









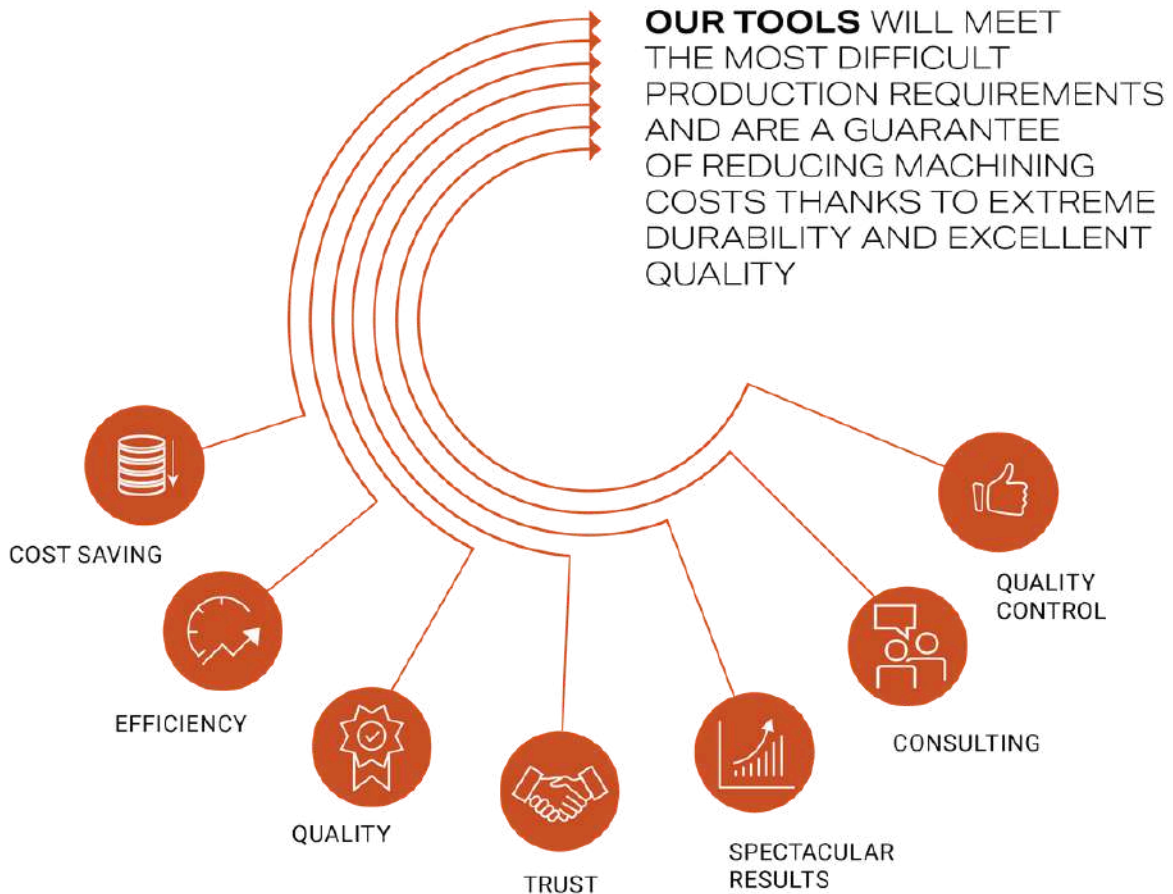
CLAMPING SYSTEMS

THE TOOL PRECISION
IS THE DETAIL PRECISION



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HUMM CLAMP

5-AXIS CENTRIC VISES

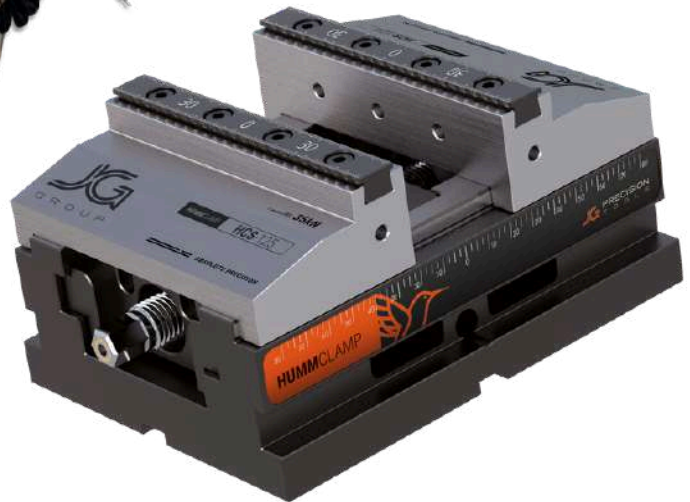
HUMM CLAMP modular 5-axis centric viSes with replaceable jaws and toothed inserts are a revolution on the clamping systems market. Our non-standard approach to 5-axis vises **ensures material and time savings**. We guarantee **a stable production process** in your company.

Easy and quick replacement of key components without tools. **Stable grip, no twisting, lifting or blocking of the jaws**, and high repeatability and clamping force. These are the features that characterize the HUMM CLAMP series of centric vises and make our vises **ideal for working in difficult conditions**.

WATCH THE VIDEO



Scan the code and watch the material presenting the capabilities of our vises.



MAIN INFORMATION

about Humm Clamp vises

Humm Clamp vises are mainly designed for rough machining and working with pre-machined materials. They are not intended for precision or finishing machining, which requires small dimensional tolerances.



Suitable for rough machining



Quick jaw replacement/rotation system



High clamping force in vises

KEY FEATURES

-  High repeatability of clamping
-  High clamping force of 27 kN in the HC-125 vise and 14 kN in the HC-80 vise
-  Guides preventing transverse twisting of the jaws and blocking
-  No lifting of the jaws during tightening of the workpiece
-  Chip and coolant discharge holes
-  Working range: 0–95 mm and 93–180 mm
-  Possibility of mounting two parts simultaneously thanks to the use of a central jaw
-  No 'dead spot' in the jaw spacing
-  Central spindle screw adjustment
-  Hardened, ground body
-  Can be attached to a table using clamps
-  Possibility of manufacturing a base compatible with ZeroPoint APS, WPS, ZeroAct, UNILOCK
-  Various types of attachment jaws
-  Possibility of making extensions from steel or aluminium

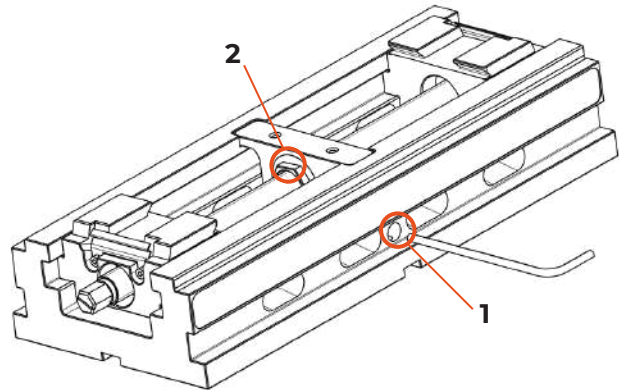
HOW TO INCREASE THE RIGIDITY OF THE CLAMPING

procedure manual

It is possible to achieve greater vise rigidity, thereby reducing vibration during machining and increasing precision. However, this results in a shorter service life for consumables.

How to adjust the precision of the vise and the repeatability of clamping?

