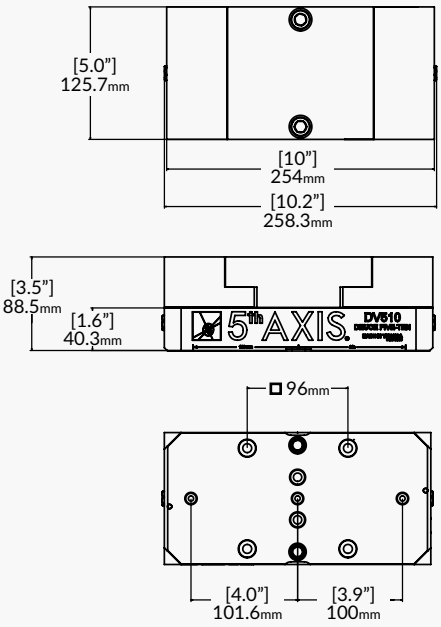


DV510-J2
Machinable Aluminum Jaws



Size: 125.7mm x 258.3mm x 88.5mm
Jaw Set: Machinable Aluminum Jaws
Jaw Set Material: 6061 Aluminum
Jaw Width: 125.7mm
Max Torque: 75 Nm

Double station vise with 6061 aluminum machinable jaws. Perfect for secondary operation work

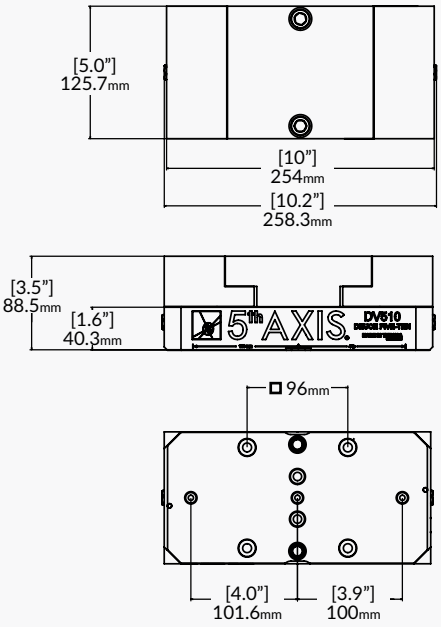


DV510-J3
Machinable Steel Jaws



Size: 125.7mm x 258.3mm x 88.5mm
Jaw Set: Machinable Steel Jaws
Jaw Set Material: 1018 Steel
Jaw Width: 125.7mm
Max Torque: 75 Nm

Double station vise with 1018 steel machinable jaws. Perfect for secondary operation work

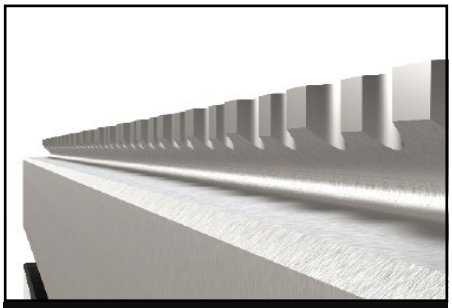


Self-Centering Vises

Self-Centering Vises



Built in 45° dovetail can be utilized for increased clamping force



Serrated gripper teeth for superior bite into soft material



Quick change jaws without disassembling vise

30% MORE CLAMPING FORCE

with new X-series vises



Pre-drilled for pull studs	Hardened steel
+/- 0.0127mm on center	Large leadscrew
Jaws are easy to remove	Easy mounting to machine

CAD models available for download at 5thaxis.com/downloads

Self-Centering Vises

Part Number	V75100X	V75150X
		
Part Number (No Jaws)	**V75100X-NJ**	**V75150X-NJ**
		
Size	75mm x 100mm x 56mm	75mm x 150mm x 56mm
Jaw Width	75mm	75mm
Clamping Force	22.2 kN @ 60 Nm	22.2 kN @ 60 Nm
Max Torque	61 Nm	61 Nm
Forward Clamping Range	0 - 43.6mm	0 - 94.1mm
Reverse Clamping Range	38.5mm - 76.3mm	38.5mm - 128.8mm

Part Number	V562X	V510X
		
Part Number (No Jaws)	**V562X-NJ**	**V510X-NJ**
		
Size	125.7mm x 152.4mm x 73.6mm	125.7mm x 254mm x 73.6mm
Jaw Width	125.7mm	126mm
Clamping Force	25.1 kN @ 75 Nm	25.1 kN @ 75 Nm
Max Torque	75 Nm	75 Nm
Forward Clamping Range	0 - 78.0mm	0 - 184.7mm
Reverse Clamping Range	60.3mm - 128.0mm	60.3mm - 234.7mm

CAD models available for download at 5thaxis.com/downloads

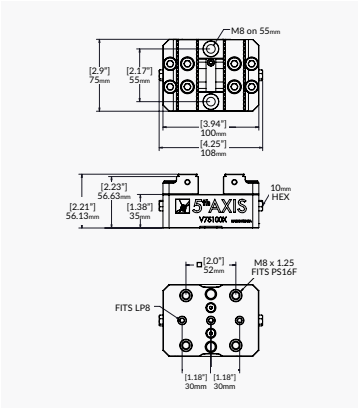
Self-Centering Vises

V75100X
Metric



Size: 75mm x 100mm x 56mm
Jaw Width: 75mm
Forward Jaws Clamping Range: 0 - 43.6mm
Reverse Jaws Clamping Range: 38.5mm - 76.3mm
Clamping Force: 13.5 kN @ 60 Nm

The **V75100X** is the most recent revision of our V75100 vise. Now equipped with 4 bolt jaw mounting to reduce jaw lift providing robust clamping and sharper teeth for a better bite.

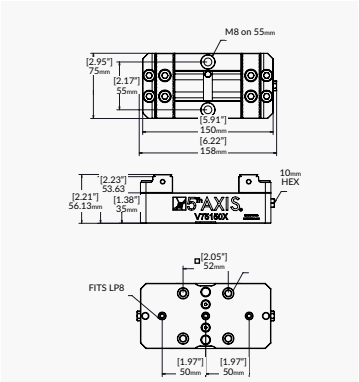


V75150X
Metric



Size: 75mm x 150mm x 56mm
Jaw Width: 75mm
Forward Jaws Clamping Range: 0 - 92.8mm
Reverse Jaws Clamping Range: 38.5mm - 128.8mm
Clamping Force: 13.5 kN @ 60 Nm

The **V75150X** was created out of customer demand for a small self-centering vise with an increased clamping range over the popular V75100X vise. The base is 50mm longer than the standard V75100X, allowing the max workpiece size to increase from 76mm to 128mm. The new 4 bolt jaw mounting design reduces jaw lift and the sharper teeth provide a superior bite in raw material.



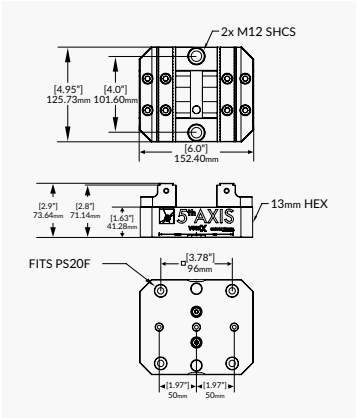
V562X
Metric



Size: 125.7mm x 152.4mm x 73.6mm
Jaw Width: 125.7mm
Forward Jaws Clamping Range: 0 - 78.0mm
Reverse Jaws Clamping Range: 60.3mm - 128.0m
Clamping Force: 25.1 kN @ 75 Nm
Torque Vise Assembly: 75 Nm

The **V562X** is the updated version of the best selling self-centering vise in the product line (V562M). The new model features 30% more clamping force due to the updated 4 jaw mounted bolts keyed jaw and truck.

The V562X is built from heat treated 4100 series steel and is precision ground and hard milled to ensure accuracy and repeatability.

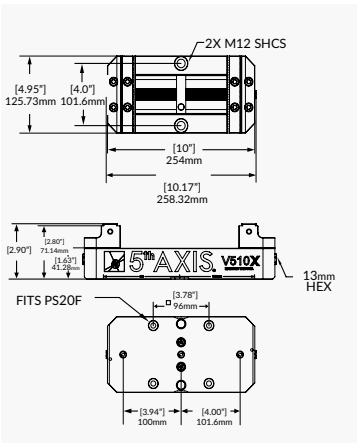


V510X
Metric



Size: 125.7mm x 254mm x 73.6mm
Jaw Width: 125.7mm
Forward Jaws Clamping Range: 0 - 184.7mm
Reverse Jaws Clamping Range: 60.3mm - 234.7mm
Clamping Force: 25.1 kN @ 75 Nm
Torque Vise Assembly: 75 Nm

The **V510X** has all of the robust features of the V562X including the added clamping range. The V510X is a perfect fit for shops looking for a small footprint vise with a larger clamping range. The V510X is built from hardened and ground 4100 series steel to ensure accuracy and repeatability.



