HOMGE

Quality engineering equipment
enhanced by continual research
and development for long
durability, high accuracy
and efficient operation

QUALITY SYSTEM CERTIFICATION
DNV·GL
ISO 9001

Established in 1978

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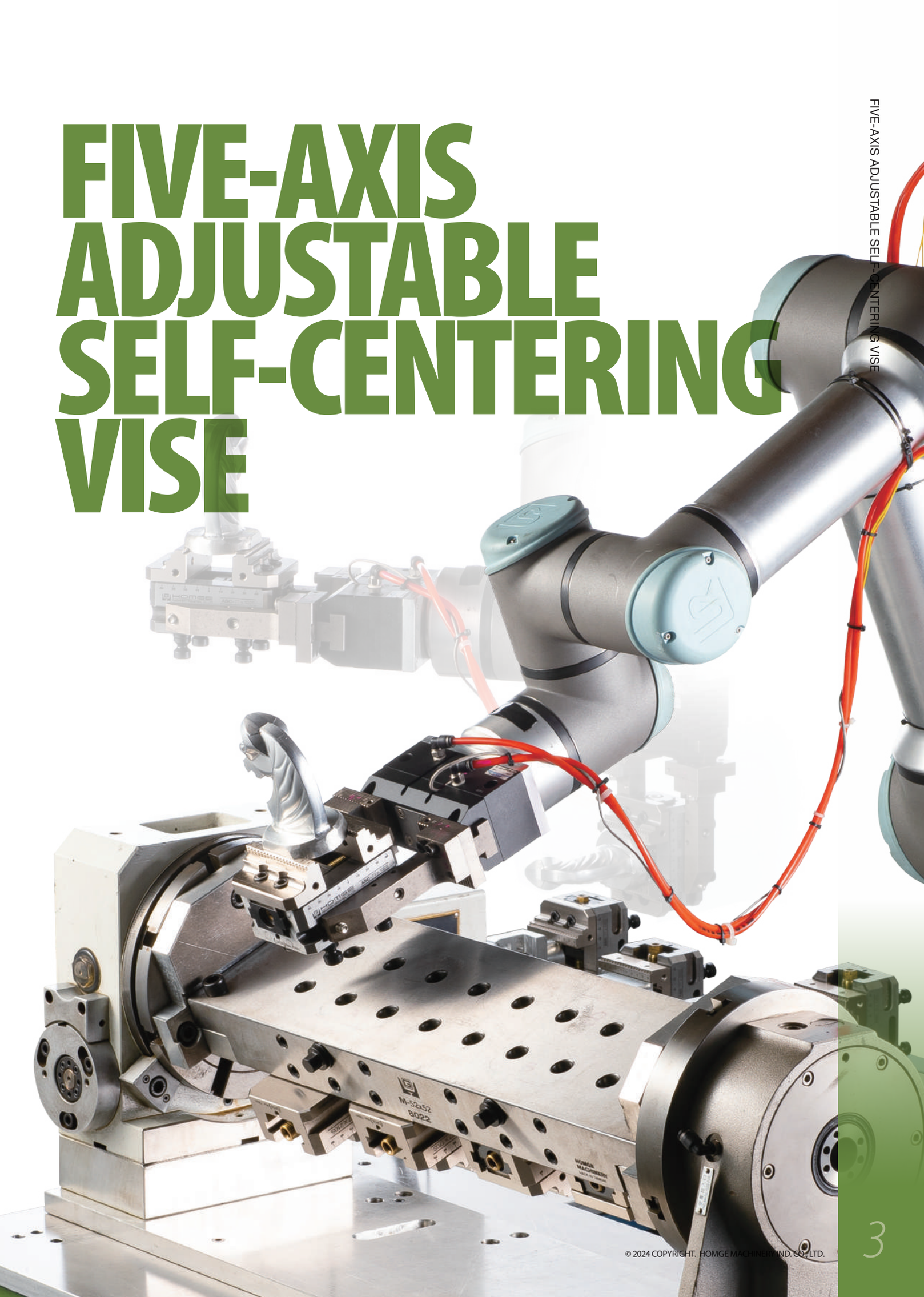
FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE



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FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

Model: ASC-77x102S, 77x130S, 77x170S, 77x210S
ASC-127x160S, 127x210S, 127x260S, 127x310S, 127x360S

- Patented stud bolt seat design can efficiently calibrate the clamping center.
- It is recommended to operate with a Master Plate on a five-axis machine.
- Compatible with Robotic Arms.

ASC-S Series

STANDARD ACCESSORIES:

- 4 pcs of Clamp
- 1 pc of Wrench

1	2	3	4	5
Users can calibrate the clamping center of vise by adjusting the screws on both ends.	Detachable jaws are made of **High quality Tool Steel (SCM440)** and gone through carburizing to achieve **HRC55**. Since both sides are fixed size and able to be used as a datum, users can reverse them to increase clamping range.	The vise's clamping force can achieve **1300KG**, the repeatability positioning precision of its clamping center is within **±0.02mm**.	The **45° dovetail structure with teeth** on the upper jaw ensures the bottom of the workpiece to be firmly clamped.	Vise body is made of **High quality Steel (S50C)** and its slideways gone through high-frequency hardening to achieve **HRC50**, which makes the whole part durable.

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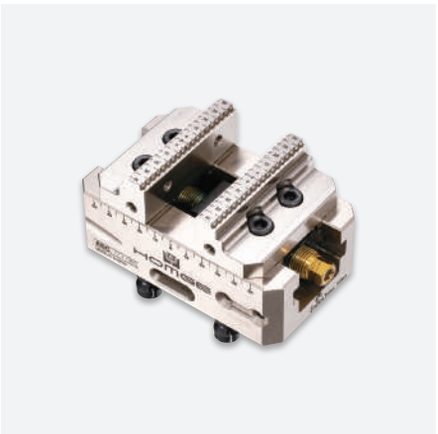
ASC-S Series

Model: ASC-77x102S, 77x130S, 77x170S, 77x210S
ASC-127x160S, 127x210S, 127x260S, 127x310S, 127x360S

ASC-77x102S

Size	107x77x70 mm
Weight (kg)	2.8



ASC-77x130S

Size	135x77x70 mm
Weight (kg)	3.5

ASC-77x170S

Size	175x77x70 mm
Weight (kg)	4.2

ASC-77x210S

Size	215x77x70 mm
Weight (kg)	4.9

ASC-127x160S

Size	165x127x87 mm
Weight (kg)	9

ASC-127x210S

Size	215x127x87 mm
Weight (kg)	11

ASC-127x260S

Size	265x127x87 mm
Weight (kg)	13

ASC-127x310S

Size	315x127x87 mm
Weight (kg)	15

ASC-127x360S

Size	365x127x87 mm
Weight (kg)	17

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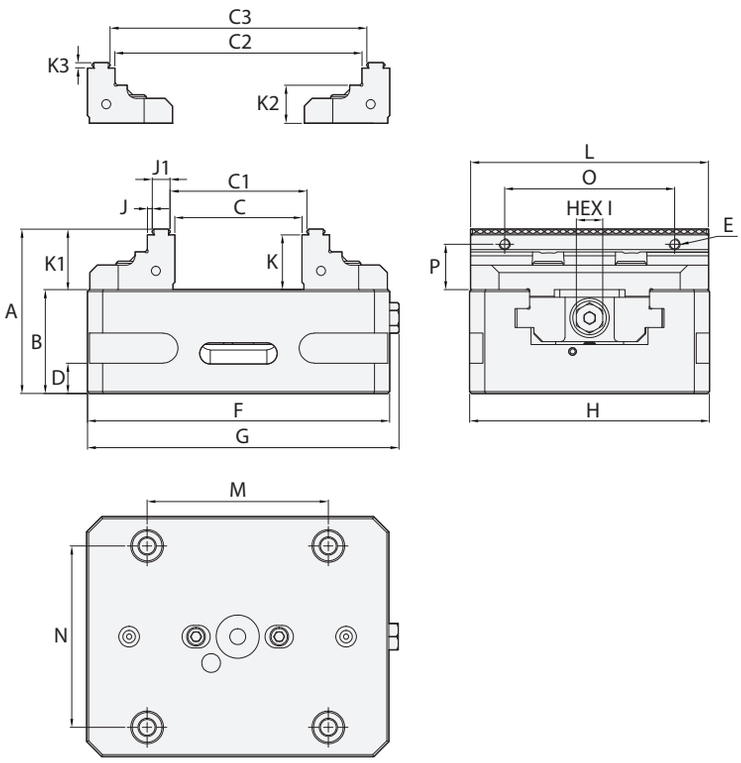
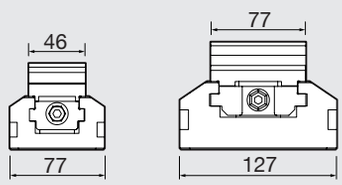


Narrow Version :

The Narrow Version of our Vise Body and Jaw Sets is a solution designed specifically to manage interference problems. All of our ASC-S series models are readily available.



SPECIFICATIONS (Material: Vise body S50C. Hardness: HRC 50/ Detachable Jaws SCM440. Hardness: HRC 55)

Unit: mm

Model	A	B	C	C1	C2	C3	D	E	F	G	H	I	J	J1
ASC- 77X102S	70	43	28	32	75	80	10	M6	102	107	77	12	2	9.5
ASC- 77X130S	70	43	56	60	103	108	-	M6	130	135	77	12	2	9.5
ASC- 77X170S	70	43	96	100	143	148	10	M6	170	175	77	12	2	9.5
ASC- 77X210S	70	43	136	140	183	188	10	M6	210	215	77	12	2	9.5
ASC- 127x160S	87	55	70	75	131	136	16	M6	160	165	127	14	2.5	9.5
ASC- 127x210S	87	55	120	125	181	186	16	M6	210	215	127	14	2.5	9.5
ASC- 127x260S	87	55	170	175	231	236	16	M6	260	265	127	14	2.5	9.5
ASC- 127X310S	87	55	220	225	281	286	16	M6	310	315	127	14	2.5	9.5
ASC- 127X360S	87	55	270	275	331	336	16	M6	360	365	127	14	2.5	9.5

Model	K	K1	K2	K3	L	M	N	O	P	Pull Stud	Weight (kg)
ASC- 77X102S	24	27	18	3	77	52	52	42	15	**M-52x52PS**	2.8
ASC- 77X130S	24	27	18	3	77	52	52	42	15	**M-52x52PS**	3.5
ASC- 77X170S	24	27	18	3	77	52	52	42	15	**M-52x52PS**	4.2
ASC- 77X210S	24	27	18	3	77	52	52	42	15	**M-52x52PS**	4.9
ASC- 127x160S	29	32	20	3	126	96	96	90	24	**M-96x96PS**	9
ASC- 127x210S	29	32	20	3	126	96	96	90	24	**M-96x96PS**	11
ASC- 127x260S	29	32	20	3	126	96	96	90	24	**M-96x96PS**	13
ASC- 127X310S	29	32	20	3	126	96	96	90	24	**M-96x96PS**	15
ASC- 127X360S	29	32	20	3	126	96	96	90	24	**M-96x96PS**	17

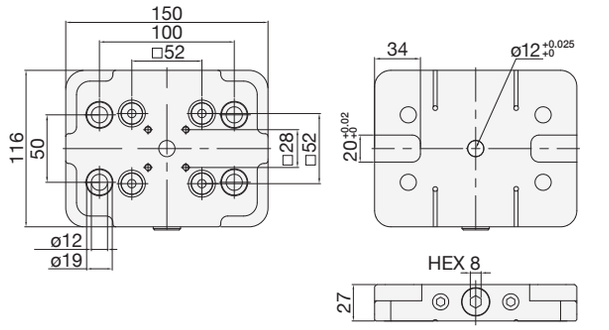
Optional Accessories

Please refer to Page 22~61 Zero Point Quick Change Devices

Rectangular Plate

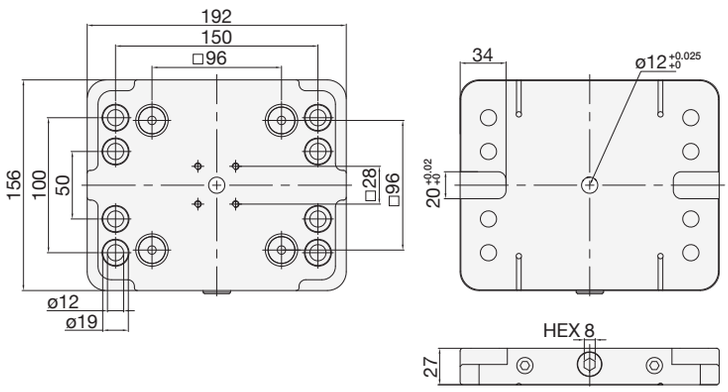
Model: M-52x52 (8001)

- Size: 150x116x27 mm
- Pull Stud: M-52x52PS
- Weight: 3 kg
- Suitable for
  ASC-77x102S
  ASC-77x130S
  ASC-77x170S
  ASC-77x210S



Model: M-96x96 (8051)

- Size: 192x156x27 mm
- Pull Stud: M-96x96PS
- Weight: 5.5 kg
- Suitable for
  ASC-127x160S
  ASC-127x210S
  ASC-127x260S
  ASC-127x310S
  ASC-127x360S



Master Gauging Pallet

Suitable for quick checking the precise alignment of Quick Changing Plates and for concentric alignment of rotary or chucks.

Model: M-52x52 (8010)

- Size: 80x80x27 mm
- Pull Stud: M-52x52PS
- Weight: 1.1 kg

Model: M-96x96 (8058)

- Size :126x126x27 mm
- Pull Stud: M-96x96PS
- Weight: 2.6 kg

Pull Studs

Can be adapted onto vises or workpieces to use together with any Quick Change Device.

Model: M-52x52PS

- 4 pcs / set
- Weight: 0.16 kg / set

Model: M-96x96PS

- 4 pcs / set
- Weight: 0.28 kg / set

Spacer Studs

Improve the machining accessibility of edges or angles by making a through space between workpieces and Quick Change Devices.

Model: M-52x52SS

- 4 pcs / set
- Weight: 0.27 kg / set

Model: M-96x96SS

- 4 pcs / set
- Weight: 0.4 kg / set

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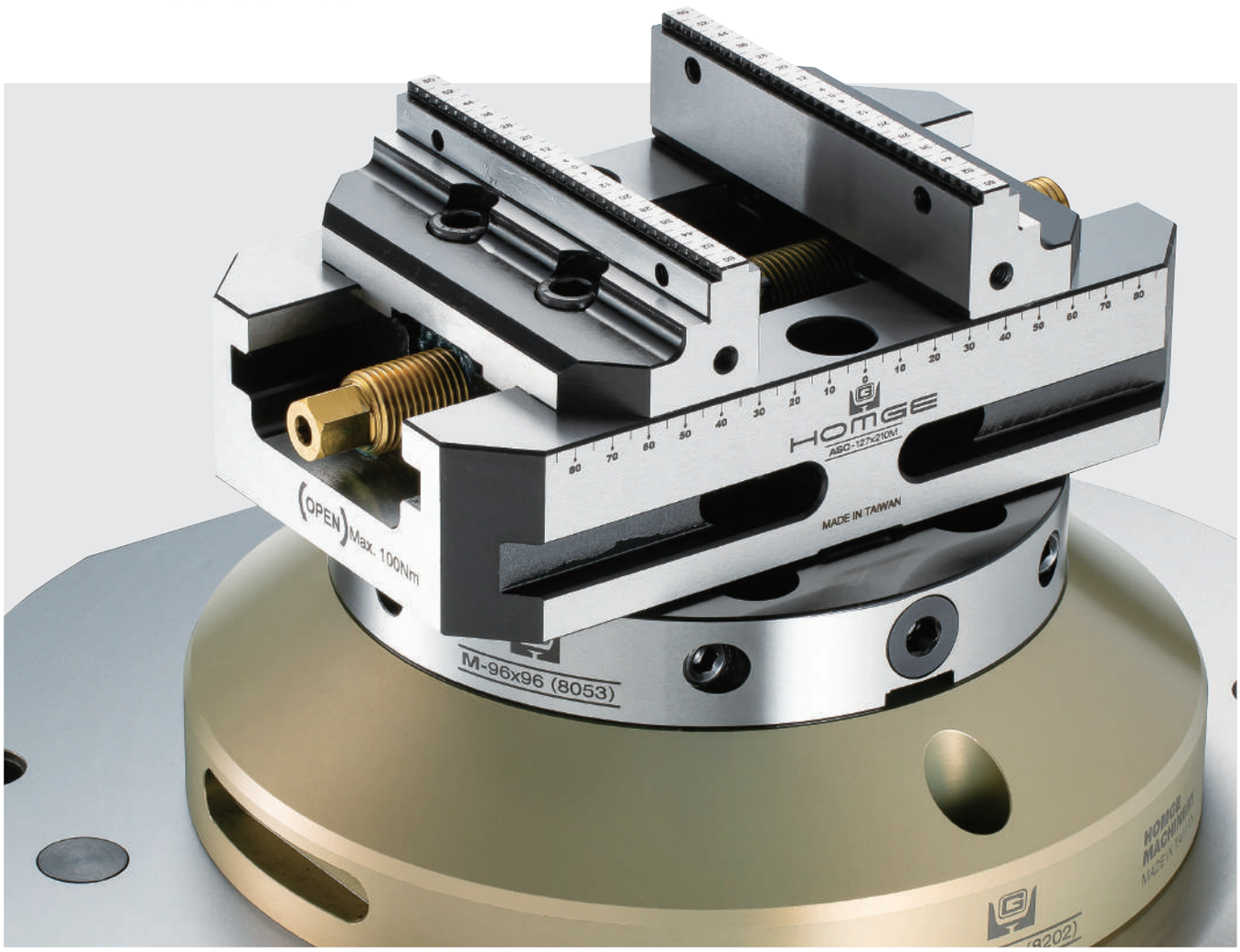
FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

Model: ASC-127x130M, 127x160M, 127x210M, 127x260M, ASC-150x260M



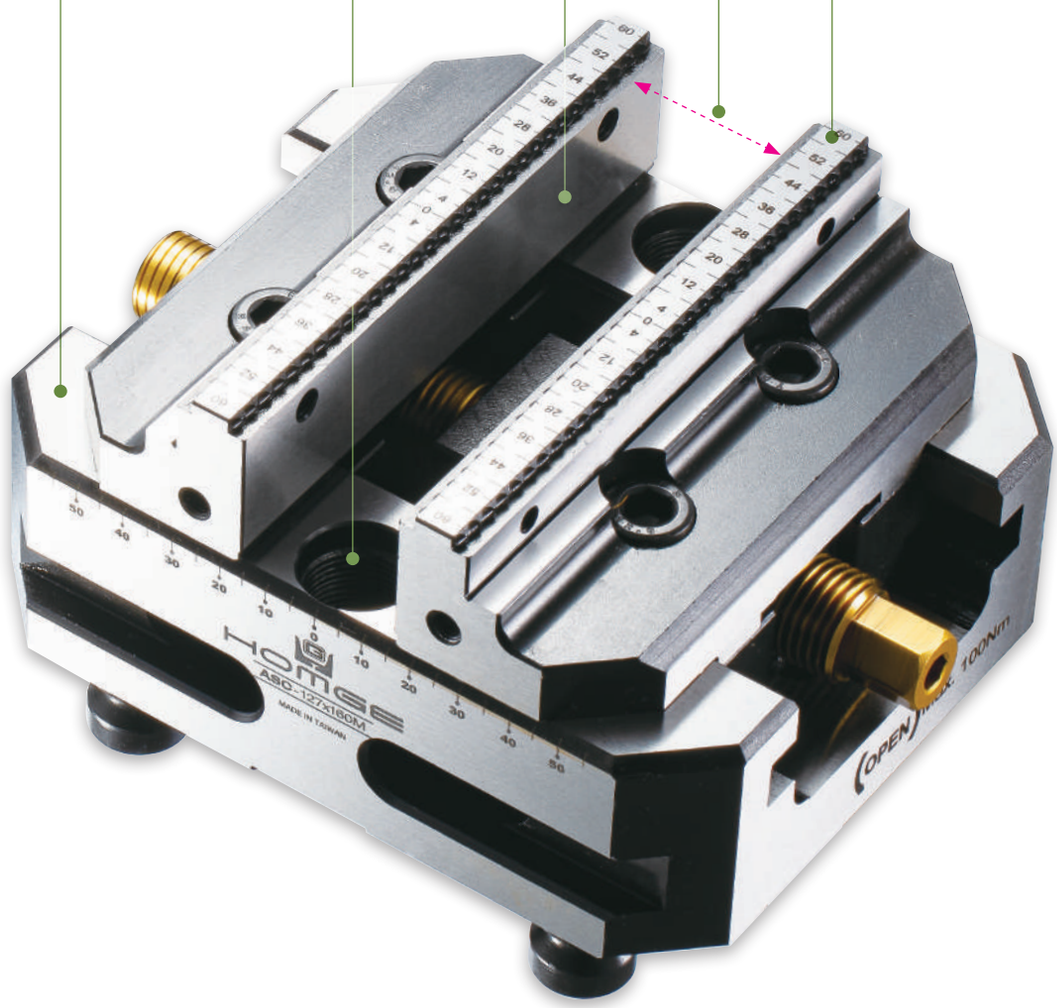
- Special 45° dovetail structure with teeth
- With a pair of mounting holes, ASC-M series can be directly fixed on the 3rd, 4th or 5th-Axis machine bed.
- Purchase an additional Fixed Jaw to enable dual clamping.