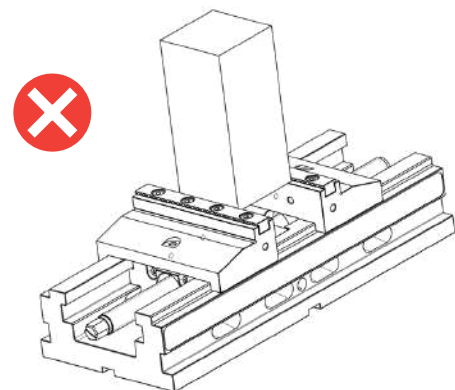
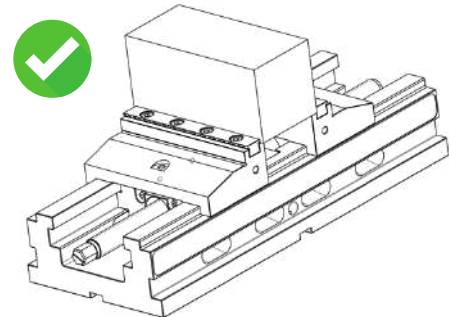
- Loosen the screw marked with number 1 using a 4 mm Allen key
- Tighten or loosen the 22 mm or 19 mm nut marked with the number 2 using a flat spanner
- Screw the screw marked with number 1 back in until it stops



When the vise is tightened more firmly, the screw works with greater resistance. This solution is particularly effective when there is vibration on the workpiece during machining or when higher precision and repeatability of clamping is required.

Recommended method of clamping parts in a vise

For machining tall workpieces, we recommend using the lowest possible jaws to minimise material deflection. If the workpiece moves, consider clamping it in the smooth parts of the jaws using toothed inserts to increase the contact area with the workpiece. If it is not possible to grip more material, we recommend changing the clamping method so that the workpiece is gripped by the longer edge of the material.

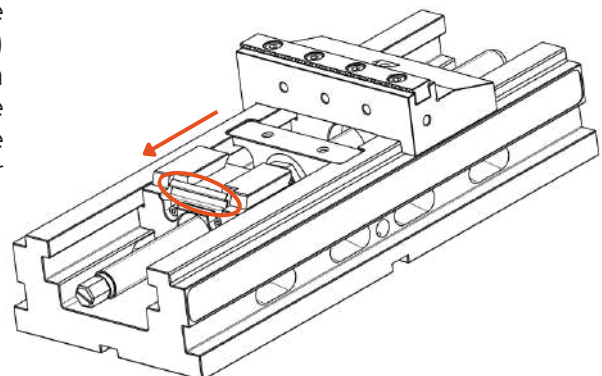


Jaw construction clearance – normal feature

Toothed inserts (due to their tightening) may have a clearance of approx. 0.03 mm. We do not recommend performing finishing operations with them.

Loose jaws and their movement when the vise is not clamped (without a workpiece clamped) is a natural occurrence. This does not indicate a defect in the vise. After clamping the workpiece, the jaws adjust to the workpiece and the vise body, thus maintaining proper contact with the surface.

It is possible to stiffen the jaw on the body. To do this, bend the metal plate in the movable insert in the body in the appropriate direction (see the drawing opposite).



READY-MADE VISE SETS

HC-80-SET



HC-125-SET

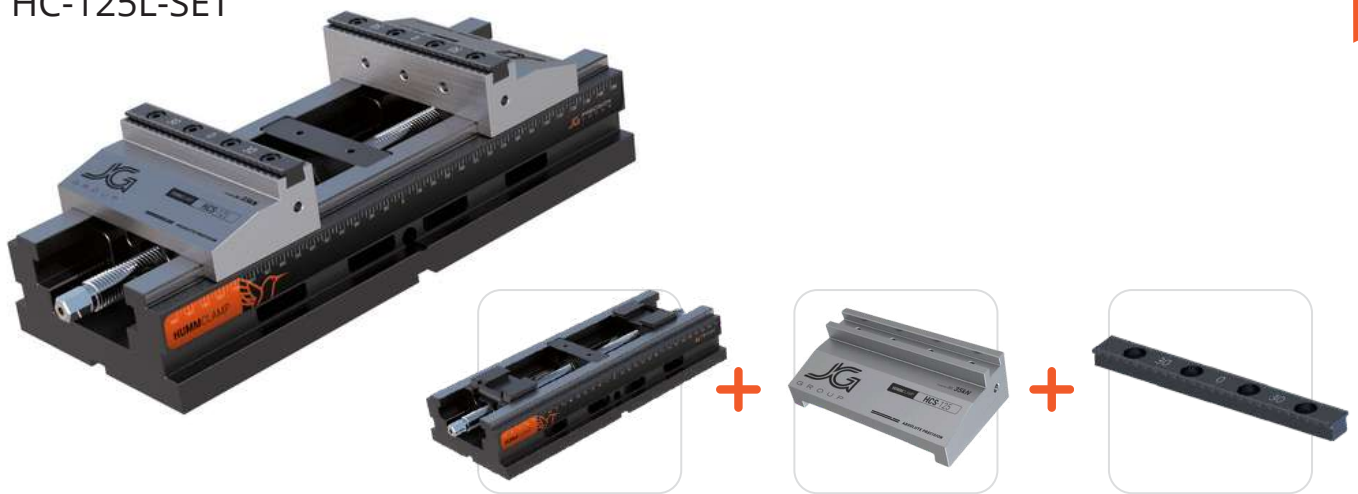


HC-125-FJ-SET

A fixed jaw vise is a type of vise in which one of the jaws is permanently attached to the base of the vise.

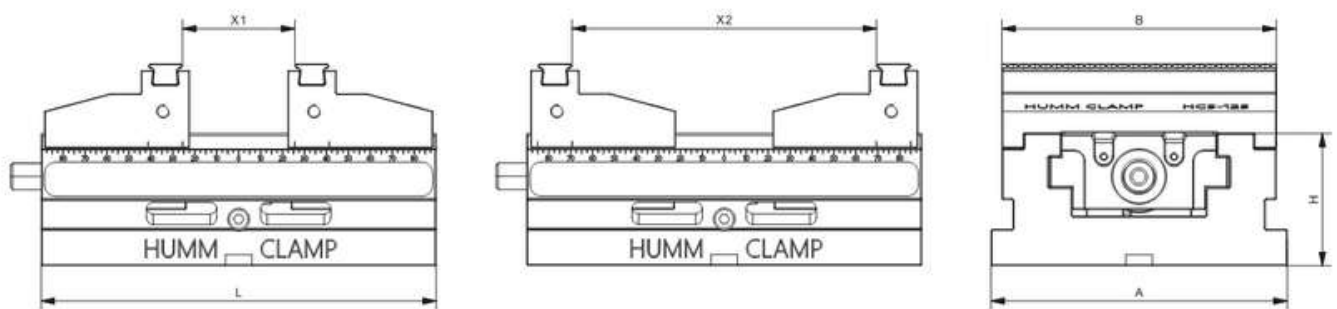


HC-125L-SET



HC-125L-FJ-SET

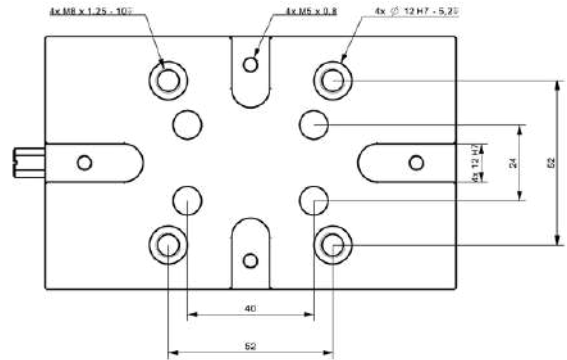
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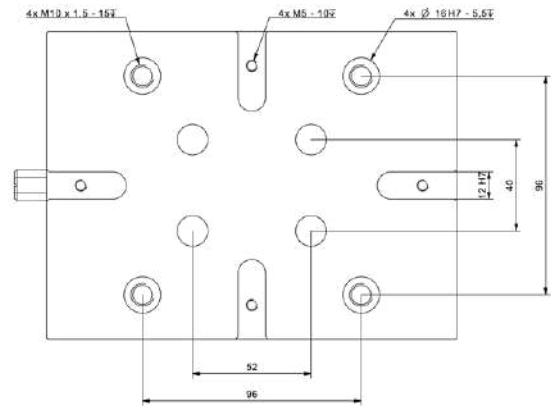
STOCK NO.	Weight (kg)	L (mm)	H (mm)	A (mm)	B (mm)	X1 (mm)	X2 (mm)
HC-80-SET	3,5 kg	130	47	80	80	0 - 75	55 - 130
HC-125-SET	10,5 kg	180	60	135	125	0 - 95	93 - 180
HC-125-FJ-SET	11 kg	205	60	135	125	0 - 75	93 - 160
HC-125L-SET	15 kg	320	60	135	125	0 - 195	93 - 290
HC-125L-FJ-SET	16 kg	344	60	135	125	0 - 190	93 - 280