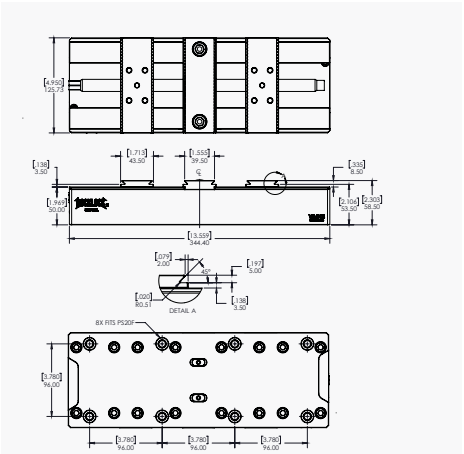
Self-Centering Vises

LITEVISE VA513
Metric



Size: 344mm x 125mm x 50mm (13” x 5” x 2”)
Jaw Width: 125mm (5”)
Clamping Force: 22.2 kn @ 61 Nm (5000lbs)
Max Torque: 61 Nm
Clamping Range - Lower Gripper Jaws: .188” - 4” (Double Station)
Clamping Range - Master Tall Gripper **Jaws:** 375” - 5.25” (Double Station)
Weight: 20 lbs

Are you ready to elevate your **CNC** machining operations with unparalleled precision and efficiency? Meet LiteVise, the game-changing lightweight vise designed to optimize your workflow and deliver exceptional results.and deliver exceptional results.

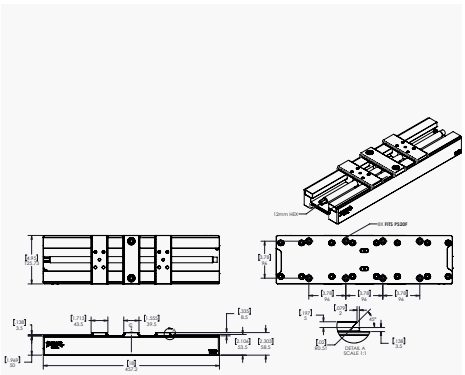


LITEVISE VA518
Metric



Size: (457mm x 125mm x 50mm) (18” x 5” x 2”)
Jaw Width: 125 (5”)
Clamping Force: 22.2 kN @ 61 Nm (5000lbs)
Max Torque: 61 Nm
Clamping Range - Lower Gripper Jaws: 375”-14.1” (Self-centering), .188” – 6.2” (Double Station)
Clamping Range - Master Tall Gripper **Jaws:** .375”-16.4” (Self-centering), .375” – 7.2” (Double Station)
Weight: 25 lbs

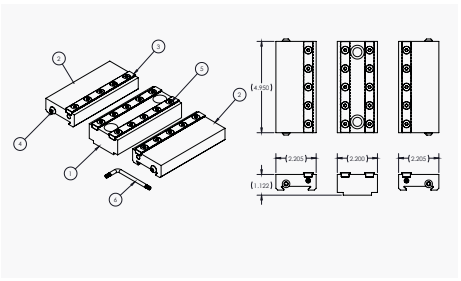
Are you ready to elevate your **CNC** machining operations with unparalleled precision and efficiency? Meet LiteVise, the game-changing lightweight vise designed to optimize your workflow and deliver exceptional results.and deliver exceptional results.



VA513-GJ-A
Master Gripper Jaws Set



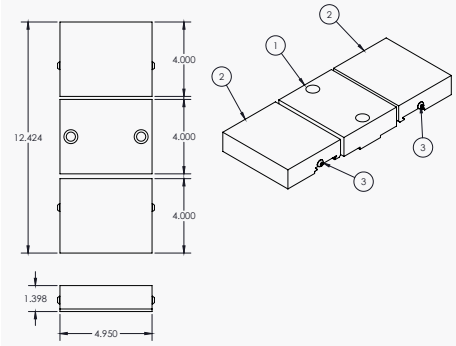
Crafted from billet aluminum, these machinable jaws are built to withstand the rigors of daily use in a variety of industrial and manufacturing environments. Their robust construction ensures a long lifespan, providing you with reliable performance and reduced maintenance costs over time. The gripper strips are built from hardened steel and **TiN** coated for longevity.



VA513-MJ-A
Aluminum Soft Jaws Set



Crafted from billet aluminum, these machinable jaws are built to withstand the rigors of daily use in a variety of industrial and manufacturing environments. Their robust construction ensures a long lifespan, providing you with reliable performance and reduced maintenance costs over time. The gripper strips are built from hardened steel and **TiN** coated for longevity.



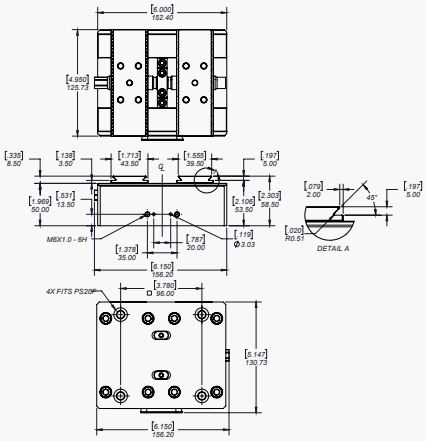
Self-Centering Vises

LITEVISE VA56
Metric



Size: 152mm x 125mm x 50mm
Jaw Width: 125mm
Clamping Force: 22.2 kn @ 61 Nm
Max Torque: 61 Nm
Clamping Range - Lower Gripper **Jaws:** .375” - 3”
Clamping Range - Master Tall Gripper **Jaws:** .375” to 5.25”
Weight: .10 lbs

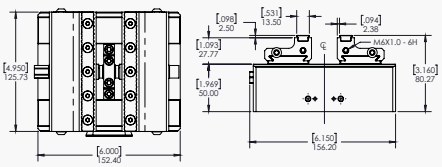
Are you ready to elevate your **CNC** machining operations with unparalleled precision and efficiency? Meet LiteVise, the game-changing lightweight automation vise designed to optimize your workflow and deliver exceptional results.



VGA-VA5
Aluminum Master Gripper Jaw Set



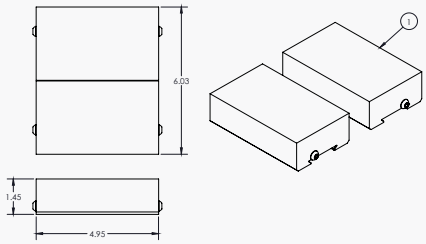
Crafted from billet aluminum, these machinable jaws are built to withstand the rigors of daily use in a variety of industrial and manufacturing environments. Their robust construction ensures a long lifespan, providing you with reliable performance and reduced maintenance costs over time. The gripper strips are built from hardened steel and TiN coated for longevity.



VGJ-VA5
Aluminum Soft Jaw Set



Crafted from billet aluminum, these machinable jaws are built to withstand the rigors of daily use in a variety of industrial and manufacturing environments. Their robust construction ensures a long lifespan, providing you with reliable performance and reduced maintenance costs over time.



Mini Vise V5275
Metric



Size: 52mm x 75mm x 38mm
Jaw Width: 51.5mm
Clamping Force at Torque: 2,500 lbf @22ft-lbs (11.1KN @30Nm)
Clamping Range: 3.5mm to 38.5mm
Max Torque: 3.5mm to 38.5mm
Truck/Hardness: 45 HRC
Hardness Clamping Max (part): 25 HRC - dovetail advised for anything harder
Self-Centering Accuracy: Within ±.002”
Weight: 1.76 lb.

Introducing the Mini Vise — Think Smaller. One Vise. Countless Possibilities. Self-centering vise for small-part machining, tight machining environments, and multi-part setups.

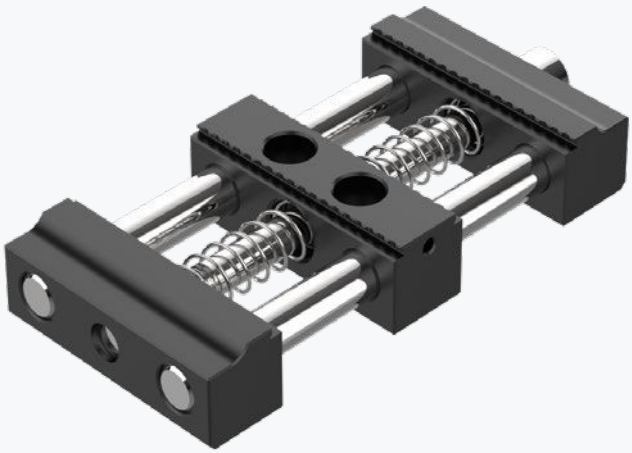
Double Station Pin Vises

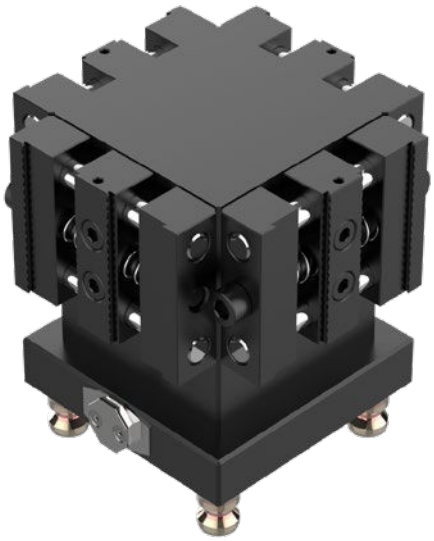
Cost Effective | Lightweight | Compact Design

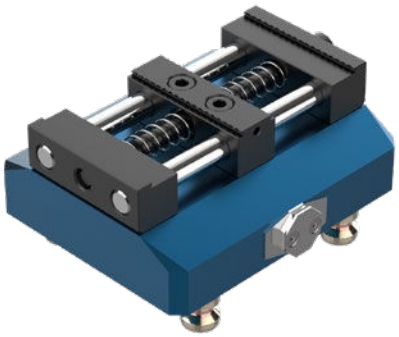
High-precision, quality vises in a skeleton design that makes them lighter, more compact, and cost-effective.