ASC-M Series

STANDARD ACCESSORIES:

- 4 pcs of Clamp
- 1 pc of Wrench

1	2	3	4	5
Vise body is made of **High quality Steel (S50C)** and its slideways gone through high-frequency hardening to achieve **HRC50**, which makes the whole part durable.	The vise body can be mounted directly on the machine table by the middle with 2 pieces of M12 screws. This vise also can clamp 2 workpieces by mounting the centre jaw in the middle.	Detachable jaws are made of **High quality Tool Steel (SCM440)** and gone through carburizing to achieve **HRC55**. Since both sides are fixed size and able to be used as a datum, users can reverse them to increase clamping range.	The vise's clamping force can achieve **1300KG**, the repeatability positioning precision of its clamping center is within **±0.02mm**.	The **45° dovetail structure with teeth** on the upper jaw ensures the bottom of the workpiece to be firmly clamped.



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ASC-M Series

Model: ASC-127x130M, 127x160M, 127x210M, 127x260M, ASC-150x260M

ASC-127x130M

Size	135x127x80 mm
Weight (kg)	7.3

ASC-127x160M

Size	165x127x80 mm
Weight (kg)	7.5

ASC-127x210M

Size	215x127x80 mm
Weight (kg)	8.5

ASC-127x260M

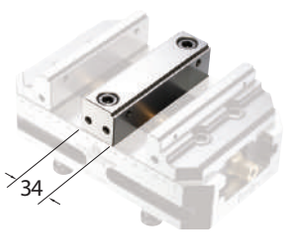
Size	265x127x80 mm
Weight (kg)	10

ASC-150x260M

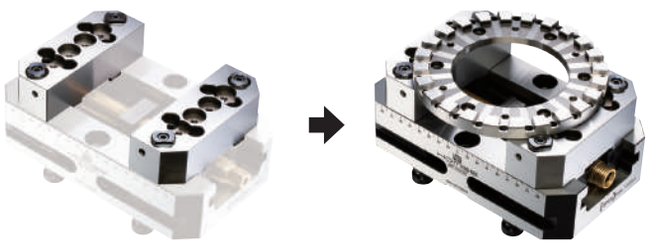
Size	265x150x80 mm
Weight (kg)	13.5

Optional Accessories

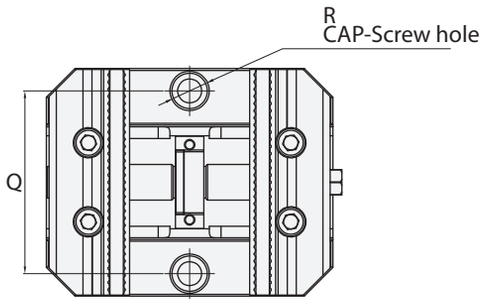
Center Jaw, Flexi Jaws & Soft Jaws

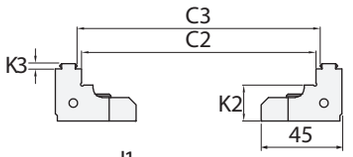


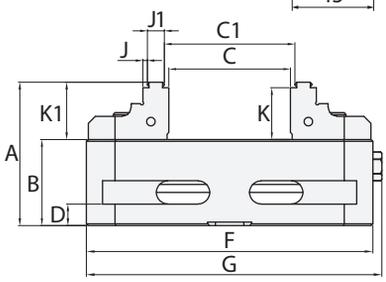
Center Jaw

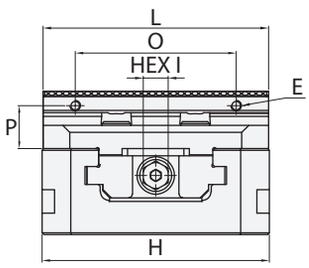


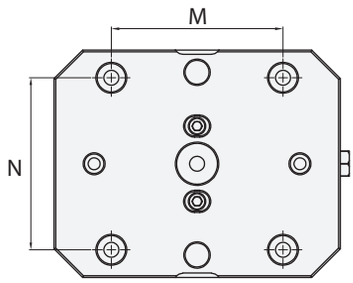
Flexi Jaws











OPTIONAL ACCESSORIES:

- Rectangular Plate
- Master Gauging Pallet
- Pull Studs
- Spacer Studs

Please refer to Page 22~61
Zero Point Quick Change Devices

SPECIFICATIONS (Material: Vise body S50C. Hardness: HRC 50/ Detachable Jaws SCM440. Hardness: HRC 55)

Unit: mm

Model	A	B	C	C1	C2	C3	D	E	F	G	H	I	J	J1
ASC-127x130M	80	48	40	45	101	106	12	M6	130	135	127	14	2.5	9.5
ASC-127x160M	80	48	70	75	131	136	12	M6	160	165	127	14	2.5	9.5
ASC-127x210M	80	48	120	125	181	186	12	M6	210	215	127	14	2.5	9.5
ASC-127x260M	80	48	170	175	231	236	12	M6	260	265	127	14	2.5	9.5
ASC-150x260M	80	48	170	175	231	236	12	M6	260	265	150	14	2.5	9.5

Model	K	K1	K2	K3	L	M	N	O	P	Q	R	Pull Stud	Weight (kg)
ASC-127x130M	29	32	20	3	126	96	96	90	24	102	M12	**M-96x96PS**	7.3
ASC-127x160M	29	32	20	3	126	96	96	90	24	102	M12	**M-96x96PS**	7.5
ASC-127x210M	29	32	20	3	126	96	96	90	24	102	M12	**M-96x96PS**	8.5
ASC-127x260M	29	32	20	3	126	96	96	90	24	102	M12	**M-96x96PS**	10
ASC-150x260M	29	32	20	3	149	96	96	90	24	120	M12	**M-96x96PS**	13.5

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FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

Model: ASC-130x310K
ASC-160x310K

- High rigidity due to reinforced stud bolt seat and hard jaws, suitable for machining large workpieces.
- Applicable to all machine tool models. With the patented center positioning threaded pin, users can regulate clamping center easily and rapidly.
- All ASC-Series Vises are dedicated to consistency in materials and manufacturing processes.

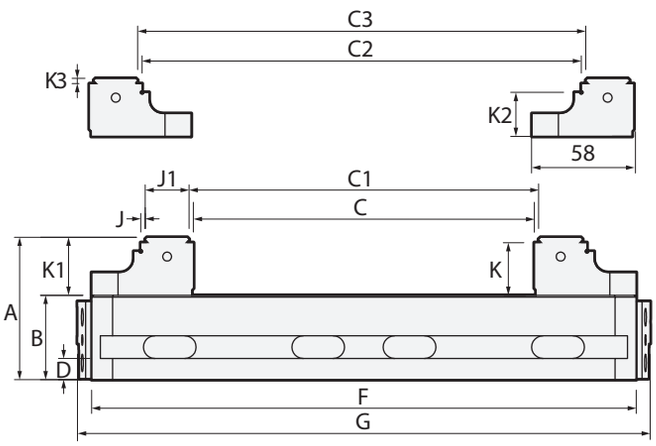
ASC-K Series

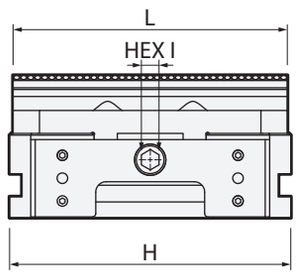
STANDARD ACCESSORIES:

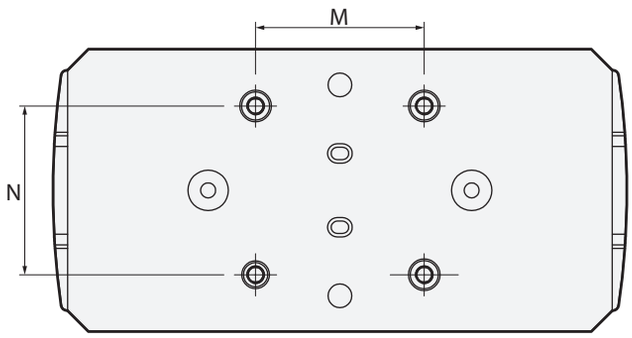
- 4 pcs of Clamp
- 1 pc of Wrench

ASC-130x310K

ASC-160x310K







OPTIONAL ACCESSORIES:

- Rectangular Plate
- Master Gauging Pallet
- Pull Studs
- Spacer Studs

Please refer to Page 22~61
Zero Point Quick Change Devices

SPECIFICATIONS (Material: Vise body S50C. Hardness: HRC 50/ Detachable Jaws SCM440. Hardness: HRC 55)

Unit: mm

Model	A	B	C	C1	C2	C3	D	F	G	H	I	J
ASC-130x310K	81	48	194	199	250	255	12	310	326	130	10	2.5
ASC-160x310K	81	48	194	199	250	255	12	310	326	160	10	2.5

Model	J1	K	K1	K2	K3	L	M	N	Pull Stud	Weight (kg)
ASC-130x310K	25	30	33	25	3	126	96	96	**M-96x96PS**	13.6
ASC-160x310K	25	30	33	25	3	156	96	96	**M-96x96PS**	17.4

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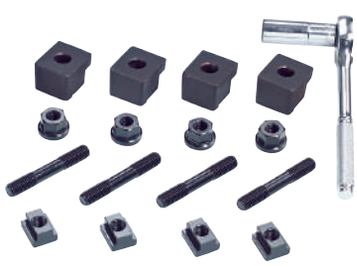
FIVE-AXIS COMPACT MULTI-POWER VISE

Model: ACM-130, 160

- Suitable for CNC 5-Axis Machining Centers, horizontal and vertical CNC Machining Centers
- Shortest Length with **Big Jaw Opening**
- Extremely High Accuracy and Repeatability
- Special MULTI-POWER design enhances clamping force of **0~5000KG**



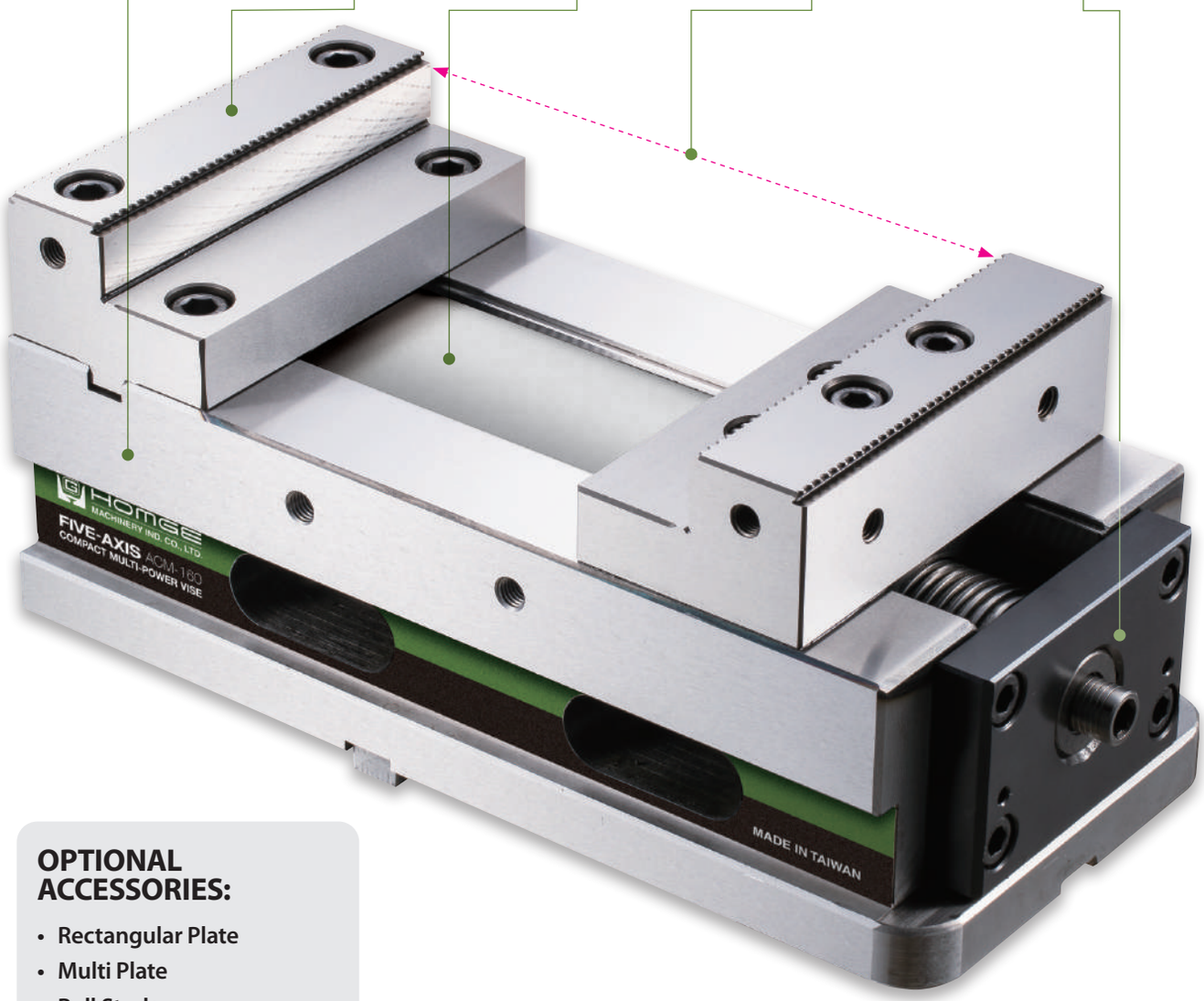
STANDARD ACCESSORIES:

- 2 pcs of Alignment Wedge
- 4 pcs of Clamp
- 1 pc of Wrench

OPTIONAL ACCESSORIES:

- Serrated Jaws
- Soft Jaws

1	2	3	4	5
Vise body is made of **Ductile Iron** above **FCD 60** grade and its slideways are **hardened** to **HRC 52**, which increase the tensile strength of the vise to ensure clamping accuracy.	Vise jaws are made of **High quality Tool Steel (SCM440)** and Hardened to achieve **HRC 55**, which makes vise clamp the workpieces easily and firmly.	Special Leadscrew Covers protect Leadscrew from swarf and avoid any possible damage to internal parts.	Compact design with **big jaw opening**, which enhances machine space utilization.	Constructed from High Grade **BEARING STEEL**, the patented **MULTIPOWER SYSTEM** doubles the clamping force of the vise, offering a clamping force range of **0 to 5000kg** . Additionally, this system guarantees a consistent application of pressure, effectively eliminating concerns related to oil leakage commonly associated with hydraulic vises.



OPTIONAL ACCESSORIES:

- Rectangular Plate
- Multi Plate
- Pull Studs
- Spacer Studs

Please refer to Page 22~61
Zero Point Quick Change Devices

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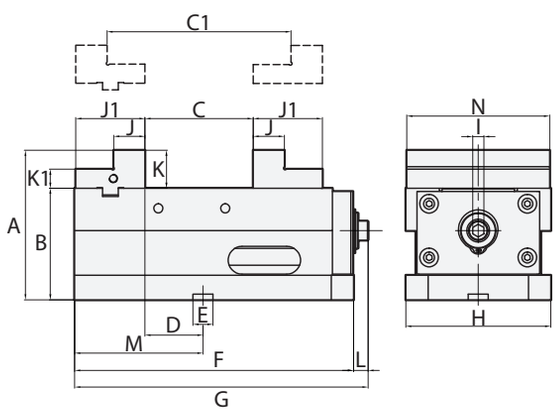
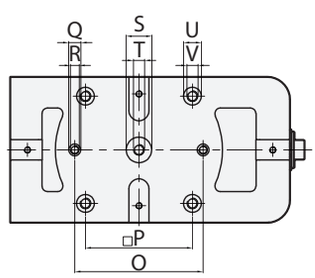
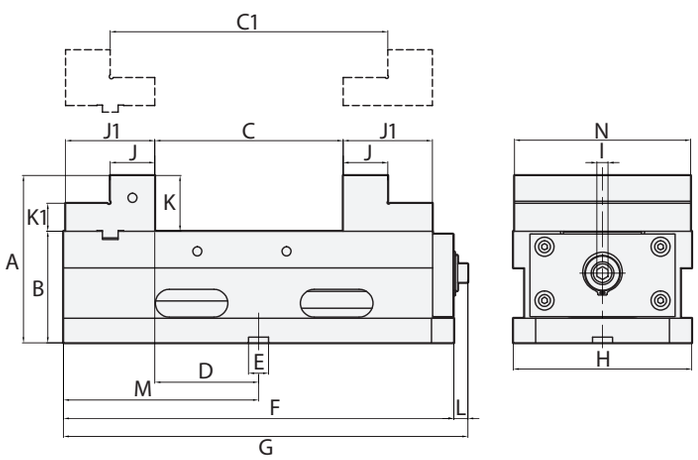
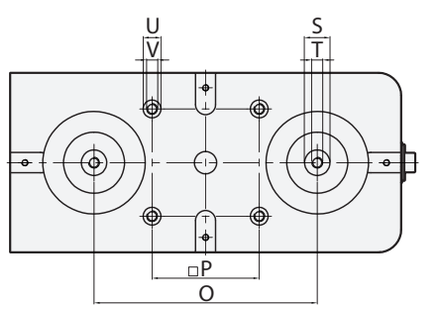
ACM-130

ACM-160









SPECIFICATIONS (Material: Vise body S50C: HRC 50 / Jaws SCM440: HRC 55)

Unit: mm

Model	A	B	C	C1	D	E	F	G	H	I	J	J1	K	K1	L	M	N	O	P
ACM-130	134	100	105	173	52	18	250	263	130	10	28	62	34	17	13	115	128	115	96
ACM-160	150	100	167	247	93	18	350	363	160	10	40	80	50	25	13	175	158	200	96

Model	Q	R	S	T	U	V	Max. Clamping Force	Weight (kg)
ACM-130	ø11H7	M8x1.25P	ø23H7	M10x1.5P	ø16H7	M10x1.5P	**5000kg**	22
ACM-160	-	-	ø23H7	M10x1.5P	ø16H7	M10x1.5P	**5000kg**	40

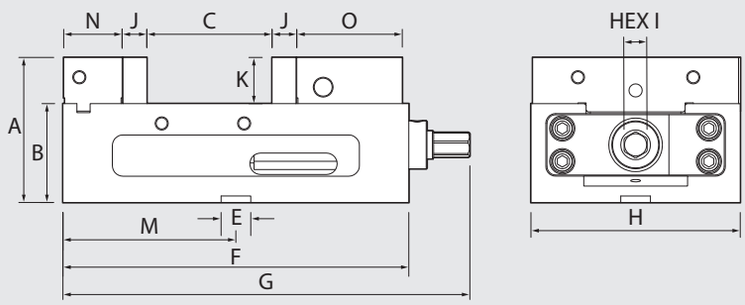
FIVE-AXIS COMPACT VISE

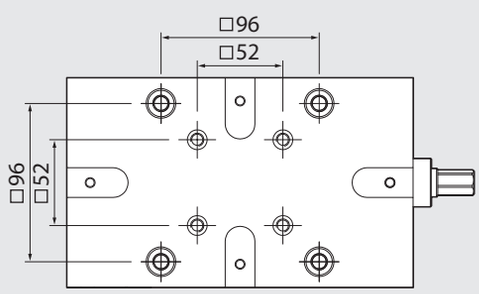
Model: ACK-127x160, 127x210

- Clamps in a single direction, ensuring repeatable positioning precision within **±0.01mm**.
- Integrates with 52/96 zero point quick change devices, enhancing workflow.
- Special **Angle-Lock System** automatically pulls the workpiece down to the accurate position.
- Suitable for precision four- and five-axis CNC machine tools, indexing tables, all kinds of vertical or horizontal machining centers.