WISE BODIES

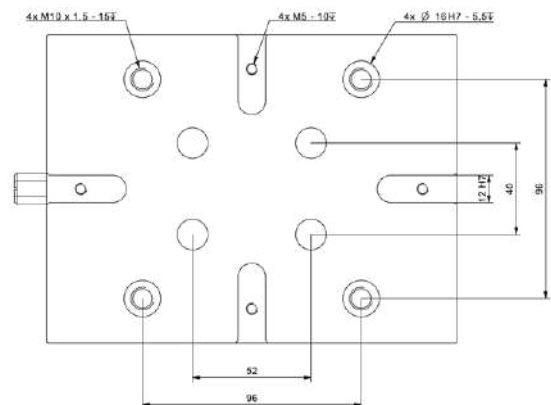
HC-80



HC-125

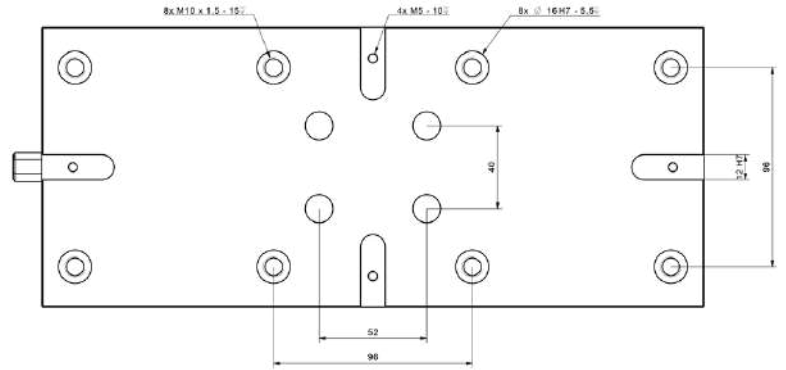


HC-125-FJ

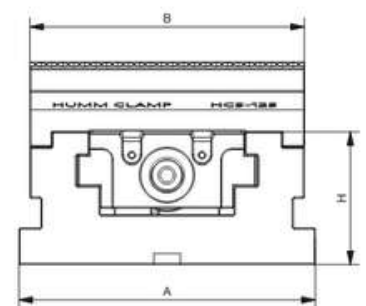
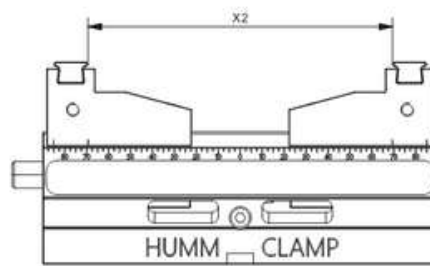
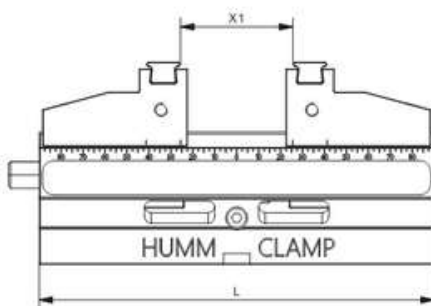
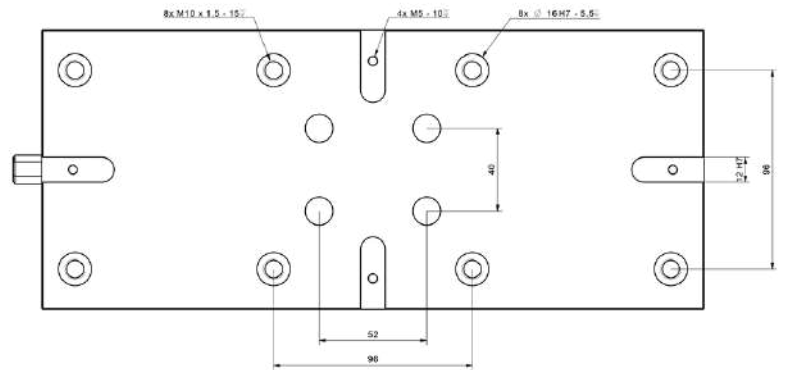


VICE BODIES

HC-125L



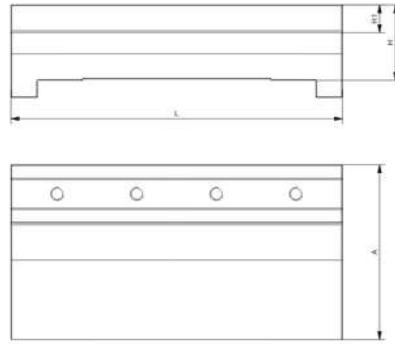
HC-125L-FJ



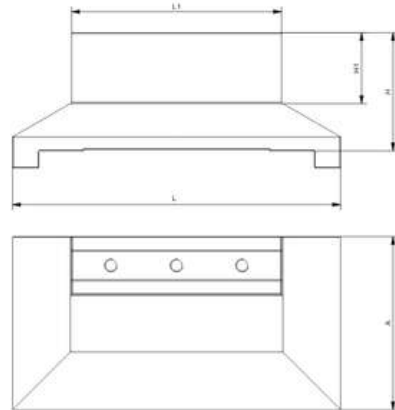
STOCK NO.	Fixing holes	Weight (kg)	L (mm)	H (mm)	A (mm)	B (mm)
HC-80	52x40 and 52x52	2,8 kg	130	47	80	80
HC-125	52x40 and 96x96	8,3 kg	180	60	135	125
HC-125-FJ	52x40 and 96x96	8,8 kg	205	60	135	125
HC-125L	52x40 and 96x96	12,8 kg	320	60	135	125
HC-125L-FJ	52x40 and 96x96	13,8 kg	344	60	135	125

JAWS

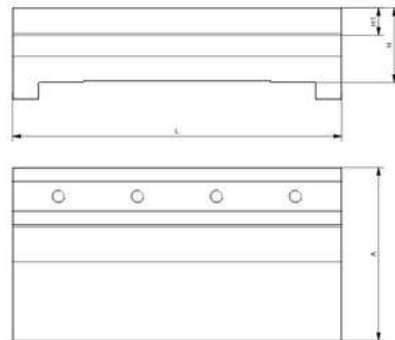
HCS-125



HCS-125-5X



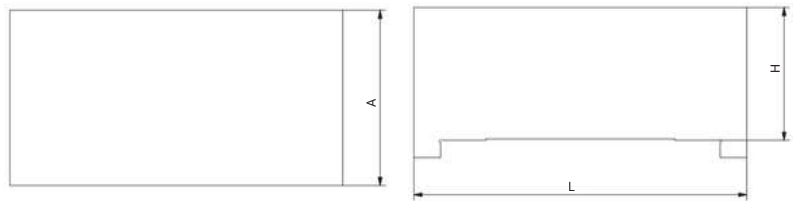
HCS-125-W



STOCK NO.	Weight (kg)	L (mm)	L1 (mm)	H (mm)	H1 (mm)	A (mm)	Dedicated tooth inserts
HCS-80	0,3 kg	80	-	20	8,5	42	HCW-80
HCS-80-5X	0,36 kg	80	50	35	23,5	42	HCW-80-5X
HCS-80-W	0,45 kg	80	-	35	23,5	42	HCW-80
HCS-125	1 kg	125	-	28,5	10,5	66	HCW-125 HCW-125-2
HCS-125-5X	1,32 kg	125	80	45	27	66	HCW-125-5X
HCS-125-W	1,1 kg	125	-	45	27	66	HCW-125 HCW-125-2