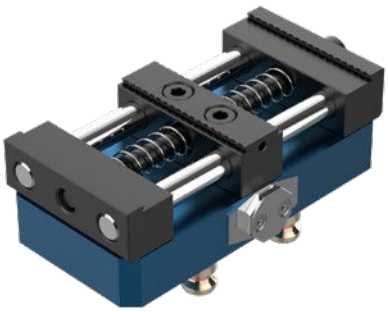
Ideal for high volume part production, Pin Vises have a small footprint, allowing more parts on a table for higher productivity. Pin Vises are also lightweight for automated applications where weight is a consideration.

Pin Vise tombstones, pyramids, and plates are configured with 96mm RockLock quick-change systems.





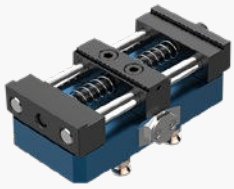




High volume applications	Hardened steel
Available in 4” & 6” models	Extreme low-profile design
Clamping range: 0.25” - 2.5”	Serrated gripper teeth and integrated 45° dovetail

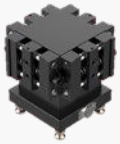
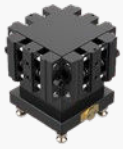
Rocklock Adapters w/ Pin Vises

Part Number	A52-PV3X-4A	A52-PV3X-4B	A52-PV3XT4-4A	A52-PV3XT4-4B
				
Size	81mm x 152.4mm x 50mm	81mm x 152.4mm x 50mm	149.86mm x 149.86mm x 137.16mm	149.86mm x 149.86mm x 137.16mm
Jaw Width	75mm [2.95”]	75mm [2.95”]	75mm [2.95”]	75mm [2.95”]
Clamping Range	19.05mm - 38.10 mm [0.75” - 1.50”]	6.35mm - 25.40mm [0.25” - 1.00”]	19.05mm - 38.10mm [0.75” - 1.50”]	6.35mm - 25.40mm [0.25” - 1.00”]

Part Number	A52-PV3X-6A	A52-PV3 A52-PV3X-6B X-6B
		
Size	163.9mm x 80.9mm x 50mm	163.9mm x 80.9mm x 50mm
Jaw Width	75mm [2.95”]	75mm [2.95”]
Clamping Ranges Based on Bolt Size*	150: 44.45mm - 63.50mm [1.75” - 2.50”]	150: 31.75mm - 50.80mm [1.25” - 2.00”]
	130: 31.75mm - 50.80mm [1.25” - 2.00”]	130: 19.05mm - 38.10mm [0.75” - 1.50”]
	100: 19.05mm - 38.10mm [0.75” - 1.50”]	100: 6.35mm - 25.40mm [0.25” - 1.00”]

*PVX3-6A & PVX3-6B pin vises come with three different bolt lengths to provide different clamping range options.

Rocklock Adapters w/ Pin Vises

Part Number	A96-PV3X-4A	A96-PV3X-4B	A96-PV3XT4-4A	A96-PV3XT4-4B
				
	60mm x 152.4mm x 130.9mm	60mm x 152.4mm x 130.9mm	149.86mm x 149.86mm x 137.16mm	149.86mm x 149.86mm x 137.16mm
Jaw Width	75mm [2.95”]	75mm [2.95”]	75mm [2.95”]	75mm [2.95”]
Clamping Range	19.05mm - 38.10mm [0.75” - 1.50”]	6.35mm - 25.40mm [0.25” - 1.00”]	19.05mm - 38.10mm [0.75” - 1.50”]	6.35mm - 25.40mm [0.25” - 1.00”]

Part Number	A96-PV3X-6A	A96-PV3X-6B
		
Size	152.4mm x 60mm x 130.9mm	52.4mm x 60mm x 130.9mm
Jaw Width	75mm [2.95”]	75mm [2.95”]
Clamping Ranges Based on Bolt Size*	150: 44.45mm - 63.50mm [1.75” - 2.50”]	150: 31.75mm - 50.80mm [1.25” - 2.00”]
	130: 31.75mm - 50.80mm [1.25” - 2.00”]	130: 19.05mm - 38.10mm [0.75” - 1.50”]
	100: 19.05mm - 38.10mm [0.75” - 1.50”]	100: 6.35mm - 25.40mm [0.25” - 1.00”]

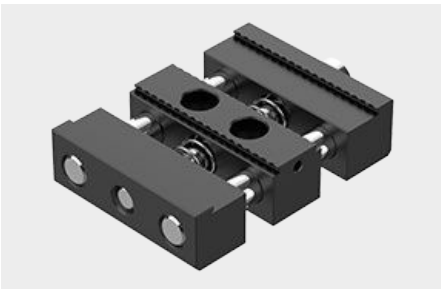
Double Station Pin Vises

Part Number	PV3X-4A	PV3X-4B
		
Size	75mm x 111.6mm x 25mm [2.95” x 4.39” x 0.98”]	75mm x 111.6mm x 25mm [2.95” x 4.39” x 0.98”]
Jaw Width	75mm [2.95”]	75mm [2.95”]
Clamping Range	19.05mm - 38.10 mm [0.75” - 1.50”]	6.35mm - 25.40mm [0.25” - 1.00”]

Part Number	PV3X-6A	PV3X-6B
		
Size	75mm x 161.6mm x 25mm [2.95” x 6.36” x 0.98”]	75mm x 161.6mm x 25mm [2.95” x 6.36” x 0.98”]
Jaw Width	75mm [2.95”]	75mm [2.95”]
Clamping Ranges Based on Bolt Size*	150: 44.45mm - 63.50mm [1.75” - 2.50”]	150: 31.75mm - 50.80mm [1.25” - 2.00”]
	130: 31.75mm - 50.80mm [1.25” - 2.00”]	130: 19.05mm - 38.10mm [0.75” - 1.50”]
	100: 19.05mm - 38.10mm [0.75” - 1.50”]	100: 6.35mm - 25.40mm [0.25” - 1.00”]

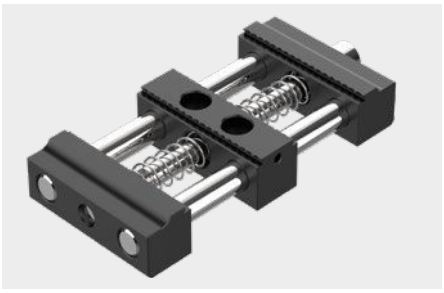
*PVX3-6A & PVX3-6B pin vises come with three different bolt lengths to provide different clamping range options.

PV3X-4



The **PV3X-4** is a 4” pin vise that offers a low-cost, low profile solution ideal for 3 axis, horizontal, and lights out manufacturing.

PV3X-6



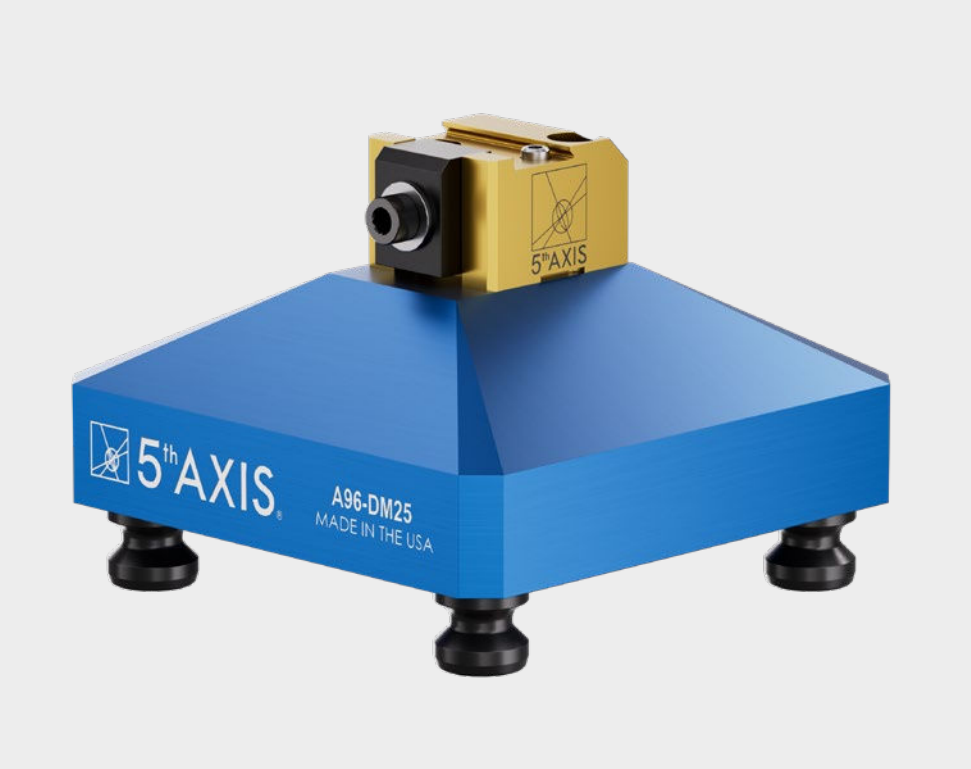
The **PV3X-6A & 6B** are 6” pin vises that come with three sets of bolts with different lengths to provide three clamping range options.