OPTIONAL ACCESSORIES:

- Serrated Jaws
- Soft Jaws





SPECIFICATIONS (Material: Vise body S50C. Hardness: HRC 50 / Jaws SCM440. Hardness: HRC 55)

Unit: mm

Model	A	B	C	C1	E	F	G	H	I
ACK-127x160	88	60±0.01	29.5	31	18	160	193	127	14
ACK-127X210	88	60±0.01	79.5	81	18	210	247	127	14

Model	J	K	M	N	O	Pull Stud	Weight (kg)
ACK-127x160	15	28	80	35.5	64	M-52x52PS M-96x96PS	10.4
ACK-127X210	15	28	105	35.5	64	M-52x52PS M-96x96PS	12

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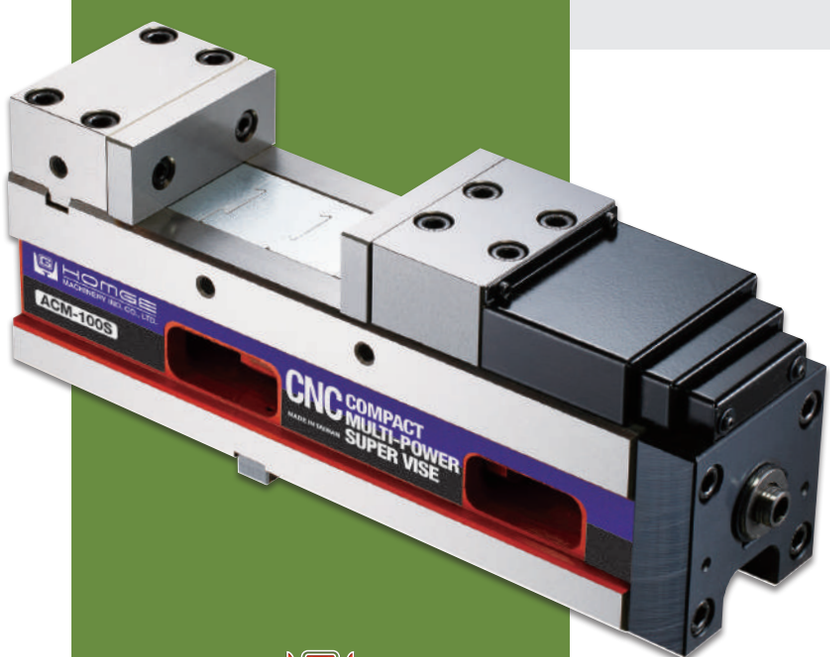
CNC COMPACT MULTI-POWER SUPER VISE

Model: ACM-100S, 160S

- Shortest Vise Body
- Big Jaw Opening
- Compact Multi-Power System clamping force
  0-5000 kg

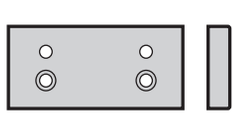


STANDARD ACCESSORIES:

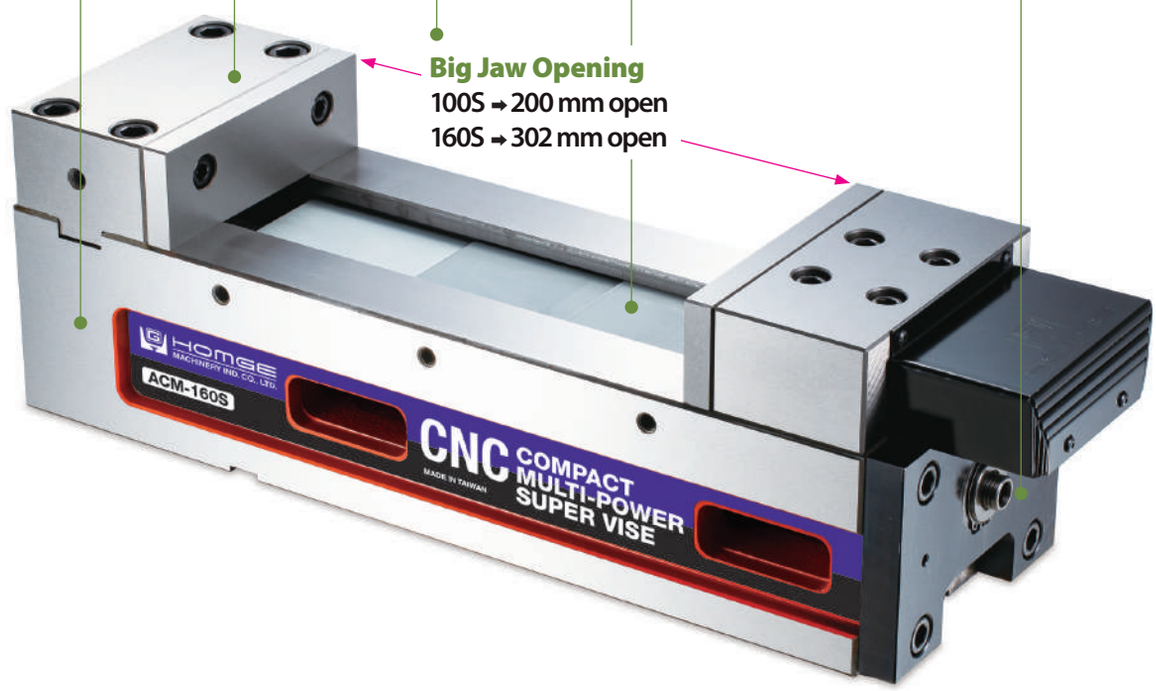
- 2 pcs of Alignment Wedge
- 4 pcs of Clamp
- 1 pc of Wrench

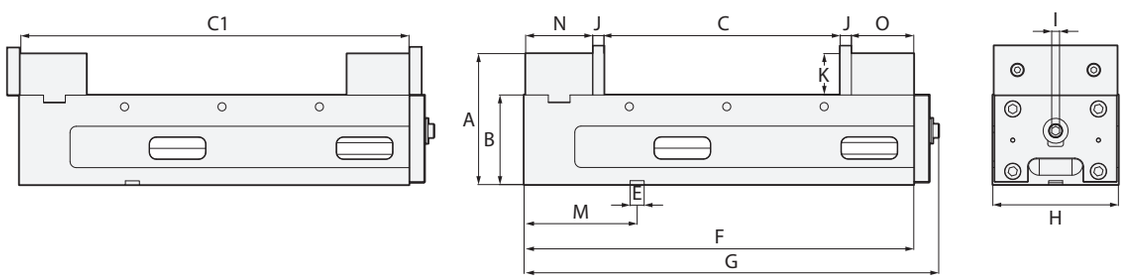
OPTIONAL ACCESSORIES:

- Front / Back Jaws



1	2	3	4	5
Vise body is made of **Ductile Iron** above **FCD 60** grade and its slideways are **hardened** to **HRC 50**, which make the vise tensile strength with high precision accuracy.	Vise jaws are made of **High Quality Tool Steel (SCM440)** and Hardened to achieve **HRC 50**, which makes vise clamp the workpieces easily and firmly.	**Compact design** with **big jaw opening**, which enhances machine space utilization. Suitable for all kinds of horizontal and vertical CNC Machining Centers, also Tapping Centers.	Special Leadscrew Covers protect **Leadscrew** from swarf and avoid any possible damage to internal parts.	Constructed from High Grade **BEARING STEEL**, the patented **MULTIPOWER SYSTEM** doubles the clamping force of the vise, offering a clamping force range of **0 to 5000kg** . Additionally, this system guarantees a consistent application of pressure, effectively eliminating concerns related to oil leakage commonly associated with hydraulic vises.





SPECIFICATIONS (Material: Vise body: Ductile Iron FCD 60. HRC 50 / Fixed Jaw & Moveable Jaw: S50C. HRC 50)

Unit: mm

Model	A	B	C	C1	E	F	G	H	I	J	K	M	N	O	Max. Clamping Force	Weight (kg)
ACM-100S	140	100±0.01	**200**	350	18	352	**392**	100	10	15	40	145	60	62	**4000**	31
ACM-160S	168	115±0.01	**302**	498	18	500	**532**	161	10	15	53	145	86	80	**5000**	63

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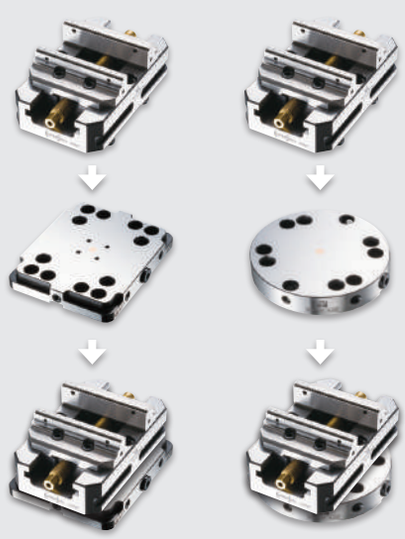
ZERO POINT QUICK CHANGE DEVICES

Quick Change Device and its accessories (including Base Plate, Adapter Plate 52/96, Column, Riser Block, Multi Plate, Clamping Bridge, etc.) are highly modular, and their combination can satisfy different machine tools, fixtures and processes

- Installing Quick Change Device can greatly save the positioning time of the fixture during change over
- Installing Quick Change Device in the entire production line can effectively reduce the accumulated tolerance
- Fixtures can be rotated 90 degrees while maintaining centering accuracy
- Support common stud specifications in the market (52/ 96 mm bolt distance)
- Various specifications for flexible configuration, especially suitable for 4, 5-axis machine tool with limited bed space



Base Plate

Base plate is made of High quality Steel (S50C) with heat treatment to HRC 46, then grounded precisely to ensure the durability and accuracy.

Repeatability: < 0.008 mm.
Pull stud spacing: 52mm or 96mm

1. Mechanical clamping with a screw or fast actuation system
2. 4xM5 threads are used as positioning support for vises
3. Ø12 mm for concentrical alignment and 20 mm keyways for axial alignment
4. A flexible positioning solution for vertical and horizontal machining centers. Suitable for using on 3- and 5-axis machine tables and 4th axis rotary or trunnion systems.

FRONT

BACK

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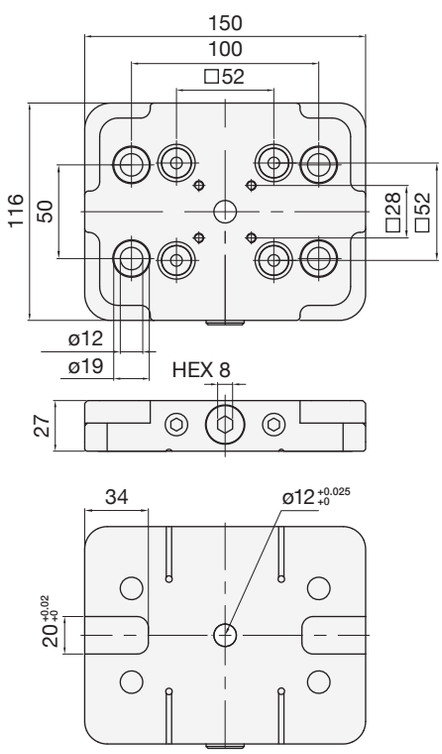
Rectangular Plate

with clamping edge & mounting bores

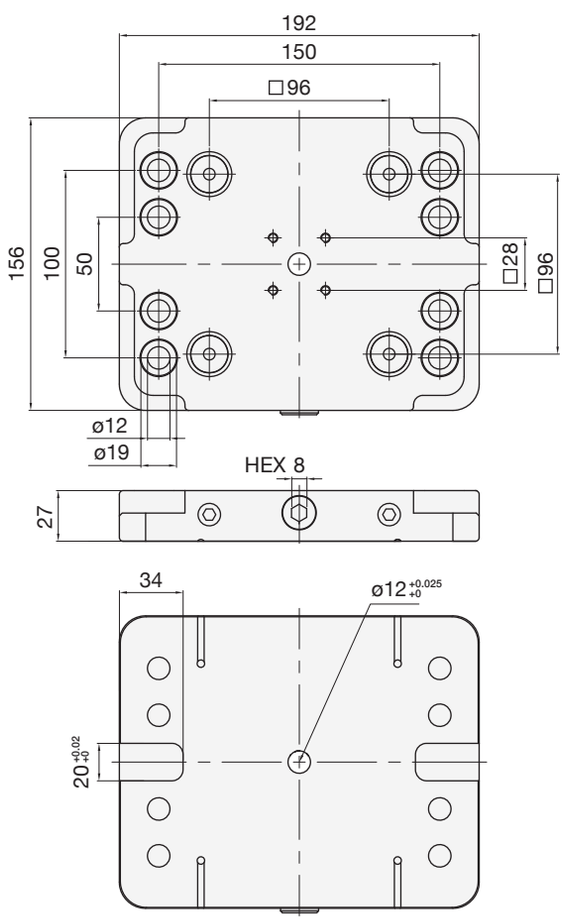
M-52x52 (8001)

Size	150x116x27 mm
Pull Stud No.	M-52x52PS
Mounting Holes	100x50 mm
Weight (kg)	3



M-96x96 (8051)

Size	192x156x27 mm
Pull Stud No.	M-96x96PS
Mounting Holes	150x50/100 mm
Weight (kg)	5.5



Rectangular Plate

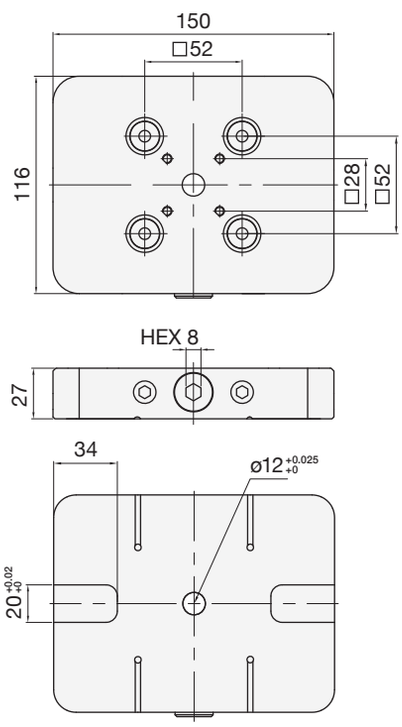
without clamping edge & mounting bores

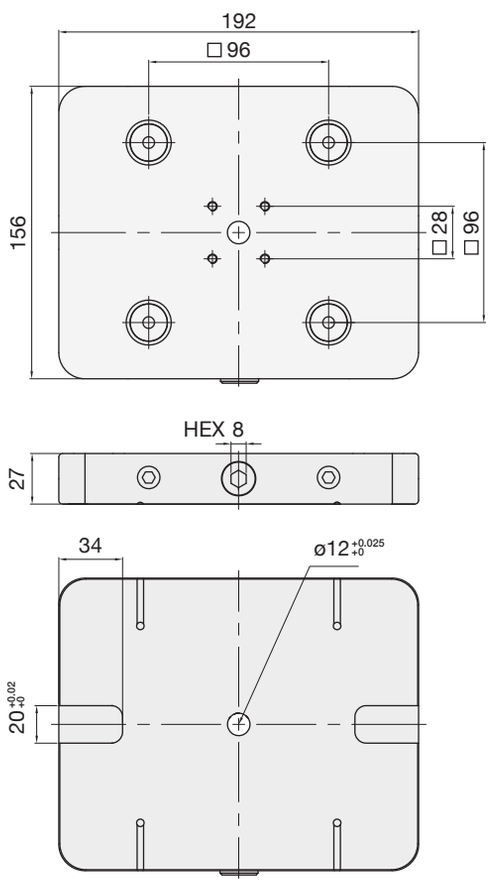
M-52x52 (8002)

Size	150x116x27 mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	3.3

M-96x96 (8052)

Size	192x156x27 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	5.8





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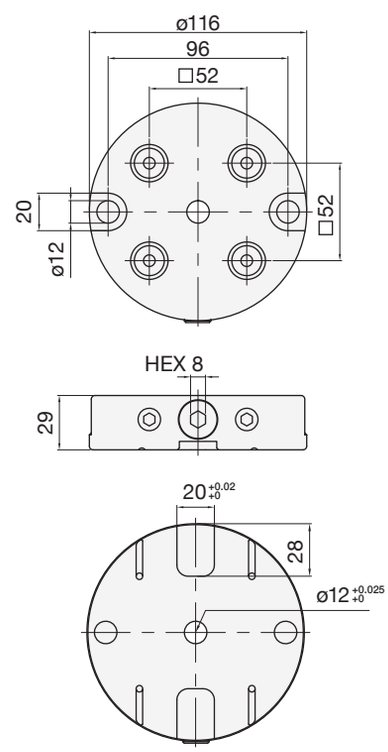
Round Plate

with clamping edge & mounting bores

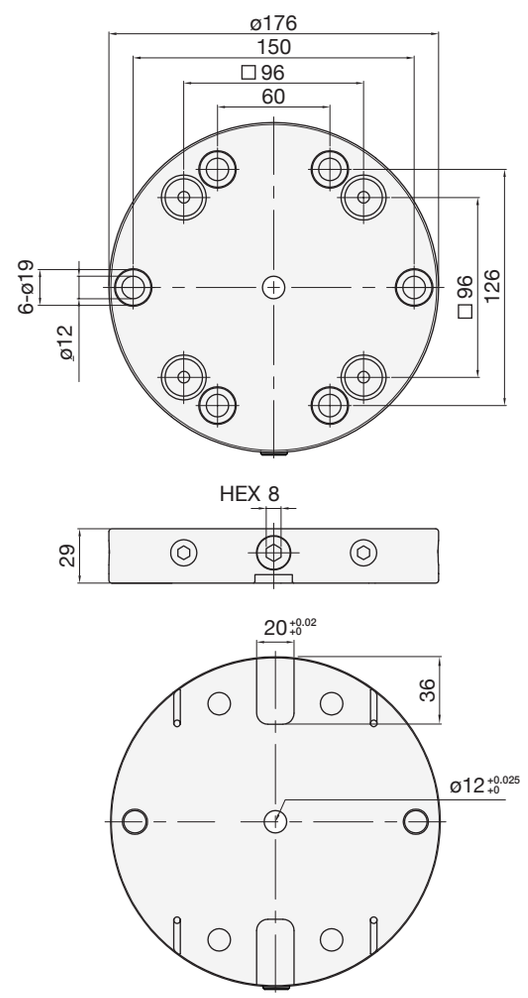
M-52x52 (8004)

Size	ø116x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	96 mm
Weight (kg)	2



M-96x96 (8053)

Size	ø176x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	150 mm / 60x126 mm
Weight (kg)	5



