

# Технические характеристики

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## 29 TOOL MAKER'S VEE BLOCK &amp; CLAMP SETS

No. 030

ESP Calzos en "V" FR Vés de précision DE Doppelprismenpaar mit Spannbo

## Acc BS 3731 Grade 2

This range of Vee blocks are made from finely selected tool steel fully hardened to 55-60 HRC.

Manufactured and numbered in matched pairs, each pair has two 90° Vees of different capacities which are identical to the Vees of its matching block. The Vees are ground central, parallel and square with the ends and sides.

These Vee Blocks are very useful for holding work securely during drilling, milling and grinding operations and also in layout and inspection work. Each pair of Vee Blocks comes complete with a pair of rigid and robust clamps.

Available in two types: Regular type and Non protruding clamp type. Top clamping design of the Non protruding clamp type allows the blocks to be used on the side faces in addition to the base.



Regular Vee Block set used as an inspection tool for checking run-outs



Non Protruding Clamp Type Vee Block used on side face for holding round bar in a grinding operation



Vee Blocks & Clamp Sets - Regular

Vee Blocks & Clamp Sets - Non Protruding Clamp type

## Technical Information

Permissible Height difference between matched pairs  
Parallelism and Squareness of Vee grooves with respect to all surfaces  
Parallelism of opposite faces of Vee Blocks  
Squareness of adjacent exterior faces of Vee Blocks  
Flatness of Working Faces

Within 0.0002" (5 microns)  
Within 0.0003" (8 microns)  
Within 0.0003" (8 microns)  
Within 0.0003" (8 microns)  
Within 0.0002" (5 microns)

## Ordering Information

| Cat. Nr                                                    | Ordering Nr. | Block Length |     | Block Width |    | Block Height |    | Width of small Vee (V1) |    | Width of large Vee (V2) |    | Clamping Capacity |    |
|------------------------------------------------------------|--------------|--------------|-----|-------------|----|--------------|----|-------------------------|----|-------------------------|----|-------------------|----|
|                                                            |              | Inch         | mm  | Inch        | mm | Inch         | mm | Inch                    | mm | Inch                    | mm | Inch              | mm |
| <b>Vee Blocks &amp; Clamps - Regular Type</b>              |              |              |     |             |    |              |    |                         |    |                         |    |                   |    |
| u VB/T/30                                                  | 03050        | 1-19/32      | 40  | 1-1/4       | 32 | 1-1/4        | 32 | 7/16                    | 11 | 13/16                   | 20 | 1                 | 25 |
| u VB/T/35                                                  | 03051        | 2            | 50  | 1-1/2       | 37 | 1-1/2        | 37 | 1/2                     | 13 | 1-3/32                  | 28 | 1-1/4             | 32 |
| VB/T/45                                                    | 03052        | 1-3/4        | 45  | 1-19/32     | 40 | 1-7/16       | 36 | 9/16                    | 14 | 1-3/32                  | 28 | 1-1/4             | 32 |
| VB/T/60                                                    | 03053        | 2-3/8        | 60  | 1-19/32     | 40 | 1-7/8        | 47 | 11/16                   | 17 | 1                       | 25 | 1-3/16            | 30 |
| u VB/T/70                                                  | 03054        | 2-3/4        | 70  | 1-3/4       | 45 | 1-7/16       | 37 | 11/16                   | 17 | 1-5/16                  | 33 | 1-1/2             | 37 |
| VB/T/80                                                    | 03056        | 3-5/32       | 80  | 2-9/16      | 65 | 2-9/16       | 65 | 7/8                     | 22 | 1-3/4                   | 45 | 2                 | 50 |
| VB/T/100                                                   | 03057        | 4            | 100 | 3           | 75 | 3            | 75 | 1-3/16                  | 30 | 2-5/32                  | 55 | 3                 | 75 |
| <b>Vee Blocks &amp; Clamps - Non Protruding Clamp Type</b> |              |              |     |             |    |              |    |                         |    |                         |    |                   |    |
| VB/SP/R/T/70                                               | 03080        | 2-3/4        | 70  | 2-1/2       | 63 | 1-3/4        | 45 | 1                       | 25 | 1-3/16                  | 30 | 1-1/2             | 37 |
| VB/SP/R/T/125                                              | 03081        | 4-7/8        | 125 | 3-1/2       | 89 | 2-3/4        | 70 | 1-1/4                   | 32 | 1-19/32                 | 40 | 1-3/4             | 45 |

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## 30 MULTIPURPOSE VEE BLOCK & CLAMP SET

VB-MP

ESP Calzos en "V" FR Vés de précision DE Doppelprismenpaar mit Spannbügel

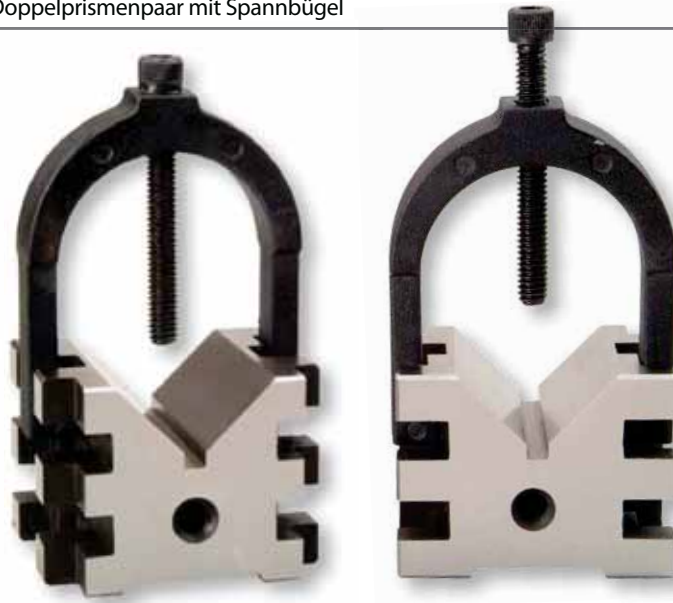
High Precision Multi Purpose Vee Blocks- ideal for use in layout work in tool rooms

Designed for holding square or round pieces with high accuracy

Blocks have stepped grooves that allow the clamps to be inserted without protrusion allowing blocks to be used on ends or sides in addition to the base