FLAT JAWS

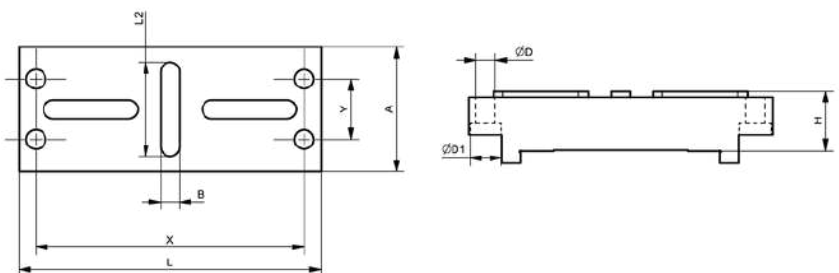
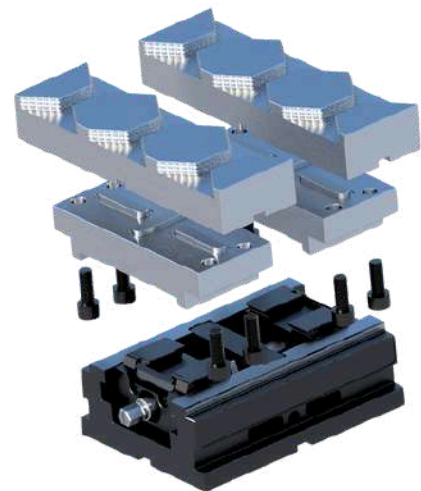
Thanks to the universal clasp that fits Humm Clamp vises, each flat jaw can be individually machined and adapted by the customer to specific processing needs.



STOCK NO.	L (mm)	H (mm)	A (mm)
HCS-80-F	80	35	42
HCS-125-F	125	50	66

BASE JAWS

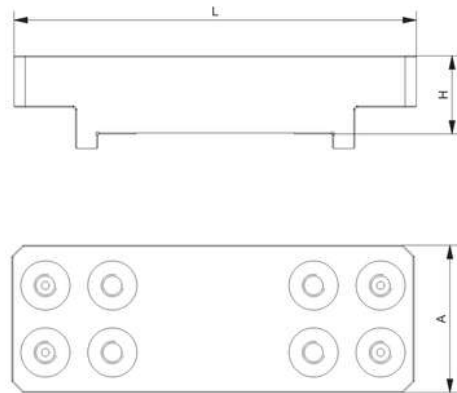
The base jaw is a universal base to which you can screw any self-made upper part of the jaw. Special assembly elements ensure connection, enabling the creation of many different jaws, adapted to various details, using one common base. The jaw is also available in a central version - HCSC-125-B.



STOCK NO.	Weight (kg)	L (mm)	H (mm)	A (mm)	ØD	ØD1	X (mm)	Y (mm)	L2 (mm)	B (mm)
HCS-80-B	0.65	112	25.5	42	8.5	13.5	92	24	32	8
HCS-125-B	1.95	160	31.5	66	10.2	16.5	92	24	32	8
HCSC-125-B	1.95	160	31.5	66	10.2	16.5	92	24	32	8

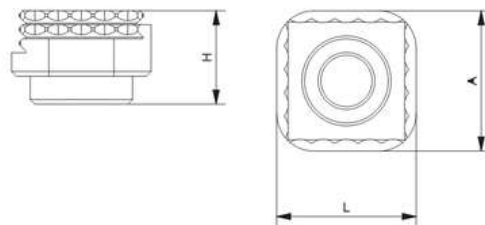
SYSTEM JAW

The system jaw, thanks to replaceable inserts, allows you to grip details of any, irregular shape. Enables quick and easy attachment of details by placing inserts in selected holes.



STOCK NO.	Weight (kg)	L (mm)	H (mm)	A (mm)	Dedicated tooth inserts
HCS-125-S	2,5 kg	180	40	66	HCW-125-SU

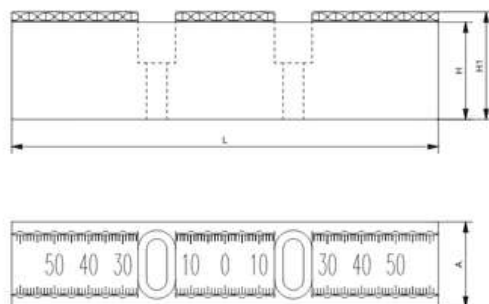
SYSTEM INSERT



STOCK NO.	Weight (kg)	L (mm)	H (mm)	A (mm)	Mounting screws
HCW-125-SU	0,1 kg	30	20	30	M10

CENTER JAW WITH INSERT

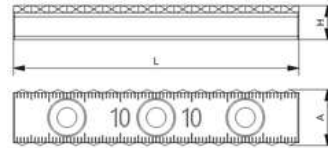
HCSC-125



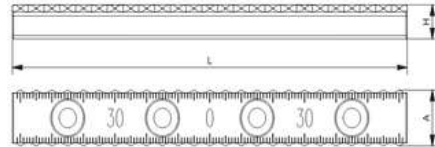
STOCK NO.	Weight (kg)	L (mm)	H (mm)	H1 (mm)	A (mm)	Mounting screws
HCSC-125	0,7 kg	125	28,5	31,5	25	M5

TOOTH AND SMOOTH INSERTS

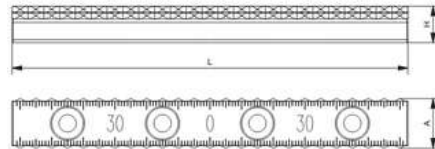
HCW-125-5X



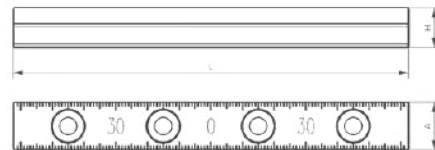
HCW-125



HCW-125

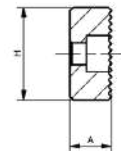
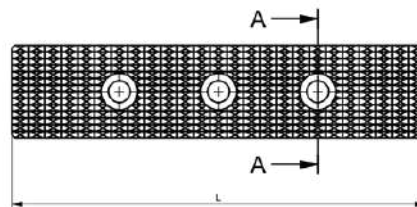


HCW-125-G



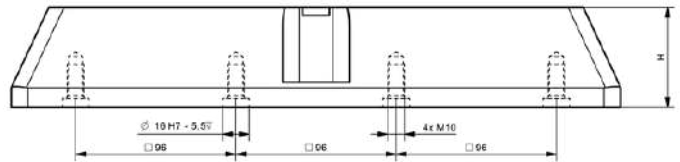
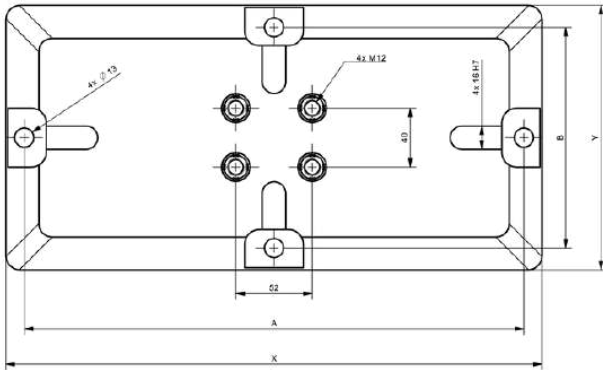
STOCK NO.	Weight(kg)	L (mm)	H (mm)	A (mm)	Mounting screws
HCW-80	0,05 kg	80	9,5	12,6	M3
HCW-80-5X	0,03 kg	50	9,5	12,6	M3
HCW-125	0,1 kg	125	9,5	15,5	M3
HCW-125-5X	0,1 kg	80	9,5	15,5	M3
HCW-125-2	0,12 kg	125	11,5	15,5	M3