Round Plate

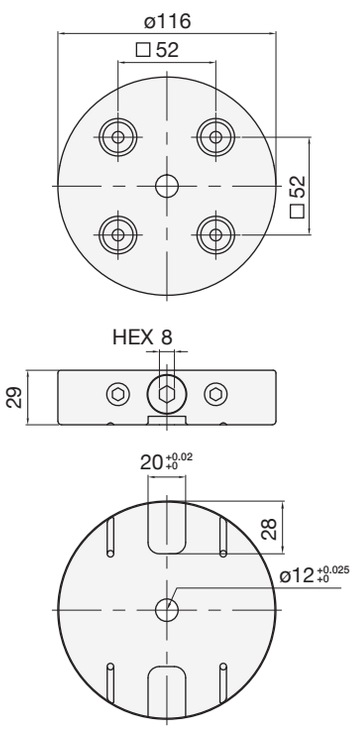
without clamping edge & mounting bores

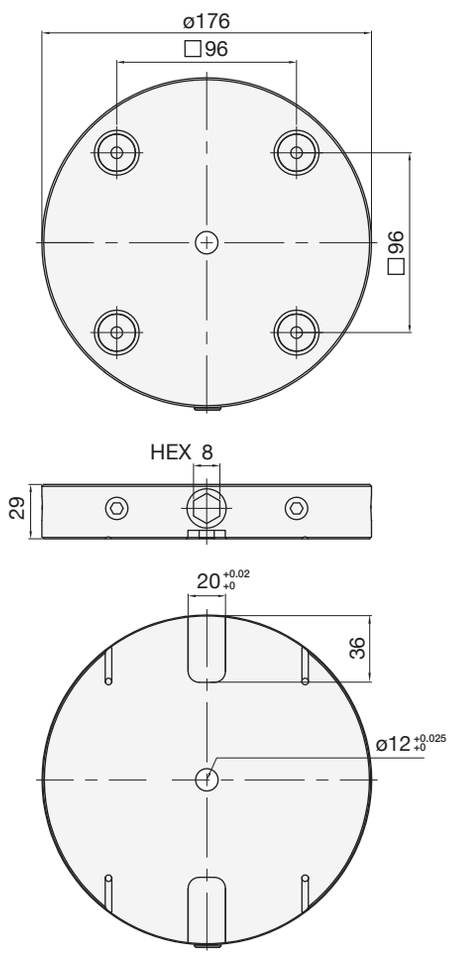
M-52x52 (8005)

Size	ø116x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	2.2

M-96x96 (8054)

Size	ø176x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	5.5





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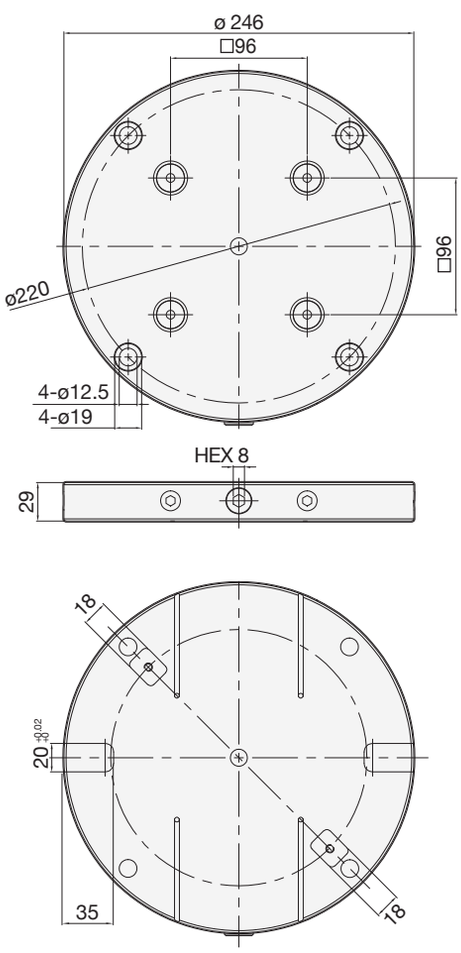
Round Plate

with mounting bores for tables with 90° grooves

M-96x96 (8057)

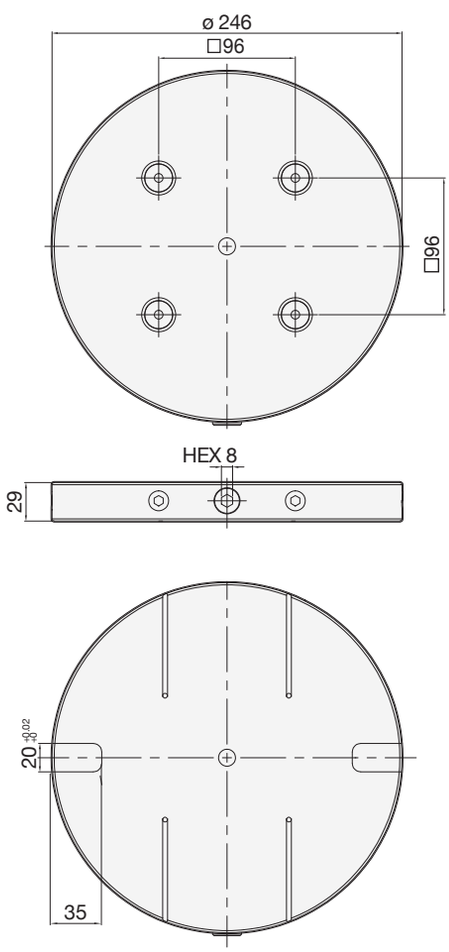
Size	ø246x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	4x90° / Diameter 220 mm
Weight (kg)	9.2



without mounting bores for tables with 90° grooves

M-96x96 (8059)

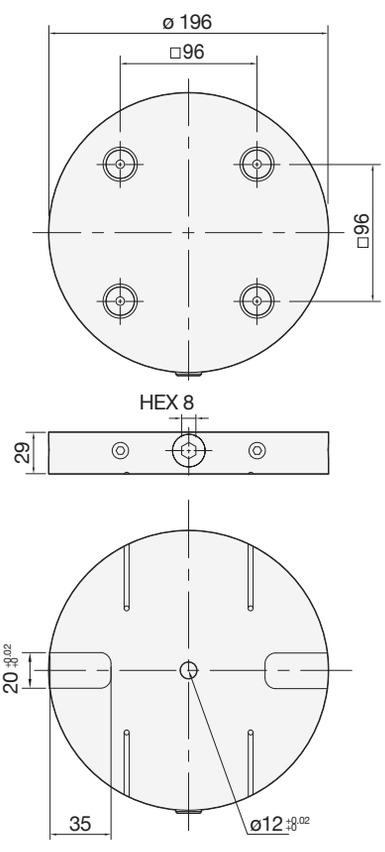
Size	ø246x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	9.5



without mounting bores for tables with 90° grooves

M-96x96 (8060)

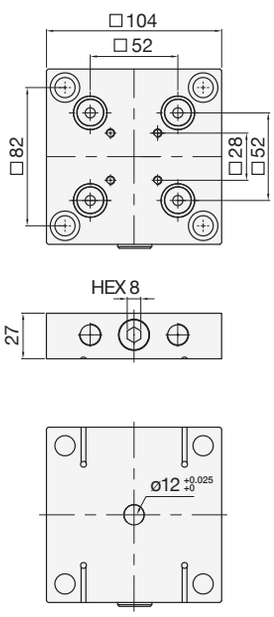
Size	ø196x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	6



Grid Plate

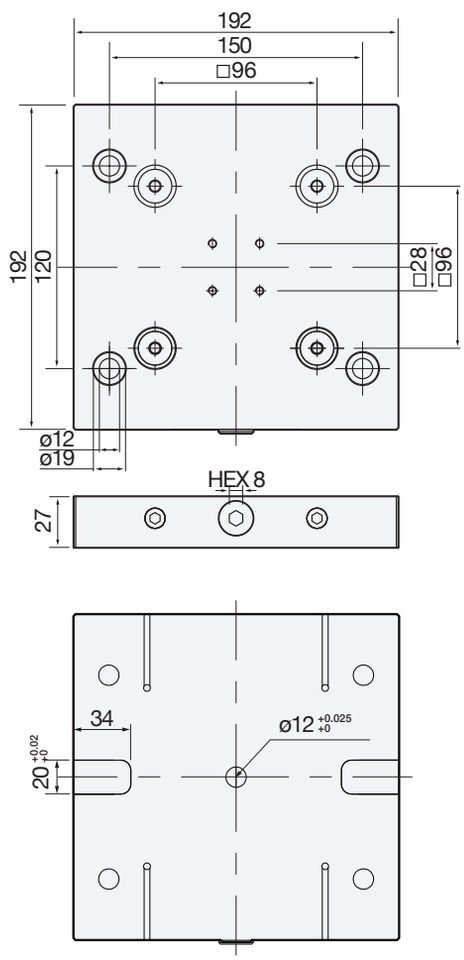
M-52x52 (8011)

Size	104x104x27 mm
Pull Stud No.	M-52x52PS
Mounting Holes	82x82 mm
Weight (kg)	1.8



M-96x96 (80522)

Size	192x192x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	150x120 mm
Weight (kg)	7.6



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Round Modification Plate

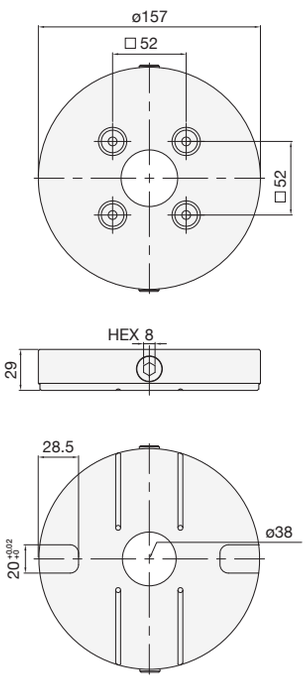
M-52x52 (8009)

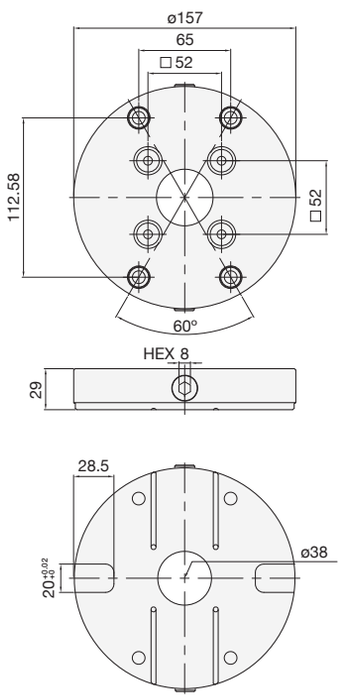
Size	ø157x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	3.7

for machine tables with 6x60° groove

M-52x52 (8009-M)

Size	ø157x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	for machine tables with 6x60° grooves
Weight (kg)	3.7



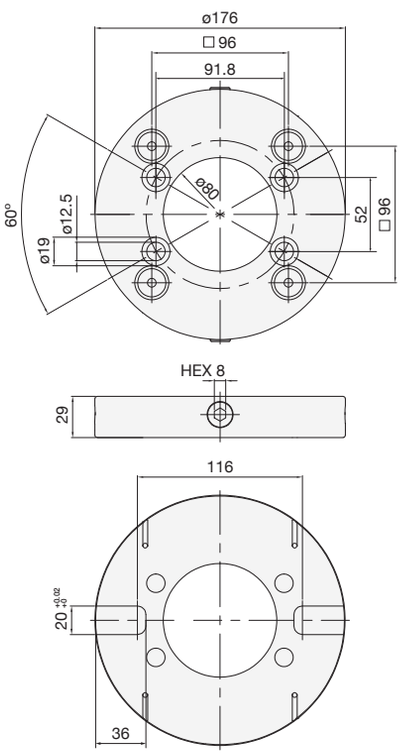


Round Modification Plate

for machine tables with 6x60° grooves

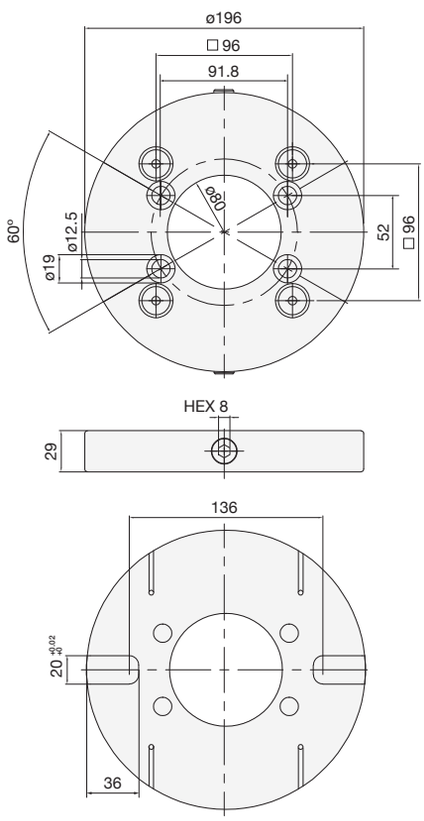
M-96x96 (8055)

Size	ø176x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	for machine tables with 6x60° grooves
Weight (kg)	5



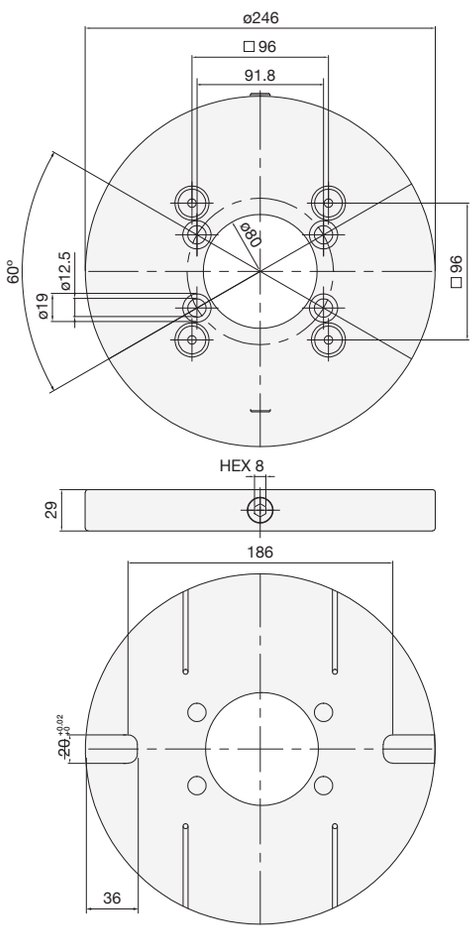
M-96x96 (8055-1)

Size	ø196x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	for machine tables with 6x60° grooves
Weight (kg)	6



M-96x96 (8055-2)

Size	ø246x29 mm
Pull Stud No.	M-96x96PS
Mounting Holes	for machine tables with 6x60° grooves
Weight (kg)	9.5



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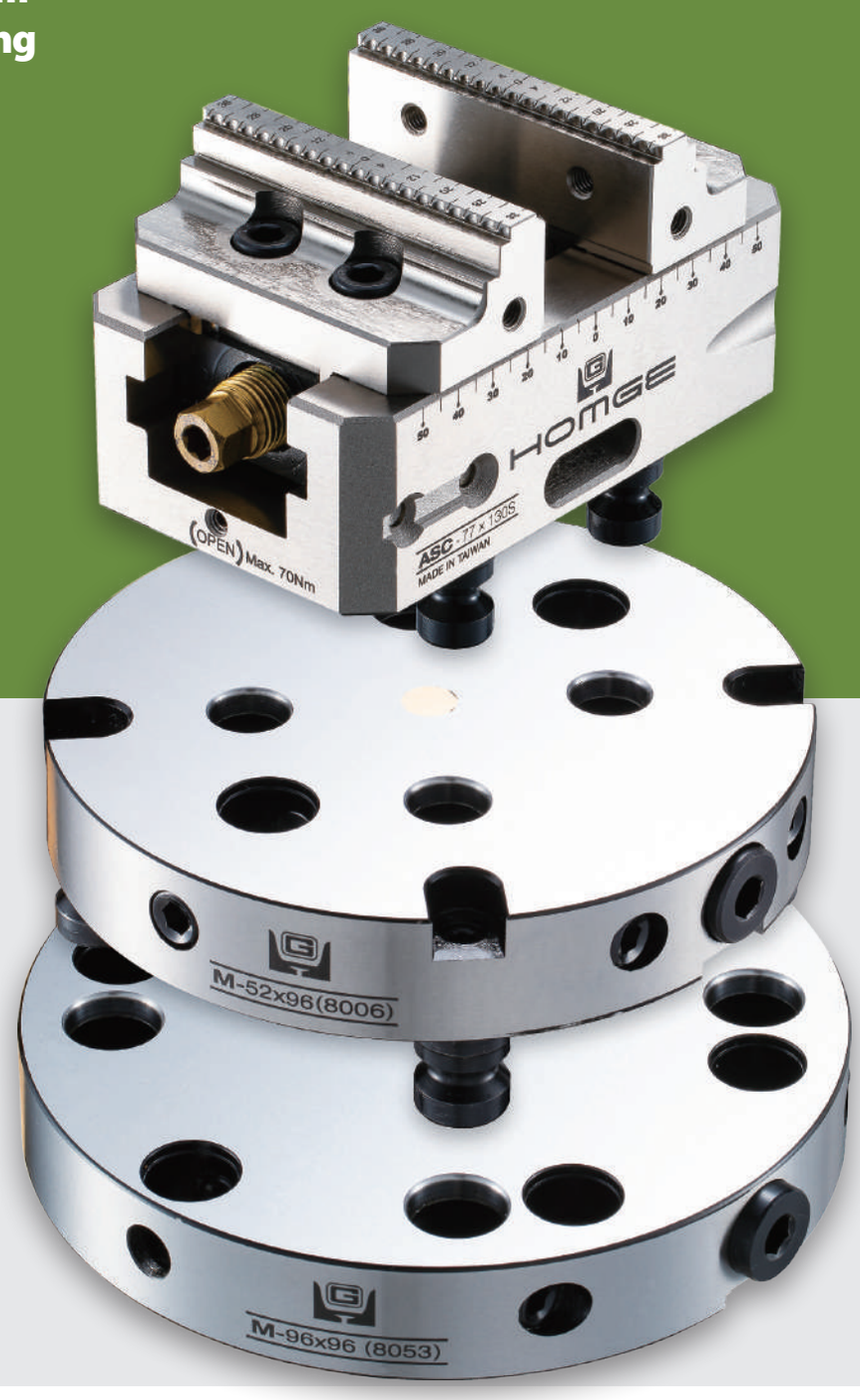
Adapter Plates-52/96

For users of our 96mm Zero-Point Positioning System who are looking to integrate the 52mm standard, we recommend our Adapter Plate. This design allows for a smooth transition between standards without the need for recalibration.

