

TRU-FORCE CHUCK

QUICK-FIX MOUNTING SYSTEM

SELF-CENTERING VISE

TOMBSTONES

CHUCKS FOR CLAMPING HEADS

SELF-CENTERING MILLING FIXTURES



BISON

2024

BISON

NEW PRODUCT RELEASES

NEW

BISON

4397

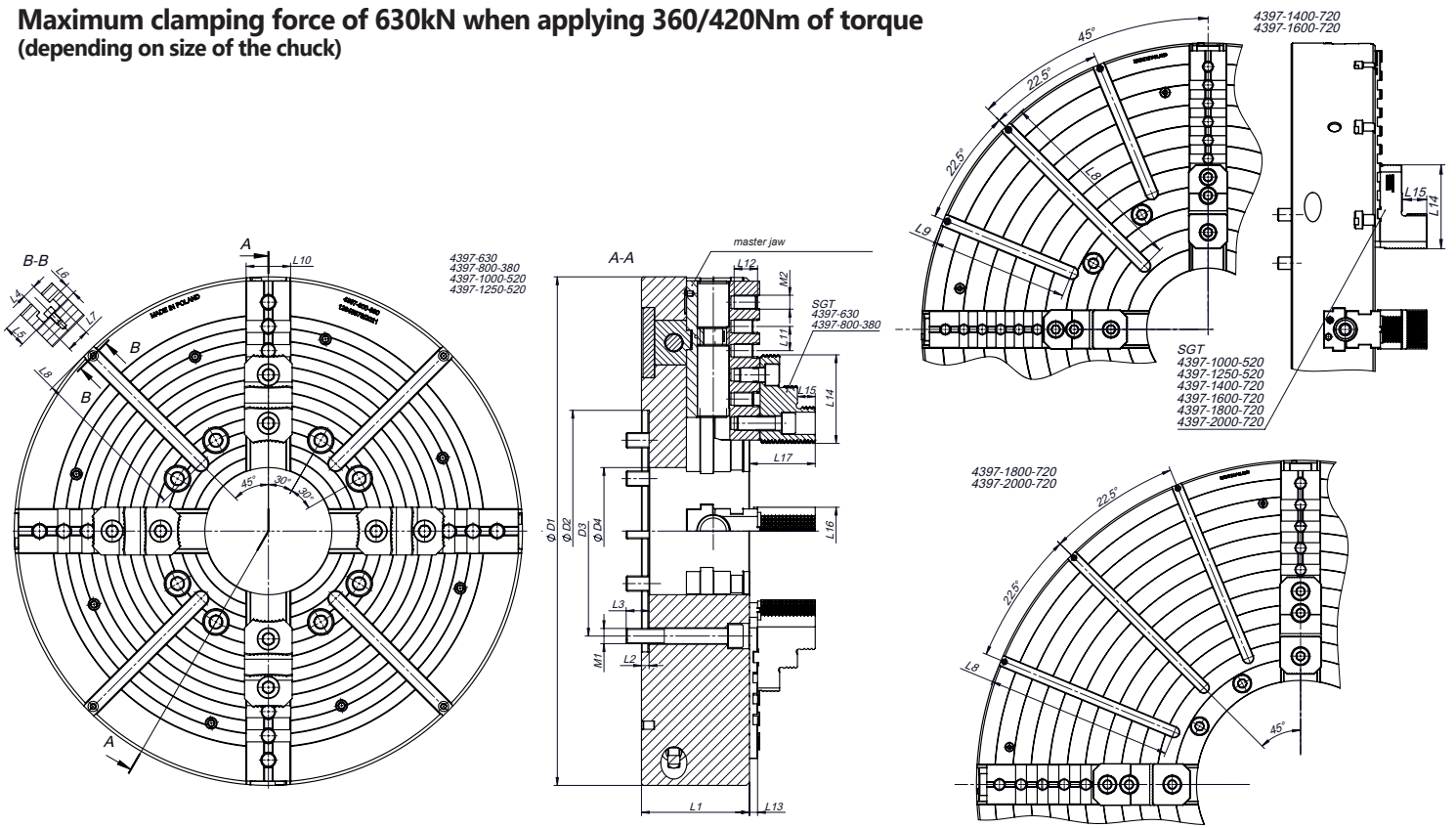
**Tru-Force 4-Jaw Independent
Chuck With Wedge Jaw System**



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**Maximum clamping force of 630kN when applying 360/420Nm of torque
(depending on size of the chuck)**



Type	4397-630	4397-800-380	4397-1000-520	4397-1250-520	4397-1400-720	4397-1600-720	4397-1800-720	4397-2000-720
Code No.	354397020000	354397030100	354397041600	354397050500	354397060700	354397070900	354397080000	354397090200
D1	630	800	1000	1250	1400	1600	1800	2000
D2	270	380	520	520	720	720	720	720
D3	235	330.2	463.6	463.6	647.6	647.6	647.6	647.6
D4	160	200	200	210	300	300	578	578
L1	170	170	190	190	205	205	220	220
L2	12	12	12	12	12	12	12	12
L3	30	36	36	36	45	45	45	45
L4	22	22	22	28	28	28	28	28
L5	35	35	35	50	50	50	50	50
L6	16	16	16	20	20	20	20	20
L7	37	37	37	46	46	46	46	46
L8	160	250	340	400	480	550	520	620
L9	-	-	-	-	340	440	-	-
L10	70	70	70	70	90	90	110	110
L11	38.1	38.1	38.1	38.1	45	45	60	60
L12	34	34	39	39	39	39	54	54
L13	12.8	12.8	12.8	12.8	12.8	12.8	20.8	20.8
L14	135	135	150	150	205	205	270	270
L15	28	28	60	60	60	60	60	60
L16	75	75	80	80	95	95	115	115
L17	103.5	103.5	121.5	121.5	126.5	126.5	144.5	149.5
M1	M20	M24	M24	M24	M30	M30	M30	M30
M2	M22	M22	M24	M24	M24	M24	M30	M30
Master jaw stroke	9	9	9	9	9	9	9	9
Weight	375.5	587.6	1049.7	1672.2	2189.2	2914	3768.2	4767.8
Max. detail weight without support	240	400	800	1300	1900	2500	3300	4100
Max. detail weight with support	15000	20000	35000	40000	45000	50000	55000	55000
Max. rotation speed	970	760	610	490	440	380	340	300
Max. clamping force/torque on wrench [kN]/[Nm]	630/360	630/360	630/360	630/360	630/420	630/420	630/420	630/420



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NEW

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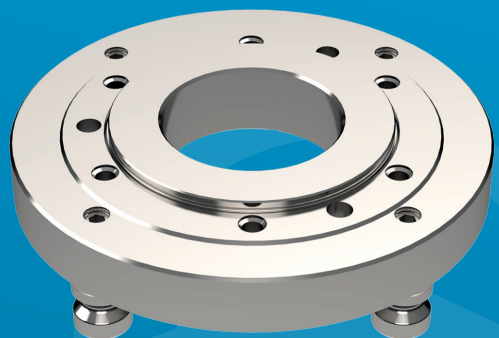
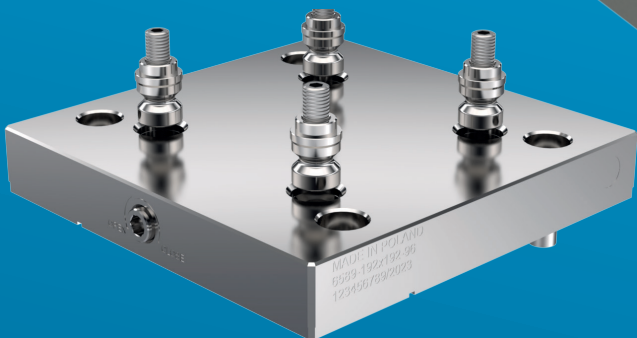
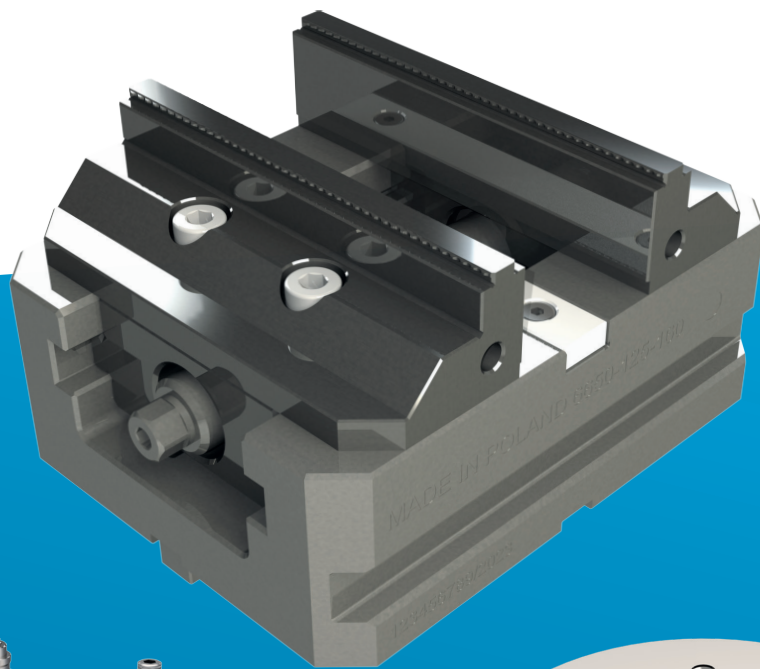
6650

6589

9470

Quick-Fix Clamping System:

- 5-axis self-centering vise
- Base plates for vises
- Base plates for chucks



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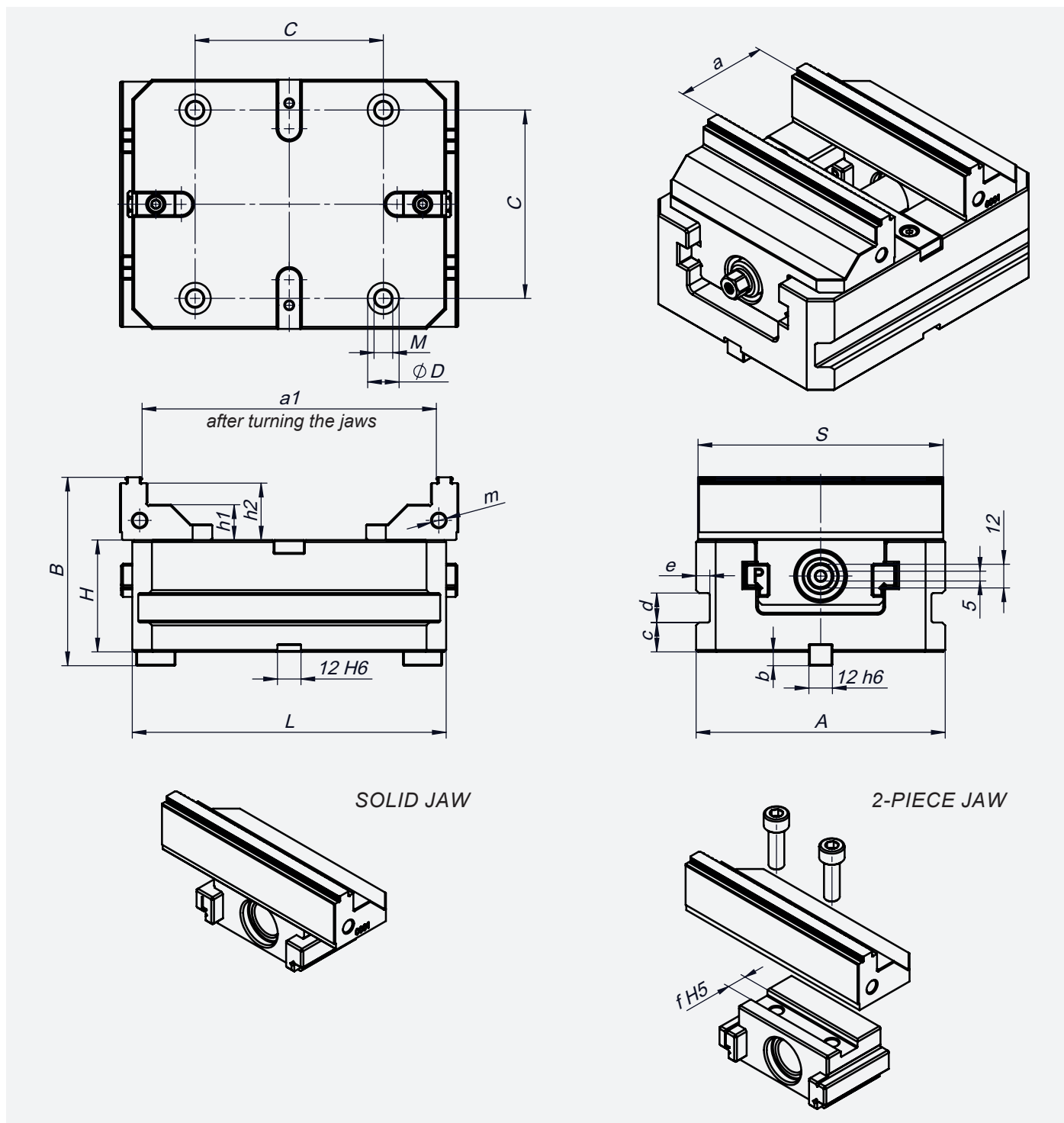


Features:

- Compact and symmetrical design makes this vise ideal for 5-axis machining centers.
- Using the serrated jaws reduces the area needed for holding the workpiece to only 3 mm, which ensures better access to the workpiece from multiple angles and enables more complex machining operations. The advantage is reducing the machining cycle time, as well as the number of required machining operations and frequency of the tool exchanges.
- The vise can be mounted on the machine table with clamps and T-nuts or with Bison type 6589 quick-fix bases. The vise is also compatible with 52 mm and 96 mm quick-fix bases available on the market (size of the compatible base depends on size of the vise).
- Wide clamping range can be further increased by reversing the jaws.
- The vise jaws have serrated surfaces, which can bite into raw or heat-treated material. Pre-stamping is not required.
- The jaws also have ground surfaces for clamping machined materials.
- The jaws allow for mounting side-stops.
- The operating screw is heat-treated for increased service time.
- The vises with 2-piece jaws allow for exchanging the hard top jaws with soft top jaws. The soft top jaws can be machined for clamping irregular shaped parts.
- Self-centering clamping action distributes the clamping force between both jaws. The force is more evenly distributed across the area of the workpiece, minimizing the risk of damage or deformation.

