



Accessories for Tower Workholding Systems TS, TS TriStar and TS Vector
Clamping jaws and jaw openings
Accessories for operation



Delivery of clamping jaws

All clamping jaws are supplied with the associated fixing screws.
For clamping jaws with jaw inserts, please make your selection tailored to your application.

Important notes

- By the use of clamping jaws with jaw inserts, the jaw opening is reduced by approx. 4 mm per clamping point.
- When using jaw inserts, the dimension “h” indicated in the figures is increased by 4 mm.
- Technical information and application recommendations for jaw inserts see data sheet [WS 12-SE](#).

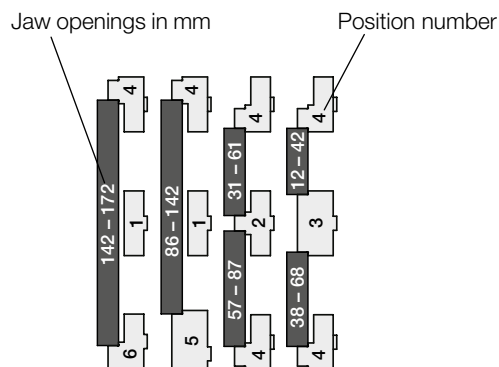
Clamping jaws

TS 80 and TS 80 TriStar

Design: with 3rd-hand function

Position	Description	Part no.
1	Guide plate	93791 4140
2	Central step jaw 16 mm	93791 4111
3	Central step jaw 54 mm	93791 4121
4	Reversible step jaw	93791 4211
5	Fixed step jaw	93791 4341
6	Fixed step jaw	93791 4311

Jaw openings

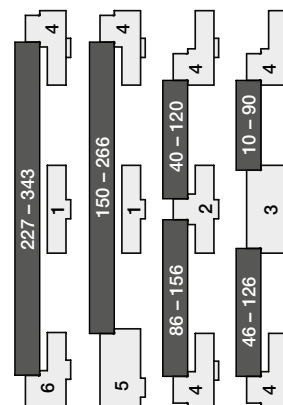


TS 100 and TS 100 TriStar

Designs: 3rd-hand function and Vector with 1 central jaw

Position	Description	Part no.
1	Guide plate	93791 5140
2	Central step jaw 26 mm	93791 5111
3	Central step jaw 86 mm	93791 5121
4	Reversible step jaw	93791 5211
5	Fixed step jaw	93791 5341
6	Fixed step jaw	93791 5311

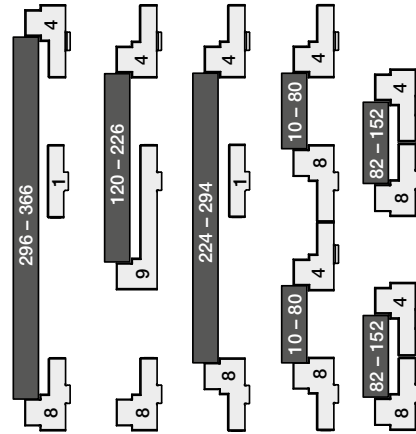
Position	Clamping jaws for jaw inserts	Part no.
2	Central step jaw for 1 jaw insert	93791 5711
3	Central step jaw for 2 jaw inserts	93791 5721
4	Reversible step jaw for 1 jaw insert	93791 5811
5	Fixed step jaw for 1 jaw insert	93791 5941
6	Fixed step jaw for 1 jaw insert	93791 5911