Blocks are hardened within 50-55 HRC. Matched pair of Vee Blocks are perfectly aligned with 90° Vee grooves ground central and parallel to the sides and base

Available as matched pairs complete with two clamps



**NEW!**

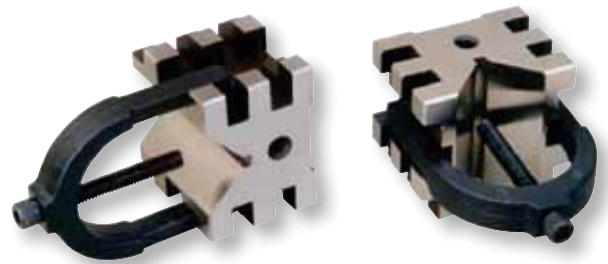
### Technical Information

Flatness of working surface  
Permissible height difference between matched pairs  
Parallelism and squareness of sides

Within 0.0002" (5 microns)  
Within 0.0002" (5 microns)  
Within 0.0004" (10 microns)

### Ordering information

| Cat. Nr  | Ordering Nr. | Block Length |    | Block Width |    | Block Height |    | Clamping Capacity |    |
|----------|--------------|--------------|----|-------------|----|--------------|----|-------------------|----|
|          |              | Inch         | mm | Inch        | mm | Inch         | mm | Inch              | mm |
| VB/MP/1P | 02920        | 2-3/8        | 60 | 2-3/4       | 70 | 2            | 50 | 2                 | 50 |



## 31 ULTIMATE VEE BLOCK & CLAMP SET

S-48

ESP Calzos en "V" FR Vés de précision DE Doppelprismenpaar mit Spannbügel

Manufactured from selected steel, Vee Blocks are fully hardened and ground.

Following enhanced features incorporated in the design render greater versatility to this Vee Block set

- Capable of being used on base, on end and flat on either sides as the clamp is within the outside width of the block.
- Adjustable side screw with cap in the clamp supports the block and prevents tilting during drilling, milling or grinding operations.
- Four 3/8" - 16 tapped holes, two in the base and one on each side allow attachment to an angle iron which can then be attached to a lathe face plate or held by a magnetic chuck.



Groove at the stepped end, right angled to the base, provides a handy means for holding shouldered studs, round pins etc.



### Ordering Information

| Cat. Nr. | Ordering Nr. | Block Length |    | Block Width |    | Block Height |    | Clamping Capacity |    |
|----------|--------------|--------------|----|-------------|----|--------------|----|-------------------|----|
|          |              | Inch         | mm | Inch        | mm | Inch         | mm | Inch              | mm |
| VB/S/48  | 02910        | 3-19/32      | 90 | 1-7/8       | 48 | 1-7/8        | 48 | 1-5/16            | 33 |

## 32 VEE BLOCK &amp; CLAMP SET – VERSATILE

V-63

V-100

V-150

V-150XL

ESP Calzos en "V"

FR Vés de précision - "ULTIMATE"

DE Doppelprismenpaar mit Spannbügel

The "Versatile" Vee block is made from finely selected tool steel fully hardened to 55-60 HRC

The special design with 90° Vee angle provides a quick, accurate and positive means of holding workpieces for machining, grinding and in layout and inspection work

In addition to use on base, the Vee block can also be used on its side or end

The unit comes complete with a reversible swing away style clamp that clamps

against almost any shape of product

The three tapped hole positions in the Vee block for the clamp allows the clamp to be positioned at either end or at the centre of the Vee block

Tapped holes on the Vee block end allow mounting the block perpendicular to the face plate. Each unit comes complete with the basic block, reversible clamp and 2 clamp screws

Also available in matched pairs with 2 block, 2 clamps and 4 screws



## Technical Information

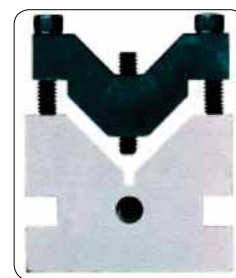
Parallelism and Squareness of Vee Grooves with respect to the base  
Matched Pair Tolerance

Within 0.0003" (8microns)  
Within 0.0002" (5 microns)

## Ordering information

| Cat. Nr           | Ordering Nr. | Type   | Block Length |     | Block Width |     | Block Height |     | Clamping Capacity |     |
|-------------------|--------------|--------|--------------|-----|-------------|-----|--------------|-----|-------------------|-----|
|                   |              |        | Inch         | mm  | Inch        | mm  | Inch         | mm  | Inch              | mm  |
| VB/SP/V/63S       | 03090        | Single | 2-1/2        | 63  | 2-1/2       | 63  | 2            | 50  | 1-5/8             | 41  |
| VB/SP/V/63P       | 03091        | Pair   | 2-1/2        | 63  | 2-1/2       | 63  | 2            | 50  | 1-5/8             | 41  |
| u VB/SP/V/100S    | 03092        | Single | 4            | 100 | 3           | 75  | 3            | 75  | 2-1/4             | 57  |
| VB/SP/V/100P      | 03093        | Pair   | 4            | 100 | 3           | 75  | 3            | 75  | 2-1/4             | 57  |
| l VB/SP/V-150S    | 03094        | Single | 6            | 150 | 6           | 150 | 4            | 100 | 4-3/8             | 111 |
| l VB/SP/V-150XL-S | 03096        | Single | 6            | 150 | 6           | 150 | 6            | 150 | 4-3/8             | 111 |

u BESTSELLER | NEW SIZE



Versatile Vee Block allows reversal of clamp to facilitate clamping of jobs with a smaller diameter or irregular form