PMV3XS



The **PMV3X** is a 1018 steel machinable jaw version of the PV3X-6 pin vises.

Dovetail Fixtures



- 45° dovetail for increased clamping force
- Locating pins for precise repeatability
- Low profile design
- Hardened steel clamp and body

Dovetail Fixtures

Part Number	DM12	DM25	DM50
			
Size	21mm x 32mm x 19mm	37mm x 41mm x 27mm	50mm x 50mm x 38mm
Stock Size	12mm - 25mm	25mm - 75mm	50mm and Above
Dovetail Depth	2.54mm	2.54mm	5.08mm

CAD models available for download at 5thaxis.com/downloads

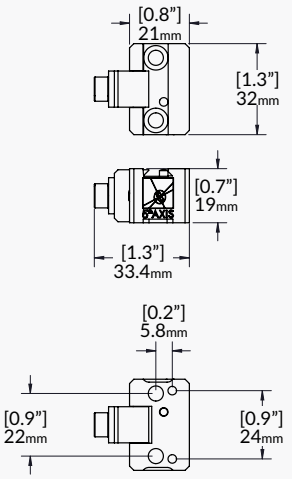
Dovetail Fixtures

DM12
Metric



Size: 21mm x 32mm x 19mm
Material: 4100 Series Steel
Stock Size: 12mm - 25mm
Dovetail Depth Required: 2.54mm

The **DM12** is the smallest dovetail fixture in the 5th Axis workholding line. The DM12 features a wedge style clamp for superior gripping force and a low profile design that optimizes tool clearance. This micro dovetail fixture is the perfect choice for multi-axis work on smaller parts.

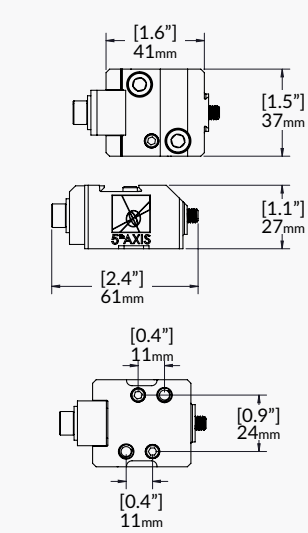


DM25
Metric



Size: 37mm x 41mm x 27mm
Material: 4100 Series Steel
Stock Size: 25mm - 75mm
Dovetail Depth Required: 2.54mm

The **DM25** is the most versatile dovetail fixture in the 5th Axis workholding line. It is a simple and robust dovetail fixture built for stock under 75mm. The DM25 features a robust clamp for superior gripping force and a low profile design that optimizes tool clearance. This dovetail fixture is the perfect choice for multi-axis work on small to medium sized parts.

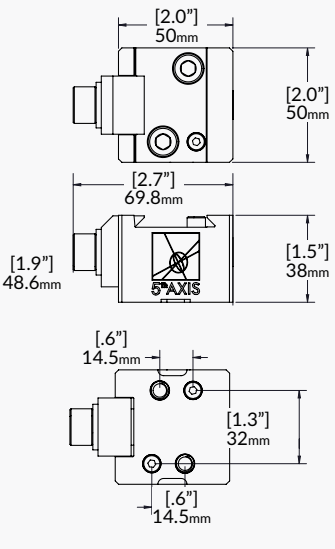


DM50
Metric



Size: 50mm x 50mm x 38mm
Material: 4100 Series Steel
Stock Size: 50mm+
Dovetail Depth Required: 5.08mm

The **DM50** is a simple and robust dovetail fixture built for stock 50mm and above. It features a wedge style clamp for superior gripping force, and a low profile design that optimizes tool clearance.

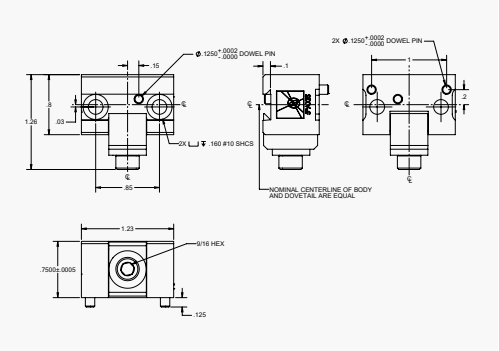


D05125
Inch



Size: 1.26” x 1.23” x .75”
Material: 4100 Series Steel
Stock Size: 1/2” x 1/2”
Dovetail Depth Required: 0.8”

The D05125 small dovetail fixture delivers exceptional precision for tight tolerances and exacting specifications. Its unique dovetail design provides superior workholding strength, stability, and rigidity. Access complex, multi-sided machining tasks with ease while reducing setup time.

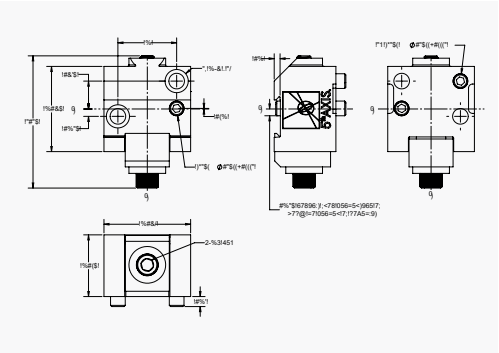


D115
Inch



Size: 1.48” x 2.25” x 1.05”
Material: 4100 Series Steel
Stock Size: 1” x 1”
Dovetail Depth Required: 0.8”

The D115 medium dovetail fixture delivers exceptional precision for tight tolerances and exacting specifications. Its unique dovetail design provides superior workholding strength, stability, and rigidity. Access complex, multi-sided machining tasks with ease while reducing setup time

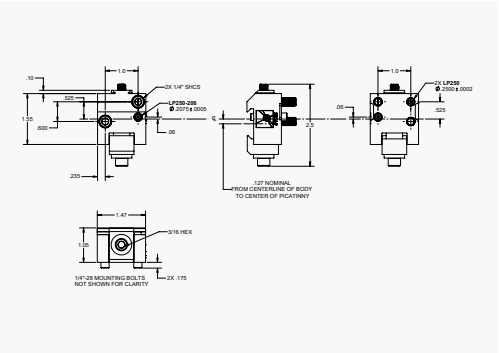


D115P
Inch



Size: 1.55” x 1.47” x 1.05”
Material: 4100 Series Steel
Stock Size: 1” x 1” (Double check)
Dovetail Depth Required: Picatinny

The D115 medium picatinny dovetail fixture delivers exceptional precision for tight tolerances and exacting specifications. Its unique dovetail design provides superior workholding strength, stability, and rigidity. Access complex, multi-sided machining tasks with ease while reducing setup time.



Dovetail Fixtures

D22
Inch



Size: 2” x 2” x 1.5”
Material: 4100 Series Steel
Stock Size: 2” x 2”
Dovetail Depth Required: 0.150”

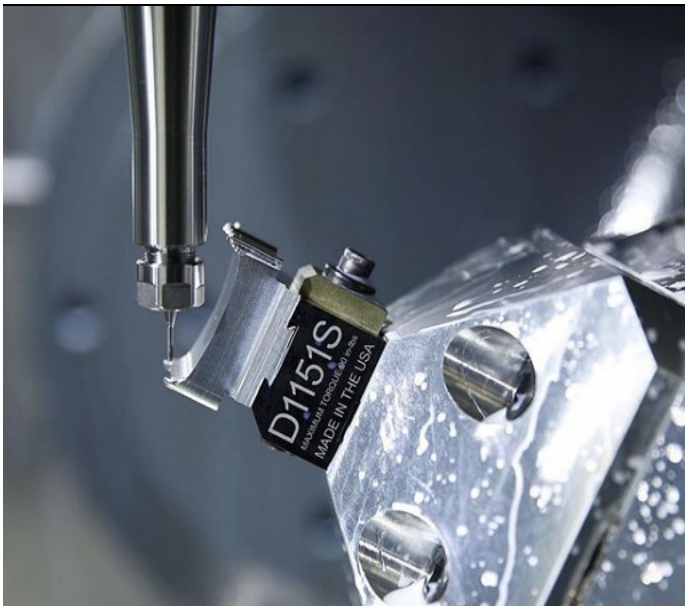
The D22 large dovetail fixture delivers exceptional precision for tight tolerances and exacting specifications. Its unique dovetail design provides superior workholding strength, stability, and rigidity. Access complex, multi-sided machining tasks with ease while reducing setup time.