TOOTHED CAP FOR JAWS



STOCK NO.	Weight (kg)	L (mm)	H (mm)	A (mm)	Mounting screws	Fits jaws
HCAN-z	0,3 kg	125	28	12,5	M6	HCS-125 / HCS-125-W

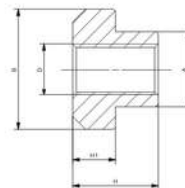
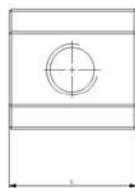
RISERS



STOCK NO.	Dimensions (mm)	Height (mm)	Vise mounting holes (mm)	Holes for mounting pins (mm)	Weight (kg)
HC-80-P60	175x125	60	4xM8 40x24	16H7 96x96	2.4
HC-80-P120	175x125	120	4xM8 40x24	16H7 96x96	4.7
HC-125-P60	225x180	60	4xM12 52x40	16H7 96x96	5
HC-125-P120	225x180	120	4xM12 52x40	16H7 96x96	10
HC-125L-P60	365x180	60	4xM12 52x40	3x 16H7 96x96	8.65
HC-125L-P120	365x180	120	4xM12 52x40	3x 16H7 96x96	17.2

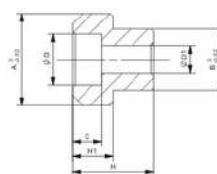
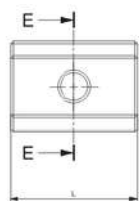
ADDITIONAL ACCESORIES

T-stones



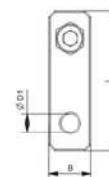
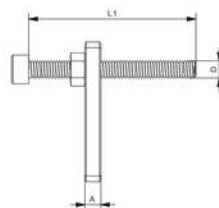
STOCK NO.	H (mm)	H1 (mm)	A (mm)	B (mm)	D (mm)	L (mm)
HCAT-1	18	9	15,6	25	M12	27
HCAT-2	20	10	17,6	28	M12	30
HCAT-3	24	12	19,6	32	M12	32
HCAT-4	28	14	21,6	35	M12	36

Base stones



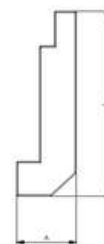
STOCK NO.	H (mm)	H1 (mm)	A (mm)	L (mm)	Mounting screws
HCAB-1	16	8	14	25	M5
HCAB-2	16	8	18	25	M5

Resistance



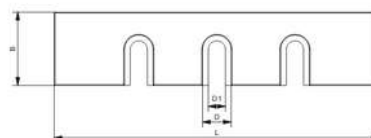
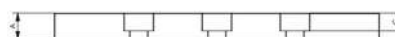
STOCK NO.	A (mm)	B (mm)	L (mm)	L1 (mm)	ØD	ØD1 (mm)
HCAO-1	6	15	50	60	M6	5,5

Vise bench



STOCK NO.	A (mm)	B (mm)	L (mm)	C (mm)	D (mm)
HCAL-1	26	40	80	16,5	35

Jaw cap*



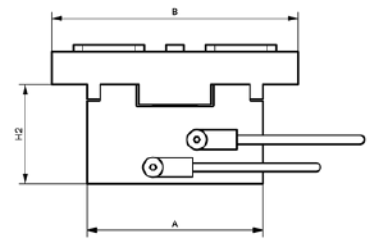
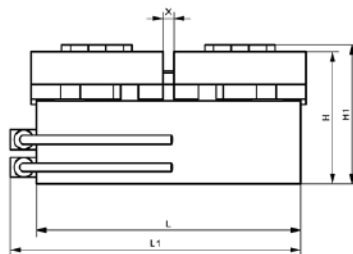
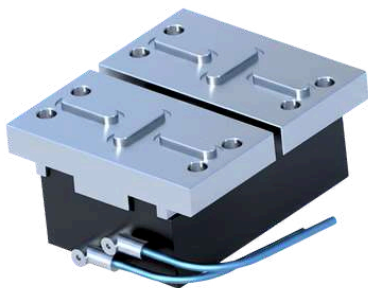
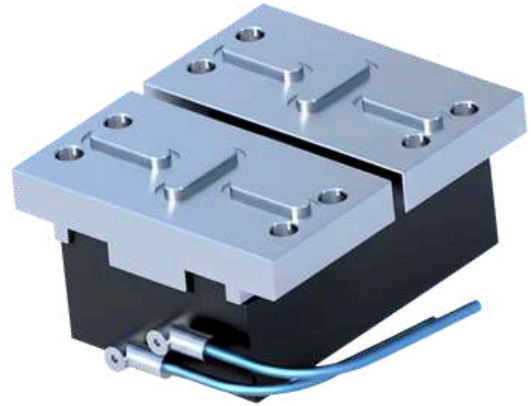
*possibility of making any size at the customer's request

PNEUMATIC VISES

A pneumatic vise enables quick and precise clamping of workpieces using compressed air. It ensures constant clamping force, increases machining repeatability and significantly reduces operation time. It is ideal for automated production processes and CNC machining.

Mechanism of action

The mechanism is based on a compressed air-powered actuator that moves the base jaws and clamps the component with repeatable force. When pressure is applied, the actuator spreads or closes the jaws to a maximum spacing of 5 mm, enabling quick, automatic clamping of the component.



STOCK NO.	L (mm)	L1 (mm)	A (mm)	B (mm)	H (mm)	H1 (mm)	H2 (mm)	X (mm)
HCP-80-SET	120	132	80	112	60	63	45	0-5
HCP-125-SET	160	172	125	160	65	68,5	50	0-5

HUMM CLAMP

CLAMPING PAWS

Clamping clamps are **the ideal solution for series production** and complement the JG Group's range of clamping systems. It provides **repeatable clamping and an extremely attractive price compared to traditional vises.**

Thanks to their serrated design, the clamping claws **guarantee a secure and robust grip**, which is suitable for a wide range of applications, especially when machining soft materials. Their **versatility and durability** make them an indispensable choice for both advanced industrial plants and smaller workshops.

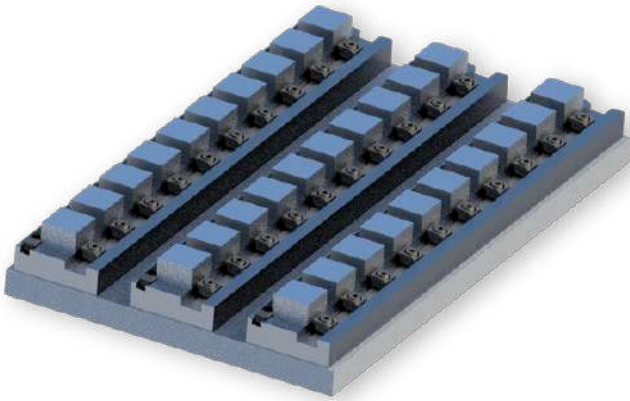
We currently offer **three sizes of clamps, M8, M10 and M12**, which, depending on the size, **have two or three rows of serrated teeth** on the workpiece clamping surface.

WATCH THE VIDEO



Scan the code and watch the material presenting the capabilities of our paws.