## 33 ADJUSTABLE ANGLE BLOCK 0-60°

PAB-01

PAB-02

PAB-03

ESP Bloque angular ajustable 0-60°

FR Vés de montage orientation facile

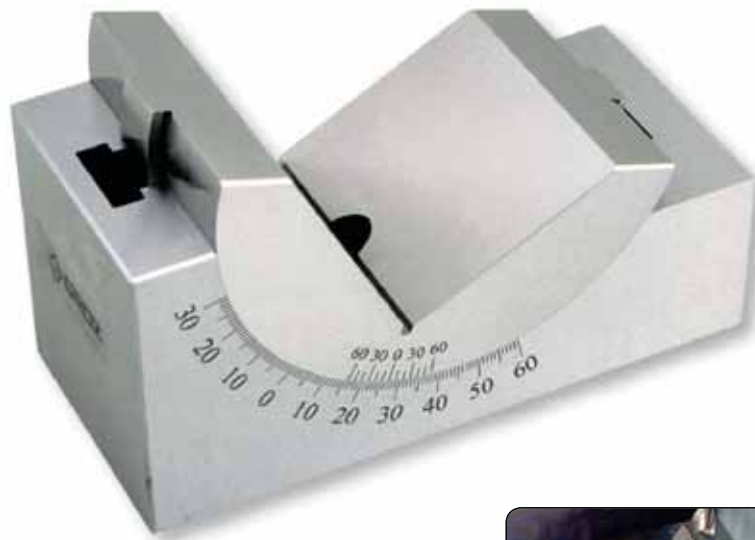
DE Doppelprismenpaar

Made from fully hardened 50-55 HRC and ground tool steel, these precision Adjustable Angle Blocks are useful for most drilling, milling and set up jobs where a particular angle to a reference face is required

The block is fully adjustable from 0°-60° and can be set at any desired position by locking of the hex screw located in the base

Angle Accuracy:  $\pm 10^\circ$

Squareness: 0.0004" (10 microns)



## Ordering Information

| Cat. Nr    | Ordering Nr. | Block Length |    | Block Width |    | Block Height |    | Width of Vee |      |
|------------|--------------|--------------|----|-------------|----|--------------|----|--------------|------|
|            |              | Inch         | mm | Inch        | mm | Inch         | mm | Inch         | mm   |
| u PAB/01/A | 02100        | 3-3/4        | 95 | 1-3/4       | 45 | 2            | 50 | 1-29/32      | 48.5 |
| PAB/02/A   | 02101        | 3-3/4        | 95 | 1-3/16      | 30 | 2            | 50 | 1-29/32      | 48.5 |
| PAB/03/A   | 02103        | 3            | 75 | 1           | 25 | 1-11/32      | 34 | 1-5/32       | 29.5 |

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AdjustableAngleBlock allows the job to held at any angle 0-60° for angular machining jobs

## 34 MAGNETIC VEE BLOCKS

MVB-3

MVB-4

MVB-5

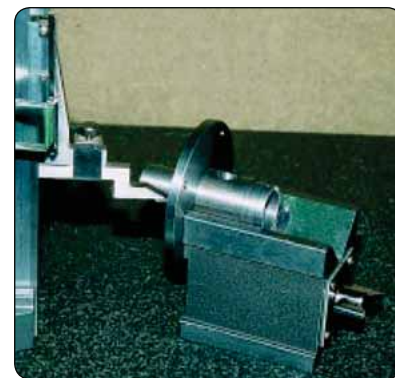
ESP Calzos Magnéticos en "V"    FR Vés Magnétique    DE Permanent -magnetischer Prismenblock

Designed for versatility and accuracy, these Vee Blocks are ideal for holding round or irregular shapes for scribing, grinding, measuring, machining and testing applications

These can be used either ways, up or standing on end. All Vee's and faces can be energised or de energised simultaneously by turning the rotary action control knob. This feature enables the Vee Block to hold both itself and the work on any flat ferrous surface including a permanent magnetic chuck (without energising the chuck). Brass knob ensures no interference with the magnetic field, unlike the conventionally used steel knobs.

Also available with hardened Vee's: 55-60 HRC for increased wear resistance

For applications requiring two Vee blocks matched and numbered pairs are available



Magnetic Vee Block security holds jobs for accurate marking

### Technical Information

Permissible Height Difference between matched pairs  
Squareness of Vee Grooves with respect to the base

Within 0.00015" (4 microns)  
Within 0.00023" (6 microns)

### Ordering Information

| Cat. Nr. | Ordering Nr. | Cat. Nr.       | Ordering Nr. | Block Length |     | Block width |    | Block Height |    | Width of Small Vee |      | Width of Large Vee* |    | Clamping Capacity |            |
|----------|--------------|----------------|--------------|--------------|-----|-------------|----|--------------|----|--------------------|------|---------------------|----|-------------------|------------|
|          |              |                |              | Inch         | mm  | Inch        | mm | Inch         | mm | Inch               | mm   | Inch                | mm | Inch              | mm         |
| Regular  |              | Hardened Vee's |              |              |     |             |    |              |    |                    |      |                     |    |                   |            |
| MVB/3S   | 02906        | MVB/3S/H       | 02915        | 6            | 150 | 3           | 75 | 3-3/4        | 95 | 1                  | 25   | 2-1/8               | 55 | 3/16 - 2-3/4      | 5.0 - 70.0 |
| MVB/3P   | 02907        | MVB/3P/H       | 02916        | 6            | 150 | 3           | 75 | 3-3/4        | 95 | 1                  | 25   | 2-1/8               | 55 | 3/16 - 2-3/4      | 5.0 - 70.0 |
| MVB/4S   | 02900        | MVB/4S/H       | 02904        | 4            | 100 | 3           | 75 | 3-3/4        | 95 | 7/8                | 22.5 | 2-1/8               | 55 | 3/16 - 2-3/4      | 5.0 - 70.0 |
| MVB/4P   | 02901        | MVB/4P/H       | 02905        | 4            | 100 | 3           | 75 | 3-3/4        | 95 | 7/8                | 22.5 | 2-1/8               | 55 | 3/16 - 2-3/4      | 5.0 - 70.0 |
| MVB/5S   | 02902        | MVB/5S/H       | 02917        | 3-3/16       | 80  | 2-3/8       | 60 | 3-3/4        | 95 | 11/16              | 17.5 | 1-11/16             | 43 | 3/16 - 2-3/8      | 5.0 - 60.0 |
| MVB/5P   | 02903        | MVB/5P/H       | 02918        | 3-3/16       | 80  | 2-3/8       | 60 | 3-3/4        | 95 | 11/16              | 17.5 | 1-11/16             | 43 | 3/16 - 2-3/8      | 5.0 - 60.0 |

u BESTSELLER | NEW    S - Single    P - Pair    \* in hardened Vee Blocks width of Large Vee is slightly lower than that mentioned