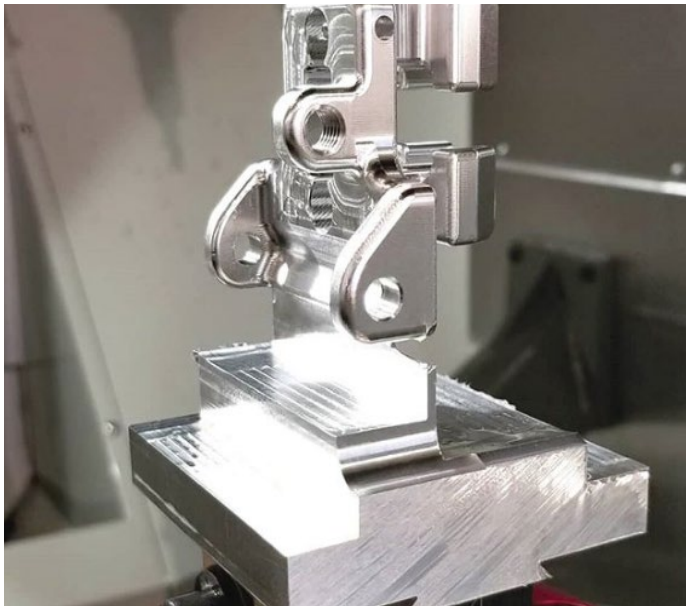
D362
Inch

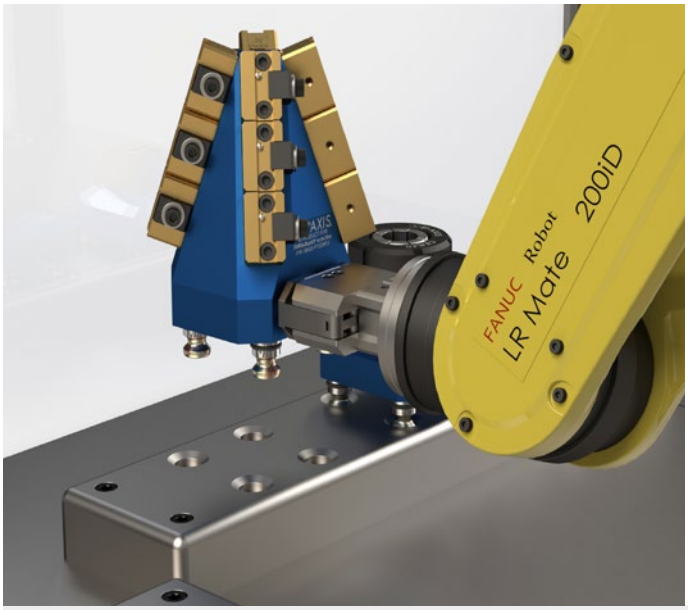


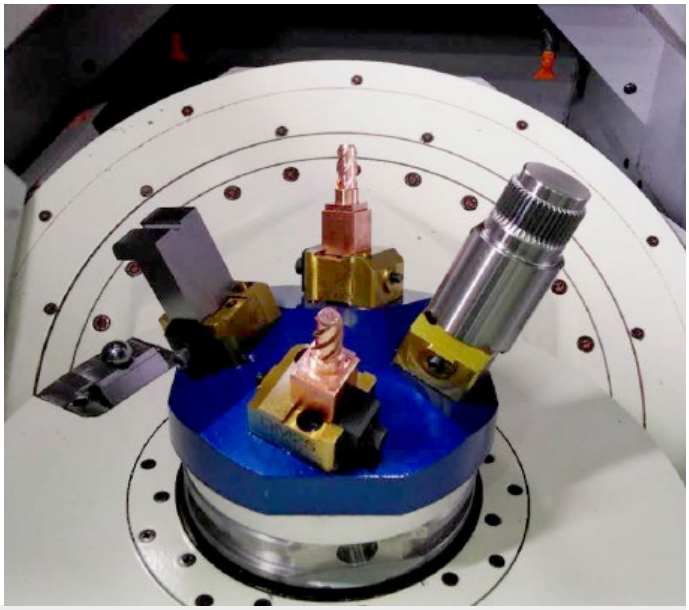
Size: 3” x 6” x 1.35”
Material: 4100 Series Steel
Stock Size: 3” x 3”
Dovetail Depth Required: 0.150”

The D362 extra large dovetail fixture delivers exceptional precision for tight tolerances and exacting specifications. Its unique 45 degree dovetail design for superior workholding strength, stability, and rigidity. Access complex, multi-sided machining tasks with ease while reducing setup time.



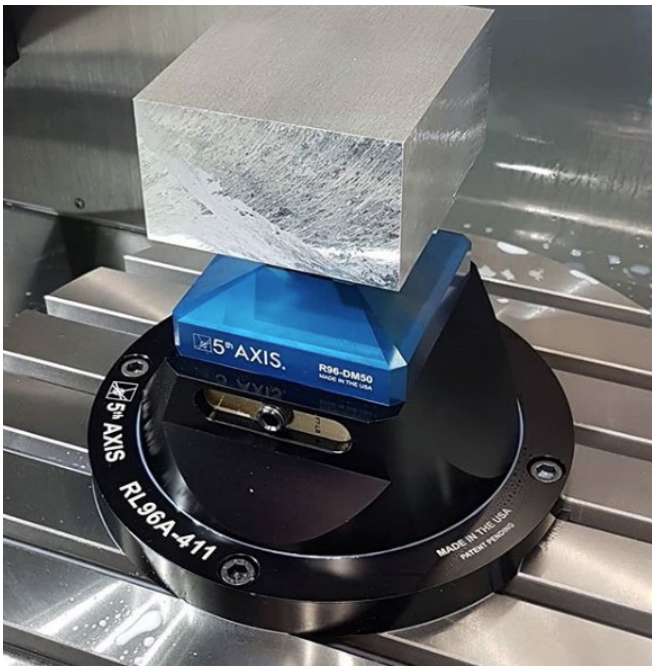






REAL WORKHOLDING APPLICATIONS
PROVIDED BY CUSTOMERS

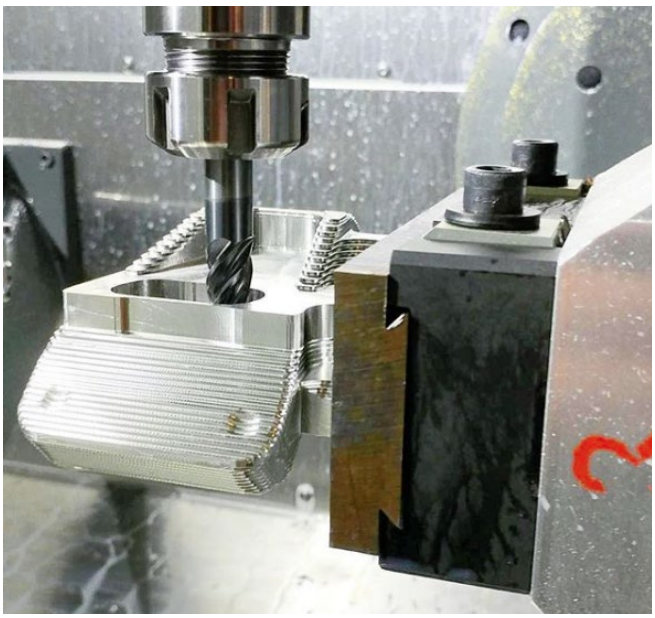
Dovetail Fixtures Examples











Real workholding applications provided by customers

A52-P12DM12



Metric

Spacing: 125.73mm x 125.73mm x 133.5mm
Material Construction: 6061 Aluminum

Built for our 52mm RockLock Quick Change System, the **R52-P12DM12** provides maximum amount of flexibility. This 4-sided pyramid utilizes twelve DM12 dovetail fixtures for stock under 25mm. The orientation of the fixtures on the pyramid ensures optimal tool clearance for multiple parts. Machine up to 12 parts on this compact unit. The modular design allows for fixtures to be added or removed depending on the length of the workpiece.

A96-P12DM12



Metric

Spacing: 125.73mm x 125.73mm x 133.5mm
Material Construction: 6061 Aluminum

Built for our 96mm RockLock Quick Change System, the **R96-P12DM12** provides maximum amount of flexibility. This 4 sided pyramid utilizes twelve DM12 dovetail fixtures for stock under 25mm. The orientation of the fixtures on the pyramid ensures optimal tool clearance for multiple parts. Machine up to 12 parts on this compact unit. The modular design allows for fixtures to be added or removed depending on the length of the workpiece.

A52-P4DM25

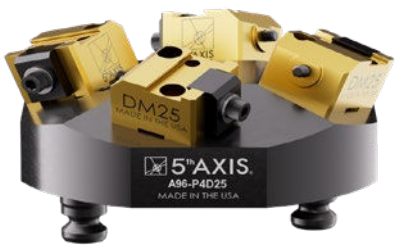


Metric

Spacing: Ø152.4mm x 64.9mm
Material Construction: 6061 Aluminum

This compact pyramid utilizes **4 DM25** dovetail fixtures. The small foot print ensures no space is wasted allowing simultaneous machining of four parts. Run more parts per cycle and minimize pallet and tool changes. This versatile fixture can be mounted on trunnions, pallets, and machine tables using our 52mm RockLock Quick Change System.