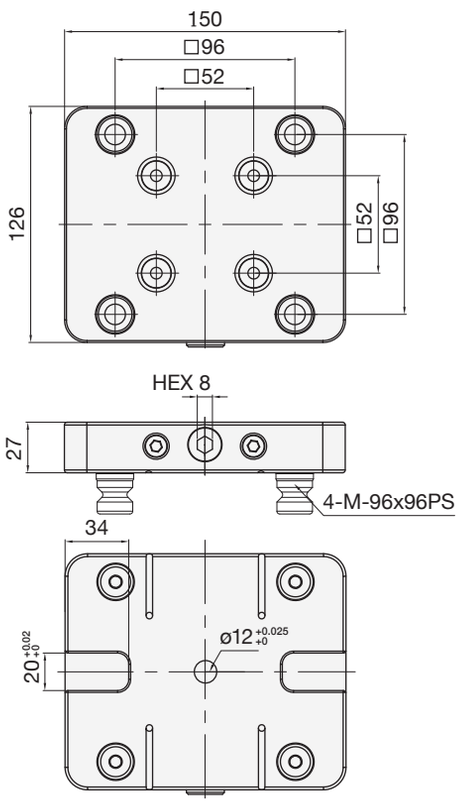


Adapter Plates

Rectangular Adapter Plate

M-52x96 (8003)

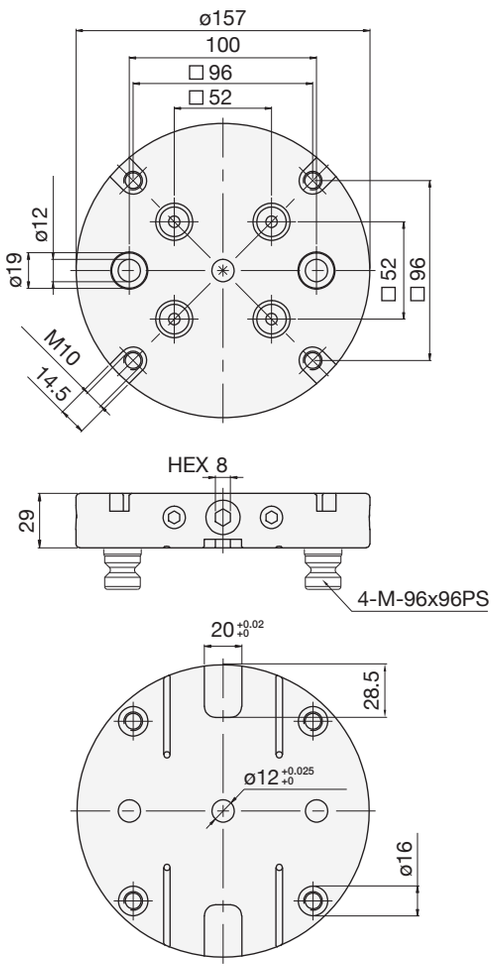
Size	150x126x27 mm
Pull Stud No.	M-52x52PS
Mounting Holes	96x96 mm
Weight (kg)	3.7



Round Adapter Plate

M-52x96 (8006)

Size	ø157x29 mm
Pull Stud No.	M-52x52PS
Mounting Holes	100 mm / 96x96 mm
Weight (kg)	4



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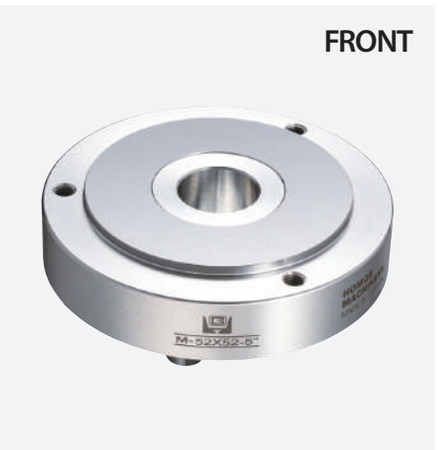
Adapter Plate for 3-Jaw Chuck

3 Jaw Chuck Adapter Plate for M-52x52



M-52x52 (4")

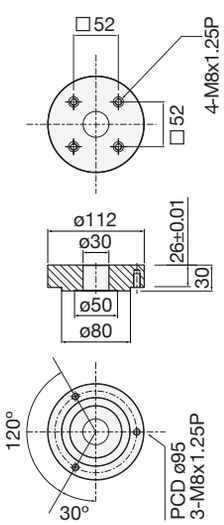
Size	ø112x30 mm
Pull Stud No.	M-52x52PS
Mounting Holes	M8
Weight (kg)	2

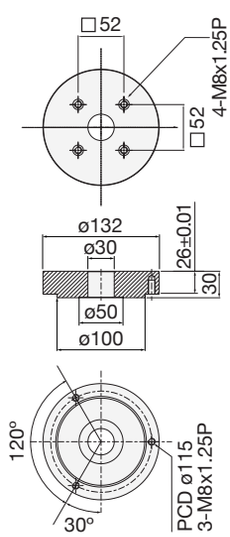
M-52x52 (5")

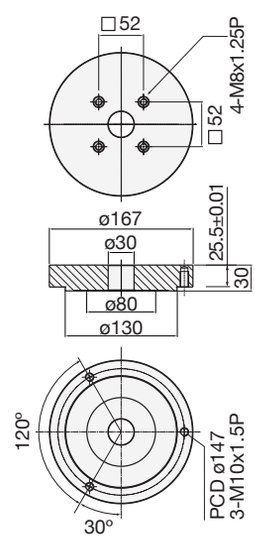
Size	ø132x30 mm
Pull Stud No.	M-52x52PS
Mounting Holes	M8
Weight (kg)	2.9

M-52x52 (6")

Size	ø167x30 mm
Pull Stud No.	M-52x52PS
Mounting Holes	M10
Weight (kg)	4.6







3 Jaw Chuck Adapter Plate for M-96x96

M-96x96 (6")

Size	ø167x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	M10
Weight (kg)	4.6

M-96x96 (7")

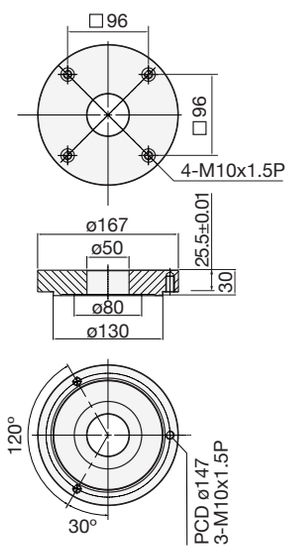
Size	ø193x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	M10
Weight (kg)	6

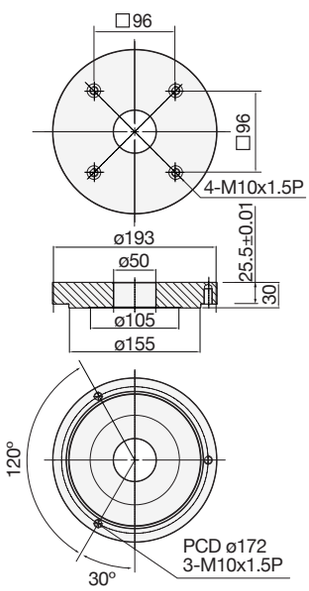
M-96x96 (8")

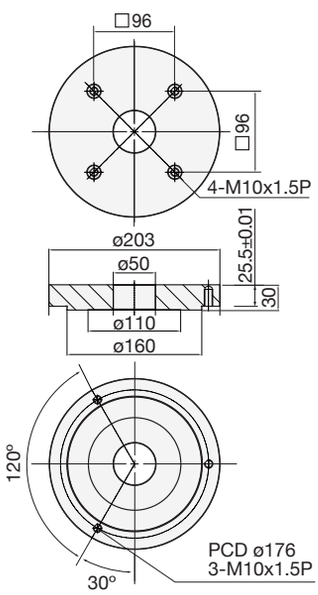
Size	ø203x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	M10
Weight (kg)	6.7

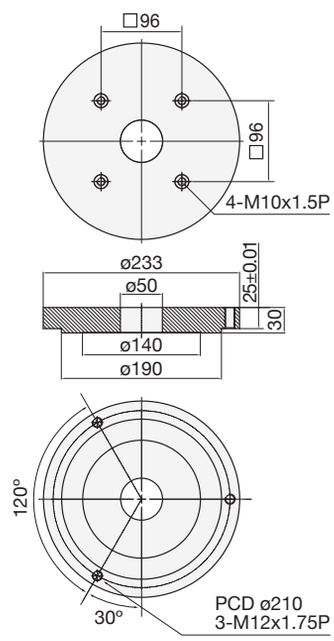
M-96x96 (9")

Size	ø233x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	M12
Weight (kg)	8.9









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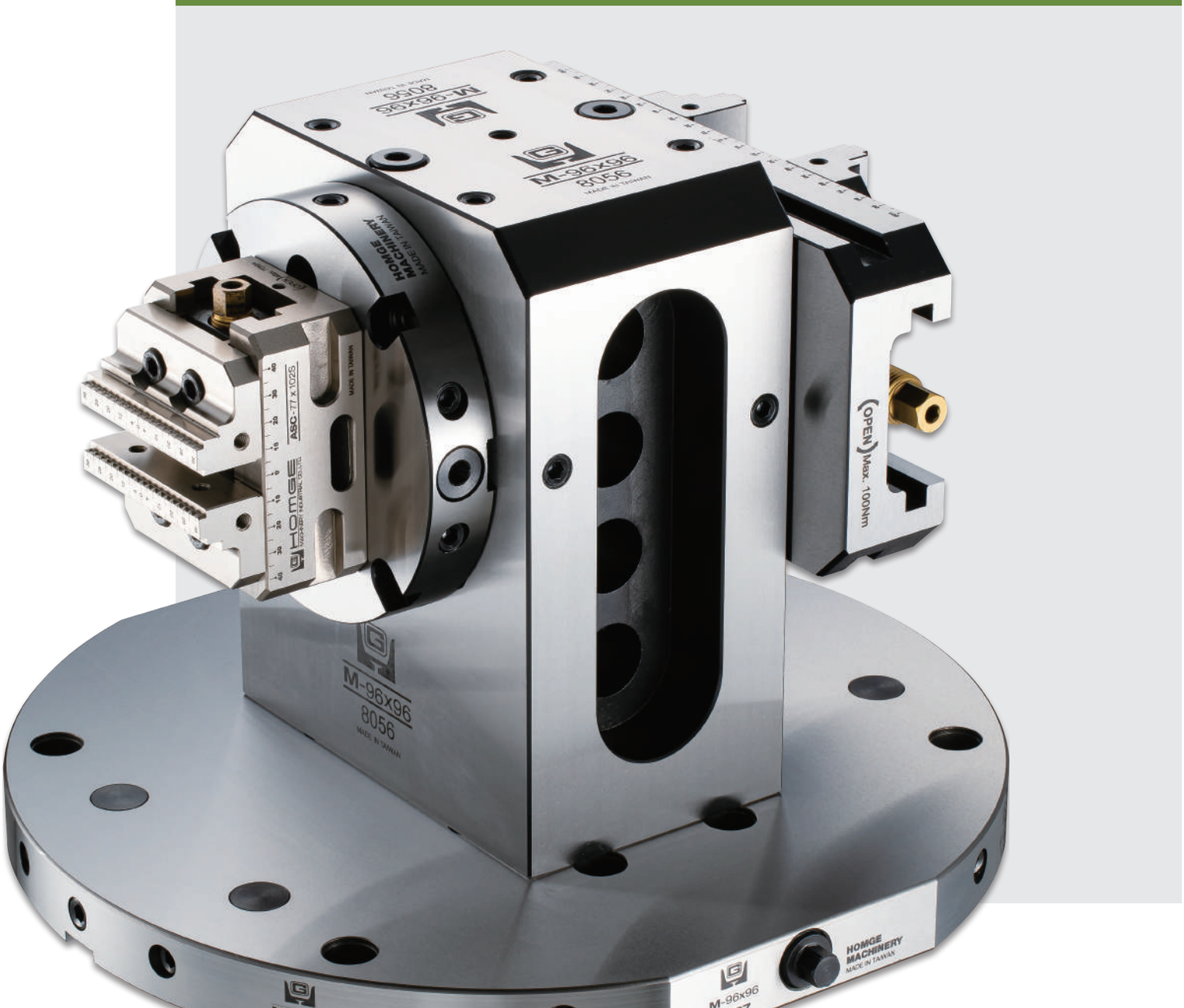
Column

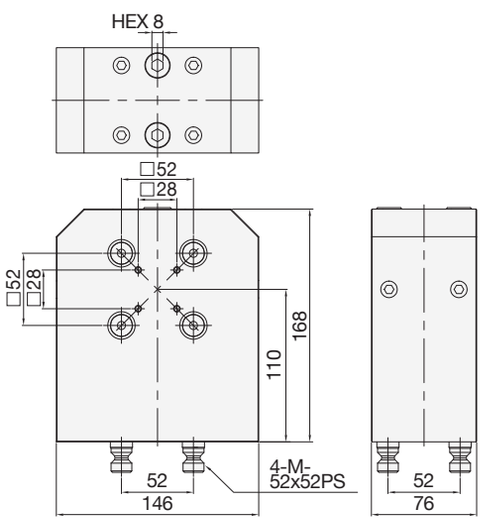
Double-sided positioning tombstone inherits the characteristics of the positioning plate and can utilize the processing space of the machine tool. Suitable for 3-axis machine tool users who often apply dual-sided processing.



Twin Base

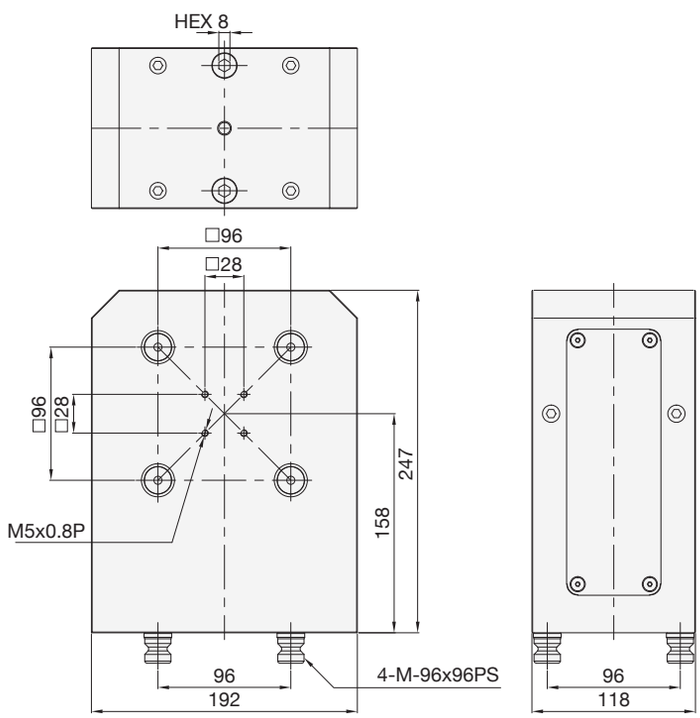
M-52x52 (8008)

Size	146x76x168 mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	14



M-96x96 (8056)

Size	192x118x247 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	37



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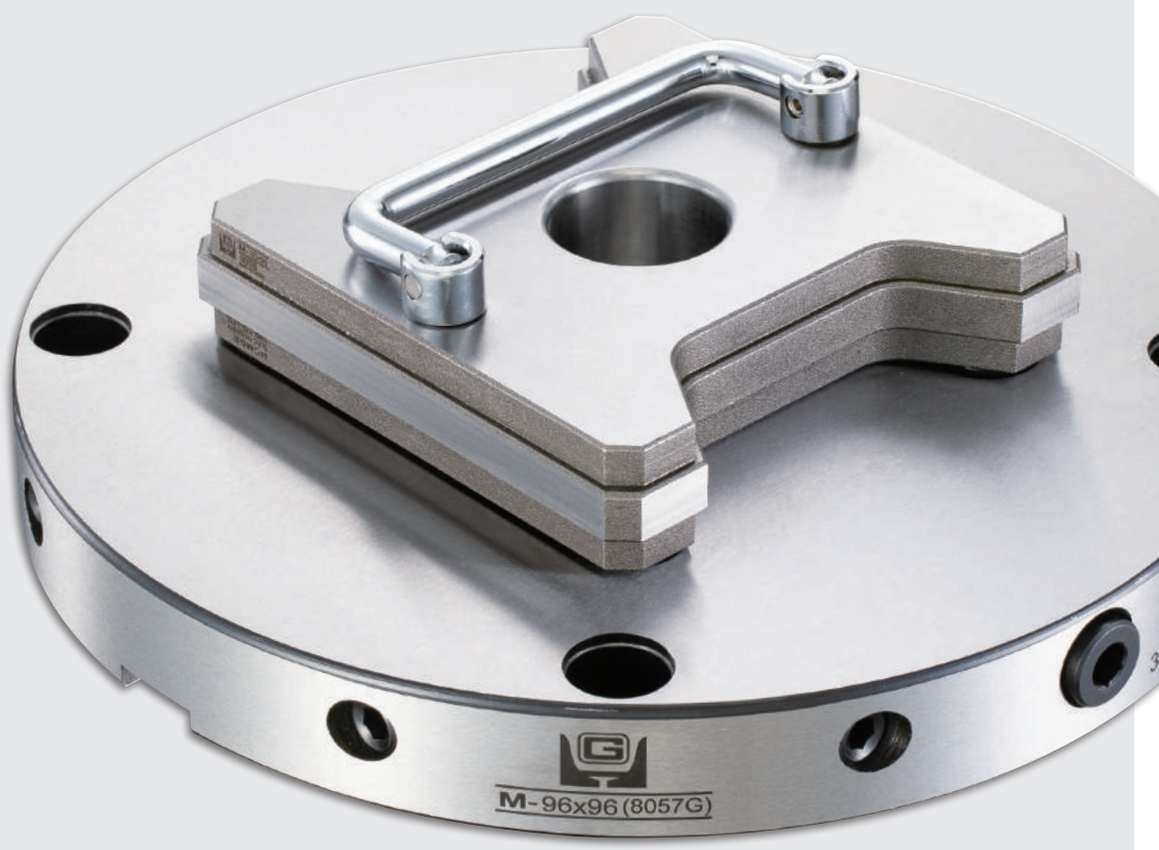
Master Gauging Pallet

Suitable for quick checking the precise alignment of Quick Changing Plates and for concentric alignment of rotary or chucks.

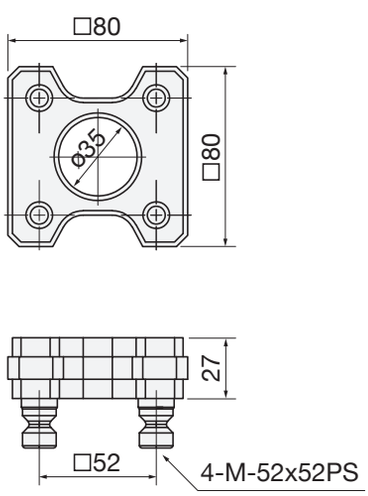
How it works:

After clamping the gauging pallet in a Quick Change Device - plate, the axial alignment of the Quick Change Device - plate is done by probing the jig-ground sides of the gauging pallet. For a concentric alignment the inner diameter of the gauging pallet can be used.