Additional accessories:

- Soft jaws
- Fastening pins
- Side Stop



Code No.	Type	S	L	H	A	B	C	ØD	M	a	a1	h1	h2	m	b	c	d	e	f	Centering accuracy	Weight [kg]	Jaw type	ACCESSORIES	
																							Soft jaws set	Fastening pins
7-226-031	6650-80-105 SJ	80	105	38	82	70.5	52	12	M8	6+56	56+91	12	22	M6	7.5	13	12	6	12	0.02	2.5	solid	-	6589-M8 ZP SL 32600000900
7-226-032	6650-80-105	80	105	38	82	70.5	52	12	M8	6+56	56+91	12	22	M6	7.5	13	12	6	12	0.05	2.5	2-piece	SGM 6650-80 398267710600	6589-M8 ZP SL 32600000900
7-226-051	6650-125-160 SJ	125	160	57	127	96	96	16	M10	6+80	72+150	18	29	M8	7	15	15	7	16	0.02	8.75	solid	-	6589-M10 ZP SL 32600000700
7-226-052	6650-125-160	125	160	57	127	96	96	16	M10	6+80	72+150	18	29	M8	7	15	15	7	16	0.05	8.75	2-piece	SGM 6650-125 398267711900	6589-M10 ZP SL 32600000700
7-226-055	6650-125-310 SJ	125	310	57	127	96	96	16	M10	6+230	72+300	18	29	M8	7	15	15	7	16	0.02	14.35	solid	-	6589-M10 ZP SL 32600000700
7-226-056	6650-125-310	125	310	57	127	96	96	16	M10	6+230	72+300	18	29	M8	7	15	15	7	16	0.05	14.35	2-piece	SGM 6650-125 398267711900	6589-M10 ZP SL 32600000700

6589

PATENTED

Quick-Fix Mounting Base Series 6589

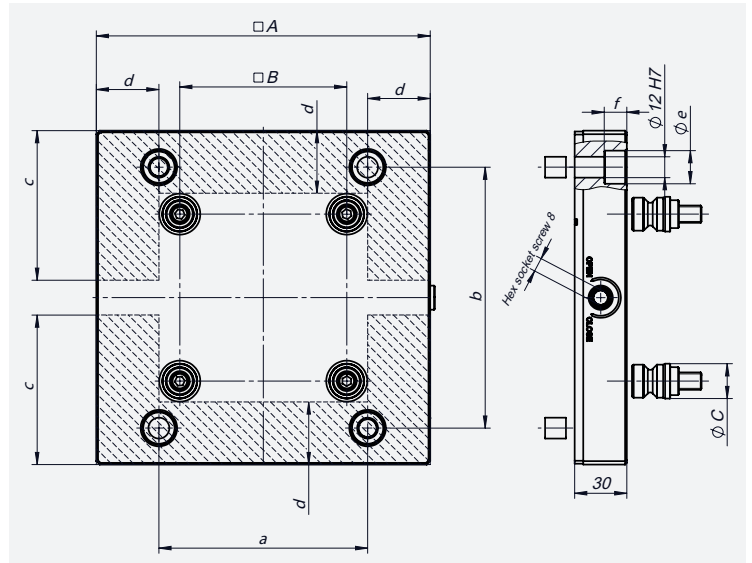


Code No.	Type	A	B	C	a*	b*	c	d	e	f
7-631-3045	6589-105x105-52	104	52	16	82	82	44	16	16.8	11
7-631-3089	6589-192x192-96	192	96	20	120	150	86	36	19	13
326589011000	6589-105x105-52 BL	104	52	16	**	**	44	16	16.8	11
326589032600	6589-192x192-96 BL	192	96	20	**	**	86	36	19	13

* Standard location of mounting pins, custom setups available on request.

** The "BL" type baseplates are produced without mounting holes.

Machinable area for mounting holes or sockets for clamps - made on customer's request.



Features:

- High repeatability with mounting hole tolerance of ± 0.005 mm tolerance.
- Mounting plate height tolerance of 0.01mm.
- Low-profile mounting plate (30 mm height).
- Quick-action mounting, using only one screw.
- Suitable for mounting vises, other fixtures or direct mounting of workpieces with pre-made mounting holes, matching the location of the mounting pins.
- Pre-made base mounting holes for M10 bolts, available arrangements: 82x82 mm or 120x150 mm. Other setups of mounting holes or sockets for clamps available on request.

The Bison quick-fix system is equivalent to the following systems:

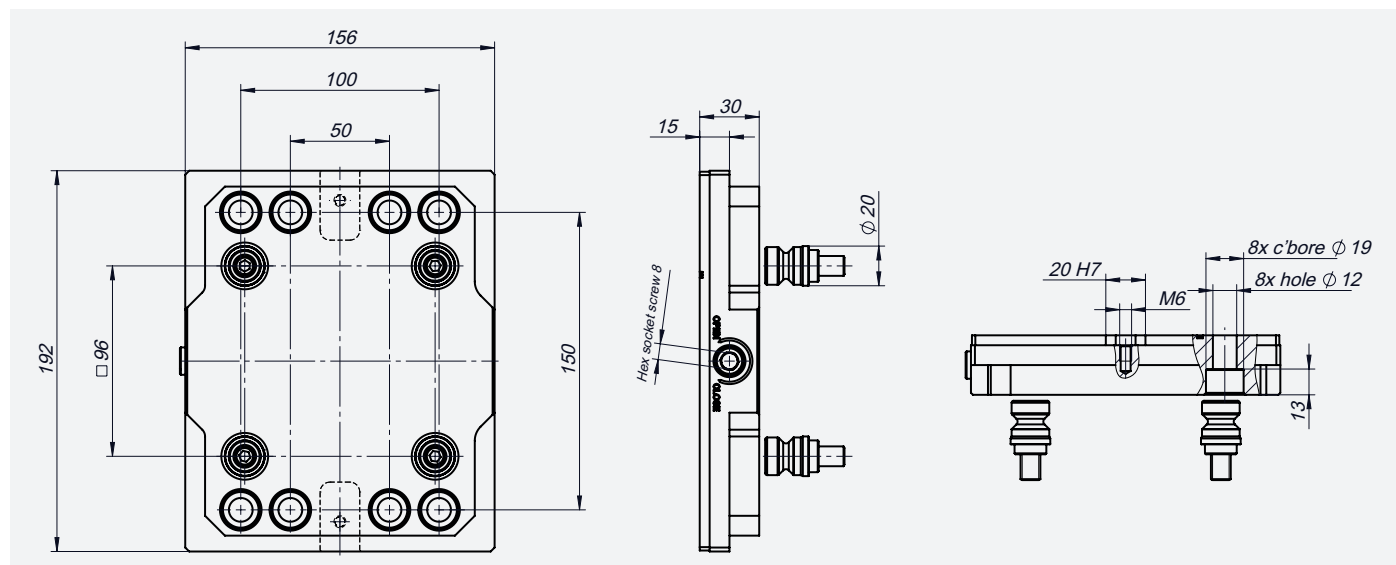
- LANG Quick Point series
- Gerardi QUICK CHANGE TABLE FOR COMPACT GRIP VISES Art. 660
- Piranha Clamp Zero Point
- HWR SolidPoint

6589- FOR T-SLOT MOUNTING

Quick-Fix Mounting Base Series 6589



PATENTED



Features:

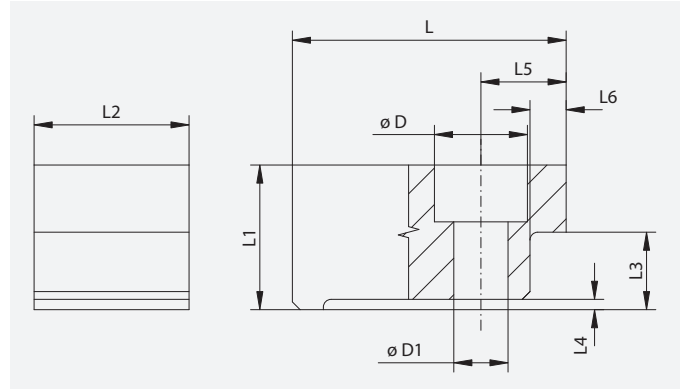
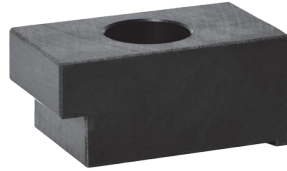
- High repeatability with mounting hole tolerance of ± 0.005 mm tolerance.
- Mounting plate height tolerance of 0.01 mm.
- Low-profile mounting plate (30 mm height).
- Quick-action mounting, using only one screw.
- Suitable for mounting vises, other fixtures or direct mounting of workpieces with pre-made mounting holes, matching the location of the mounting pins.
- Pre-made base mounting holes for M10 bolts, available arrangements: 82x82 mm or 120x150 mm. Other setups of mounting holes or sockets for clamps available on request.

The Bison quick-fix system is equivalent to the following systems:

- LANG Quick Point series
- Gerardi QUICK CHANGE TABLE FOR COMPACT GRIP VISES Art. 660
- Piranha Clamp Zero Point
- HWR SolidPoint

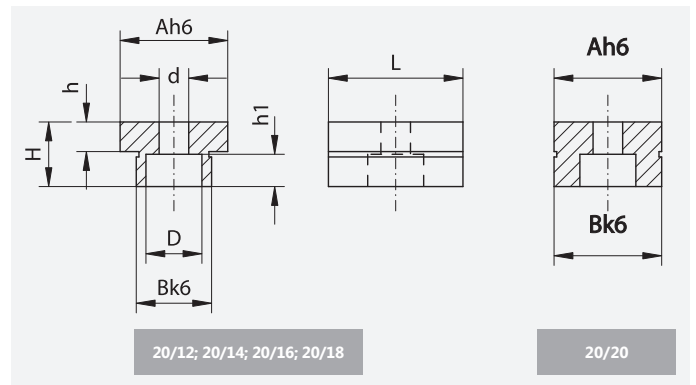
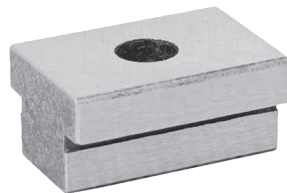
The Bases Type 6589 For T-Slot Mounting Use Clamps And Keys Offered By Bison.