## 35 ADJUSTABLE VEE BLOCK SET

AVB

ESP Calzos en "V" ajustable

FR Vés de précision

DE Doppelprismenpaar mit Spannbügel

Precision made tool performing all of the functions that would normally require usage of various shims, blocks or machinist's jacks. Ideal for inspecting shafts and parts with multiple diameters

Anvil height on the block is easily adjustable to support shafts, bars of varying diameters making for quick inspection without having to use centers

Anvil supports upto 450 kgs (1000 lbs)

Vibration lock (position lock) prevents creeping

Wide angle Vee accepts 3/16" (5mm) to 5" (125mm) diameters

Top flats ground parallel to the base can hold wide, flat parts. Narrow flats may be held on a parallel across the top

Total Rise of Vee - 1/2" (12mm). Dial graduated in increments of 0.001" (25 microns)

Sold as a set of 2 blocks in matched pairs



### Technical Information

Permissible height difference between matched pairs  
Flatness of base

Within 0.001" (25 microns)  
Within 0.0002" (5 microns)

### Ordering information

| Cat. Nr | Ordering Nr. | Block Length |    | Block Width |     | Block Height |    | Clamping Capacity |       |
|---------|--------------|--------------|----|-------------|-----|--------------|----|-------------------|-------|
|         |              | Inch         | mm | Inch        | mm  | Inch         | mm | Inch              | mm    |
| AVB/1P  | 02930        | 7/8          | 23 | 4           | 100 | 3            | 75 | 3/16-5            | 5-125 |

Adjustable Vee Block being used to check cocentricity of different diameters on a stepped rod



## 36 BALL BEARING VEE BLOCK & CLAMP SETS

VB-BB

ESP Calzos en "V"

FR Vés de précision

DE Doppelprismenpaar mit Spannbügel

High precision Ball Bearing Vee Blocks are used to inspect & detect out of round conditions, defects and lobes without damage to both the parts being checked and the Vee Block itself

Ideal for use where inspection set-ups are not otherwise possible using regular Vee Blocks. Design allows inspection of components from two angles by turning the spacer block 90°

Vee Block bases are made from cast iron and use hardened 60HRC wear resistant balls with sphericity controlled to within 0.000025" (0.6microns) on the small and medium sets and 0.00005" (1.27 microns) on the large set. Balls are finished to 0.2 micro inches

Supplied in matched pairs, complete with two clamps and one test ball

Matched pairs are controlled to within  $\pm 0.0002"$  ( $\pm 0.005\text{mm}$ )



### Ordering Information

| Cat. Nr.    | Ordering Nr. | Detail      | Capacity Without Clamps |      |         |     | Dia of Balls | Clamping Capacity |     |
|-------------|--------------|-------------|-------------------------|------|---------|-----|--------------|-------------------|-----|
|             |              |             | Minimum                 |      | Maximum |     |              | Kgs               | Lbs |
|             |              |             | Inch                    | mm   | Inch    | mm  |              |                   |     |
| VB/BB/1-2   | 02940        | Small Pair  | 3/64                    | 1.20 | 2-1/2   | 63  | 100          | 220               |     |
| VB/BB/15-16 | 02941        | Medium Pair | 3/32                    | 2.38 | 5       | 127 | 500          | 1100              |     |
| VB/BB/1-1-2 | 02942        | Large Pair  | 3/16                    | 4.76 | 15      | 381 | 900          | 2000              |     |

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Ball Bearing Vee Blocks with non-marring balls being used to check the roundness of a stepped rod



## 37 VEE BLOCKS – CAST IRON

No. 031

ESP Calzos en "V" - Hierro Colado FR Vés à 1 entaille DE Doppelprismenp-Paare

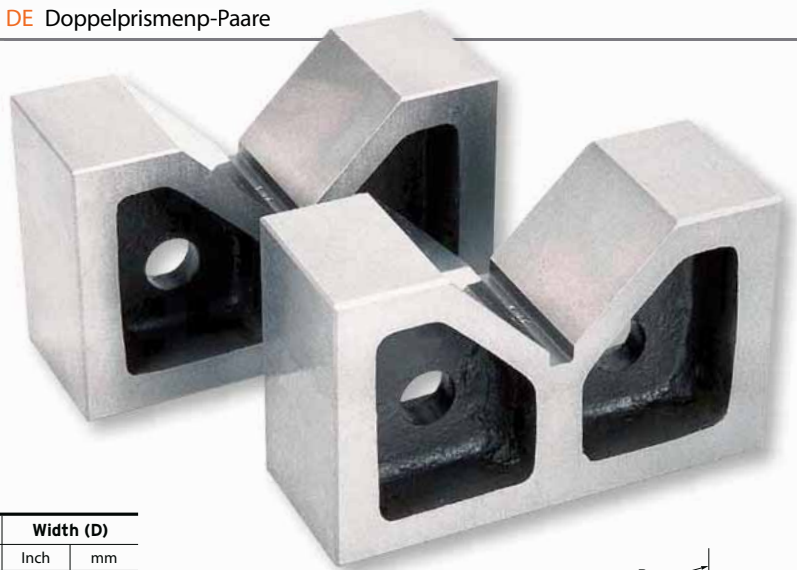
Made from close grained cast iron, these blocks are precisely ground and machined square and parallel

The Vee's are 90° centred in true

The blocks are manufactured and supplied in numbered pairs and come in handy for holding large jobs where clamping is not necessary

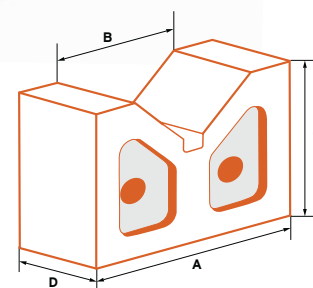
**Technical Information**

Squareness and Parallelism of Vee Groves with respect to base  
Within 0.0012" (30 microns)