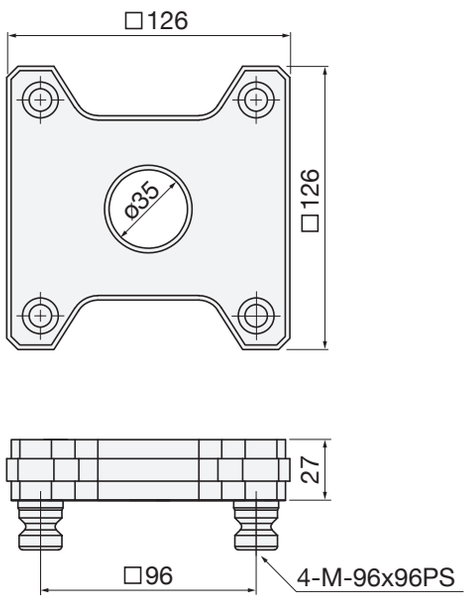
M-52x52 (8010)

Size	80x80x27 mm
Pull Stud No.	M-52x52PS
Weight (kg)	1.1



M-96x96 (8058)

Size	126x126x27 mm
Pull Stud No.	M-96x96PS
Weight (kg)	2.6



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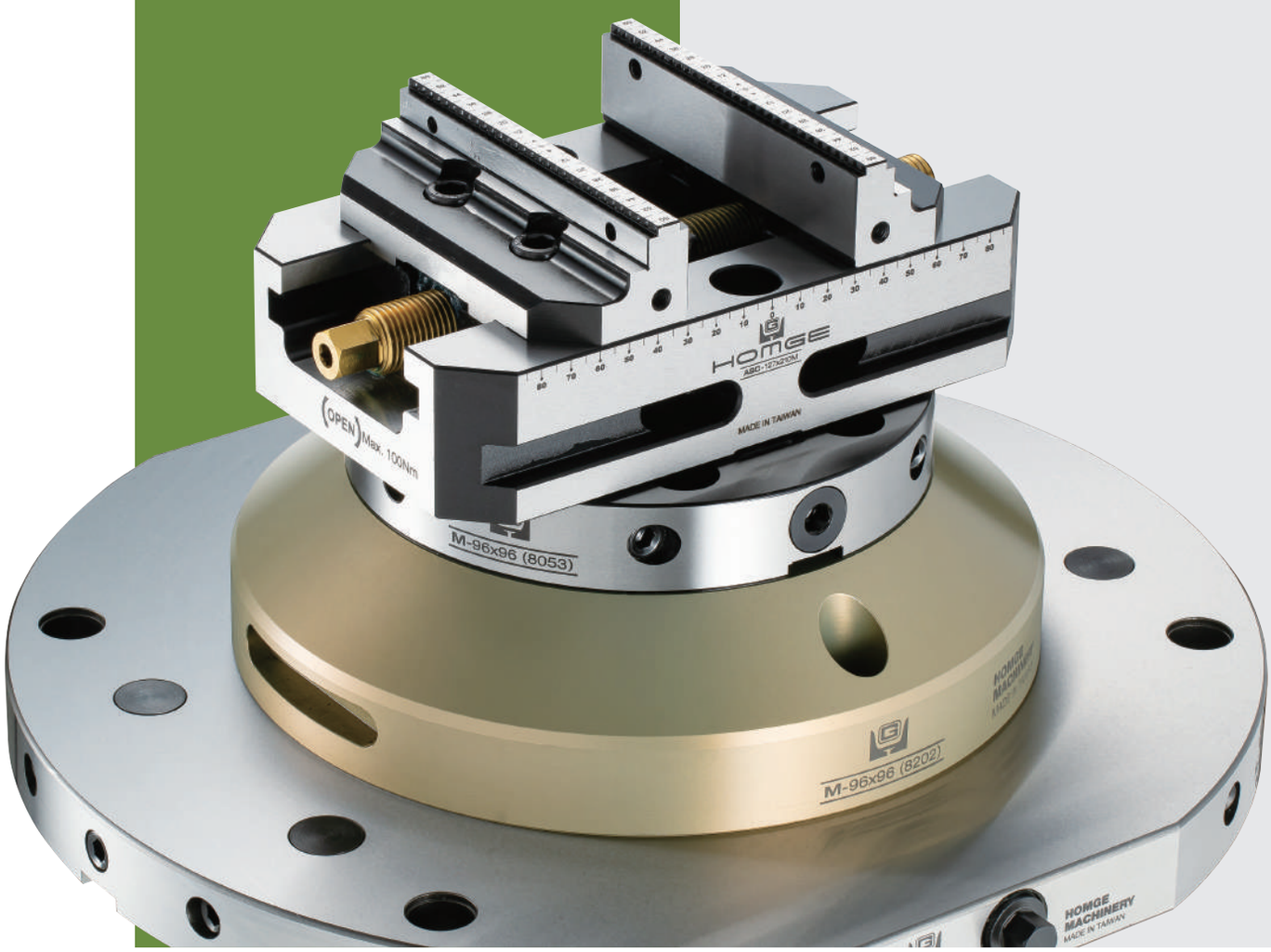
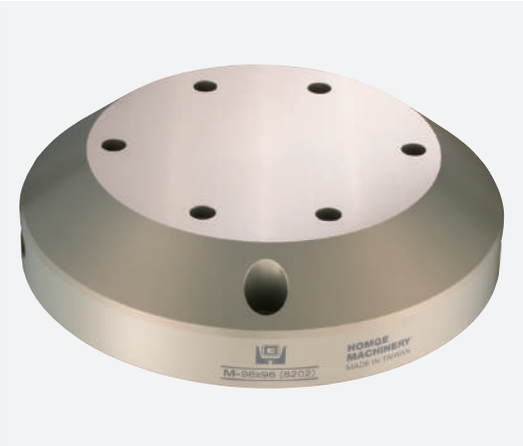
Riser Block

Riser Block provides sufficient space for tool feed by reducing the interference between the bed and the machining tool Suitable for multi-axis machining and one-piece formed processes

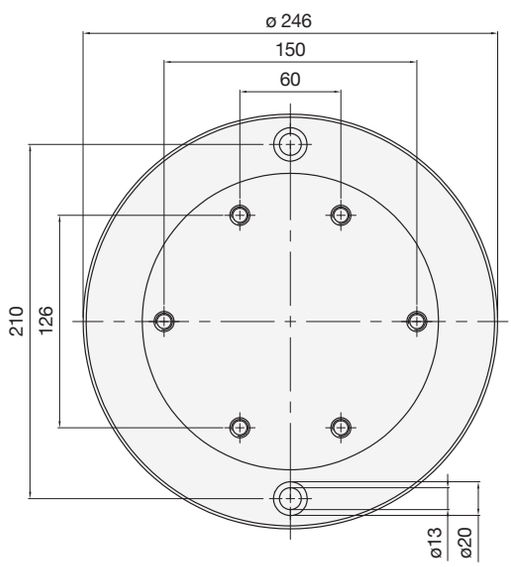


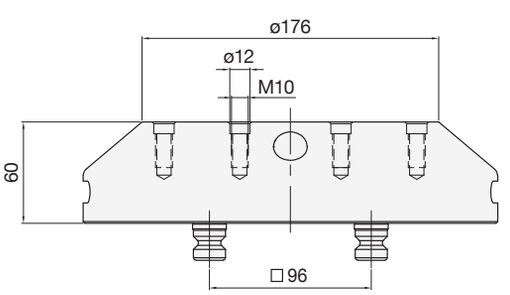
Round Aluminum Riser

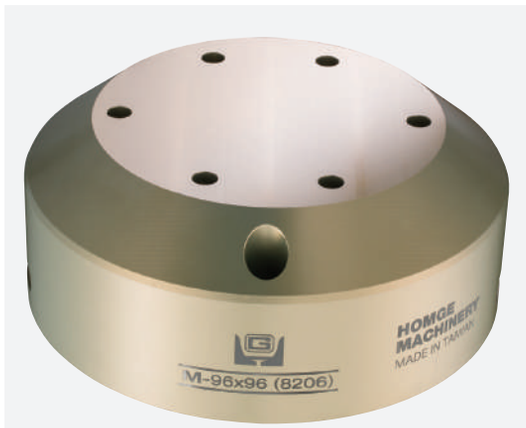


M-96x96 (8202)

Size	ø246x60 mm
Pull Stud No.	M-96x96PS
Mounting Holes	210mm / 150 mm / 60x126 mm
Weight (kg)	7
Material	Aluminum

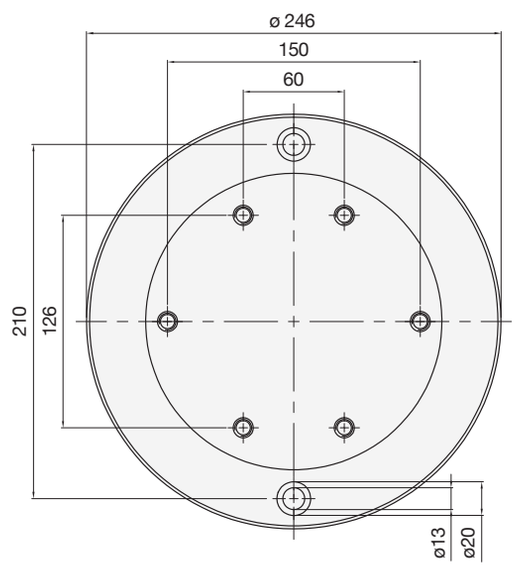


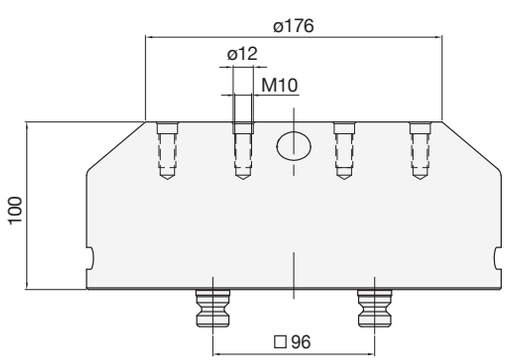




M-96x96 (8206)

Size	ø246x100 mm
Pull Stud No.	M-96x96PS
Mounting Holes	210mm / 150 mm / 60x126 mm
Weight (kg)	12
Material	Aluminum





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Rectangular Riser

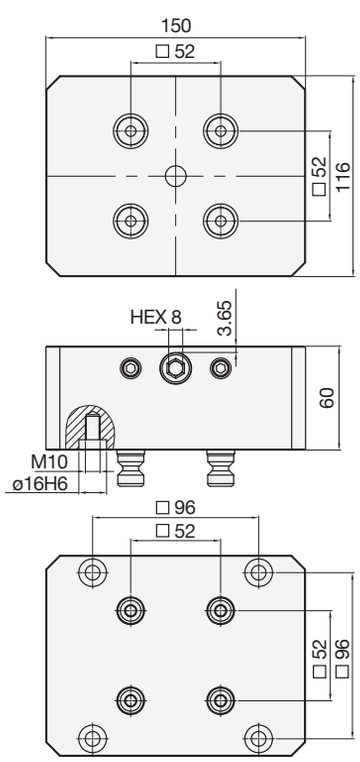
(Height: 60 mm)

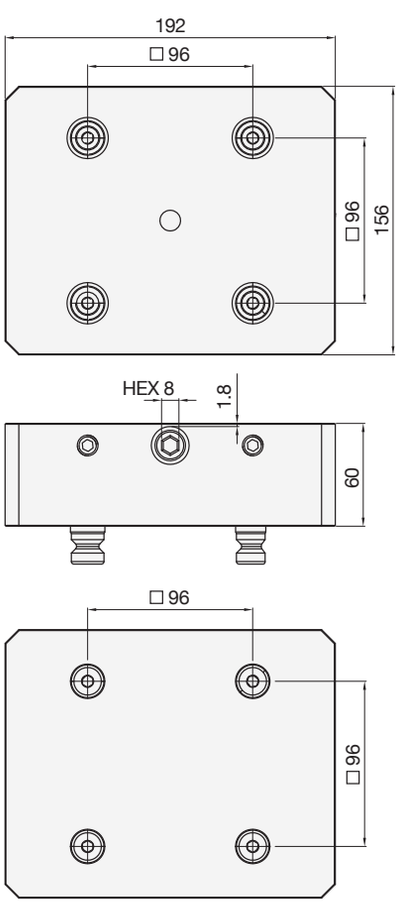
M-52x52 (3131)

Size	150x116x60 mm
Pull Stud No.	M-52x52PS / M-96x96PS
Mounting Holes	-
Weight (kg)	6.1

M-96x96 (8222)

Size	192x156x60 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	11.2





Rectangular Riser

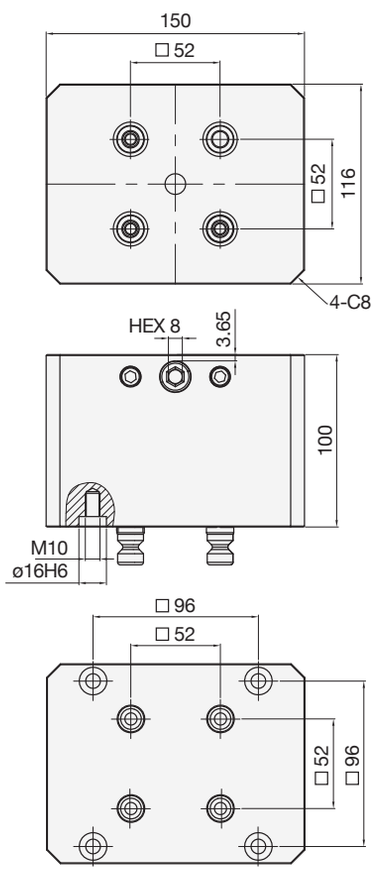
(Height: 100 mm)

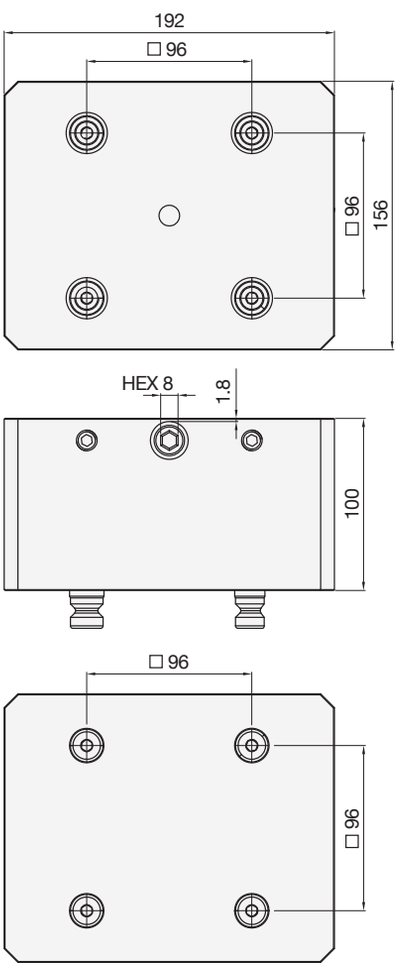
M-52x52 (3133)

Size	150x116x100 mm
Pull Stud No.	M-52x52PS / M-96x96PS
Mounting Holes	-
Weight (kg)	10

M-96x96 (8226)

Size	192x156x100 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	18.1





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Multi Plates

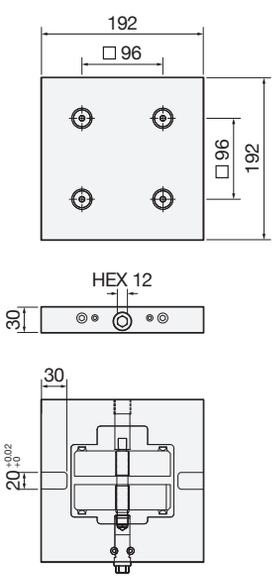
Multi plates provide more positioning points, allowing users to effectively use the space of machine tables; whether it is fixing a single large workpiece or multiple small parts, the fixture positioning is fast and accurate

Side-Mounted Plate

M-96x96
1-Fold

M-96x96 (8086G)

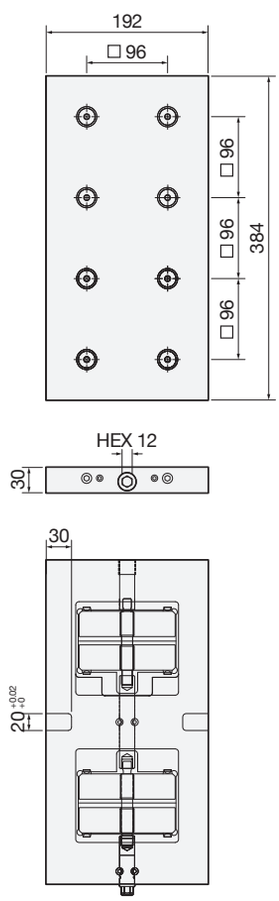
Size	192x192x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	–
Weight (kg)	7.8



M-96x96
2-Fold

M-96x96 (8088G)

Size	384x192x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	–
Weight (kg)	15.7
Standard Accessories	Cover Plug M-96x96CPS x 8 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc



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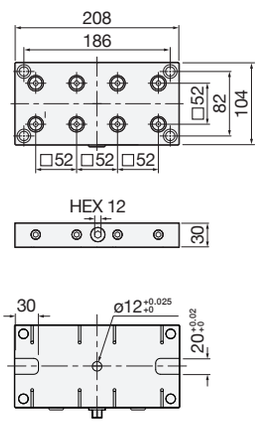
Multi Plate / 2-Fold Grid Plate

RECTANGULAR

with Mounting Bores

M-52x52 (7062)

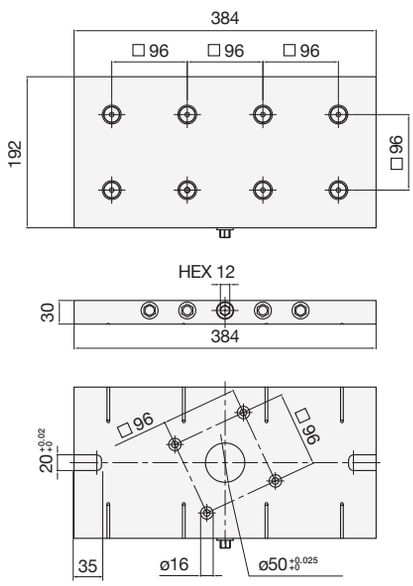
Size	208x104x30 mm
Pull Stud No.	M-52x52PS
Mounting Holes	186x82 mm
Weight (kg)	4.6
Standard Accessories	Cover Plug M-52x52CPS x 8 pcs Cover Plug with Hook M-52x52H x 2 pcs Cover Plug Remover x 1 pc



without Mounting Bores

M-96x96 (8062)

Size	384x192x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	14.7
Standard Accessories	Cover Plug M-96x96CPS x 8 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc

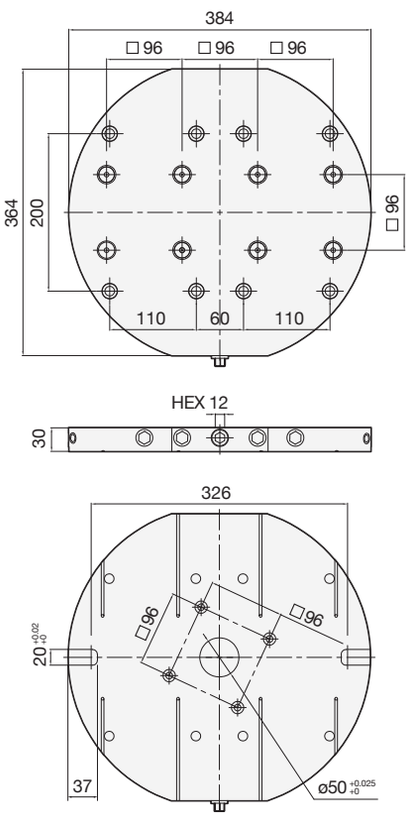


ROUND

with Mounting Bores for 100mm T-Slot distance

M-96x96 (8067)

Size	ø384x364x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	as the drawing shown
Weight (kg)	22.4
Standard Accessories	Cover Plug M-96x96CPS x 8 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc



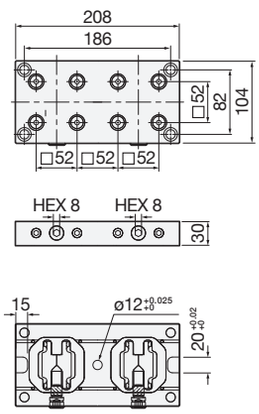
Multi Plate / 2-Fold Grid Plate

RECTANGULAR

with Mounting Bores

M-52x52 (7062G)

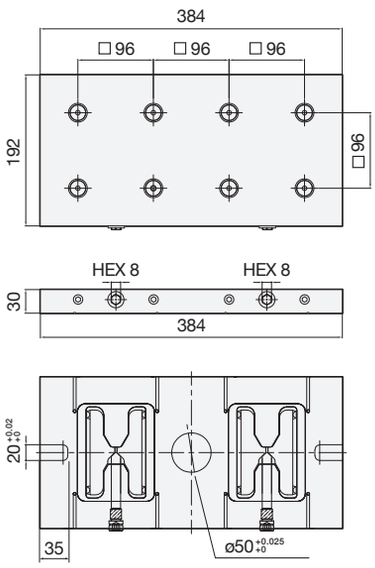
Size	208x104x30 mm
Pull Stud No.	M-52x52PS
Mounting Holes	186x82 mm
Weight (kg)	4.6
Standard Accessories	Cover Plug M-52x52CPS x 8 pcs Cover Plug with Hook M-52x52H x 2 pcs Cover Plug Remover x 1 pc



without Mounting Bores

M-96x96 (8062G)

Size	384x192x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	–
Weight (kg)	14
Standard Accessories	Cover Plug M-96x96CPS x 8 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc



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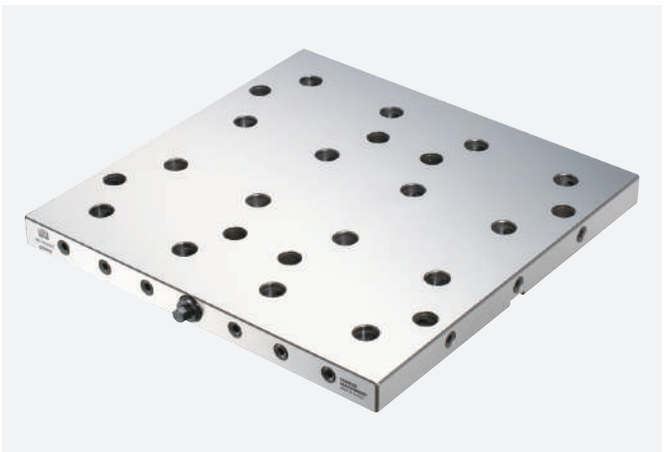
Multi Plate / 4-Fold Grid Plate