TOE CLAMP



Code No.	L	L1	L2	L3	L4	L5	L6	D	D1
398266720000	53	28	30	15	2	16.6	7.0	18	10.5
398263660100	62	22.5	28	15	2	20	8	20	13

T-SLOT NUT

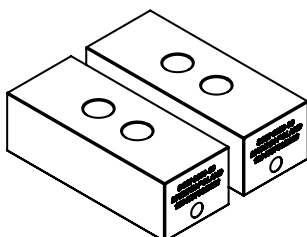


Code No.	Size	A	B	L	H	h	h1	D	d
398263758200	20/12	20	12	25	12	4.5	6.8	10.4	6.6
398263760200	20/14	20	14	25	12	4.5	6.8	10.4	6.6
398263762800	20/16	20	16	25	12	4.5	6.8	10.4	6.6
398263764300	20/18	20	18	25	12	4.5	6.8	10.4	6.6
398263766900	20/20	20	20	25	12	4.5	6.8	10.4	6.6

Accessories

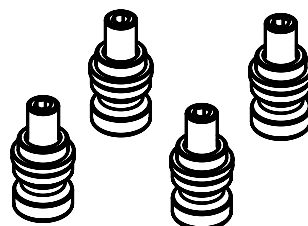
SOFT JAWS

Code No.	Type
7-226-303	SGM 6650-80
7-226-305	SGM 6650-125



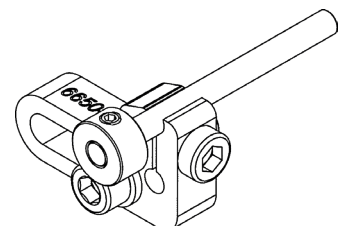
FASTENING PINS

Code No.	Type
7-631-3990	6589-M8 ZP SL
326000000700	6589-M10 ZP SL



SIDE STOPS

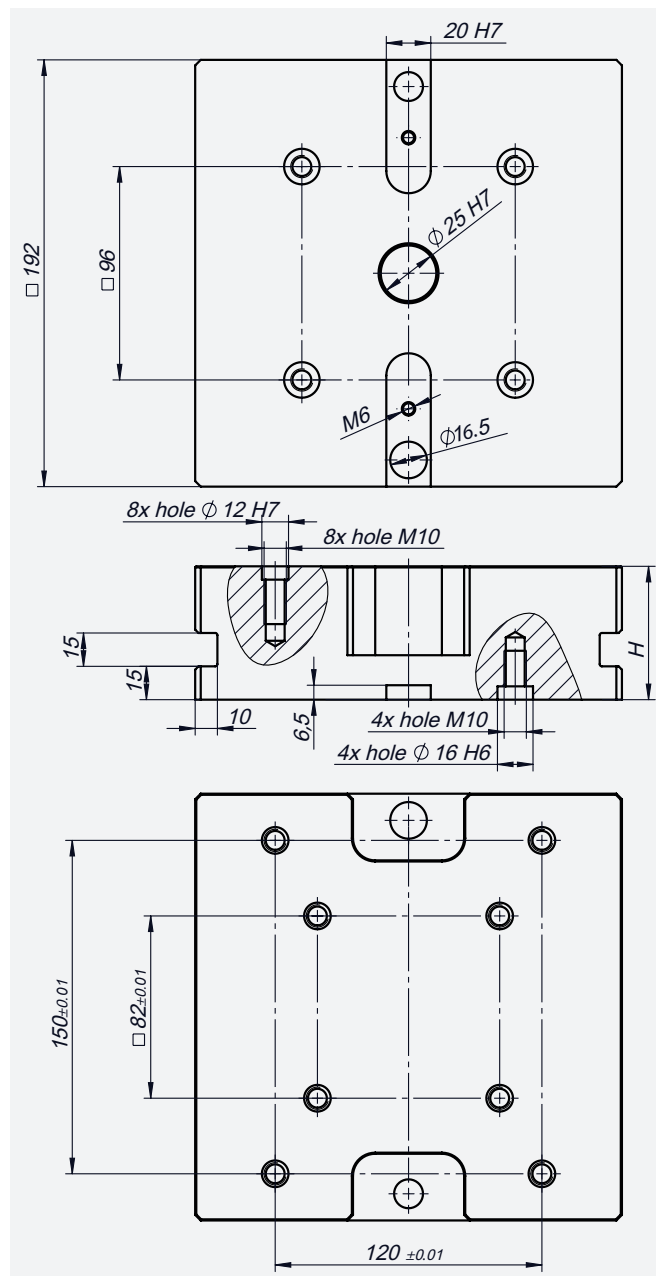
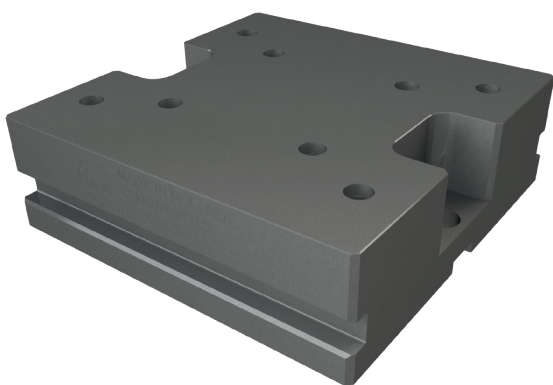
Code No.	Type
7-226-930	SIDE STOP 6650-80
7-226-950	SIDE STOP 6650-125



PD 6589

Riser Plate

Code No.	Type	H
7-631-3986	PD 6589-192x192-96 H=60	60
396000002300	PD 6589-192x192-96 H=100	100

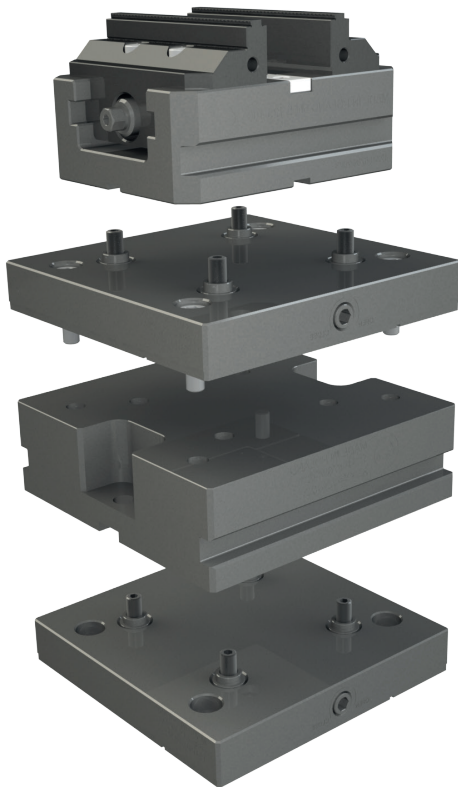


Features:

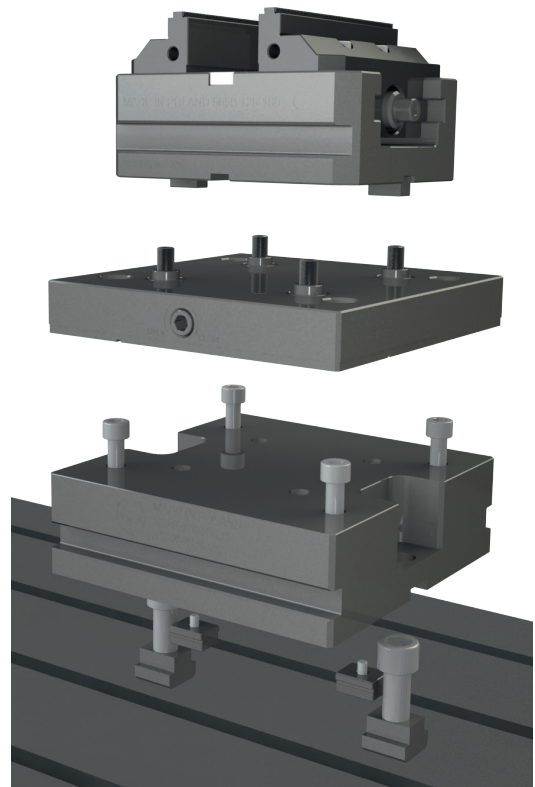
- The riser plate is used on 5-axis CNC machines to increase the height of the vise or the workpiece mounted to the zero-point base plate.
- With the riser plate, it's possible to increase the angle range of the rotation axis, which allows for machining larger sized or more complex workpieces.
- The riser plate gives access to workpieces from multiple angles, increasing the precision and quality when machining complex parts.
- Multiple side machining in one setup minimizes setup time and increases productivity.
- The riser plate can be mounted to 96x96 zero-point bases or directly to a T-slotted table using keys and clamps, or screws with T-nuts.



Example application with a vise, zero-point plate, and riser plate – 60 mm and 100 mm height.



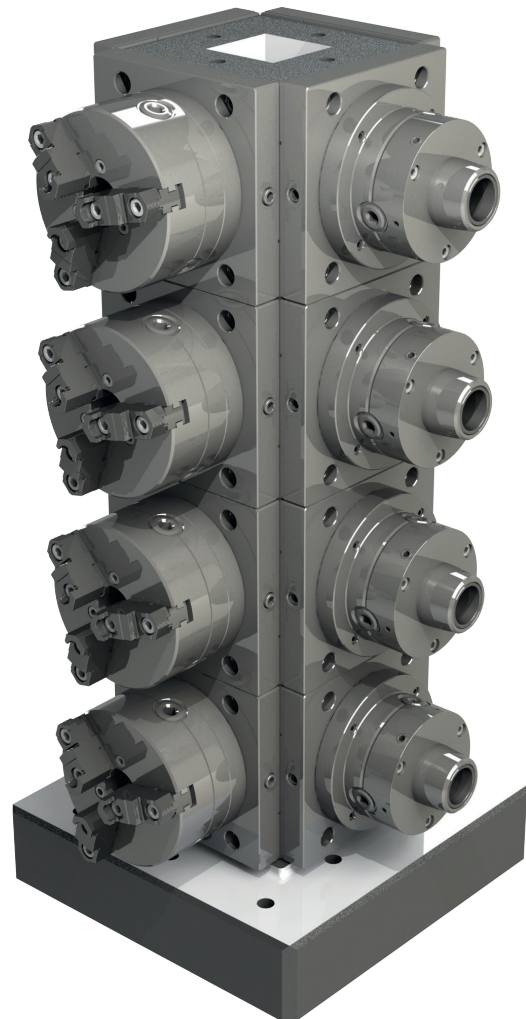
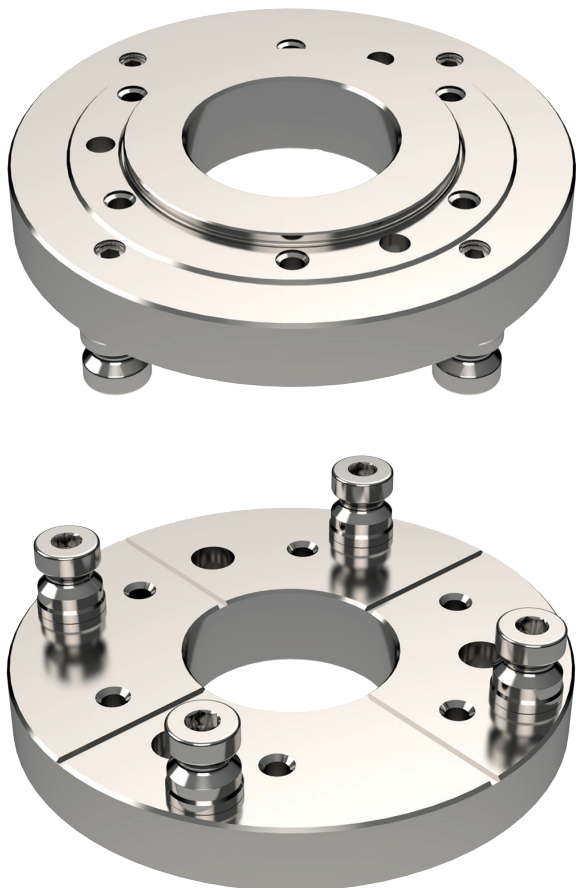
Example of mounting on a quick-fix mounting base.



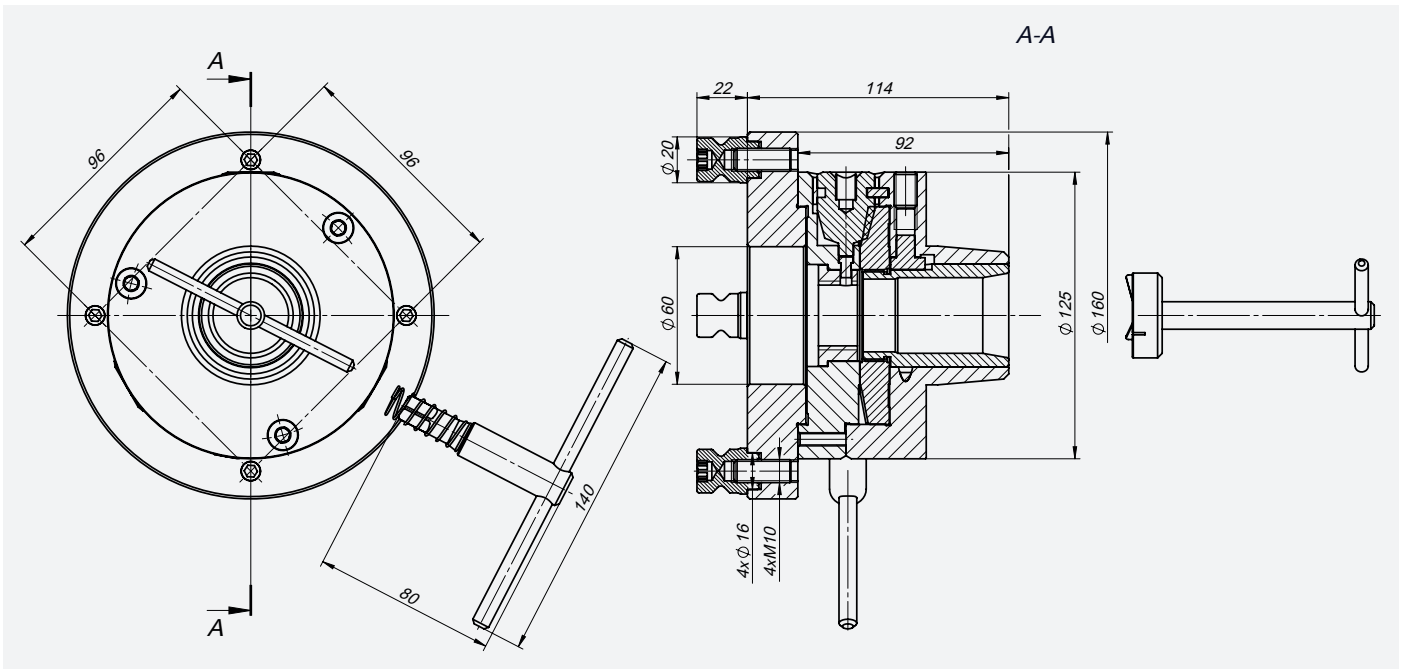
Example of mounting on a T-slotted table.