A96-P4DM25



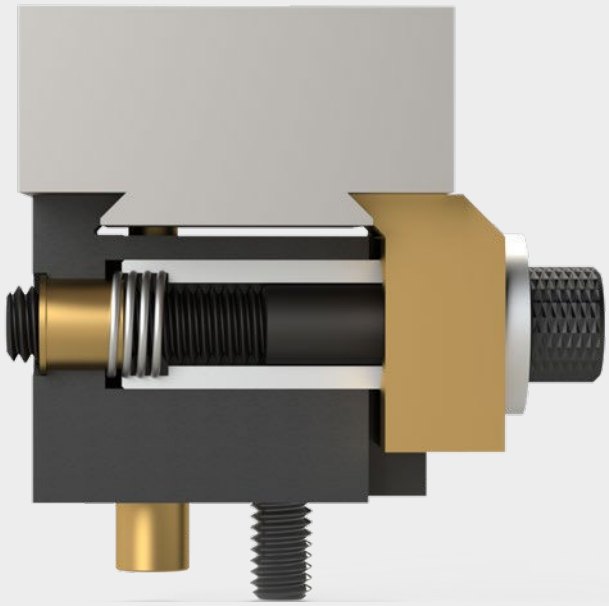
Metric

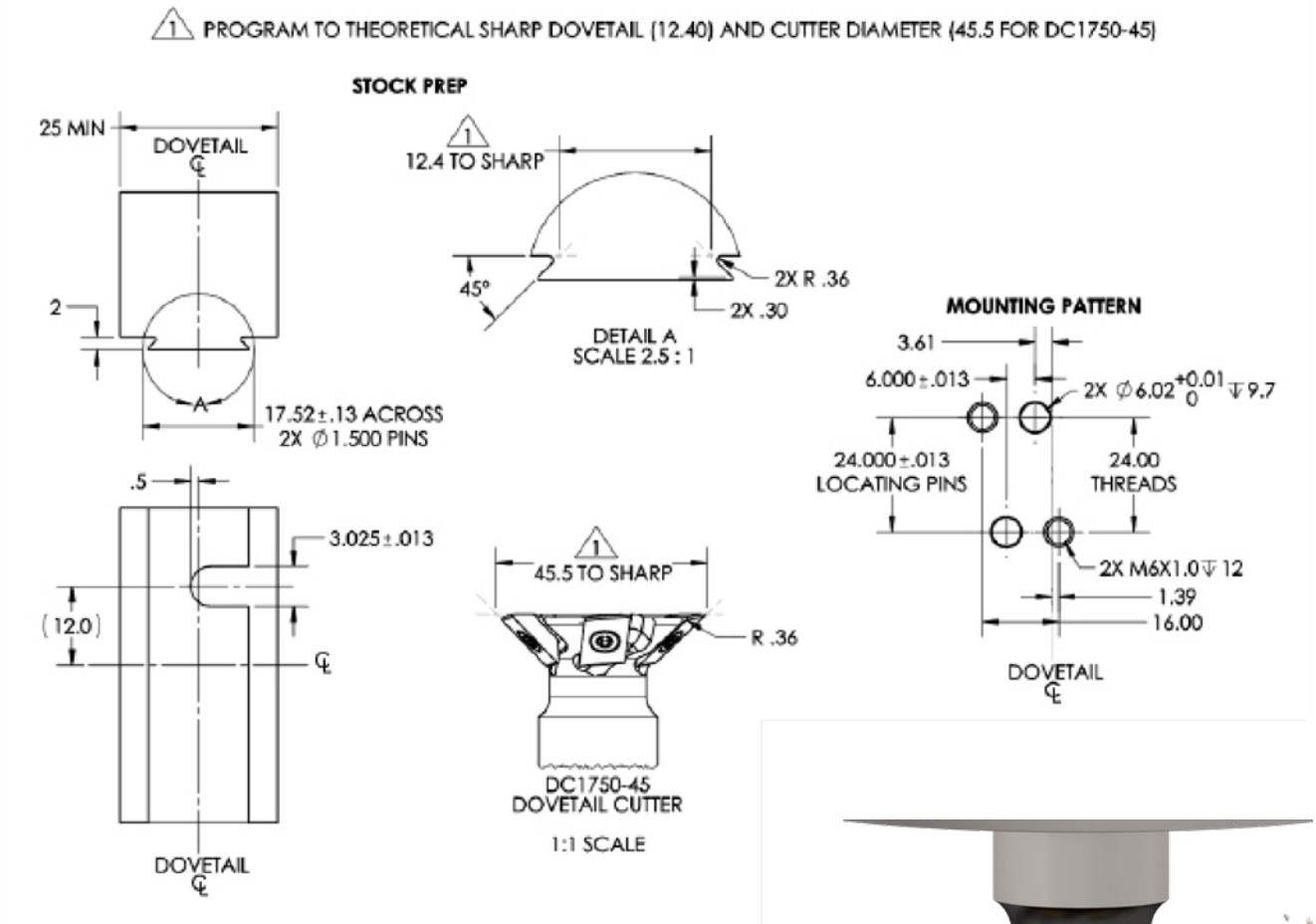
Spacing: Ø152.4mm x 64.9mm
Material Construction: 6061 Aluminum

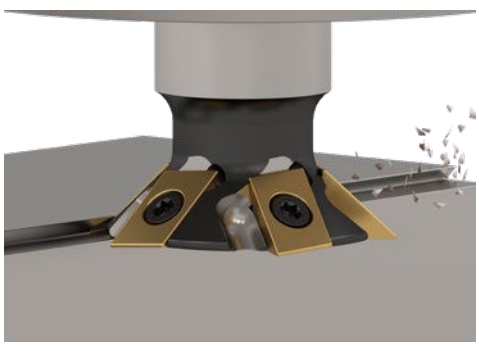
This compact pyramid utilizes **4 DM25** dovetail fixtures. The small foot print ensures no space is wasted allowing simultaneous machining of four parts. Run more parts per cycle and minimize pallet and tool changes. This versatile fixture can be mounted on trunnions, pallets, and machine tables using our 96mm RockLock Quick Change System.

Dovetail Fixtures

SAMPLE DOVETAIL STOCK PREP (DM25)









CERX-40 & CERX-32

The **CERX-40** and **CERX-32** are quick and efficient fixtures for holding round stock. The collets utilizes your existing set of standard **ER40** and **ER32** collets allowing you to clamp different diameters of stock. The bodies are manufactured from hardened alloy steel to exacting standards.

Part Number	A52-CERX-40	A96-CERX-40
		
Size	75mm X 75mm x 68mm	126mm x 126mm x 81mm
Mounting	Includes PS16F	Includes PS20F
Stock Size	ER40 Collet	ER40 Collet

Part Number	A52-CERX-32	A96-CERX-32
		
Size	75mm X 75mm x 68mm	126mm x 126mm x 81mm
Mounting	Includes PS16F	Includes PS20F
Stock Size	ER32 Collet	ER32 Collet

CAD models available for download at 5thaxis.com/downloads

Accessories



Dovetail Cutters

DC1750-I
45° Indexable Dovetail Cutter, 1” shank
All of our fixtures feature 45° dovetail.

DC1750-M
45° Indexable Dovetail Cutter, 25mm shank
All of our fixtures feature 45° dovetail.

DC1750-B
Inserts for Dovetail Cutters
Compatible with all 5th Axis dovetail cutters.

DC1750-S
Replacement screws for Dovetail Cutters
Compatible with all 5th Axis dovetail cutters.



Clamps

Replacement Clamps:
CA10-R - Compatible with D05125
CA10M-R- Compatible with DM12
CA25-R- Compatible with D115
CA25M-R - Compatible with DM25
CA375-R - Compatible with D22 & D362
CA375M-R - Compatible with DM50



Replacement Leadscrew Kits

Replacement Leadscrew Kits:
V510M-4RK - Compatible with V510M and V510X
V56124-4RK - Compatible with V552 and V562
V562M-4RK - Compatible with V552M and V562M
V562X-4RK - Compatible with V562X
V75100X-4RK - Compatible with V75100X
V75150X-4RK - Compatible with V75150X

*Inserts sold separately.

CAD models available for download at 5thaxis.com/downloads



Thumb Screws

Replacement Thumbscrews:

TS10 - 10mm | Compatible with V75100X, V75150X, and DV75150X

TS12 - 1/2” | Compatible with V552 and V562

TS13 - 1/2” | Compatible with DV56, DV510, V552M, V562M, V562X, and V510X

TS17 - 17mm | Compatible with V6105M

TS58 - 5/8” | Compatible with V6105

Thumb screws are included with every vise. Fits standard 3/8” drives.



Threaded Locating Pins

Replacement Locating Pins:

LP6 - 6mm OD

LP8 - 8mm OD

LP10 - 10mm OD

LP250 - 6.35 mm OD

LP375 - 9.53 mm OD

Locating pins are included with every vise.



Work Stop For Vise Jaws

WS - Suitable for use with all 5th Axis self-centering and double station vises.