TS 100 and TS 100 TriStar

Design: TS Vector with 2 fixed jaws

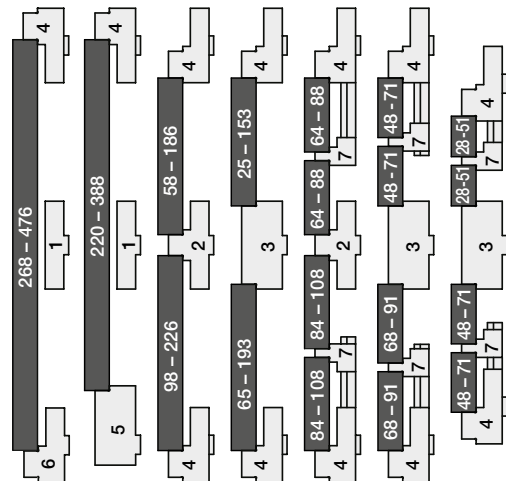
Position	Description	Part no.
1	Guide plate	937915143
4	Reversible step jaw	937915211
8	Fixed reversible step jaw	937915371
9	Fixed step jaw, long	937915381
Position	Clamping jaws for jaw inserts	
4	Reversible step jaw for 1 jaw insert	937915811
8	Fixed reversible step jaw for 1 jaw insert	937915971
9	Fixed step jaw, long, for 1 jaw insert	937915981



TS 125 and TS 125 TriStar

Designs: 3rd-hand function and Vector with 1 central jaw

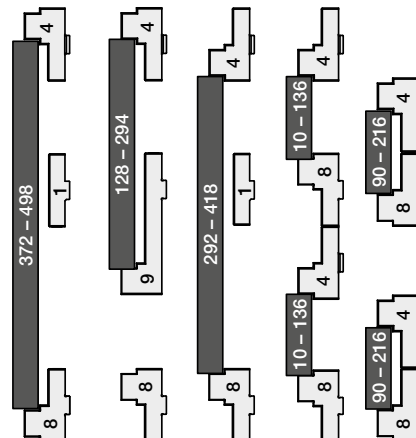
Position	Description	Part no.
1	Guide plate	937916142
2	Central step jaw 24 mm	937916151
3	Central step jaw 90 mm	937916161
4	Reversible step jaw	937916211
5	Fixed step jaw	937916351
6	Fixed step jaw	937916311
7	Floating central jaw	937916511
Position	Clamping jaws for jaw inserts	
2	Central step jaw for 1 jaw insert	937916751
3	Central step jaw for 2 jaw inserts	937916761
4	Reversible step jaw for 1 jaw insert	937916811
5	Fixed step jaw for 1 jaw insert	937916951
6	Fixed step jaw for 1 jaw insert	937916911



TS 125 and TS 125 TriStar

Design: TS Vector with 2 fixed jaws

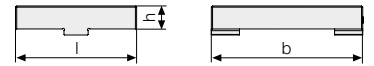
Position	Description	Part no.
1	Guide plate	937916143
4	Reversible step jaw	937916211
8	Fixed reversible step jaw	937916371
9	Fixed step jaw, long	937916381
Position	Clamping jaws for jaw inserts	
4	Reversible step jaw for 1 jaw insert	937916811
8	Fixed reversible step jaw for 1 jaw insert	937916971
9	Fixed step jaw, long, for 1 jaw insert	937916981



Dimensions of clamping jaws

Position 1: Guide plates for 3rd-hand function and Vector
Design with 1 central jaw

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	12							93791 4140
TS 100	96	100	16							93791 5140
TS 125	100	125	19							93791 6142

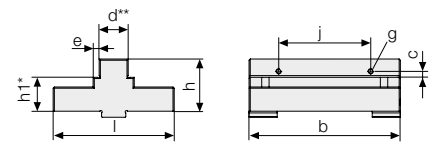


Position 1: Guide plates for Vector
Design with 2 fixed jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	72	100	16							93791 5143
TS 125	78	125	19							93791 6143

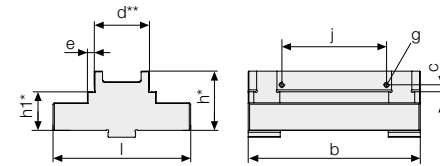
Position 2: Central step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	28	16	5	16	5	M4x6	50	93791 4111
TS 100	96	100	40	25	5	26	5	M4x6	60	93791 5111
TS 125	100	125	43	28	5	24	5	M4x6	76	93791 6151