9470**Base Plates Type 9470 For Mounting Chucks****Features:**

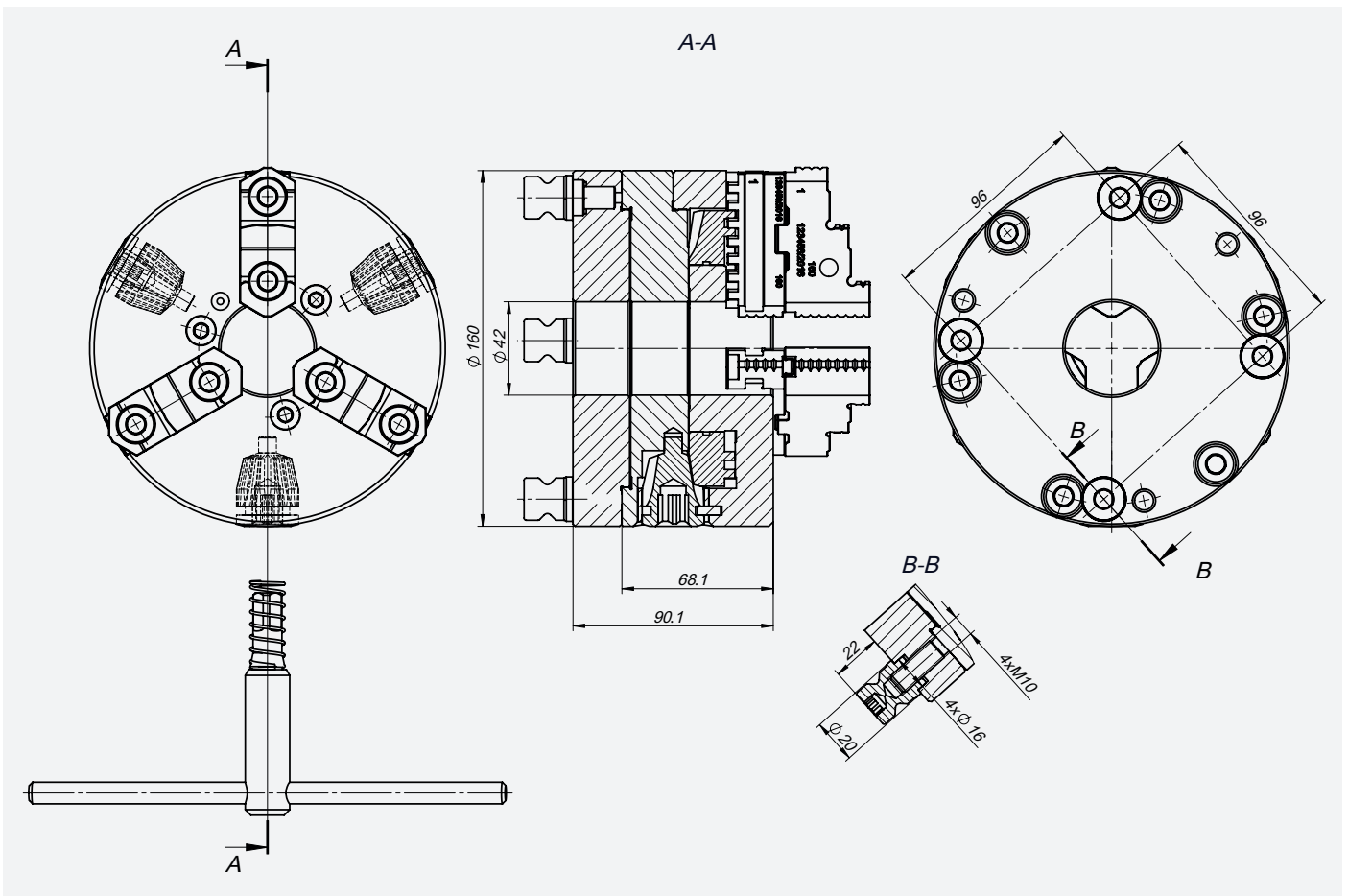
- Base plates type 9470 are designed for mounting standard plain back chucks to the quick-fix mounting bases with 96x96 stud system.
- The baseplate is an interface between a chuck with standard plain back mounting and a quick-fix base type 6589-192x192-96 P or other compatible substitute plates.
- Baseplates for other standard or special products made by Bison are available on request.
- The position tolerance for the chuck mounting pilot to the 96x96 mounting pins is $\pm 0.01\text{mm}$.



Base plates type 9470 used to mount the chucks type 3205-160 and 3975-125-5C on a tombstone.



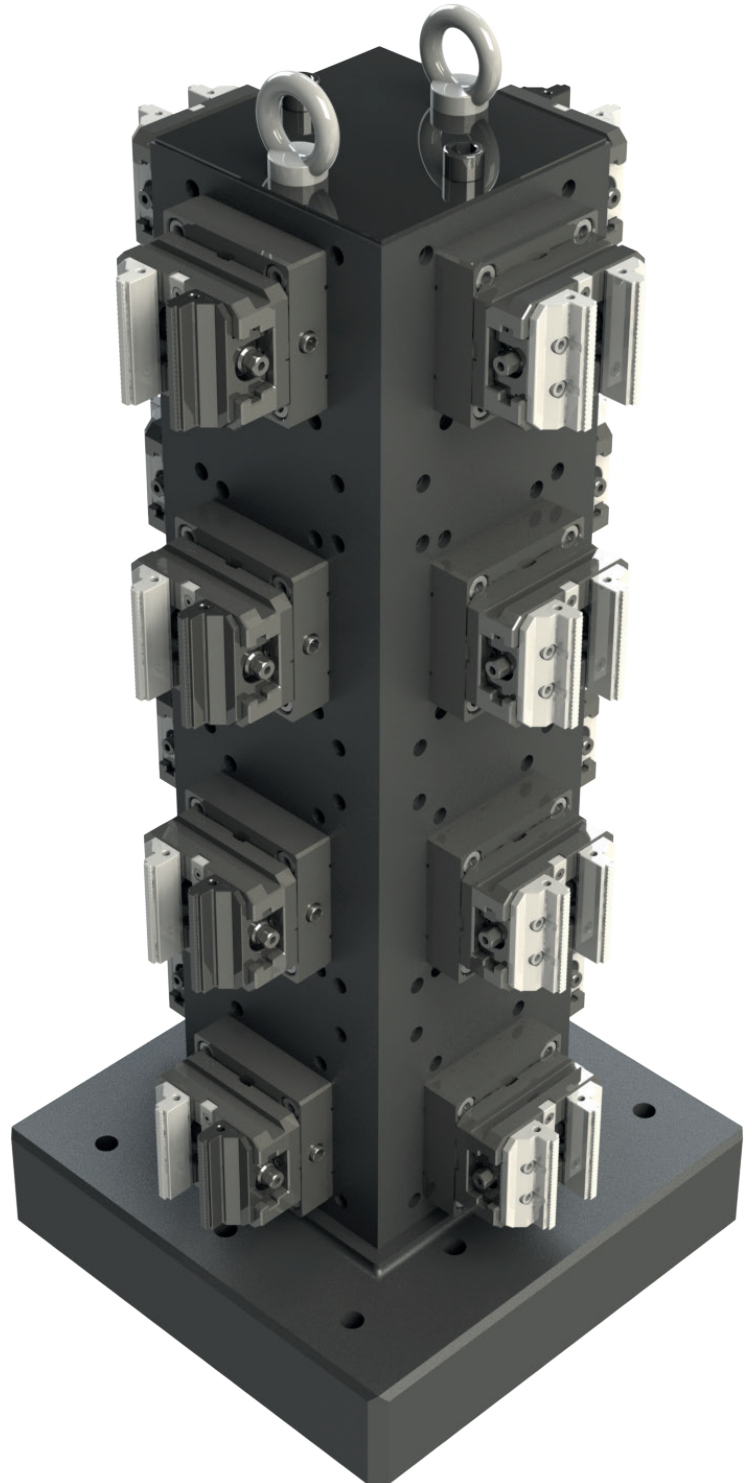
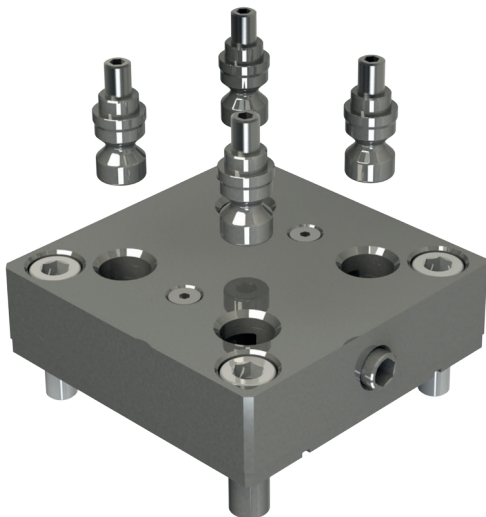
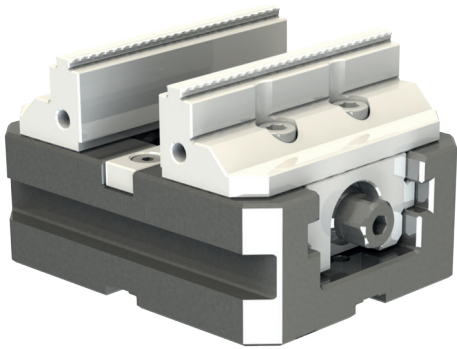
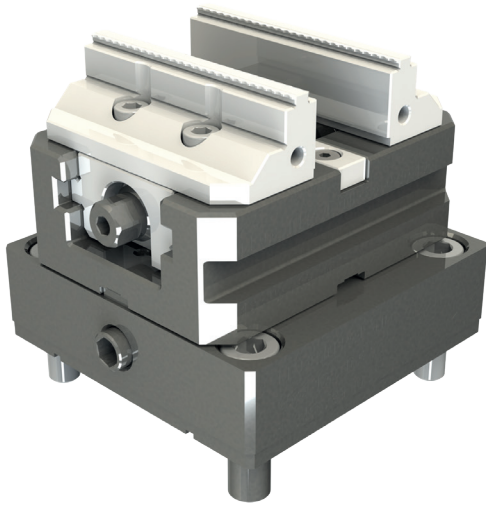
Collet chuck 3975-125-5c with 96x96 base



3-Jaw scroll chuck 3505-160 with 96x96 plate

1415-500 QA

Bison also provides custom tombstones, allowing or creating a variety of flexible fixture setups for machining centers.