Accessories



Machinable 6061 Aluminum Jaws

METRIC

VAJ75X - 75mm x 45mm x 25mm
(Compatible with V75100 / V75100X)

VAJ52X - 125.73 mm x 62.23 mm x 34.29 mm
(Compatible with V562X / V510X)

VAJ52M - 125mm x 50mm x 34mm
(Compatible with V552M / V562M / V510M)

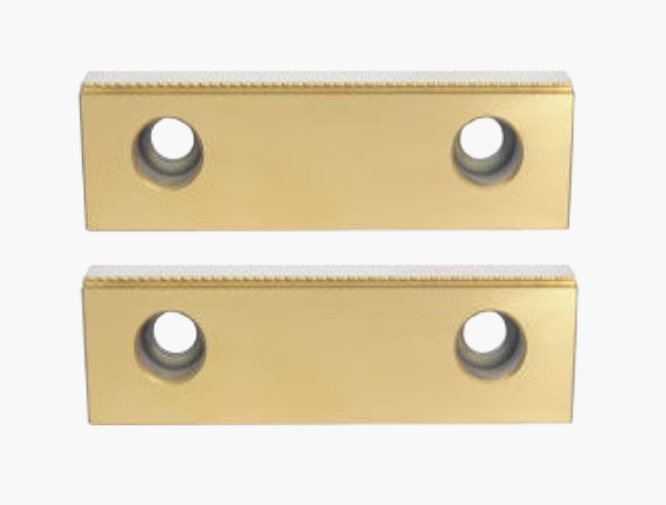


Machinable 1018 Steel Jaws

METRIC

VSJ75X - 75mm x 45mm x 25mm
(Compatible with V75100 / V75100X)

VSJ52M - 125mm x 50mm x 34mm
(Compatible with V552M / V562M / V510M)



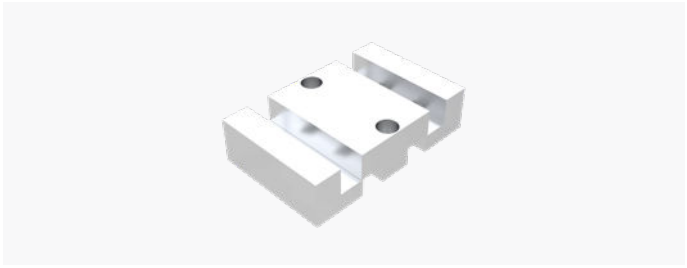
DJ6 Gripper Jaws

DJ6 - Compatible with standard 6” Kurt Vise.

The DJ6 gripper jaws with built-in 45° dovetails are the perfect accessory for your 6” machine vise. Jaws are heat treated and precision ground for superior repeatability and longevity. The jaws are **55 HRC, TiN** coated and feature a 25mm step depth.

Jaws & Jaw Sets

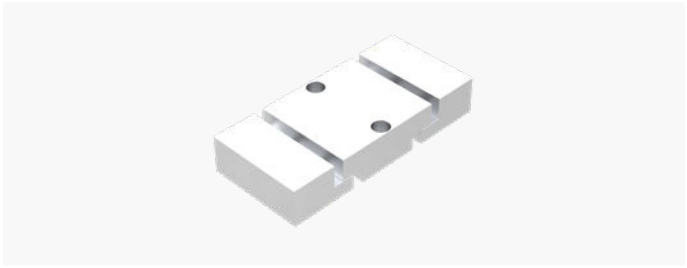
DV56-MJ-A (Aluminum) / **DV56-MJ-S** (Steel)
Double Station Machinable Jaws for DV56



DV56-3R (Steel) Hard Jaw Set for **DV56**



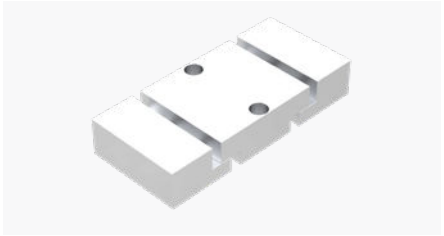
DV510-MJ-A (Aluminum) / **DV510-MJ-S** (Steel)
Double Station Machinable Jaws for **DV510**



DV510-3R - Hard Jaw Set for **DV510**



DV75150X-MJ-A (Aluminum)
DV75150X-MJ-S (Steel) Double Station Machinable Jaws for **DV75150X**



DV75150X-3R (Steel) Hard Jaw Set for **DV75150X**



V562X-5 (Steel) Master Hard Jaw for **V562X & V510X**



V75100X-5 (Steel)
Master Hard Jaw **V75100X, V75150X, and DV75150X**



PMV3XS (Steel)
Machinable Jaws for **Pin Vises**



VGT-VA5 (Steel)
Replacement Gripper Teeth for **VA56 and VA513**



Accessories







Anti-Lift Jaws

AL75A - Anti-Lift Aluminum Machinable Jaws, Starter Set. Includes steel cleats, aluminum machinable jaws, and brackets. (Compatible with V75100, V75100X, V75150X)

A**L75-2A -** Set of 2, Replacement Anti-Lift Machinable Aluminum Jaws. (Compatible with V75100, V75100X, V75150X)

AL75S - Anti-Lift Steel Machinable Jaws, Starter Set. Includes steel cleats, steel machinable jaws, and brackets. (Compatible with V75100, V75100X, V75150X)

AL75-2S - Set of 2, Replacement Anti-Lift Machinable Jaws, Steel. (Compatible with V75100, V75100X, V75150X)

AL52A - Anti-Lift Aluminum Machinable Jaws, Starter Set. Includes steel cleats, aluminum machinable jaws, and brackets. (Compatible with V552 / V562 / V552M / V562M / V510M)

AL52-2A - Set of 2, Replacement Anti-Lift Machinable Aluminum Jaws. (Compatible with V552 / V562 / V552M / V562M / V510M)

AL52-2S - Set of 2, Replacement Anti-Lift Machinable Jaws, Steel. (Compatible with V552 / V562 / V552M / V562M / V510M)

AL52XA - Set of 2, Replacement Anti-Lift Machinable Aluminum Jaws (Compatible with V562X & V510X)

AL52XS- Set of 2, Replacement Anti-Lift Machinable Steel Jaws (Compatible with V562X & V510X)

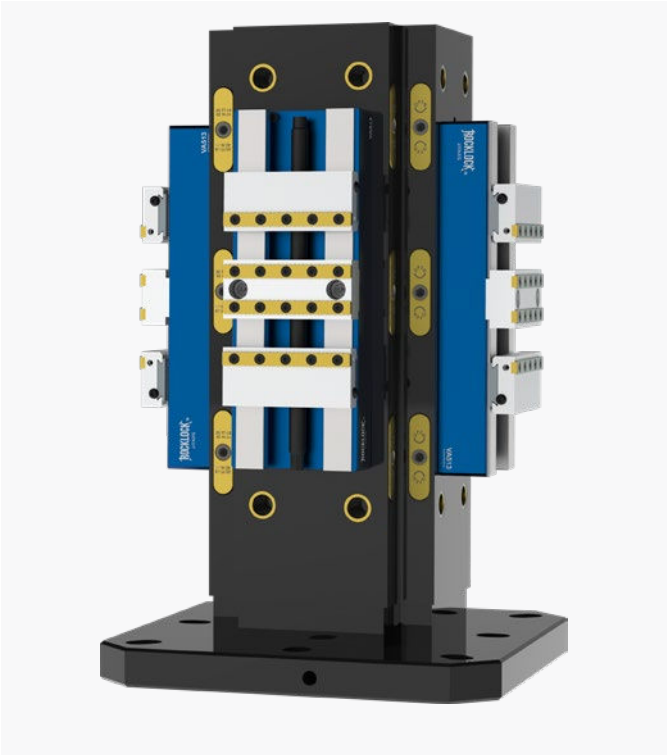
Our Anti-Lift Jaws use a cleat and angled soft jaw to pull the jaw in and down when torque is applied to the lead screw. This design decreases jaw lift and jaw deflection commonly seen in self-centering vises.

RockLock Examples



400mm Tombstone configuration

Part number shown: RL96A-4004U
Qty. 12: VA56 vises with optional jaws



400mm Tombstone configuration

Part number shown: RL96A-4004U
Qty. 4: VA513 vises with optional jaws



R96-V75XT4 Tombstone configuration

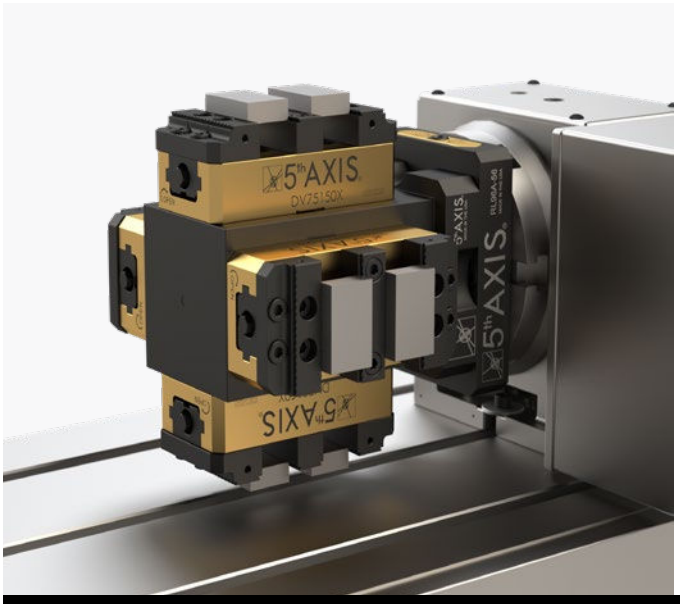
Part number shown: R96-V75XT4 with 4X DV75150X 200mm tall mini tombstone designed to work with smaller 4 and 5 Axis machines.



R96-V75100T4 Tombstone configuration

Part number shown: R96-V75100T4 with 8X V75100X 266mm tall mini tombstone designed to work with smaller 4 and 5 Axis machines.

RockLock Examples



4th Axis tombstone configuration

Part number shown: R96-V75XT4 with 4x DV75150X + RL96A-56 adapter Turn your vertical with a rotary into a mini horizontal. Produce 8 times more parts on your rotary table.