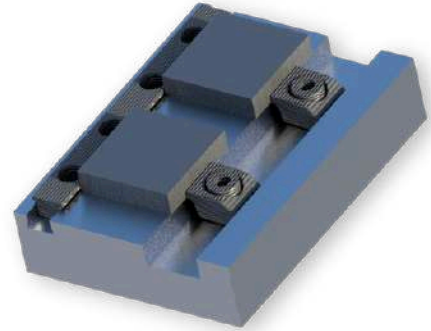




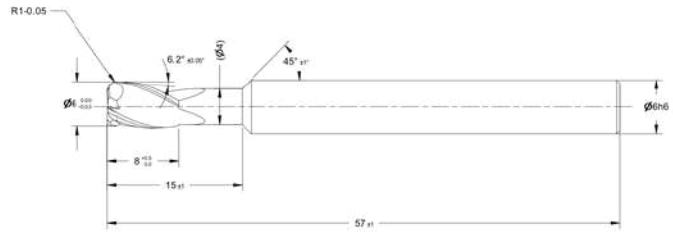
A simple and effective solution for series production, which is a great alternative to machine vises.



The set includes the option of purchasing toothed inserts, as well as a milling cutter to make a socket for the insert, so that it is possible to repeatedly mount the insert in the device together with the clamping paws.

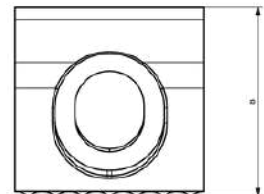
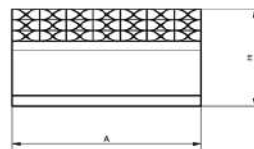


Milling cutter for making a socket for a toothed insert



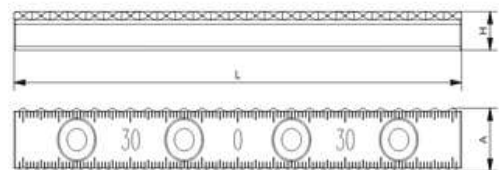
JG CODE	∅	Lc (mm)	L1	L2	R
JG00043539	6	57	8	15	1

Clamping paws



JG CODE	H (mm)	A (mm)	B (mm)	Fixing screw	O-ring	Number of rows of teeth
HCLD-M8	12	20	25	M8	8x2.5	2
HCLD-M10	15	25	30	M10	10x2.5	2
HCLD-M12	18	35	35	M12	12x2.5	3

Tooth inserts



JG CODE	Weight (kg)	L (mm)	H (mm)	A (mm)	Fixing screw	Number of rows of teeth
HCW-125	0,1 kg	125	9,5	15,5	M5	1
HCW-125-2	0,12 kg	125	11,5	15,5	M5	2

HUMM MULTI

LIGHT MULTI VISES

At **JG Group**, we have created **innovative HUMM MULTI vises**, which combine a **solid steel structure with a light base made of a mixture of concrete and resin**. Using this material, we reduced the weight of the system by approximately **55%**, while maintaining full stiffness and strength. An additional advantage over traditional steel multi vises is excellent vibration damping during operation.

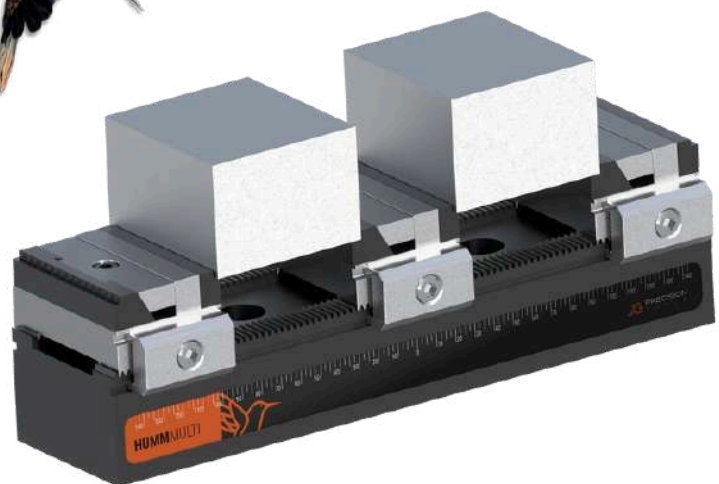
HUMM MULTI modular clamping systems for CNC machines facilitate the assembly and disassembly of elements and allow the clamping of more elements at the same time.

All parts **can be purchased separately** in our company, and the strip can be freely configured. There is no need to buy the entire system with jaws and inserts.

WATCH THE VIDEO



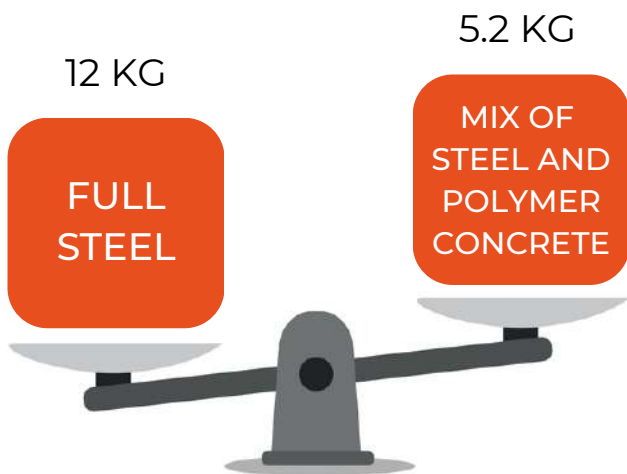
Scan the code and watch the material presenting the capabilities of our multi vises.



In the HUMM MULTI series, the jaw is universal. In practice, this means that the jaw fits any strip length. Depending on individual production needs, two, three or a maximum of six jaws can be mounted on it and any number of details can be processed simultaneously. Importantly, **it is possible to place several strips next to each other** and process a proportionally larger number of details at the same time.

A total of six types of inserts fit into the jaw, which differ in height and teeth, improving the stability of clamping elements.

What makes our systems an attractive alternative to classic steel vises? **It's primarily about reduced weight.** Take care of your employees and let them work in more favorable conditions, without additional fatigue and heavy lifting.



HUMM MULTI

THE MOST IMPORTANT FEATURES

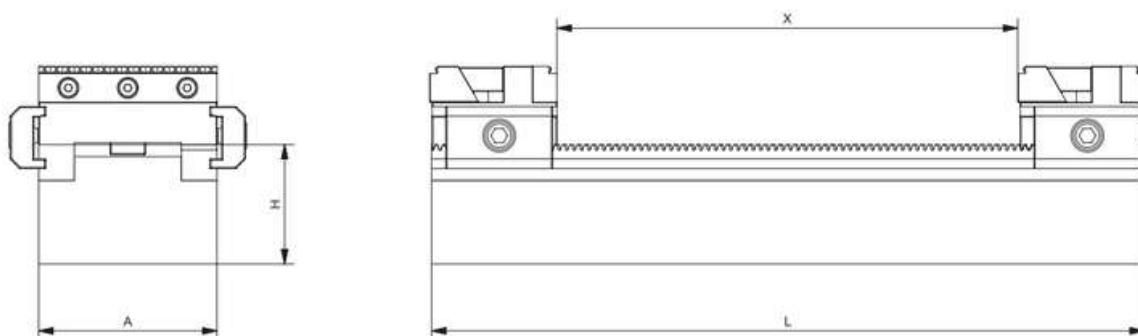
- reduced weight of the strip by approximately 55% compared to the same strip made of steel
- polyurethane filling that dampens vibrations
- possibility of installing several elements at the same time
- possibility of processing raw elements, as well as pre-machined details
- large range of detail clamping
- jaws with replaceable inserts
- quick attachment of the jaws to the strip with one screw
- universality of use – for large and small elements
- possibility of modular assembly strips next to each other or in line
- multi vises are perfect for both horizontal applications as well as vertical machining centers
- possibility of adapting the base of the strip to the customer's needs