NEW

BISON

6740

Self-Centering Power Vise



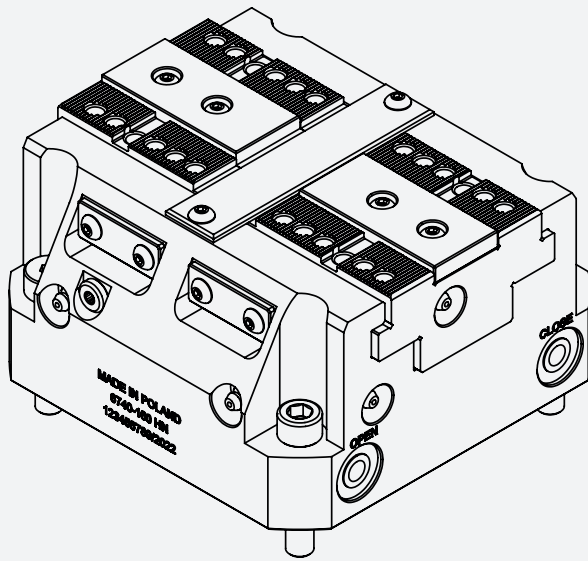
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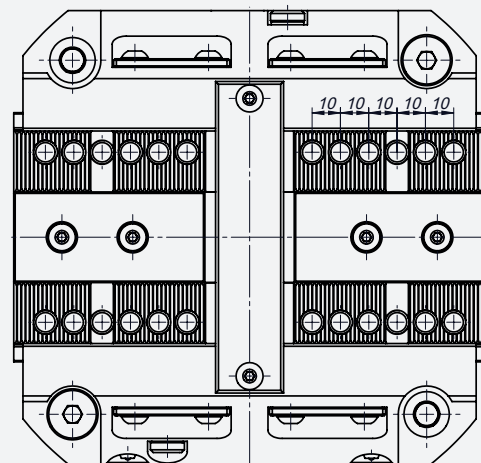
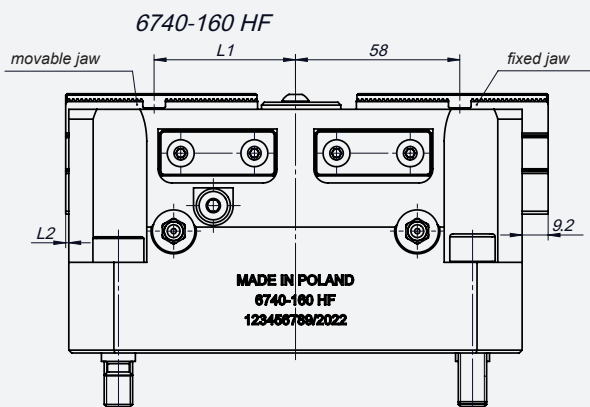
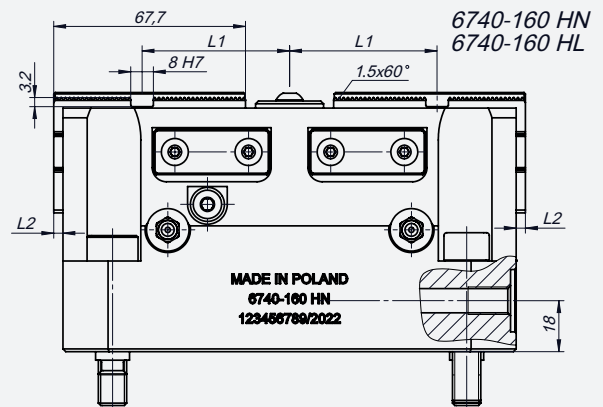
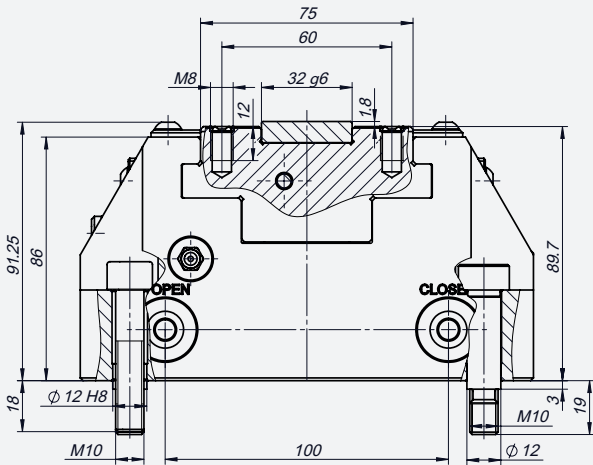
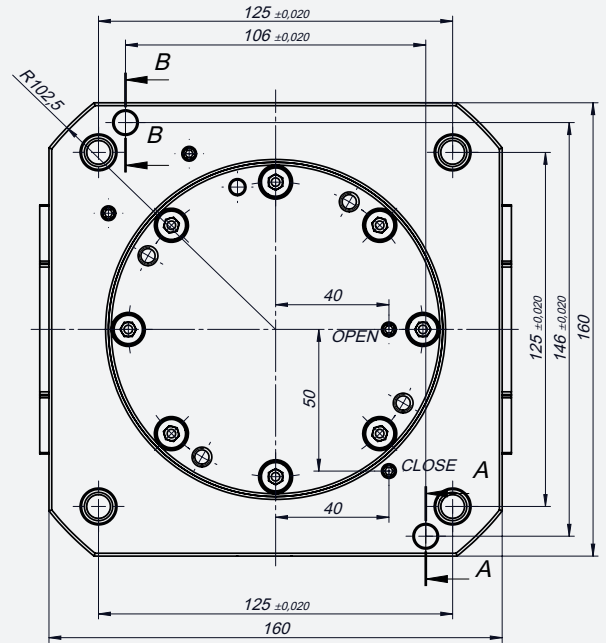
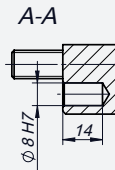
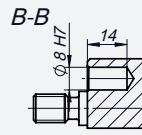


Features:

- High repeatability
- High rigidity
- Inside of the vise sealed from chips
- Easy-cleaning design of the vise body
- Compact design
- Linear adjustment of the actuating pressure
- Linear correlation between the input pressure and the clamping force
- The vises are available in two actuation setups:
 - Pneumatic actuation – type 6740 P
 - Hydraulic actuation – type 6740 H
- The vises are available in the following variants:
 - with standard jaw travel – type 6740-160 PN; 6740-160 HN
 - with extended jaw travel – type 6740-160 PL; 6740-160 HL
 - with one movable and one stationary jaw – type 6740-160 PF; 6740-160 HF
- Max clamping force:
 - Vise with pneumatic actuation:
 - with standard jaw travel – $F=40$ [kN] for input pressure $P=9$ [bar]
 - with extended jaw travel – $F=19$ [kN] for input pressure $P=9$ [bar]
 - with one movable and one stationary jaw - $F=32$ [kN] for input pressure $P=9$ [bar]
 - Vise with hydraulic actuation:
 - with standard jaw travel – $F=40$ [kN] for input pressure $P=30$ [bar]
 - with extended jaw travel – $F=38$ [kN] for input pressure $P=60$ [bar]
 - with one movable and one stationary jaw - $F=32$ [kN] for input pressure $P=25$ [bar]



6740-160 HN
6740-160 HL
6740-160 NF



Type	6740-160 HN	6740-160 HL	6740-160 HF
max. L1	52.06	58	58
max. L2	3.26	9.2	9.2
Jaw stroke	3	8.1	8.1
Max. pressure	30	60	25
Max. clamping force [kN]	40	38	32
Weight [kg]	13.9	13.9	14.02



Properties:

- Standardized location of the holes for mounting the vise on the machine table and powering connections allows for interchanging the pneumatic with hydraulic vises
- The holes for mounting the vise on the machine table are made in H7 tolerance
- The body and the working parts of the vise are hardened for high precision and long service time
- Features venting and central lubrication
- Allows for central powering
- Master jaws with a socket, T-nut and 1.5x60° serration
- Outside and inside clamping
- Stroke control with proximity switches (optional)

Standard Equipment:

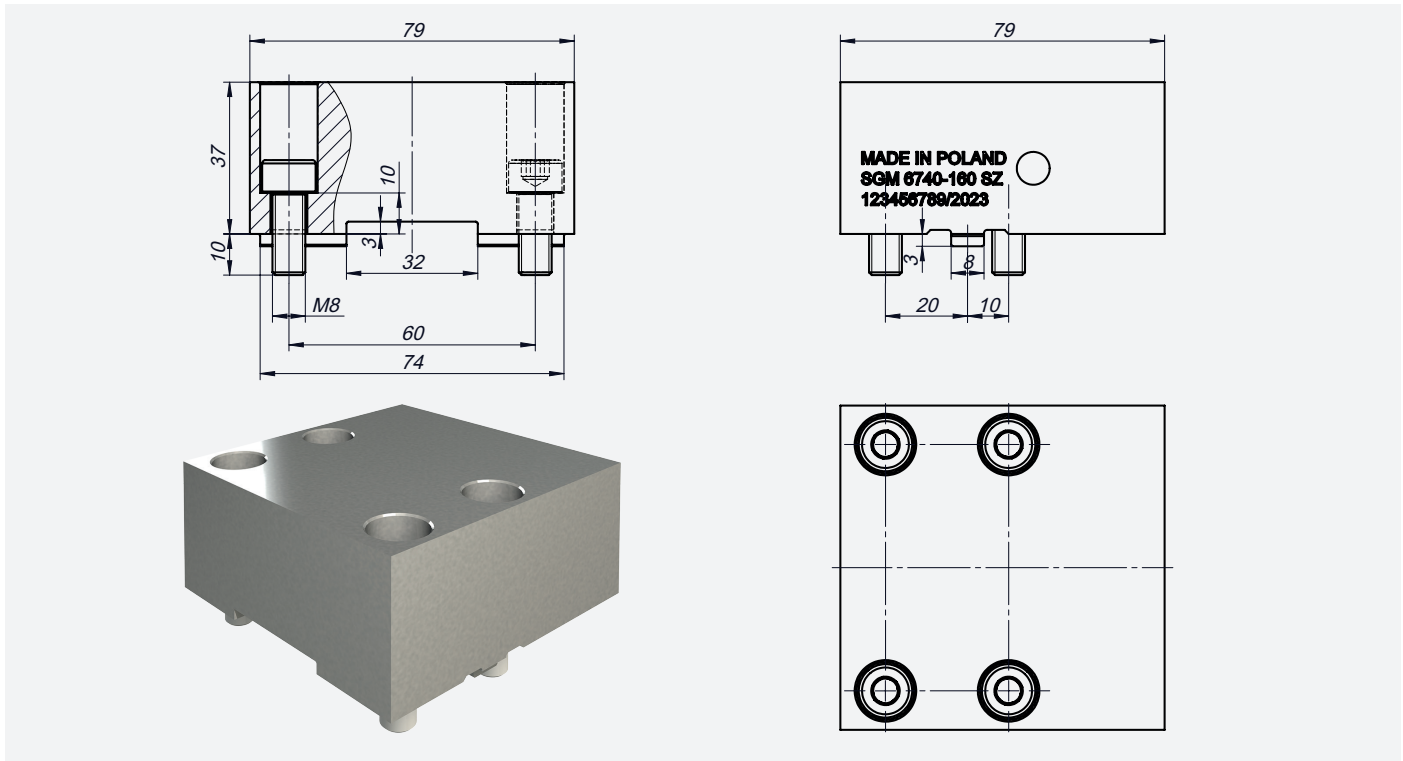
- Self-centering vise without top jaws
- Bolts for mounting the vise on the table

Optional Equipment:

- Soft Top Jaws with T-nuts
- Hard Top Jaws with Serrated Inserts, 1.5x60° serration
- Base plate with valve