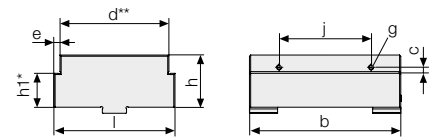
Position 2: Central step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	96	100	40	25	5	34	3	M4x6	60	93791 5711
TS 125	100	125	43	28	5	40	5	M4x6	76	93791 6751



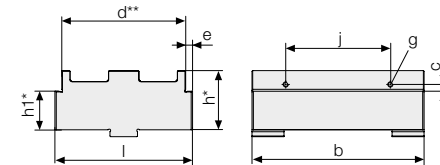
Position 3: Central step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	28	16	5	54	5	M4x6	50	93791 4121
TS 100	96	100	40	25	5	86	5	M4x6	60	93791 5121
TS 125	100	125	43	28	5	90	5	M4x6	76	93791 6161



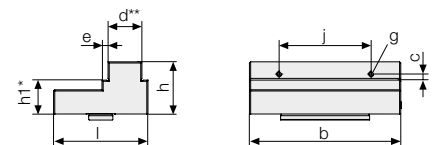
Position 3: Central step jaws for 2 jaw inserts

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	96	100	40	25	5	90	3	M4x6	60	93791 5721
TS 125	100	125	43	28	5	90	5	M4x6	76	93791 6761



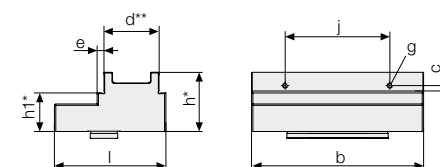
Position 4: Reversible step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	48.5	80	28	16	5	18	5	M4x6	50	93791 4211
TS 100	72	100	40	25	5	26	5	M4x6	60	93791 5211
TS 125	78	125	43	28	5	28	5	M4x6	76	93791 6211



Position 4: Reversible step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	72	100	40	25	5	34	3	M4x6	60	93791 5811
TS 125	81	125	43	28		40	5	M4x6	76	93791 6811



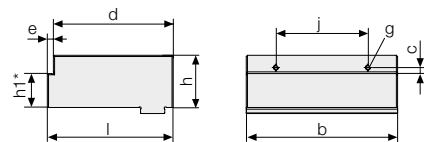
* Tolerance ±0.01 mm
 ** Tolerance ±0.02 mm

Accessories

Clamping jaws and clamping jaws for jaw inserts

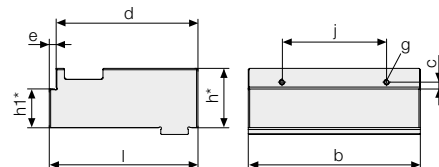
Position 5: Fixed step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	71	80	28	16	5	66	5	M4x6	50	937914341
TS 100	88	100	40	25	5	83	5	M4x6	60	937915341
TS 125	104	125	43	28	5	99	5	M4x6	76	937916351



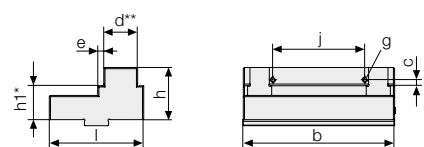
Position 5: Fixed step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	90	100	40	25	5	85	5	M4x6	60	937915941
TS 125	108	125	43	28	5	103	5	M4x6	76	937916951



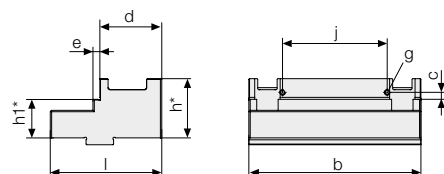
Position 6: Fixed step jaws, used for a large clamping range