FIXING STRIPES

HM-300



HM-350



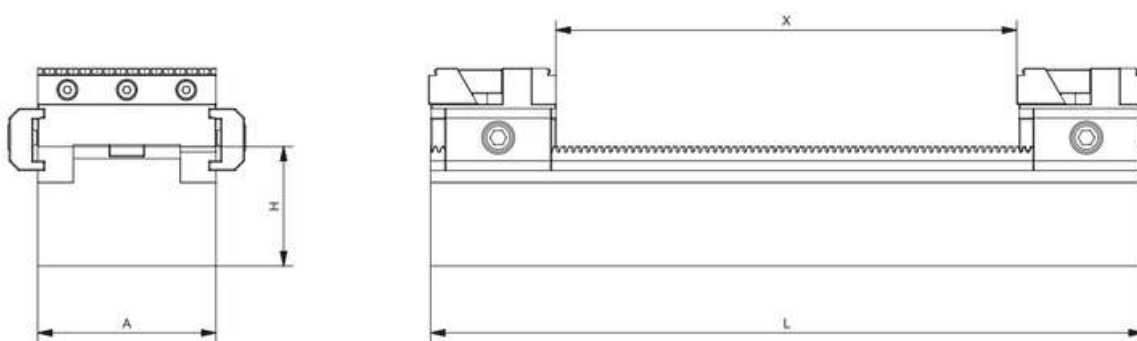
STRIPE	Weight (kg)	L (mm)	A (mm)	H (mm)	X (mm)
HM-300	3,5 kg	300	75	50	195
HM-350	10,5 kg	350	75	50	245
HM-450	11 kg	450	75	50	345
HM-600	15 kg	600	75	50	495

FIXING STRIPES

HM-450



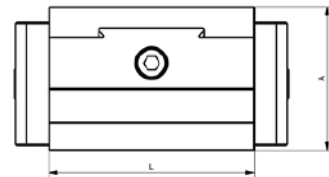
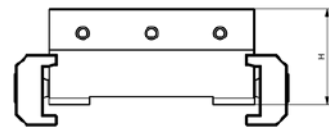
HM-600



STRIPE	Weight (kg)	L (mm)	A (mm)	H (mm)	X (mm)
HM-300	3,5 kg	300	75	50	195
HM-350	4 kg	350	75	50	245
HM-450	5.2 kg	450	75	50	345
HM-600	7 kg	600	75	50	495

UNIVERSAL JAW

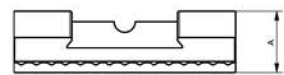
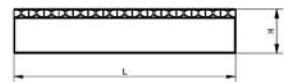
HMS-75



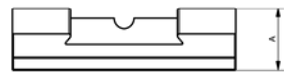
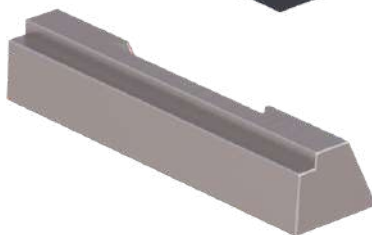
JAW	Weight (kg)	L (mm)	A (mm)	H (mm)
HMS-75	1 kg	75	52,5	36

MOVABLE JAWS INSERTS

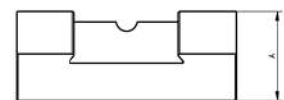
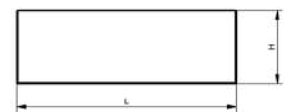
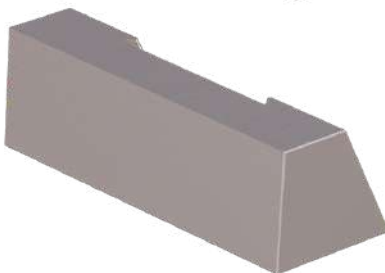
HMWr-z
tooth insert



HMWr-g
smooth insert



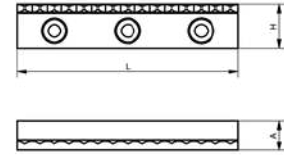
HMWr-f
flat insert



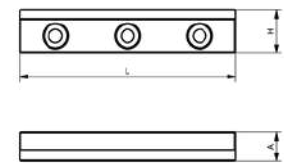
MOVABLE INSERTS	Weight (kg)	L (mm)	A (mm)	H (mm)
HMWr-z	0,12 kg	75	20,5	15
HMWr-g	0,12 kg	75	20,5	15
HMWr-f	0,12 kg	75	20,5	25

FIXED JAWS INSERTS

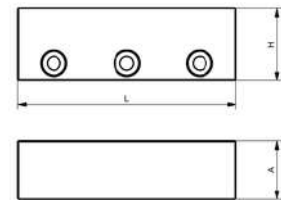
HMWs-z
tooth insert



HMWs-g
smooth insert



HMWs-f
flat insert



FIXED INSERTS	Weight (kg)	L (mm)	A (mm)	H (mm)
HMWs-z	0,1 kg	75	10	15
HMWs-g	0,1 kg	75	10	15
HMWs-f	0,3 kg	75	20	25

HUMM

SWIFT-POINT

ZERO POINT PLATES

Our **Zero-Point system** is based on the proven and popular vise hole spacing of **52×52** and **96×96** (LANG Technik standard).

The precise and easy-to-use Swift-Point system is an ideal solution for automation and shortening the time needed to prepare the machine for work. A properly designed edge of the plate makes our Zero-Point system **universal, and its installation is possible on virtually all machine tables.**

WATCH THE VIDEO

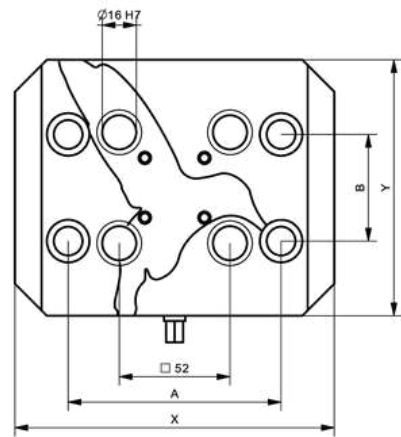


Scan the code and watch the material presenting the capabilities of our system.