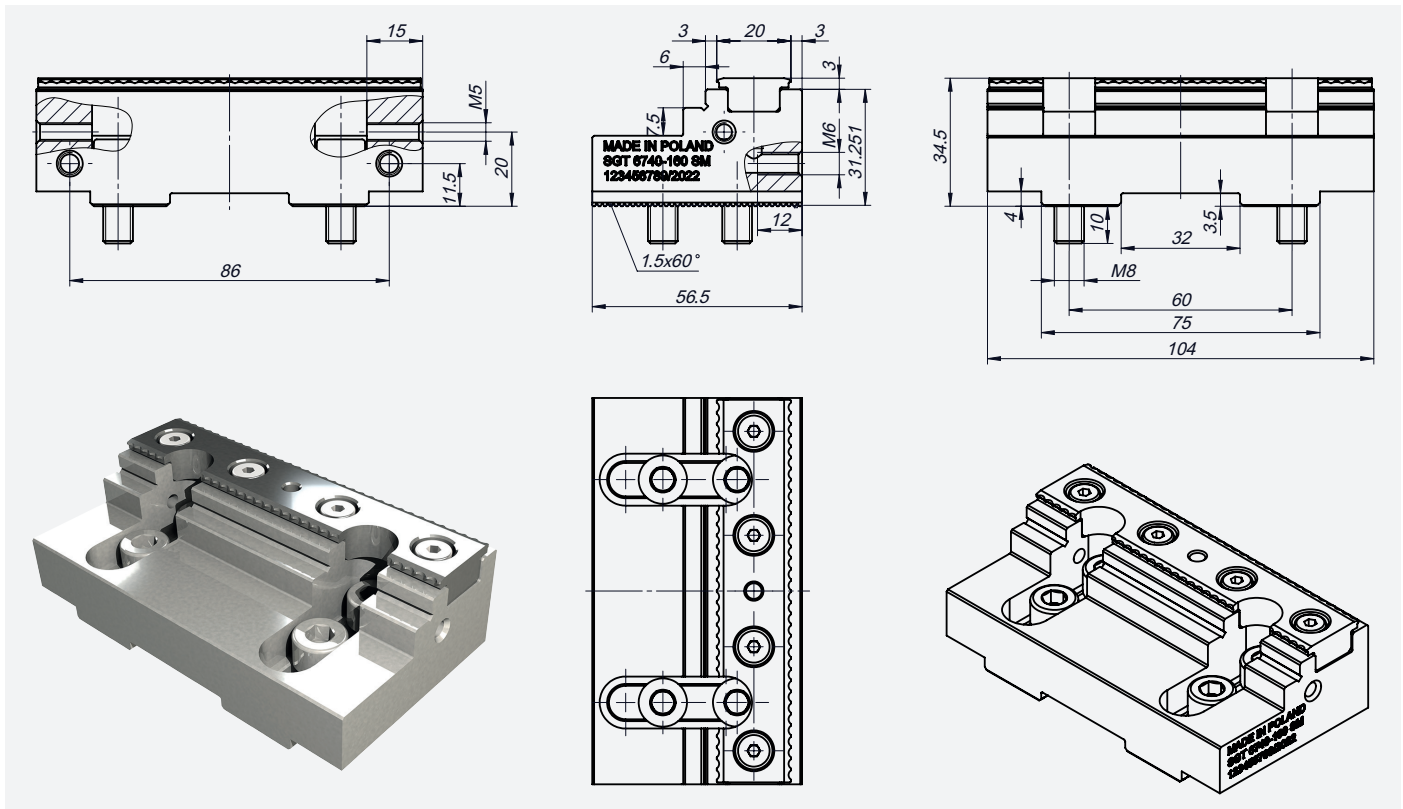
SGM 6740-160 SZ

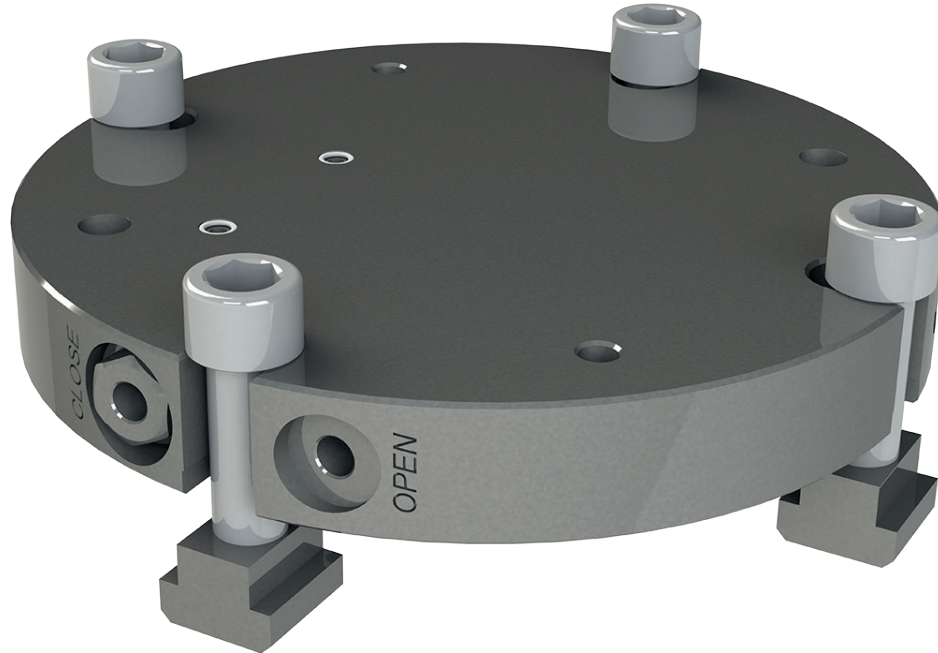
Soft top jaw



SGT 6740-160 SM

Metric hard wide top jaw



6780-160 P**Baseplate with power connector for vises type 6740 P****Features:**

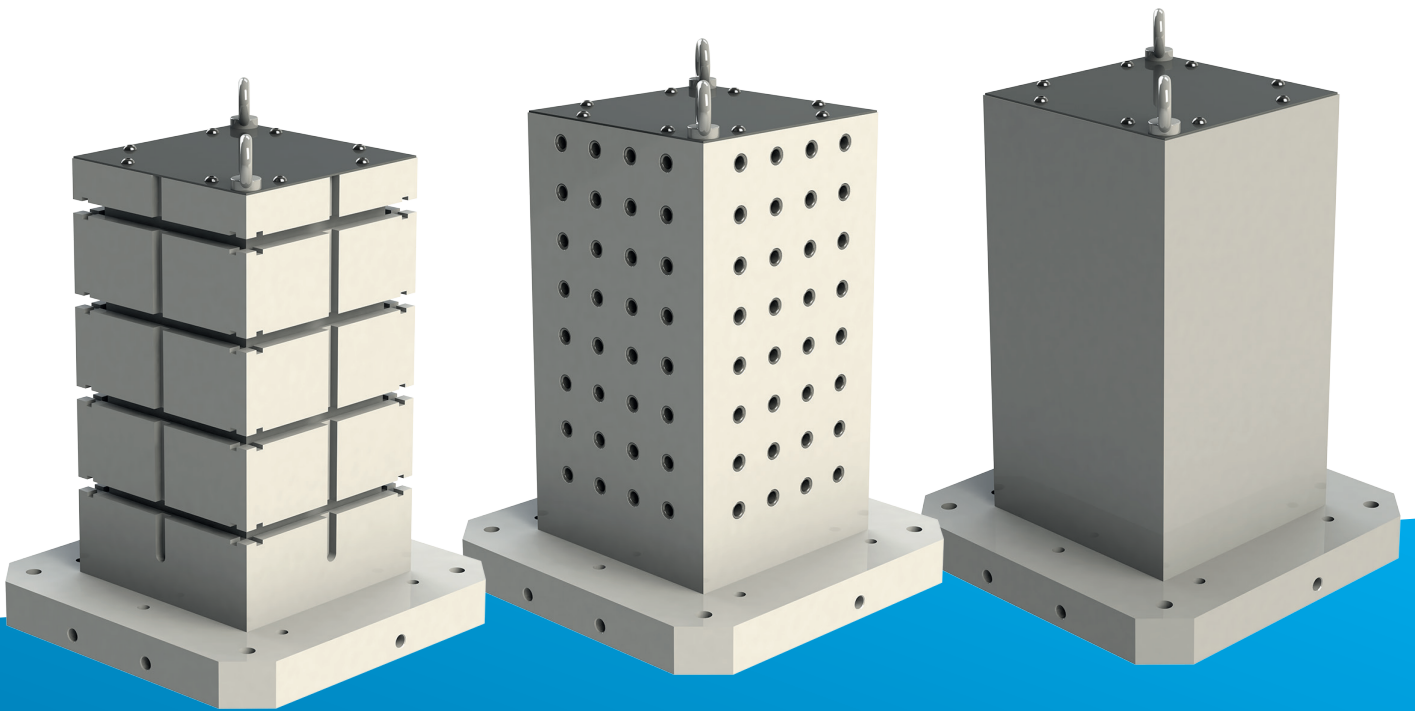
- Spacing of the clamping channels 185x185mm, T-nuts M16/18mm.
- The baseplate for type 6740 P vise is equipped with a non-return valve.
- The baseplate ensures maintaining the operating pressure of the vise after disconnecting from the power unit for transportation.
- Allows for machining of the workpieces clamped by the vise after disconnecting it from the power unit.
- Powers the vise through the additional dedicated channels located on the bottom of the vise.
- Designed to be mounted on machine tables with 100 mm t-slot spacing.
- Allows for mounting on the tables with other T-slot layouts, using additional clamps.
- The entire baseplate, including the area in the center, is made of solid material, which allows for adding a mounting hole for "Quick-Fix" system with a single pin.

NEW

BISON

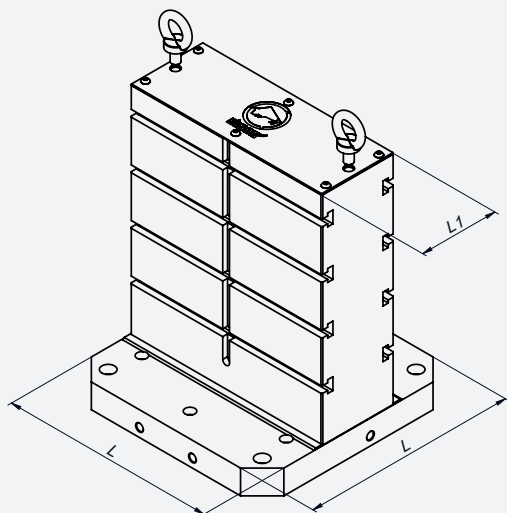
1415
1415 DS
1415 ZP

Tombstones

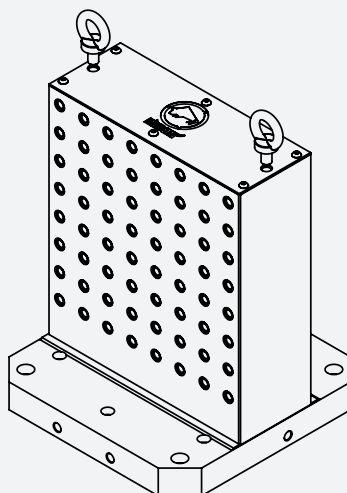


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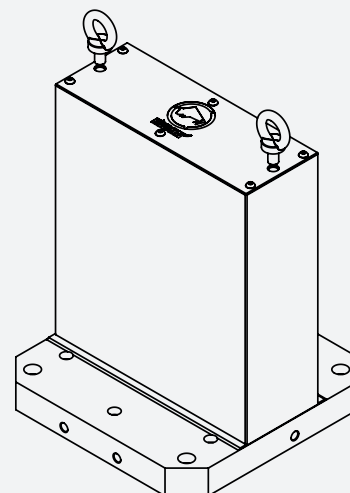




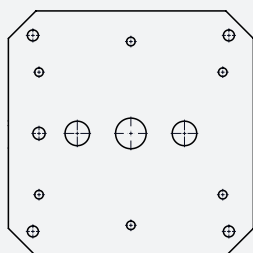
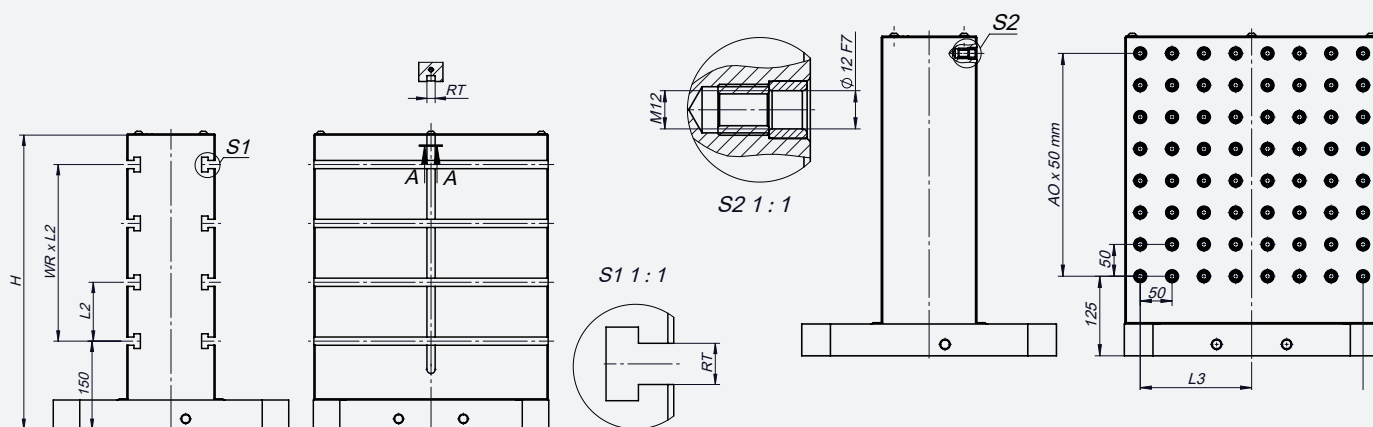
TS: T-Slots



TS: Grid Pattern

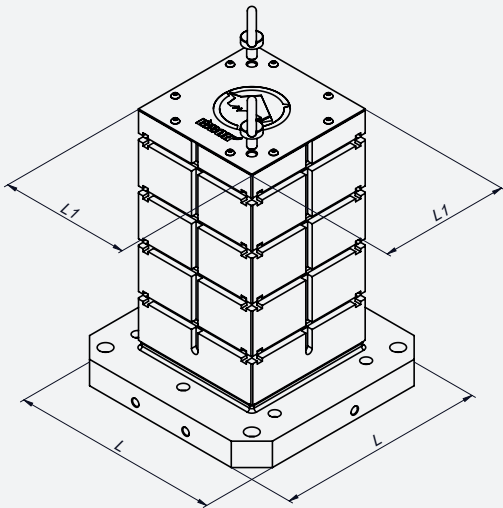


TS: Pre-Machined Surfaces

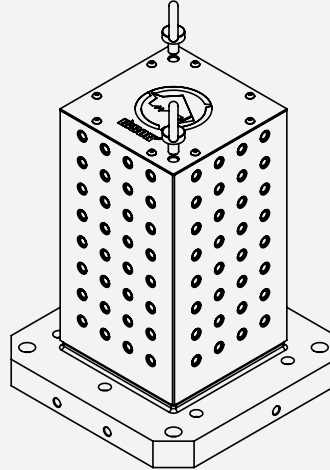


Tombstone positioning on machine according To DIN 55 201, JIS 6337-1980, or customer specifications.