**Ordering Information**

| Cat. Nr. | Ordering Nr. | Length (A) |     | Width of Vee (B) |     | Height (C) |     | Width (D) |     |
|----------|--------------|------------|-----|------------------|-----|------------|-----|-----------|-----|
|          |              | Inch       | mm  | Inch             | mm  | Inch       | mm  | Inch      | mm  |
| VB/C/2   | 03107        | 2          | 50  | 1                | 22  | 1-1/4      | 32  | 1         | 24  |
| VB/C/3   | 03100        | 3          | 75  | 1-3/4            | 45  | 2-3/8      | 60  | 1-5/16    | 33  |
| u VB/C/4 | 03101        | 4          | 100 | 2-3/16           | 56  | 2-9/16     | 65  | 1-9/16    | 40  |
| VB/C/5   | 03102        | 5          | 125 | 2-7/16           | 62  | 3-1/8      | 78  | 2         | 50  |
| u VB/C/6 | 03103        | 6          | 150 | 3-1/16           | 78  | 3-1/2      | 88  | 2-7/16    | 62  |
| VB/C/7   | 03108        | 7          | 180 | 3-17/32          | 90  | 4-17/32    | 115 | 3         | 75  |
| VB/C/8   | 03104        | 8          | 200 | 4-1/2            | 113 | 5-1/2      | 140 | 4         | 100 |
| VB/C/10  | 03105        | 10         | 250 | 5                | 125 | 6-1/2      | 165 | 5         | 125 |
| VB/C/12  | 03106        | 12         | 300 | 5-1/8            | 128 | 8          | 200 | 6         | 150 |

u BESTSELLER | NEW SIZE



## 38 4 WAY VEE BLOCKS – CAST IRON

No. 031Q

ESP Calzos en "V" de 4 servicios - Hierro Colado FR Vés à 4 entailles DE Parallelstücke

Made from close grained cast iron, these Vee Blocks are precisely ground and machined square and parallel

Each Block incorporates 4 different sized Vee's thereby supporting a wide range of sizes. This enables a single block to be used as a workholding device for supporting different sized jobs

Manufactured and supplied in matched and numbered pairs, these are very useful for marking and checking of cylindrical parts

The larger sizes incorporate a cavity on either sides for convenient handling

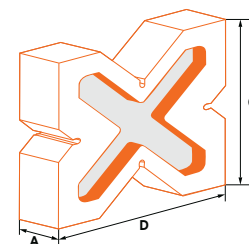
**Technical Information**

Squareness and Parallelism of Vee Groves with respect to base  
Within 0.0012" (30 microns)

**Ordering Information**

| Cat. Nr.           | Ordering Nr. | Length of Prism (A) |     | Width (D) |     | Height (C) |     | Vee Capacity                |                    |
|--------------------|--------------|---------------------|-----|-----------|-----|------------|-----|-----------------------------|--------------------|
|                    |              | Inch                | mm  | Inch      | mm  | Inch       | mm  | Inch                        | mm                 |
| u VB/QD/95-70-35   | 03110        | 1-3/8               | 35  | 3-3/4     | 95  | 2-3/4      | 70  | 3/4 x 1-3/16 x 1-9/16 x 2   | 20 x 30 x 40 x 50  |
| u VB/QD/100-100-30 | 03111        | 1-3/16              | 30  | 4         | 100 | 4          | 100 | 3/4 x 1-3/16 x 1-9/16 x 2   | 20 x 30 x 40 x 50  |
| u VB/QD/120-120-35 | 03112        | 1-3/8               | 35  | 4-3/4     | 120 | 4-3/4      | 120 | 1-3/16 x 1-9/16 x 2 x 2-3/8 | 30 x 40 x 50 x 60  |
| VB/QD/120-120-60   | 03113        | 2-3/8               | 60  | 4-3/4     | 120 | 4-3/4      | 120 | 1-3/16 x 1-9/16 x 2 x 2-3/8 | 30 x 40 x 50 x 60  |
| VB/QD/150-150-75   | 03114        | 3                   | 75  | 6         | 150 | 6          | 150 | 1-9/16 x 2 x 2-3/8 x 2-3/4  | 40 x 50 x 60 x 70  |
| VB/QD/200-200-100  | 03115        | 4                   | 100 | 8         | 200 | 8          | 200 | 2-3/8 x 2-3/4 x 3-5/32 x 4  | 60 x 70 x 80 x 100 |

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## 39 MAGNETIC BASES – MEDIUM DUTY

MB-25

ESP Soporte Magnetico - Trabajo Mediano    FR Base Magnétique    DE Magnet-Messstativ

This range of magnetic bases is very useful for light to medium duty applications that require a magnetic pull of upto 40kg (88lbs)

Equipped with a convenient to use ON/OFF control knob, these can be readily located on any ferrous surface

Three precision ground magnetic surfaces allow these to be used horizontally, vertically or upside down. V Step holds base to arbors, shafts and chucks

Available with or without fine adjustment fitting

All magnetic bases are supplied without Dial Gauge



### Ordering Information

| Cat. Nr. | Ordering Nr. | Type                         | Base Dimensions   |              | Overall height |     | Spindle mounting thread spec. (female) |
|----------|--------------|------------------------------|-------------------|--------------|----------------|-----|----------------------------------------|
|          |              |                              | Inch              | mm           | Inch           | mm  |                                        |
| MB/25    | 03400        | Standard                     | 1-3/4 x 1-7/8 x 2 | 45 x 48 x 50 | 9-11/16        | 245 | M8 x 1.25                              |
| MB/25F   | 03401        | With fine adjustment fitting | 1-3/4 x 1-7/8 x 2 | 45 x 48 x 50 | 9-11/16        | 245 | M8 x 1.25                              |



# 40 MAGNETIC BASES – HIGH POWER

MB-31

MB-32

ESP Soporte Magnetico - Alta Potencia    FR Base Magnétique    DE Magnet-Messstativ

These magnetic bases equipped with powerful permanent magnets can be readily located on any ferrous surface and are ideal for all applications that require a magnetic pull of upto 60 kg (130lbs)