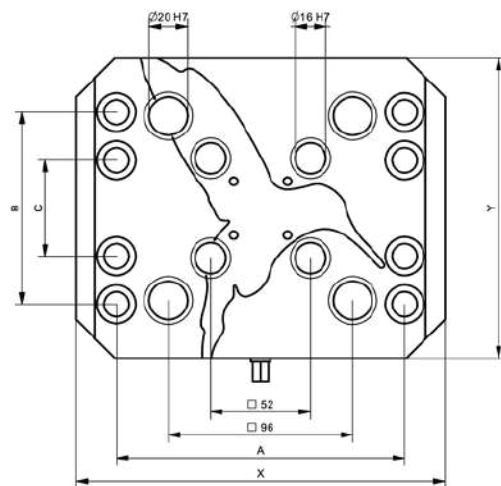


BASE PLATES

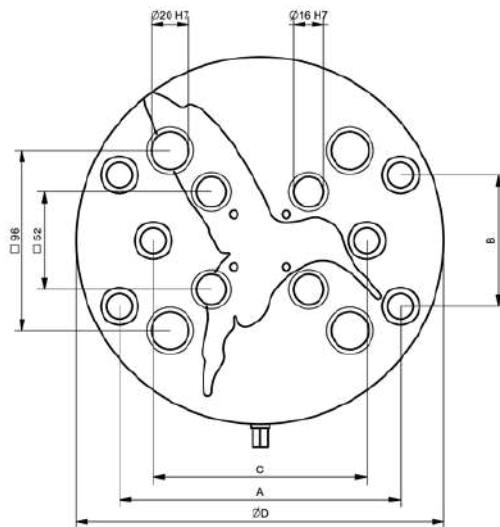
HSP-52
version for small vises



HSP-52/96
standard version
with combo spacing



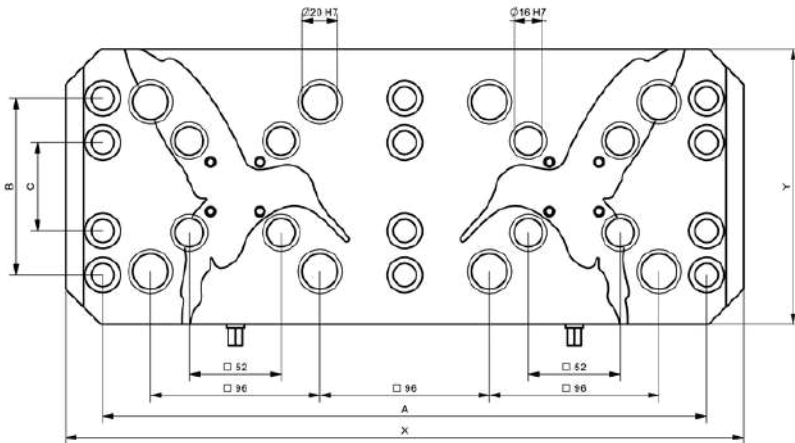
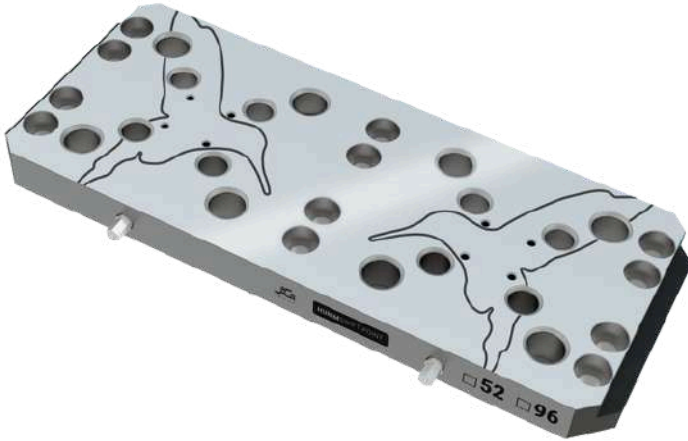
HSP-52/96-D196
standard round version
with combo spacing



Base plates	X (mm)	Y (mm)	A (mm)	B (mm)	C (mm)	$\varnothing D$	Holes for mounting pins (mm)	Weight (kg)
HSP-52	150	120	100	50	-	-	16H7 52x52	2,7
HSP-52/96	192	156	150	100	50	-	16H7 52x52 20H7 96x96	4,5
HSP-52/96-D196	-	-	150	70	114	196	16H7 52x52 20H7 96x96	5
HSP-52/96-X2	384	156	342	100	50	-	16H7 52x52 20H7 96x96	9,6

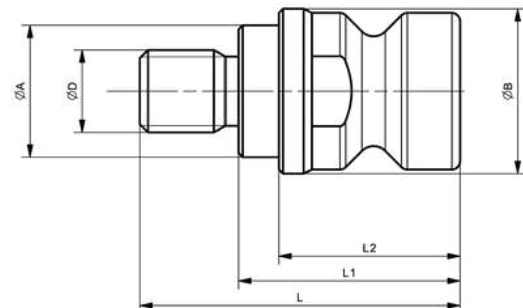
BASE PLATES

HSP-52/96-X2
 version for large vises
 with double spacing combo



Base plates	X (mm)	Y (mm)	A (mm)	B (mm)	C (mm)	∅D	Holes for mounting pins (mm)	Weight (kg)
HSP-52/96-X2	384	156	342	100	50	-	16H7 52x52 20H7 96x96	9,6

MOUNTING PINS

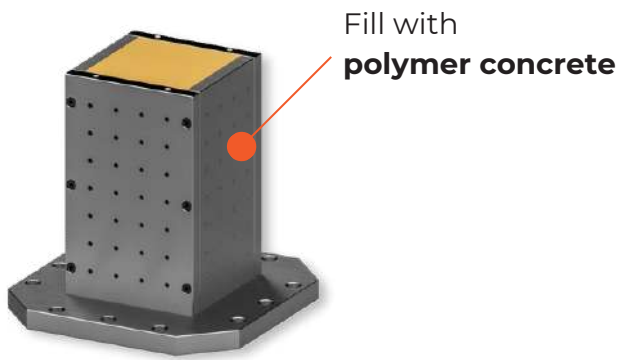






STOCK NO.	∅D	∅A	∅B	L (mm)	L1 (mm)	L2 (mm)
Pin ∅16	M8 x 1.25	∅12H6	∅16H6	34.9	26.9	22
Pin ∅20	M10 x 1.5	∅16H6	∅20H6	38.9	26.9	22

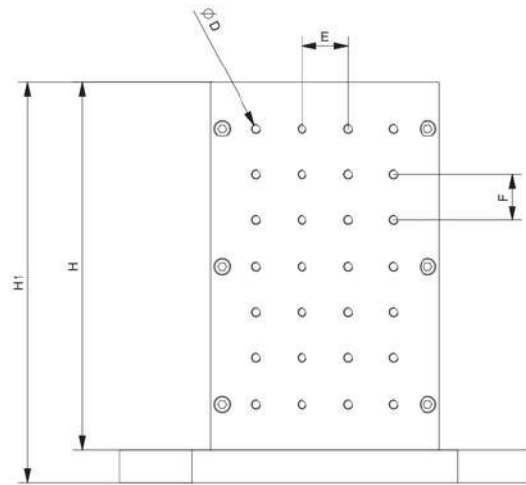
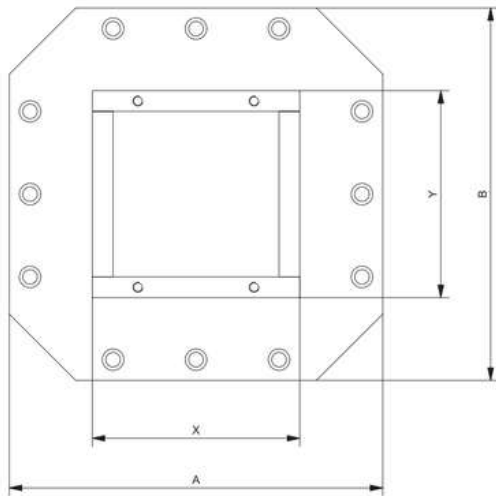
ADDITIONAL EQUIPMENT

LIGHTWEIGHT TOMBSTONES

At JG Group, we have developed our proprietary tombstones, the interior of which is filled with polyurethane. This material features vibration damping up to 10 times better than steel. The custom design allowed us to reduce the weight of the tombstone by more than 50% relative to steel, while fully maintaining rigidity and strength.



-  very good stability
-  dimensions and shape of the tower tailored to the customer's needs
-  possibility to make a tombstone with 3, 4 or 6 walls
-  tombstone base adaptable to customer's machine



H	H1	X*	Y*	A*	B*	E*	F*	ØD*
300	340	250	250	450	450	50	50	M12
350	390	250	250	450	450	50	50	M12
400	440	250	250	450	450	50	50	M12
450	490	250	250	450	450	50	50	M12
500	540	250	250	450	450	50	50	M12
550	590	250	250	450	450	50	50	M12
600	640	250	250	450	450	50	50	M12
650	690	250	250	450	450	50	50	M12

*dimensions agreed with customer upon ordering

ROTARY AXIS ADAPTER

A novelty in our offer - rotary axis adapter, custom-made for Humm Swift-Point base plate systems. This is a solution dedicated to users of CNC machining centers who are looking to expand the capabilities of the machine with an additional rotary axis - without compromising on available working space.



4-axis processing possible



compact design
in the shape of the letter “L”



custom-made
under the customer's machine