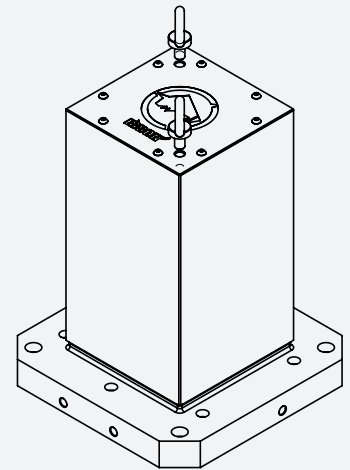
Code No.	Type	L	H	L1	RT	L2	WR	L3	AO	BO	Holes number	Weight [kg]
381415302300	1415-400 DS TS	400	500	150	14	100	3	-	-	-	-	176.5
381415312500	1415-400 DS TH	400	500	150	-	-	-	175	7	7	128	184.5
381415322700	1415-400 DS BL	400	500	151	-	-	-	-	-	-	-	188.5
381415304900	1415-500 DS TS	500	600	200	14	100	4	-	-	-	-	288.5
381415314000	1415-500 DS TH	500	600	200	-	-	-	225	9	9	200	301
381415324200	1415-500 DS BL	500	600	201	-	-	-	-	-	-	-	307.5
381415306400	1415-630 DS TS	630	700	250	14	125	4	-	-	-	-	491.5
381415316600	1415-630 DS TH	630	700	250	-	-	-	275	11	11	288	506
381415326800	1415-630 DS BL	630	700	251	-	-	-	-	-	-	-	515.5



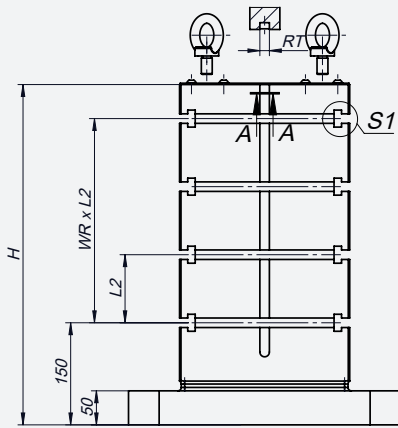
TS: T-Slots



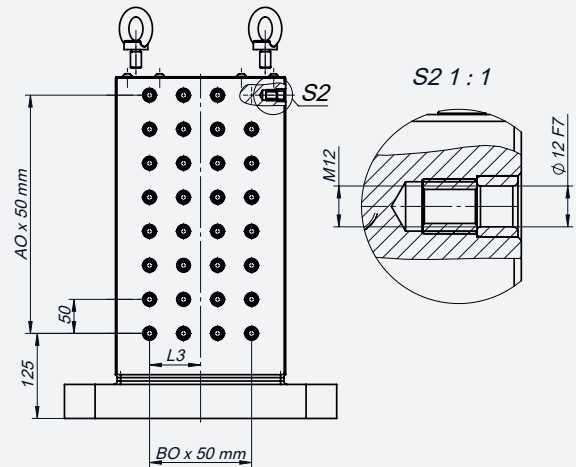
TS: Grid Pattern



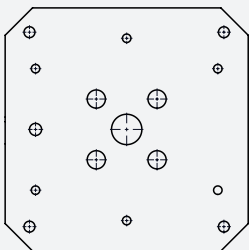
TS: Pre-Machined Surfaces



S1 1:1



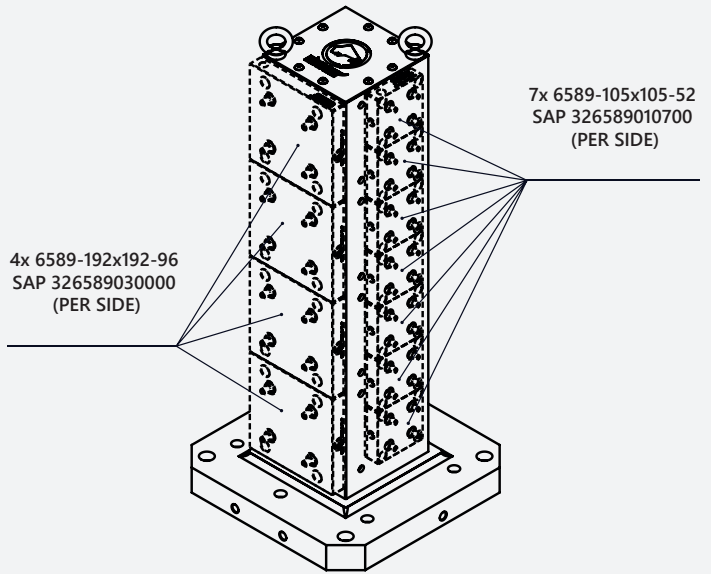
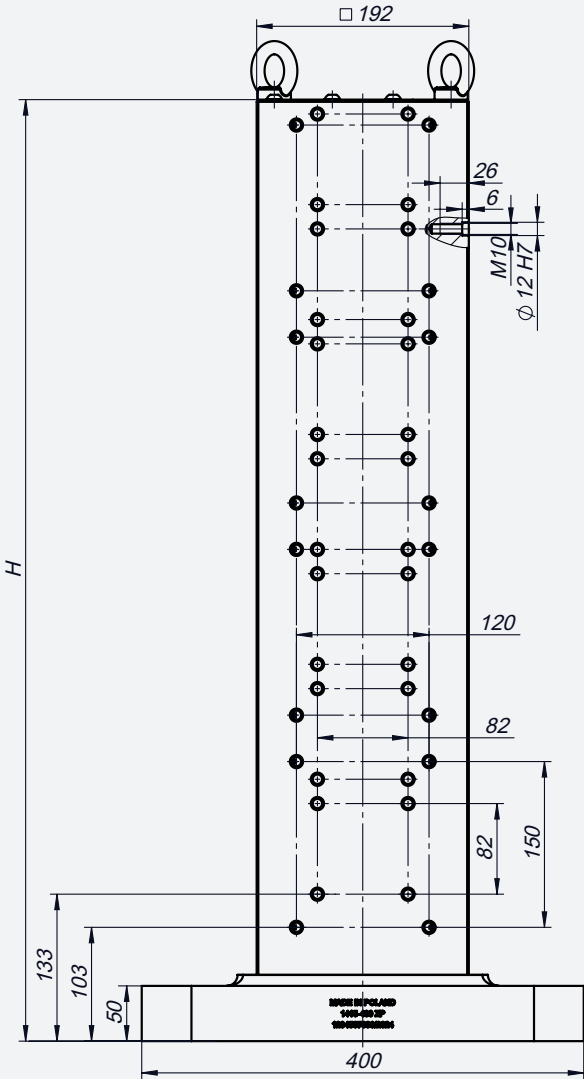
S2 1:1



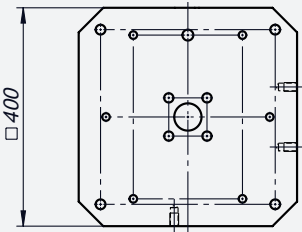
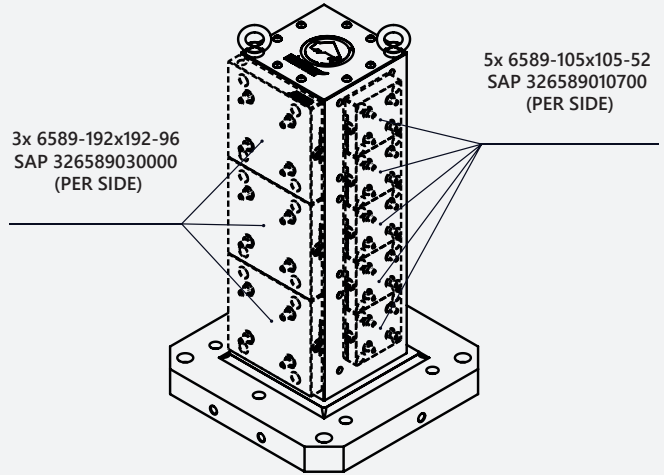
Tombstone positioning on machine according To DIN 55 201, JIS 6337-1980, or customer specifications.

Code No.	Type	L	H	L1	RT	L2	WR	L3	AO	BO	Holes number	Weight [kg]
381415202200	1415-400 TS	400	500	250	14	100	3	-	-	-	-	182
381415212400	1415-400 TH	400	500	250	-	-	-	75	7	3	128	192
381415224100	1415-400 BL	400	500	251	-	-	-	-	-	-	-	196.5
381415204800	1415-500 TS	500	600	300	14	100	4	-	-	-	-	285
381415214000	1415-500 TH	500	600	300	-	-	-	100	9	4	200	300.5
381415224100	1415-500 BL	500	600	301	-	-	-	-	-	-	-	307.5
381415206300	1415-630 TS	630	700	350	14	125	4	-	-	-	-	431
381415216500	1415-630 TH	630	700	350	-	-	-	125	11	5	288	448
381415226700	1415-630 BL	630	700	351	-	-	-	-	-	-	-	458

1415-400-850 ZP
EQUIPMENT OPTIONS



1415-400-660 ZP
EQUIPMENT OPTIONS



Tombstone positioning on 400mm machine according To DIN 55 201, JIS 6337-1980, or customer specifications.

Code No.	Type	H	Weight [kg]
381415403700	1415-400-660 ZP	660	165
381415404000	1415-400-850 ZP	852	205

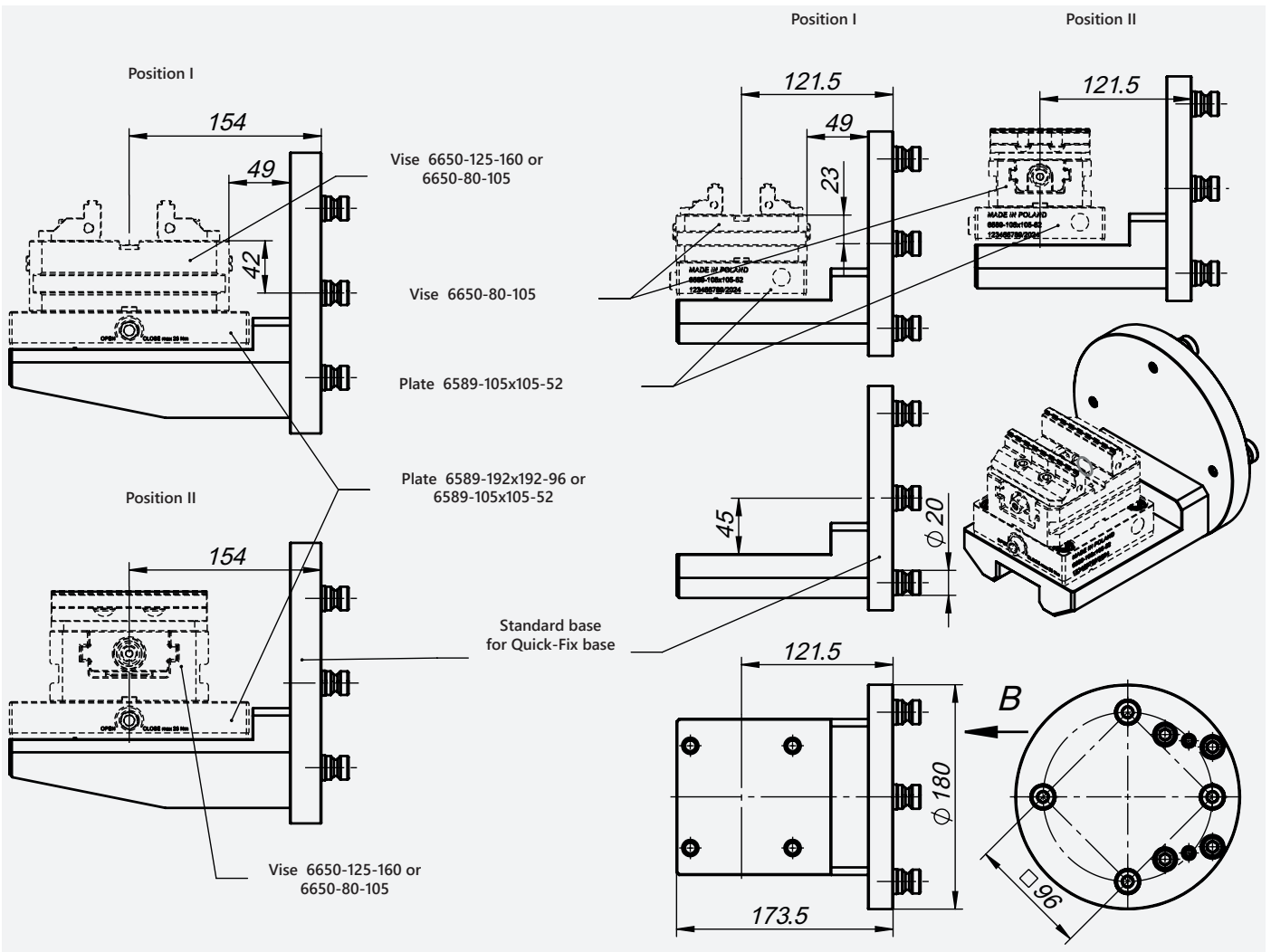
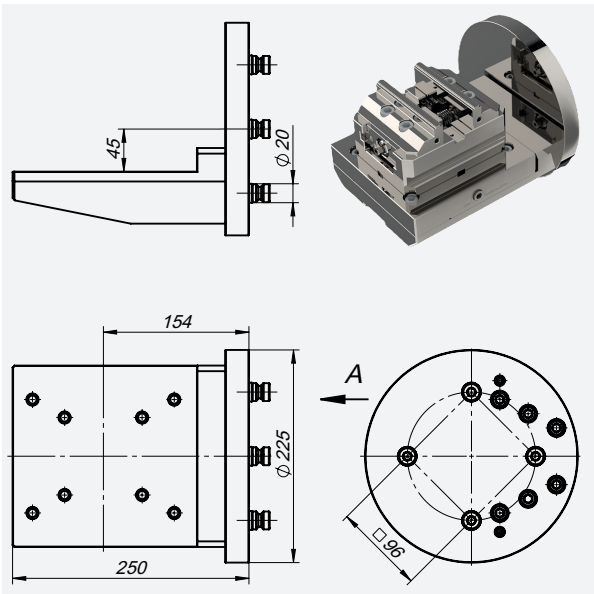
ANGLE BASE

Angled base for indexing devices (additional 4th axis)