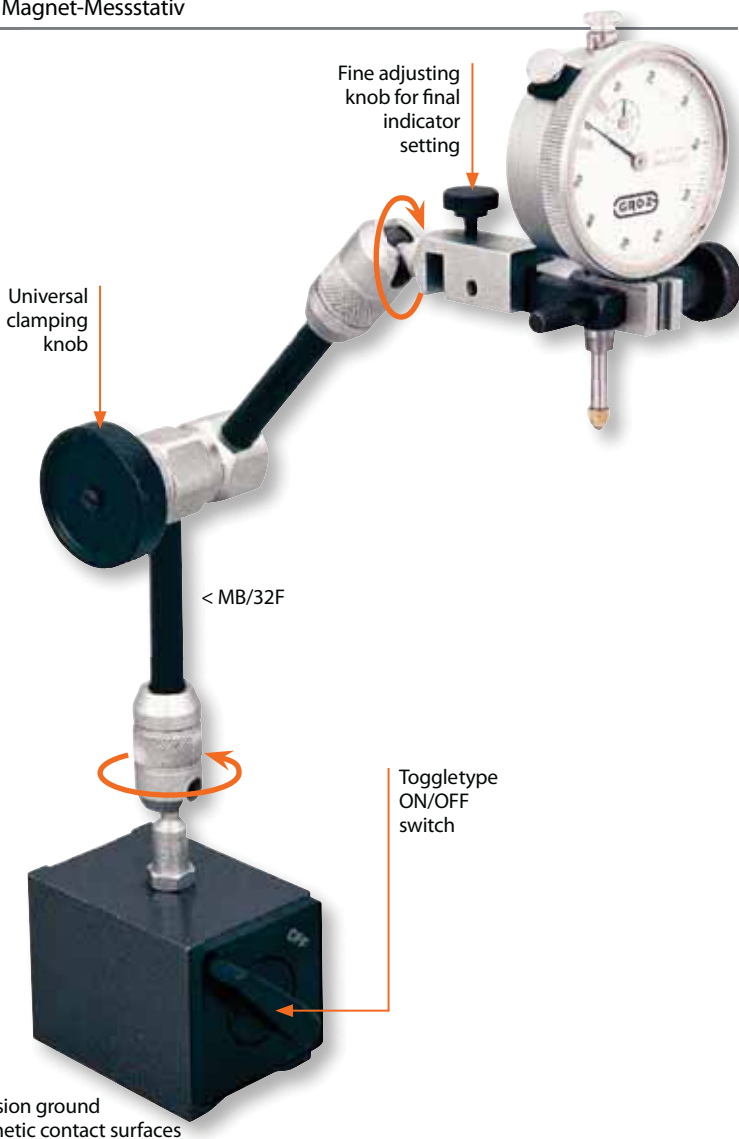
The base and one side are energised for attachment to flat surfaces. Vee groove in the base facilitates gripping on curved surfaces

Unique design allows Dial Indicator to be set at any required position and easily adjusted for use. The bases have an attractive grey hammertone finish, base post and gauge holding rod are chrome plated

All magnetic bases are supplied without a Dial Gauge



MB/31F>



Precision ground magnetic contact surfaces

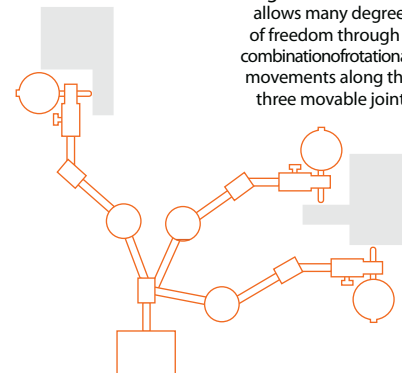
Fine adjusting knob for final indicator setting

Universal clamping knob

Toggle type ON/OFF switch

< MB/32F

Magnetic base MB/32F allows many degrees of freedom through a combination of rotational movements along the three movable joints



### Ordering Information

| Cat. Nr. | Ordering Nr. | Base Dimensions    |              | Overall height |     | Spindle mounting thread spec. (female) |
|----------|--------------|--------------------|--------------|----------------|-----|----------------------------------------|
|          |              | Inch               | mm           | Inch           | mm  |                                        |
| MB/31F   | 03405        | 2 x 2-3/8 x 2-5/32 | 50 x 60 x 55 | 10-5/32        | 258 | M8 x 1.25 mm                           |
| MB/32F   | 03406        | 2 x 2-3/8 x 2-5/32 | 50 x 60 x 55 | 14             | 350 | M8 x 1.25 mm                           |



Magnetic Base with dial gauge being used to check run out of a job on a lathe machine

## 41 POT MAGNETS

PMG

ESP Imanes FR Aimants DE Magneten

Pot Magnets are used for lifting holding & locating ferrous parts.

Aluminium, Nickel and Cobalt Steel alloy content makes them strong and permanent. Unique combination of strong magnet with nickel chrome plated insulating ring gives these magnets the superior holding power of larger ones.

The rear face of the magnet is provided with a tapped hole for attaching to fixtures and machines

Compact design with very strong magnetic pull makes these a favourite in all workshops, tool rooms etc.

NEW!



## Ordering Information

| Cat.Nr.    | Ordering Nr. | Diameter |    | Height |    | Thread Specs. | Magnetic Pull    |
|------------|--------------|----------|----|--------|----|---------------|------------------|
|            |              | Inch     | mm | Inch   | mm |               |                  |
| PMG/11-16  | 03432        | 11/16    | 18 | 5/8    | 16 | 1/4" x 20 TPI | 2.7 kg (6 lbs)   |
| PMG/13-16  | 03434        | 13/16    | 20 | 3/4    | 19 | 1/4" x 20 TPI | 4.5 kg (10 lbs)  |
| PMG/1-1-16 | 03433        | 1-1/16   | 28 | 1      | 25 | 1/4" x 20 TPI | 6 kg (13.2 lbs)  |
| PMG/1-3-8  | 03435        | 1-3/8    | 35 | 1-3/16 | 30 | 1/4" x 20 TPI | 13 kg (28.6 lbs) |

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## 42 MINI MAGNETIC STANDS

MMS

ESP Bases Magnetica Miniatura FR Mini base magnétique DE Kleinmessst

This range of handy magnetic stands provide a simple & inexpensive way of holding dial indicators on any flat ferrous surface

To activate simply pull out the base from contact face

Available with or without fine adjustment fitting



MMS/1 &gt;

MMS/DA/4&gt;

Fine adjustment knob

MMS/DA/5&gt;

## Ordering Information

| Cat. Nr. | Ordering Nr. | Base Diameter |    | Base Height |    | Spindle Mounting Threads | Magnetic Pull (Approx.) |
|----------|--------------|---------------|----|-------------|----|--------------------------|-------------------------|
|          |              | Inch          | mm | Inch        | mm |                          |                         |
| MMS/1    | 03402        | 1-1/8         | 28 | 1           | 25 | M6 x 1                   | 5 kg (11 lbs)           |
| MMS/DA/4 | 03403        | 1-1/8         | 28 | 1           | 25 | M6 x 1                   | 5 kg (11 lbs)           |
| MMS/DA/5 | 03404        | 1-3/8         | 35 | 1-3/16      | 30 | M6 x 1                   | 13 kg (28.6 lbs)        |