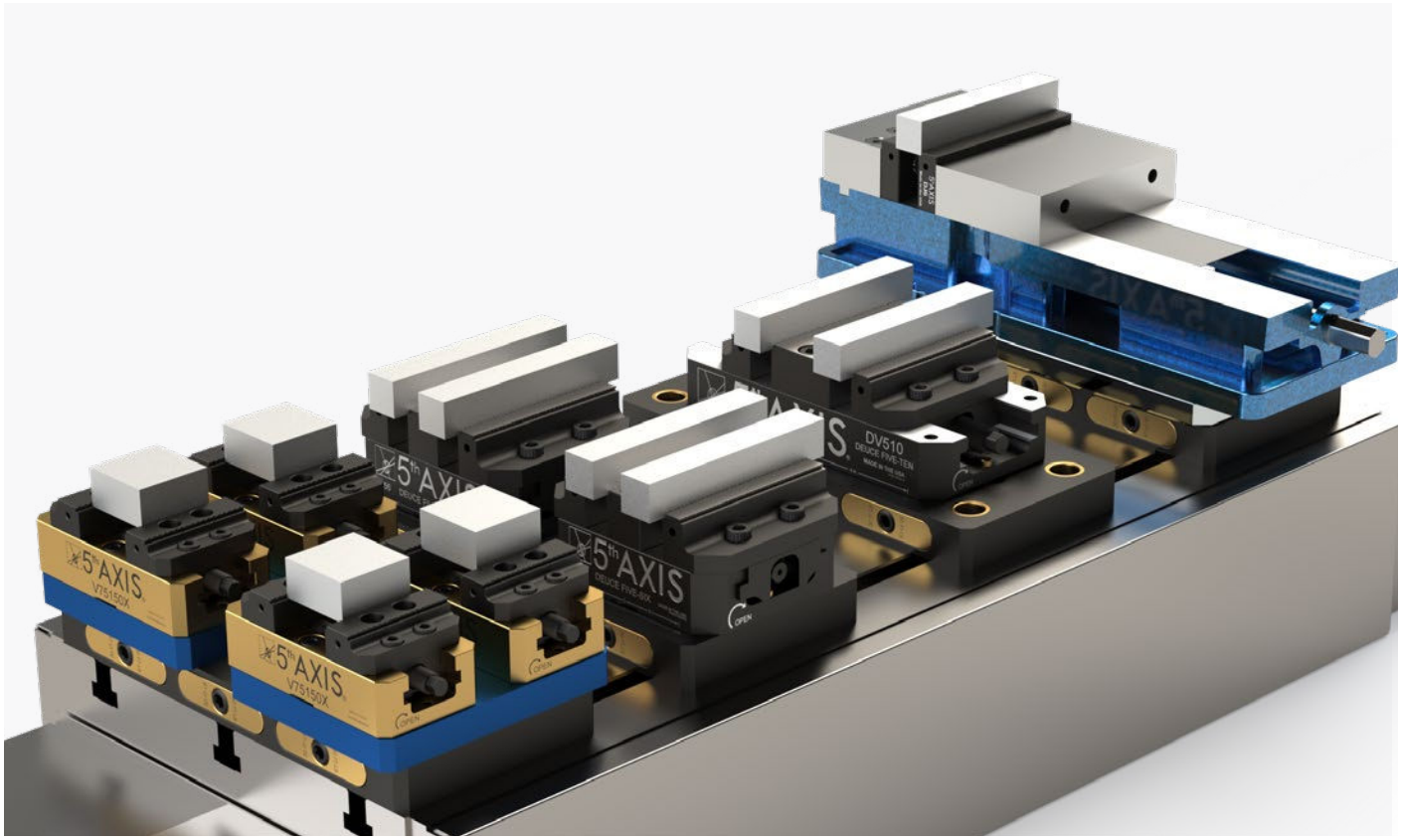
Haas TRT160 configuration

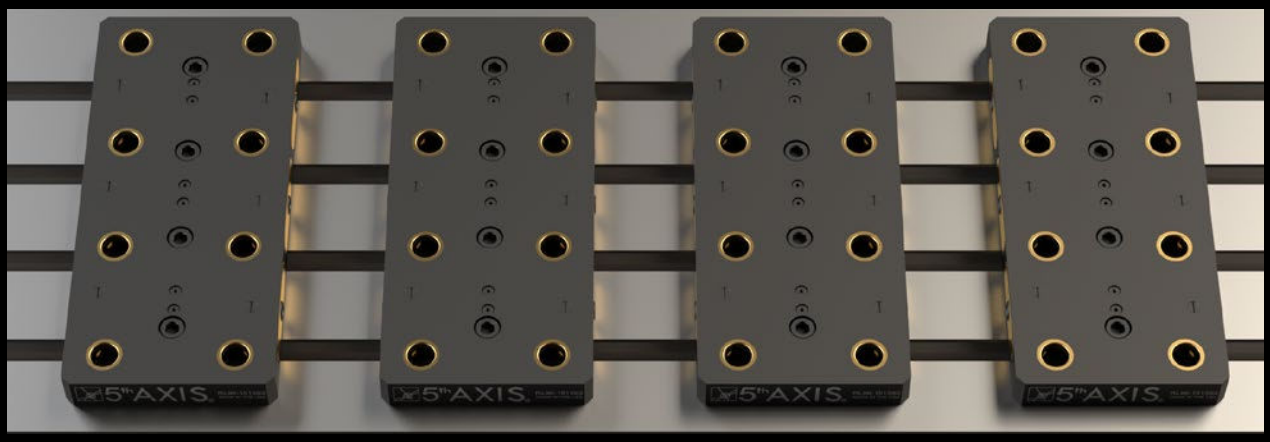
Part number shown: RL96A-60100
New 4 bolt 96mm RockLock adapter. Designed for the new style Haas TRT160 rotary.



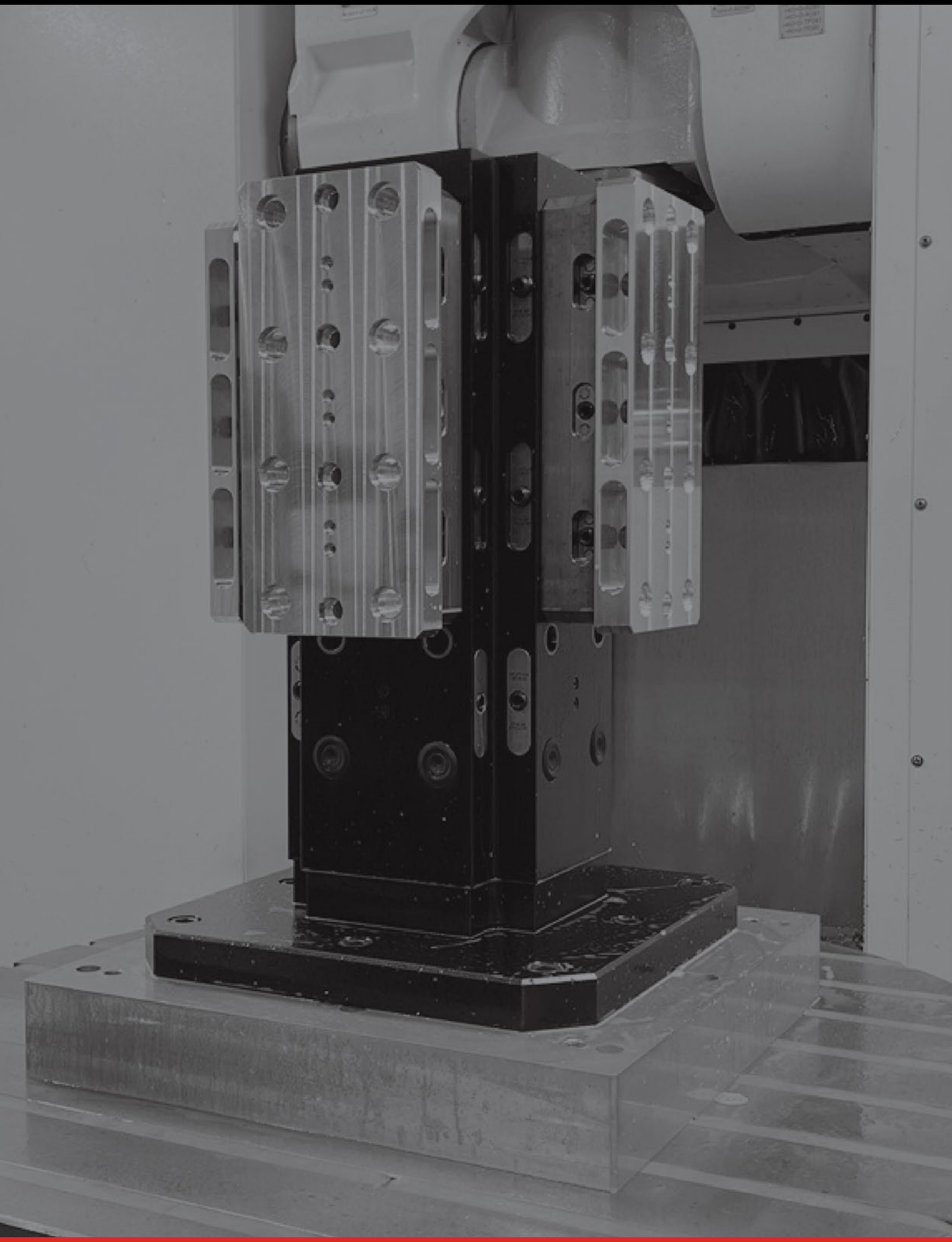
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