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	49	80	28	16	5	15	5	M4x6	50	937914311
TS 100	72	100	40	25	5	26	5	M4x6	60	937915311
TS 125	78	125	43	28	5	28	5	M4x6	76	937916311



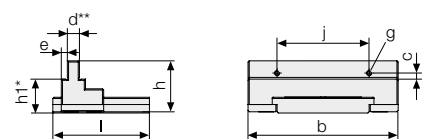
Position 6: Fixed step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	80	100	40	25	5	34	5	M4x6	60	937915911
TS 125	88	125	43	28	5	40	5	M4x6	76	937916911



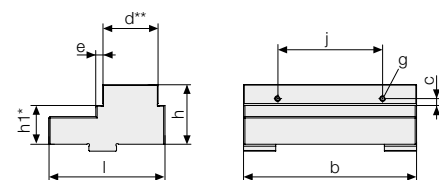
Position 7: Floating central jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	50/80	124	43	28	5	10	5	M4x6	76	937916511



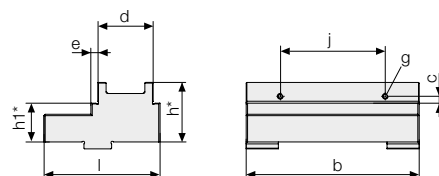
Position 8: Fixed reversible step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	72	100	40	25	5	26		M4x6	60	937915371
TS 125	78	125	43	28	5	28		M4x6	76	937916371



Position 8: Fixed reversible step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	81	100	40	25	5	34	5	M4x6	60	937915971
TS 125	88	125	43	28	5	40	5	M4x6	76	937916971



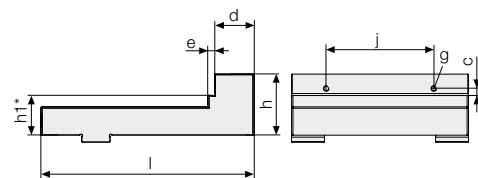
* Tolerance ± 0.01 mm
** Tolerance ± 0.02 mm

Accessories

Clamping jaws and clamping jaws for jaw inserts

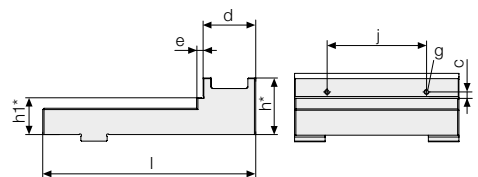
Position 9: Fixed step jaws, long, for TS Vector

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	142	100	40	25	5	34	5	M4x6	60	937915381
TS 125	164	125	43	28	5	40	5	M4x6	76	937916381



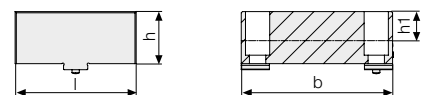
Position 9: Fixed step jaws, long, for 1 jaw insert for TS Vector

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	142	100	40	25	5	34	5	M4x6	60	937915981
TS 125	164	125	43	28	5	40	5	M4x6	76	937916981



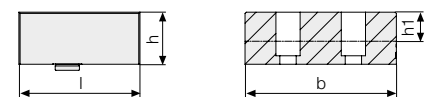
Central jaws, soft

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	35	21						937914411
TS 100	96	100	40	23						937915411
TS 125	100	125	43	24						937916411



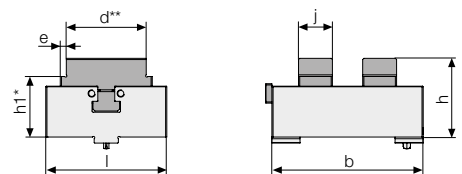
Reversible jaws, soft

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	56	80	35	21						937914421
TS 100	84	100	40	23						937915421
TS 125	100	125	43	24						937916421