## 43 STEPPED ANGLE PLATES

STP-3

STP-4

STP-6

ESP Base angular escalonda    FR Équerres de montage Etagée    DE Getretene Winkelplatten

Manufactured from a single piece of hardened tool steel, these angle plates are precision ground, square and parallel

A convenient step of 1-1/4" (32 mm) down from the top and a 1/2" (12 mm) seat for use with smaller work pieces

Presence of 24 tapped holes allows for fastening to fixtures and clamping work to the angle plate

An indispensable device for accurate work in tool rooms and in small production jobs for checking flatness, squareness and parallelism



#### Technical Information

Flatness of working faces  
Within 0.0002" (5 microns)

Squareness of exterior  
faces over height  
Within 0.0004" (10 microns)

Parallelism of opposite faces  
& edges over their length  
Within 0.0002" (5 microns)

Squareness of end faces with  
respect to exterior faces as  
measured over length  
Within 0.0004" (10 microns)

#### Ordering Information

| Cat. Nr. | Ordering Nr. | Size      |                 | Thread specs. of tapped holes |
|----------|--------------|-----------|-----------------|-------------------------------|
|          |              | Inch      | mm              |                               |
| STP/3    | 02400        | 3 x 3 x 3 | 75 x 75 x 75    | 1/4" BSW                      |
| u STP/4  | 02401        | 4 x 4 x 4 | 100 x 100 x 100 | 5/16" BSW                     |
| l STP/6  | 02402        | 6 x 6 x 6 | 150 x 150 x 150 | 3/8" BSW                      |

u BESTSELLER | NEW SIZE

Stepped angle plate makes a convenient reference tool in machining operations as the tapped holes allow fixtures to be bolted conveniently



## 44 SINE BARS

SNB

ESP Barra Del Seno    FR Règles Sinus    DE Sinus - Lineale

Sine Bars are used in conjunction with a gauge block or an adjustable parallel to attain the required height and to set up angles for layout and inspection purposes

Manufactured from Tool Steel, these are precisely hardened 58-62 HRC and ground for extreme accuracy in use. Edges are chamfered 0.5 x 45° for convenient handling and the supplied with a back plate

These are available in two types:

**Sine Bars**

**Sine Bars - Magnetic** with two magnets to ensure firm placement on ferrous surfaces

Sine Bar  
Magnetic

SineBar

**Ordering Information**

| Cat Nr.                     | Ordering Nr. | Center to Center Distance | Diameter of Rollers | Center Distance Accuracy | Parallelism |
|-----------------------------|--------------|---------------------------|---------------------|--------------------------|-------------|
| <b>Sine Bars</b>            |              |                           |                     |                          |             |
| SNB/2-1-2                   | 02112        | 2-1/2"                    | 5/8"                | ±0.0002"                 | 0.0001"     |
| SNB/5/SPL                   | 02111        | 5"                        | 5/8"                | ±0.0002"                 | 0.0001"     |
| <b>Sine Bars - Magnetic</b> |              |                           |                     |                          |             |
| SNB/MG/2                    | 02115        | 2"                        | 3/8"                | ±0.0002"                 | 0.0001"     |

## 45 SINE PLATES

SNPL

ESP Bases del seno FR Base-Sinus DE Sinus-base

Sine Plates are used as bases to which Vices, Magnetic Chucks, Angle Plates and Vee Blocks can be conveniently bolted. These are used as an inspection tool and in machining, drilling or grinding jobs

Manufactured from tool steel these are accurately hardened 54 - 58 HRC and ground square and parallel

These are available in two types:

**Standard Sine Plates**  
**Compound Angle Sine Plates:**  
 Help in setting up angles front - to back or side-to-side and a combination for true compound angles



&lt; Standard Sine Plate



Compound Angle Sine Plate &gt;

## Technical Information

Squarness and Parallelism | Within 0.0004" (10 microns)  
 Center to Center Distance | Within 0.0004" (10 microns)

## Ordering Information

| Cat. Nr.                          | Ordering Nr. | Center to Center distance (Inch) | Sine System | Plate Dimensions |              |               | Tapped Holes |
|-----------------------------------|--------------|----------------------------------|-------------|------------------|--------------|---------------|--------------|
|                                   |              |                                  |             | Length (inch)    | Width (inch) | Height (inch) |              |
| <b>Standard Sine Plates</b>       |              |                                  |             |                  |              |               |              |
| SNPL/3                            | 02133        | 3                                | 0           | 4                | 4            | 2             | 1/4" - 20    |
| u SNPL/5                          | 02120        | 5                                | 1           | 6                | 6            | 2             | 1/4" - 20    |
| SNPL/5A                           | 02134        | 5                                | 2           | 12               | 6            | 2-5/8         | 3/8" - 16    |
| SNPL/10A                          | 02131        | 10                               | 2           | 12               | 12           | 2-5/8         | 3/8" - 16    |
| SNPL/10B                          | 02132        | 10                               | 2           | 12               | 6            | 2-5/8         | 3/8" - 16    |
| <b>Compound Angle Sine Plates</b> |              |                                  |             |                  |              |               |              |
| SNPL/C/5                          | 02121        | 5 & 5                            | 1           | 6                | 6            | 3-1/8         | 1/4" - 20    |

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## 46 SURFACE PLATES

No. 026

ESP Marmol para trazador FR Marbre en fonte aciéré DE Oberflächenplatte

**Acc BS 817 Grade 3**

Manufactured from high quality close grained cast iron, these plates have thick solid top surfaces, strong heavy skirts and diagonal cross-ribbed webbing on the underside which results in high rigidity and minimum deflection

Linear measurements depend on an accurate reference surface from which final dimensions are taken

These hand scraped finished surface plates provide the reference plane for work in inspection and layout