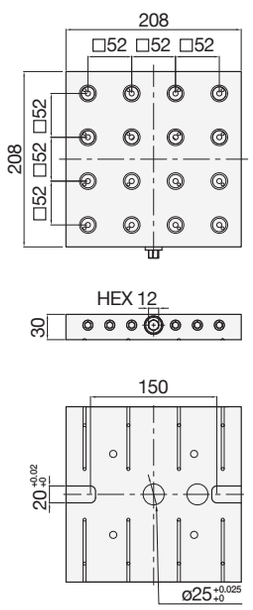
M-52x52
without Mounting Bores

M-96x96
with Mounting Bores



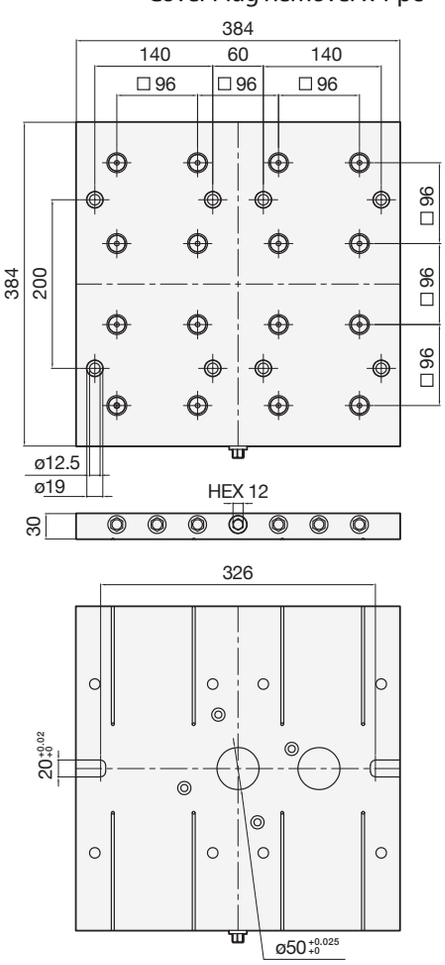
M-52x52 (8026)

Size	208x208x30mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	8.2
Standard Accessories	Cover Plug M-52x52CPS x 16 pcs Cover Plug with Hook M-52x52H x 2 pcs Cover Plug Remover x 1 pc



M-96x96 (8066)

Size	384x384x30mm
Pull Stud No.	M-96x96PS
Mounting Holes	as the drawing shown
Weight (kg)	29.2
Standard Accessories	Cover Plug M-96x96CPS x 16 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc

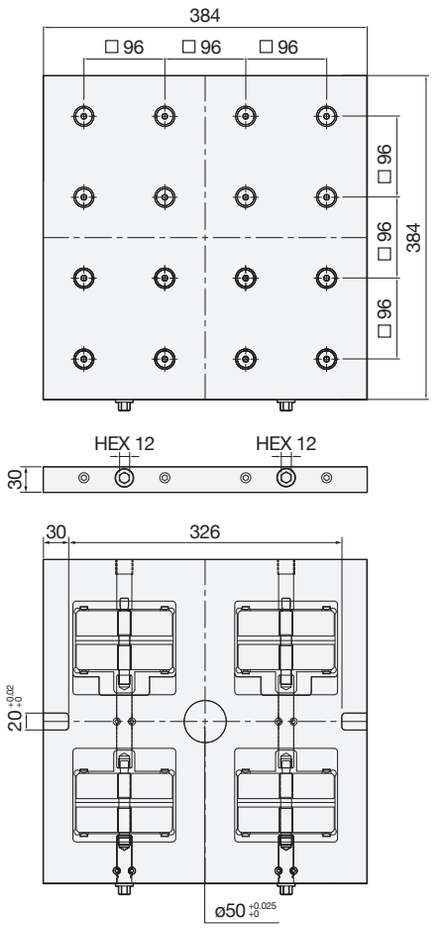


Multi Plate / 4-Fold Grid Plate

M-96x96
without Mounting Bores

M-96x96 (8066G)

Size	384x384x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	–
Weight (kg)	32
Standard Accessories	Cover Plug M-96x96CPS x 16 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc



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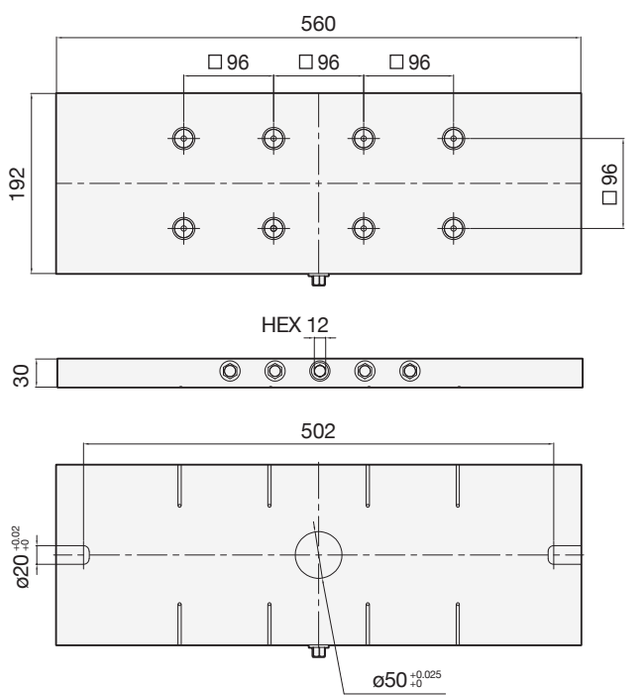
Clamping Bridge

Single Clamping Bridge

M-96x96 (8068)

Size	560x192x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	-
Weight (kg)	23
Standard Accessories	Cover Plug M-96x96CPS x 8 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc



Clamping Bridge

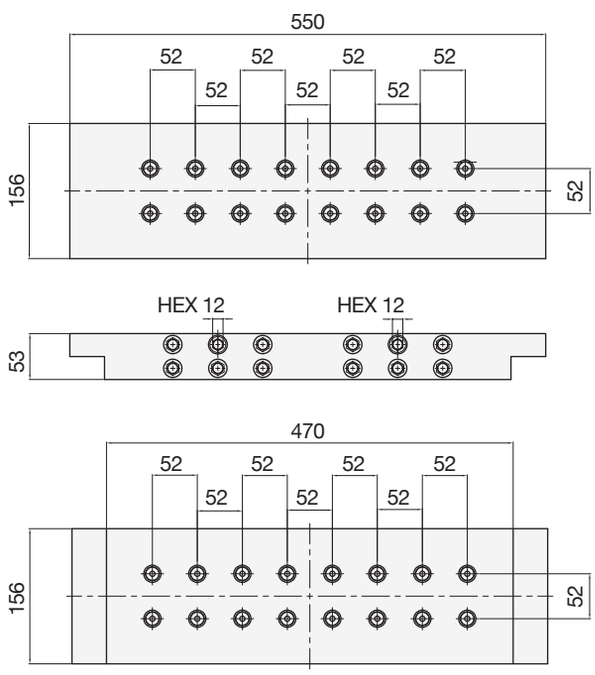
Twin Clamping Bridge

FRONT

BACK

M-52x52 (8022)

Size	550x156x53 mm
Pull Stud No.	M-52x52PS
Mounting Holes	-
Weight (kg)	27.7
Standard Accessories	Cover Plug M-52x52CPS x 32 pcs Cover Plug with Hook M-52x52H x 2 pcs Cover Plug Remover x 1 pc



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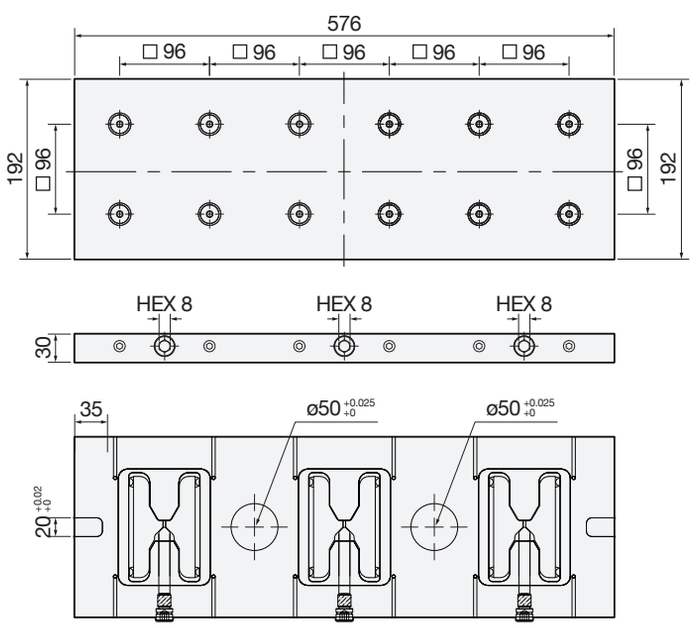
Clamping Bridge

Single Clamping Bridge for 4-Axis

M-96x96 (8072G)

Size	576x192x30 mm
Pull Stud No.	M-96x96PS
Mounting Holes	–
Weight (kg)	24.3
Standard Accessories	Cover Plug M-96x96CPS x 12 pcs Cover Plug with Hook M-96x96H x 2 pcs Cover Plug Remover x 1 pc



Clamping Bridge

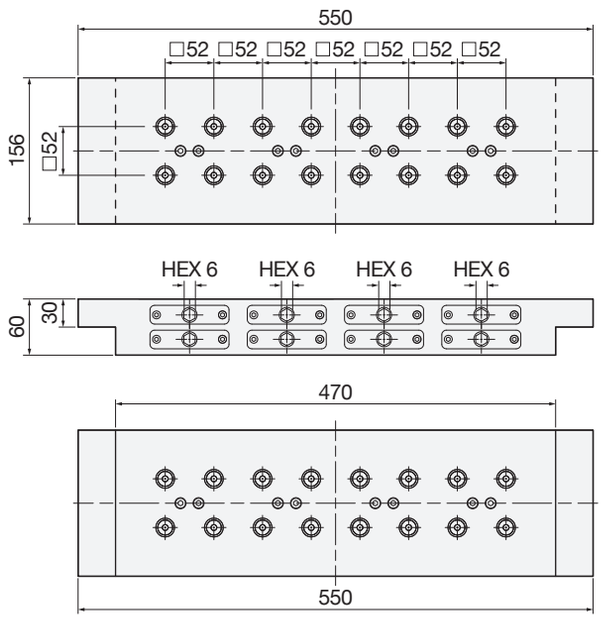
Twin Clamping Bridge for 4-Axis

FRONT

BACK

M-52x52 (8022G)

Size	550x156x60 mm
Pull Stud No.	M-52x52PS
Mounting Holes	–
Weight (kg)	34.2
Standard Accessories	Cover Plug M-52x52CPS x 32 pcs Cover Plug with Hook M-52x52H x 2 pcs Cover Plug Remover x 1 pc



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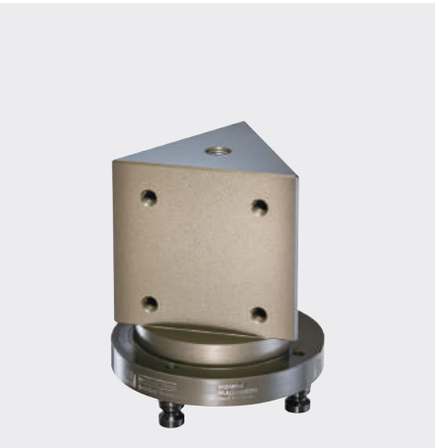
Tombstone

Advancements in Machining Centers Efficiency
The 3-sided or 4-sided Tombstone effectively enhances changeout efficiency in machining centers, particularly with smaller 5-axis machines. This innovation overcomes conventional clamping setup restrictions, enabling the execution of complex tasks even on compact machines.

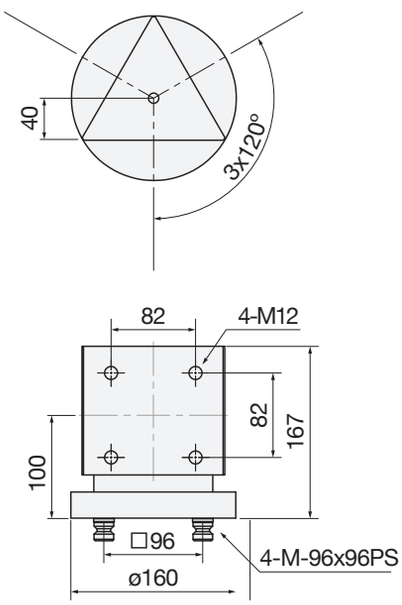
Tombstone

3-Faced Tombstone



M-52x52 (9313)

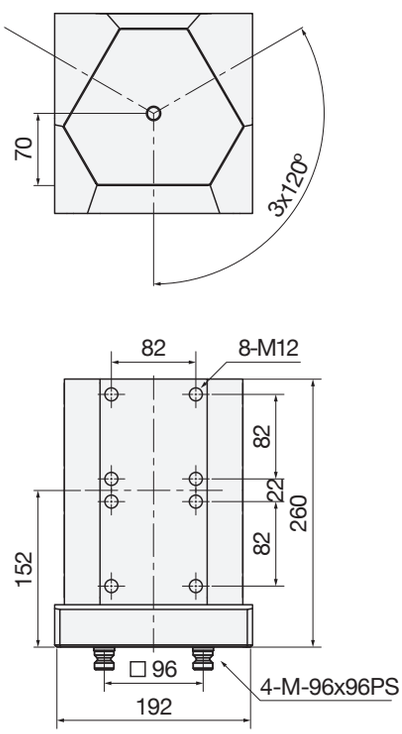
Size	Ø160x167 mm
Pull Stud No.	M-52x52PS/ M-96x96PS
Mounting Holes	–
Weight (kg)	4.5
Compatible with	Grid Plate M-52x52 (8011) x 3 pcs



4-Faced Tombstone

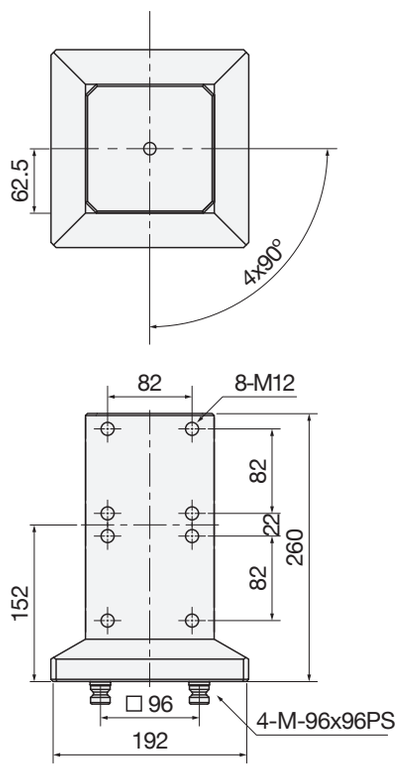
M-52x52 (9333)

Size	192x192x260 mm
Pull Stud No.	M-52x52PS/ M-96x96PS
Mounting Holes	–
Weight (kg)	15.2
Compatible with	Grid Plate M-52x52 (8011) x 6 pcs



M-52x52 (9433)

Size	192x192x260 mm
Pull Stud No.	M-52x52PS/ M-96x96PS
Mounting Holes	–
Weight (kg)	12.5
Compatible with	Grid Plate M-52x52 (8011) x 8 pcs



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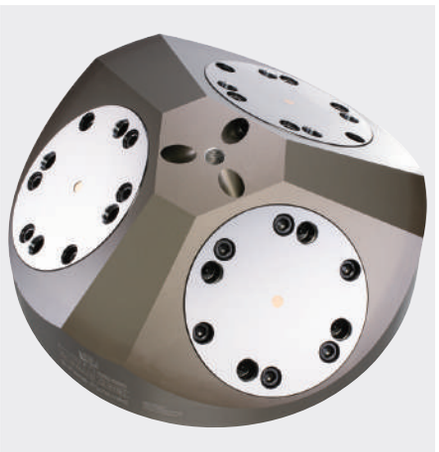
3-Faced Pyramid

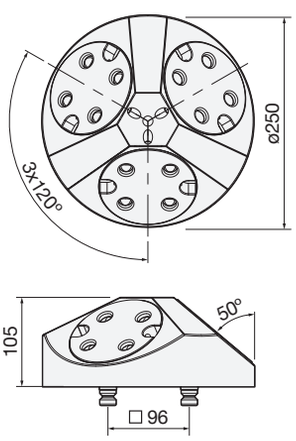
M-52x52 (9314)

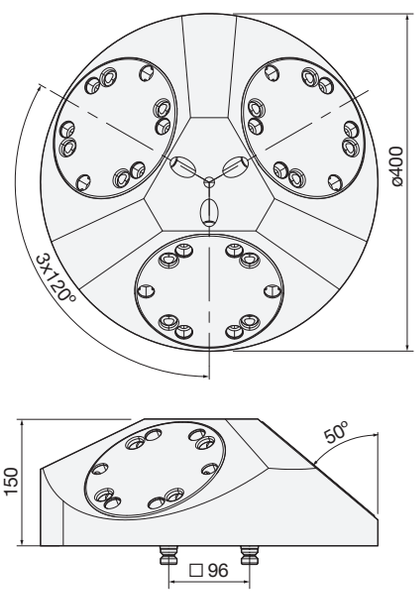
Size	Ø250x105 mm
Pull Stud No.	M-52x52PS/ M-96x96PS
Mounting Holes	–
Weight (kg)	12.7
Compatible with	Round Plate M-52x52 (8004) x 3 pcs



M-96x96 (9319)

Size	Ø400x150 mm
Pull Stud No.	M-96x96PS
Mounting Holes	–
Weight (kg)	44
Compatible with	Round Plate M-96x96 (8053) x 3 pcs





Combo Plate / Riser

M-52/96 (8287)

M-52/96 (8288)

M-52/96 (8287)

Size	192x192x27 mm
Pull Stud No.	M-52x52PS/ M-96x96PS
Mounting Holes	–
Weight (kg)	6.5

M-52/96 (8288)

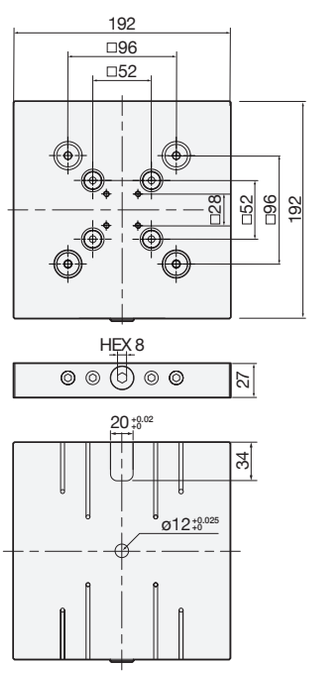
Size	Ø196x29 mm
Pull Stud No.	M-52x52PS/ M-96x96PS
Mounting Holes	–
Weight (kg)	6.2

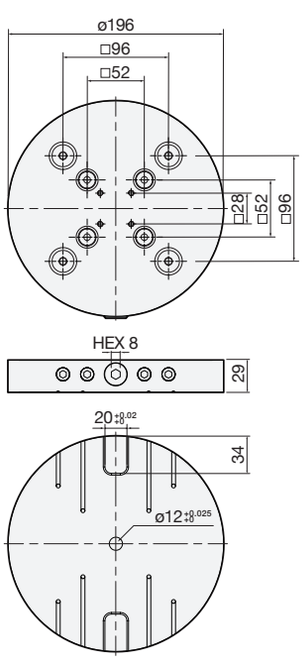
M-52/96 (8282)

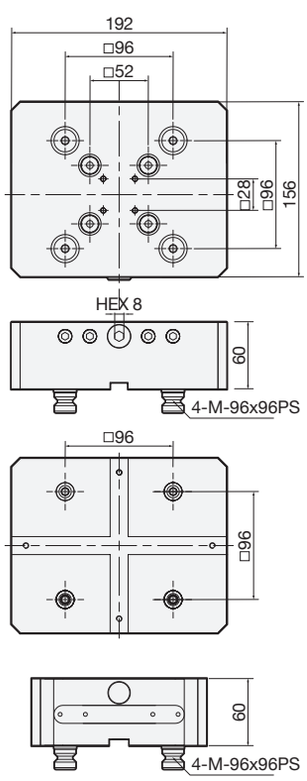
Size	192x156x60 mm
Pull Stud No.	M-52x52PS/ M-96x96PS
Mounting Holes	–
Weight (kg)	11.2

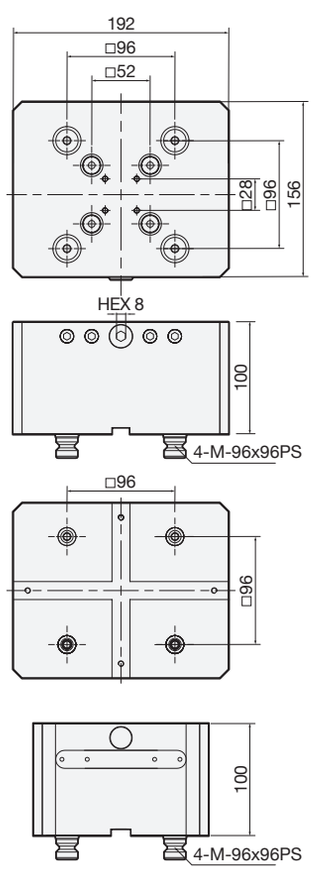
M-52/96 (82822)

Size	192x156x100 mm
Pull Stud No.	M-52x52PS/ M-96x96PS
Mounting Holes	–
Weight (kg)	18.1









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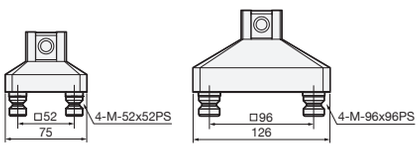
Top Clamping

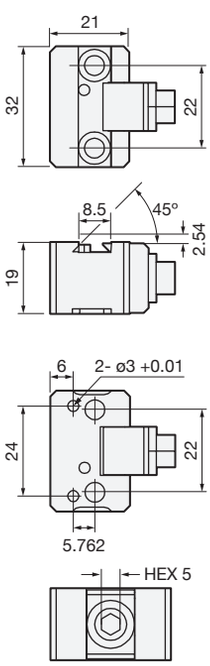
Dovetail Fixture

Aluminum Block for 52 or 96 system are available for order seperately.