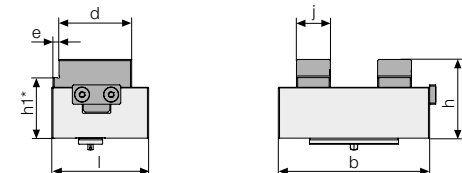
SlimFlex central jaws with inserts

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	100	125	65	50		66	5		28	937916173



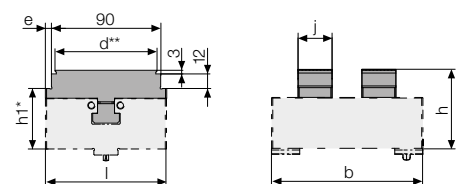
SlimFlex clamping jaws with inserts

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	80	125	65	50		60	5		28	937916273



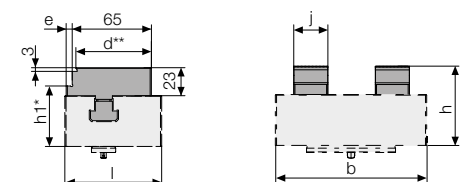
Universal retaining piece with step grip and smooth, for SlimFlex central jaw

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	100	125	65	50		84	5		28	737918173



Universal retaining piece with step grip and smooth, for SlimFlex clamping jaw

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	80	125	65	50		62	5		28	737918174



* Tolerance ±0.01 mm
** Tolerance ±0.02 mm

Accessories for operation

Torque wrench



Type	Part no.	Torque [Nm]
TS 80	937926600	5–60
TS 100	937926610	20–120
TS 125	937926610	20–120

Socket for torque wrench



Type	Part no.	SW
TS 80	131240021	12
TS 100	131240020	14
TS 125	131240017	17

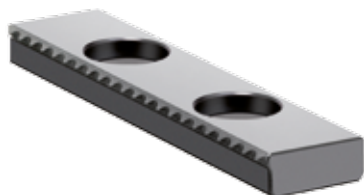
Allen wrench for clamping jaws and jaw inserts



Type	Part no.	SW
TS 100	169110003	8
TS 125	169110005	10

Accessories Jaw inserts

Jaw inserts grip serrated



Grip

Jaw inserts with coatings



Hard metal coarse



TUC fine

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

Recommendation for jaw inserts to increase the retention forces

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

Part numbers for jaw inserts

Jaw inserts for TS 100 and TS 100 Vector jaw width 100

Designation	Part no. for reversible step jaws	Part no. for fixed jaws and central jaws
Jaw inserts Grip / smooth	5 5050 0632	5 5050 0548
Jaw inserts Grip / Grip	-	5 5050 0630
Jaw inserts HM coarse / smooth	5 5050 0631	5 5050 0749
Jaw inserts HM coarse / HM smooth	-	5 5050 0629
Jaw inserts TUC / smooth	5 5050 0770	5 5050 0769
Jaw inserts TUC / TIC	-	5 5050 0768
Jaw inserts smooth / smooth	-	5 5050 0628

Jaw inserts for TS 125 jaw width 125

Designation	Part no. for reversible step jaws	Part no. for fixed jaws and central jaws
Jaw inserts Grip / smooth	5 5050 0627	5 5050 0729
Jaw inserts Grip / Grip	-	5 5050 0625
Jaw inserts HM coarse / smooth	5 5050 0626	5 5050 0694
Jaw inserts HM coarse / HM smooth	-	5 5050 0624
Jaw inserts TUC / smooth	5 5050 0767	5 5050 0777
Jaw inserts TUC / TIC	-	5 5050 0768
Jaw inserts smooth / smooth	-	5 5050 0623

Jaw inserts for TS 125 Vector with 2 fixed jaws jaw width 125

Designation	Part numbers for reversible step jaws	Part numbers for fixed jaws
Jaw inserts Grip / smooth	5 5050 0627	5 5050 0627
Jaw inserts HM coarse / smooth	5 5050 0626	5 5050 0626
Jaw inserts TUC / smooth	5 5050 0767	5 5050 0767