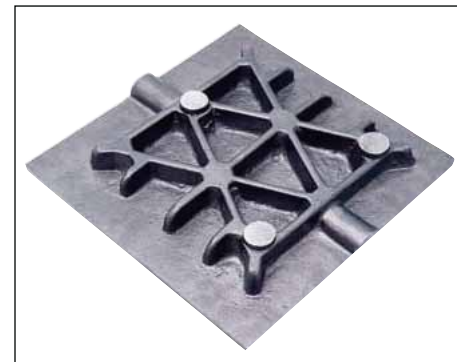
High degree of flatness, overall quality and workmanship make them ideal bases for mounting of mechanical, electronic and optical gauging systems

**Technical Information**

Flatness Within 0.0008" (20 microns)

**Ordering Information**

| Cat. Nr.       | Ordering Nr. | Length |     | Width |     | Overall Height (nominal) |    |
|----------------|--------------|--------|-----|-------|-----|--------------------------|----|
|                |              | Inch   | mm  | Inch  | mm  | Inch                     | mm |
| SFP/200-200-50 | 02600        | 8      | 200 | 8     | 200 | 2                        | 50 |
| SFP/250-250-50 | 02601        | 10     | 250 | 10    | 250 | 2                        | 50 |
| SFP/300-300-55 | 02603        | 12     | 300 | 12    | 300 | 2-11/64                  | 55 |
| SFP/400-400-55 | 02605        | 16     | 400 | 16    | 400 | 2-11/64                  | 55 |
| SFP/450-450-65 | 02607        | 18     | 450 | 18    | 450 | 2-9/16                   | 65 |
| SFP/300-200-50 | 02602        | 12     | 300 | 8     | 200 | 2                        | 50 |
| SFP/400-300-50 | 02604        | 16     | 400 | 12    | 300 | 2                        | 50 |
| SFP/500-400-50 | 02608        | 20     | 500 | 16    | 400 | 2                        | 50 |
| SFP/600-400-50 | 02609        | 24     | 600 | 16    | 400 | 2                        | 50 |
| SFP/450-300-50 | 02606        | 18     | 450 | 12    | 300 | 2                        | 50 |
| SFP/600-450-65 | 02610        | 24     | 600 | 18    | 450 | 2-9/16                   | 65 |
| SFP/600-600-85 | 02611        | 24     | 600 | 24    | 600 | 3-11/32                  | 85 |



Diagonal cross-ribbed webbing on the underside for maximum rigidity & minimum deflection

## 47 HAND SCRAPERS

No. 146

ESP Rasqueteador FR Grattoir DE Ingenieur Schaber

This range of hand scrapers has been designed for removing high spots on machined surfaces for smooth and even surface on slideways, bearings, cast iron surface plates and precision marking out plates

Manufactured from selected steel these are hardened 55-60HRC and lightly tempered for lasting durability

All sizes have round wooden handle for comfortable grip during use

These find a wide variety of applications in tool rooms for small engineering jobs

Available in 3 types:

**Triangular,  
Half Round and  
Flat**



Triangular



Triangular with grooved blade



Half Round



Flat

## Ordering Information

| Cat. Nr.     | Ordering Nr. | Length |     | Type                          |
|--------------|--------------|--------|-----|-------------------------------|
|              |              | Inch   | mm  |                               |
| I ES/F/3     | 14641        | 3      | 75  | Flat                          |
| I ES/HR/3    | 14642        | 3      | 75  | Half Round                    |
| I ES/T/3     | 14643        | 3      | 75  | Triangular                    |
| I ES/T-3/SPL | 14609        | 3      | 75  | Triangular with grooved blade |
| u ES/F/4     | 14600        | 4      | 100 | Flat                          |
| u ES/HR/4    | 14601        | 4      | 100 | Half Round                    |
| ES/T/4       | 14602        | 4      | 100 | Triangular                    |
| ES/F/6       | 14603        | 6      | 150 | Flat                          |
| ES/HR/6      | 14604        | 6      | 150 | Half Round                    |
| u ES/T/6     | 14605        | 6      | 150 | Triangular                    |
| ES/F/8       | 14606        | 8      | 200 | Flat                          |
| ES/HR/8      | 14607        | 8      | 200 | Half Round                    |
| ES/T/8       | 14608        | 8      | 200 | Triangular                    |
| I ES/F/10    | 14643        | 10     | 250 | Flat                          |
| I ES/HR/10   | 14644        | 10     | 250 | Half Round                    |
| I ES/T/10    | 14645        | 10     | 250 | Triangular                    |

u BESTSELLER | NEW SIZES

## 48 PARALLEL CLAMPS

No. 356

ESP Tornillo de apriete    FR Presses À serrage parallèle    DE Parallel-Schraubzwingen

Manufactured from case hardened steel 45 ± .5HRC. Parallel Clamps are designed for maximum strength and rigidity

All sizes are equipped with a spring clip

A retaining ring holds the loose jaw in alignment when the clamp is being opened or closed. The ends of the jaws are rounded to permit clamping under shoulders or in recesses

These clamps are extremely useful for holding work together in tapping, drilling and on various machine set ups



## Ordering Information

| Cat. Nr. | Ordering Nr. | Capacity |     | Jaw Length |     |
|----------|--------------|----------|-----|------------|-----|
|          |              | Inch     | mm  | Inch       | mm  |
| u PC/1   | 35601        | 1-1/4    | 30  | 2          | 50  |
| u PC/2   | 35602        | 1-3/4    | 44  | 2-1/2      | 63  |
| u PC/3   | 35603        | 2-1/4    | 56  | 3          | 75  |
| u PC/4   | 35604        | 2-3/4    | 70  | 4          | 100 |
| PC/5     | 35605        | 3-1/2    | 88  | 5          | 125 |
| PC/6     | 35606        | 5        | 125 | 6          | 150 |
| PC/8     | 35608        | 6        | 150 | 8          | 200 |

u **BESTSELLER**



Parallel Clamps being used to hold a job for precisiondrilling operation

## 49 MACHINIST'S JACK

MJ-01

ESP Gato de operario    FR Vérin de table    DE Maschinist Jack

Manufactured from high grade cast steel, the Machinist's Jack has a 1" adjustable screw and tilting swivel head

It finds application on drill presses, milling machines, planers etc. any place where leveling is necessary

Lifting capacity is approximately 1000 lbs (454 kgs)



## Ordering Information

| Cat. Nr. | Ordering Nr. | Range |    |
|----------|--------------|-------|----|
|          |              | Inch  | mm |
| MJ/01    | 14100        | 1     | 25 |

CA 41



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