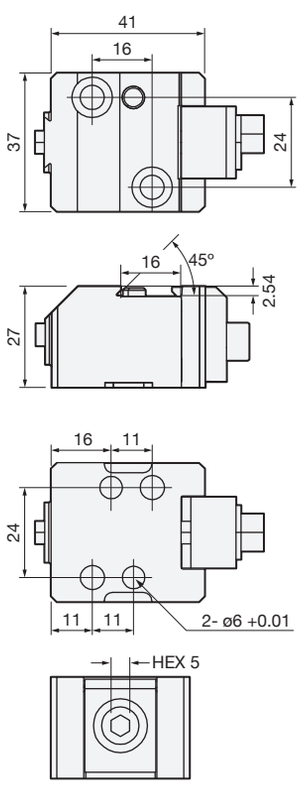
DM-12

Size	21x32x19mm
Clamping Range	8.5mm
Weight (kg)	0.07



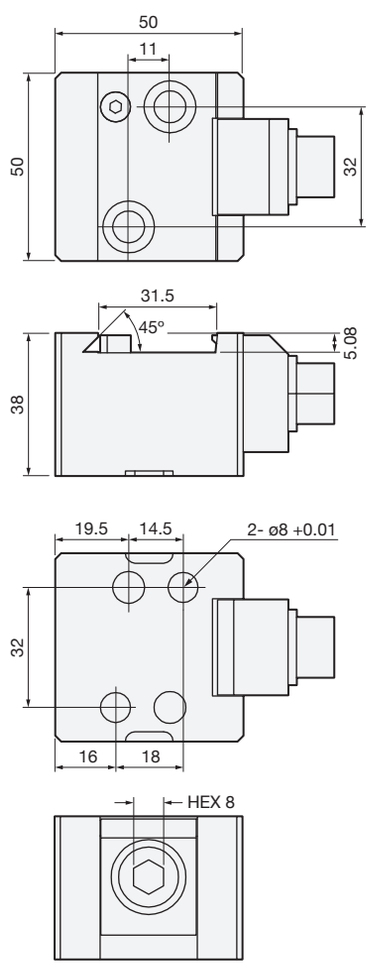
DM-25

Size	41x37x27mm
Clamping Range	16mm
Weight (kg)	0.29



DM-50

Size	50x50x38mm
Clamping Range	31.5mm
Weight (kg)	0.72

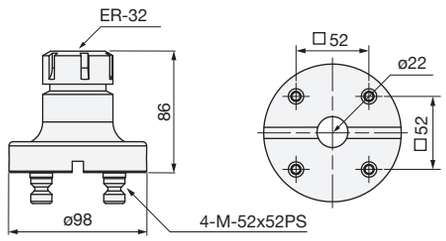


Top Clamping

Collect Chuck

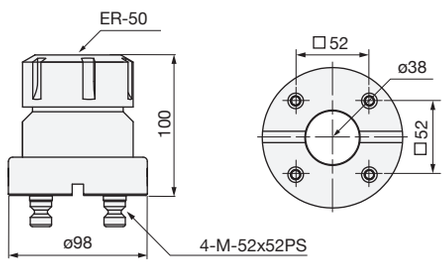
Model: M-52x52 (ER32)C

- Size: Ø98x86 mm
- Clamping Range: Ø1-20 mm
- Weight: 2.0 kg



Model: M-52x52 (ER50)C

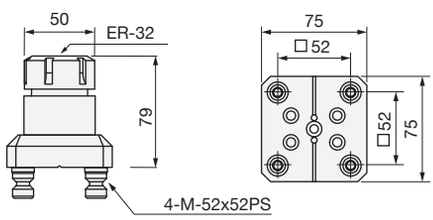
- Size: Ø98x100 mm
- Clamping Range: Ø10-34 mm
- Weight: 3.1 kg



Round Bar Fixture

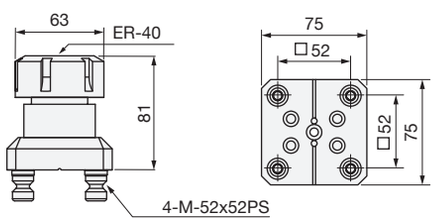
Model: M-52x52 (ER32)

- Size: 75x75x79 mm
- Clamping Range: Ø1-20 mm
- Weight: 1.5 kg



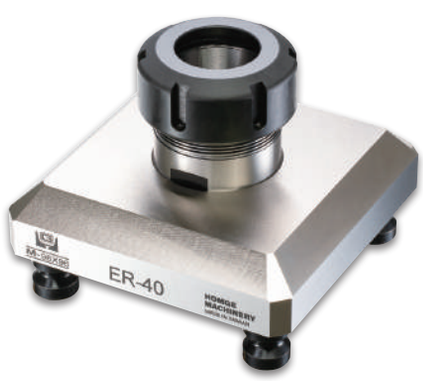
Model: M-40x52 (ER40)

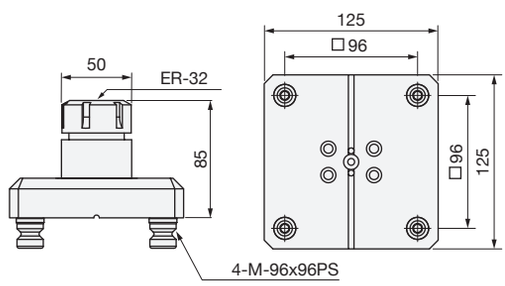
- Size: 75x75x81 mm
- Clamping Range: Ø2-26 mm
- Weight: 1.7 kg



Model: M-96x96 (ER32)

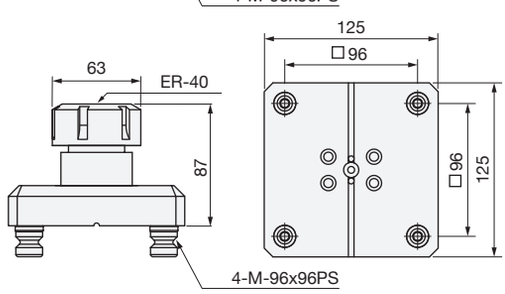
- Size: 125x125x85 mm
- Clamping Range: Ø1-20 mm
- Weight: 3.7 kg





Model: M-96x96 (ER40)

- Size: 125x125x87 mm
- Clamping Range: Ø2-26 mm
- Weight: 3.9 kg



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Optional Accessories

for Zero Point Quick Change Devices

Pull Studs

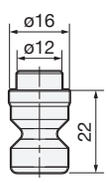
Can be adopted onto vises or workpieces to use together with any Quick Change Device.

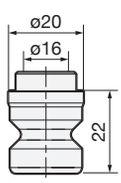
Model: M-52x52PS

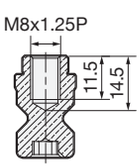
- 4 pcs / set
- Weight: 0.16 kg / set

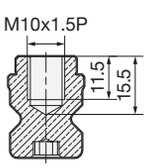
Model: M-96x96PS

- 4 pcs / set
- Weight: 0.28 kg / set









Spacer Studs

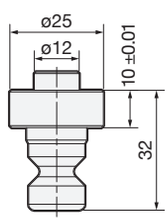
Improve the machining accessibility of edges or angles by making a through space between workpieces and Quick Change Devices.

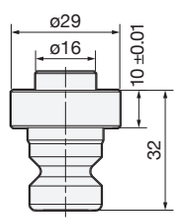
Model: M-52x52SS

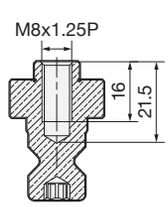
- 4 pcs / set
- Weight: 0.27 kg / set

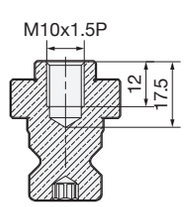
Model: M-96x96SS

- 4 pcs / set
- Weight: 0.4 kg / set

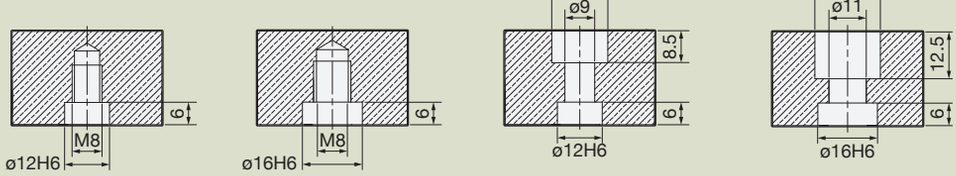








Applications:



Optional Accessories

for Zero Point Quick Change Devices

Cover Plugs - Plastic

Model: M-52x52CPP

- 4 pcs / set
- Weight: 0.01 kg / set

Model: M-96x96CPP

- 4 pcs / set
- Weight: 0.02 kg / set

Cover Plugs - Steel

Model: M-52x52CPS

- 4 pcs / set
- Weight: 0.10 kg / set

Model: M-96x96CPS

- 4 pcs / set
- Weight: 0.16 kg / set

Cover Plug with hook

Model: M-52x52H

- 2 pcs / set
- Weight: 0.18 kg / set

Model: M-96x96H

- 2 pcs / set
- Weight: 0.32 kg / set

Cover Plug Remover

for M-52x52 and M-96x96

- 1 pc
- Weight: 0.11 kg

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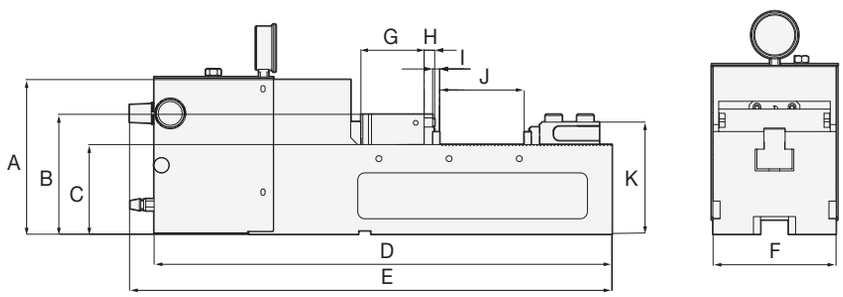
HOMGE

STAMPING UNIT

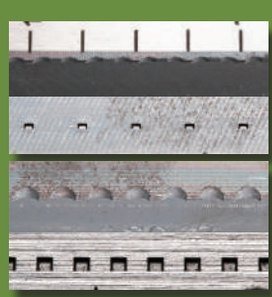
Model: ASC-153

The stamping jaws section is replaceable, depending on preferred tooth profile.

We supply specialized jaws for the ASC series and also accept orders for custom jaw designs.



Specialized stamping jaws



Custom-jaws tooth profile samples

SPECIFICATIONS (Material: Material: FCD 60 ductile Iron. Hardness: HRC 50)

Unit: mm

Model	A	B	C	D	E	F	G	H	I
ASC-153	220	170	127	652	690	175	90	15	10

Model	J	K	Stamping Force	Safety Range	Weight(kg)
ASC-153	120	160	**0-24000 kg**	10 mm	117

SIMPLE, QUICK & ACCURATE

ASC-153 Stamping Unit can easily shape tooth profile on the workpiece, which allows precise positioning between the workpiece and the vise.

1 The body of the Stamping Unit is made of Ductile Iron FCD 70 with patented PNEUMATIC SYSTEM. Required tooth profile is pre-stamped onto the workpiece with high pressure, so that the workpiece will be stably clamped by the corresponding tooth profile on five-axis vise.

2 The stamping force is between 0~24 tons, which is suitable for stamping tooth profile on both soft and hard materials. The black knob is pressure regulator, used to set pneumatic force according to processing conditions.

3 The serrated jaws of stamping unit are made of Tool Steel, heat-treated to achieve hardness above HRC55 and marked with scales to facilitate accurate positioning. It is recommended that the hardness of workpiece should not exceed HRC35.

4 The effective stamping stroke of the moveable jaw is 10mm: during the initialization phase, please adjust the jaw spacing according to the width of the workpiece and make sure to reserve 3~5mm as a margin for smooth loading/unloading. Meanwhile, please refer to the scale on the jaws to set the datum point.

5 Pre-stamping is beneficial to both hard and soft workpieces. The former can effectively reduce wear and tear caused by workpiece on the serrated jaws; the latter can avoid workpiece deformation caused by excessive pressure for stable clamping.

6 By engaging the teeth profile of both the workpiece and the vise, clamping accuracy can be fully guaranteed; therefore, it is ideal for multi-part processing and automatic processing.

7 Customized serrated jaws of the stamping unit are acceptable.

Simple setting, Quick pre-stamping, which can greatly improve the reliability of five-axis processing.

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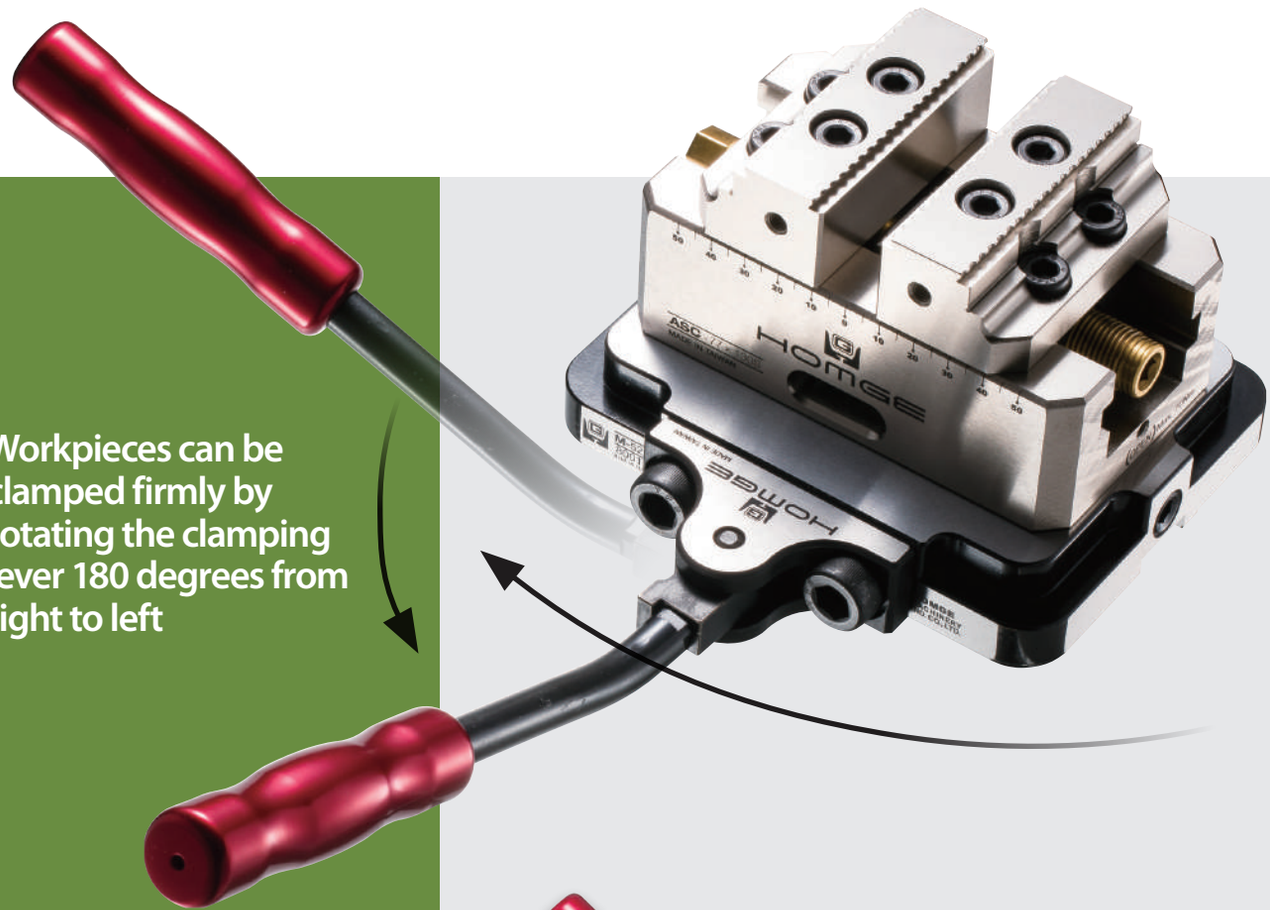
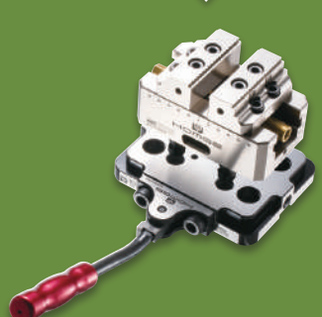
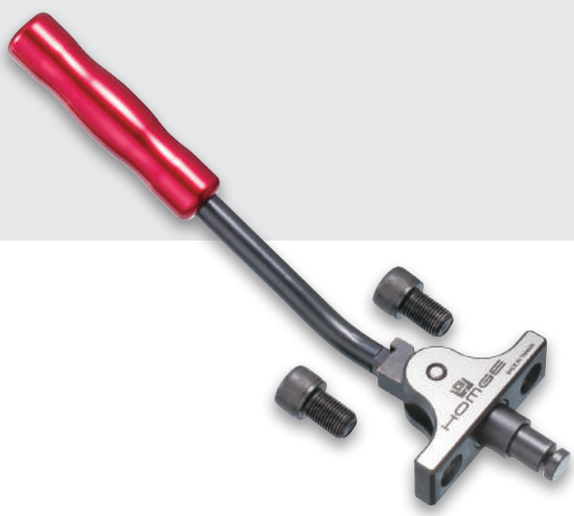
FAST ACTUATION SYSTEM



Workpieces can be clamped firmly by rotating the clamping lever 180 degrees from right to left





Model: M-52x52AS

- 1 set
- Weight: 0.49 kg / set

Model: M-96x96AS

- 1 set
- Weight: 0.63 kg / set