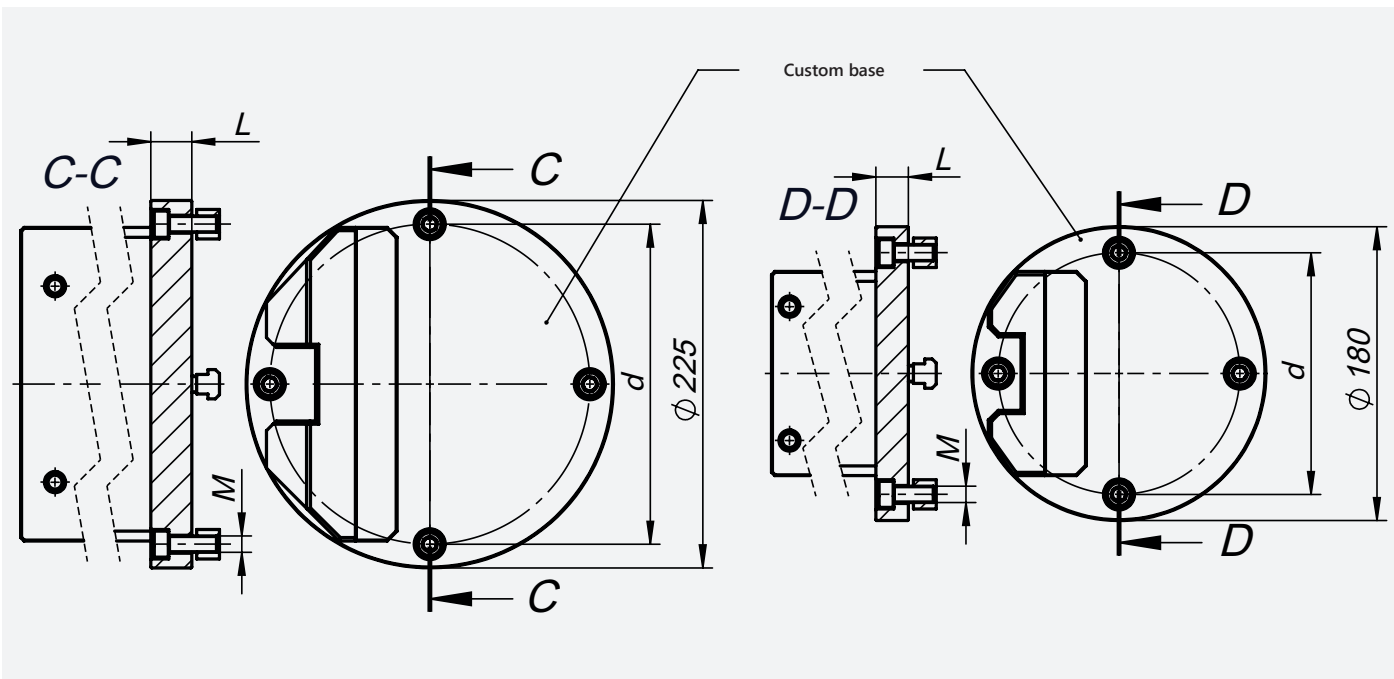
In the standard version, the base connection is equipped with Quick-Fix quick-release pins. It is possible to make a base connection on special order to any plate of the dividing device. Standard angled base works with 6589 quick-fix base and 6650 self-centering vise.

Solution advantages:

- Low weight compared to traditional solutions.
- Quick-Fix quick-release pins allow for quick mounting and removal of the angle pallet.
- The design of the base does not limit the processing area.
- Optimization of production by reducing the number of fixtures.



Name	Description	Size	Weight [kg]	Works with plate	Works with vise	Weight of the whole set [kg]
Angle Base	Standard base for Zero Point	180	8.6	6589-105x105-52	6650-80-105	13.5
Angle Base	Standard base for Zero Point	225	20.7	6589-105x105-52	6650-80-105	25.4
				6589-192x192-96	6650-125-160	



*** Custom-made angular base for any device plate**

Name	Description	Size	Works with plate	Works with vise	d	L	4xM
Angle Base	Custom base	180 *	6589-105x105-52	6650-80-105	*	*	*
Angle Base	Custom base	225 *	6589-105x105-52	6650-80-105	*	*	*
			6589-192x192-96	6650-125-160	*	*	*



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 Tel.: +44 (0) 1733 230 567

 **BISON USA CORP.**

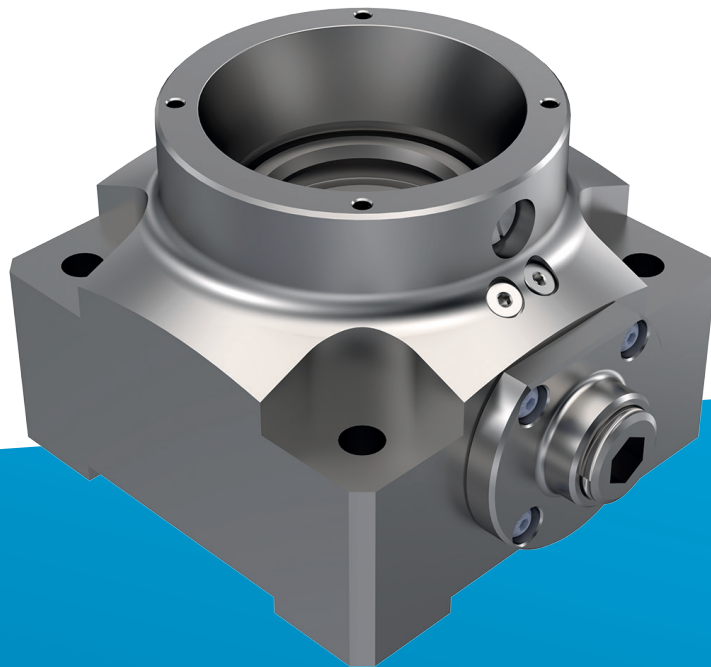
5325 Muhlhauser Road
 Hamilton, OH 45011
 e-mail: info@bison-america.com
 Tel.: +1 513 713 0513

NEW

BISON

9316

Manual Stationary Chuck For Clamping Heads

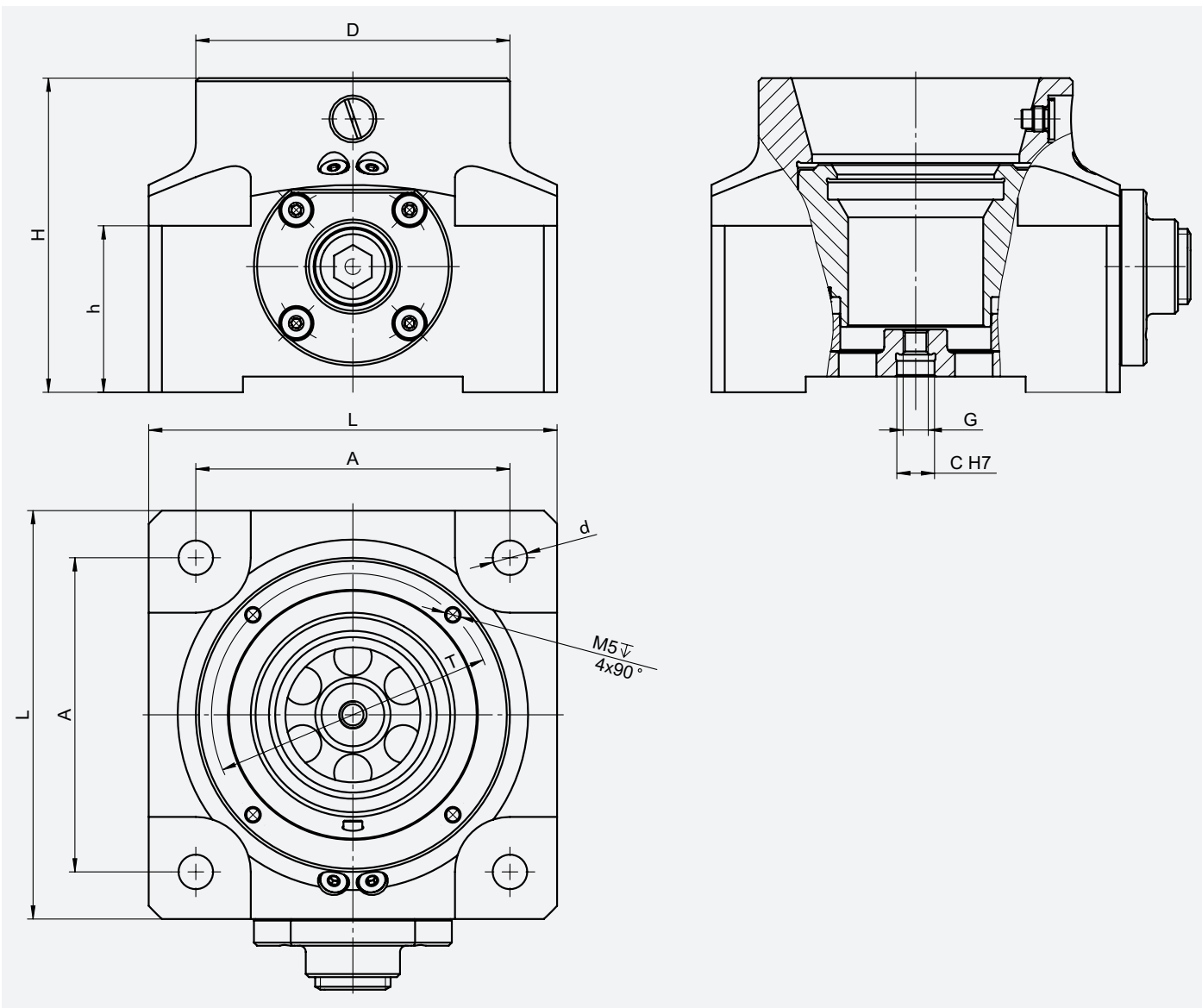


Features:

- High clamping force and rigidity ensuring high precision machining
- High efficiency due to quick change and assembly of the clamping heads
- High flexibility due to compatibility with standard clamping heads
- Ideal for 5-axis machining due to compact design

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Code No.	Type	A	L	H	h	D	d	G	C	T	Clamping range Ø	Weight [kg]
329316010500	9316-42	100	130	100	53	100	11	M8	12	90	4-42	7.9
329316020700	9316-52	100	130	100	53	100	11	M8	12	90	6-52	7.6
329316030900	9316-65	120	150	100	53	120	11	M10	16	110	4-65	9.6
329316050200	9316-100	170	200	110	60	165	13	M12	20	155	40-100	18.3

Properties:

- Manually operated with a SW 12 wrench
- Repeatability ≤ 0.01 mm
- Collets closed by pull-down action
- Optional workpiece stops
- Can be mounted horizontally or vertically
- Threaded holes for the front-side stops



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NEW

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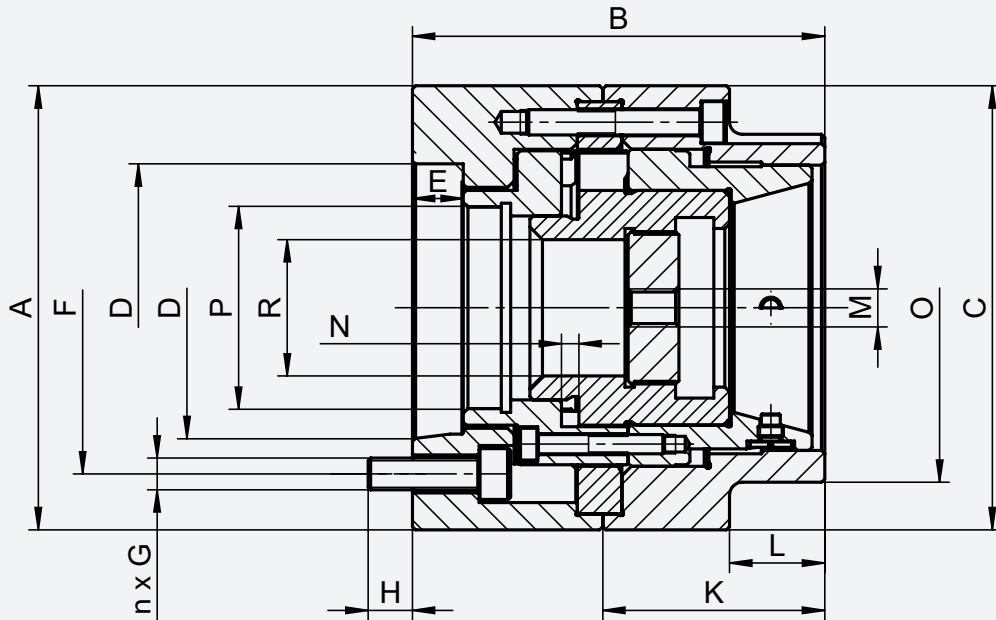
2906

**Power Chuck For Rubber Flex
GT Clamping Heads**



The 2906 power chucks for Rubber Flex GT clamping heads are designed for mounting shafts and rods of various diameter range. Especially useful for machining soft and easily deforming materials. The chucks ensure safe and secure clamping and quick change of clamping heads with a head changing gun.

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Code No.	Type	A	B	C	D	E	F	G	H	K	L	M	N	O	P	R	Max pushing force [kN]	Max speed [min ⁻¹]	n	Weight [kg]
352906020300	2906-160-42-140	160	125	140	140	6	104.8	M10	15	70	30	M12	5.5	110	M65x1.5	43	35	7000	3	10.7
352906021600	2906-140-42-5A2	140	130	140	82.563	16	104.8	M10	14	70	30	M12	5.5	110	M65x1.5	43	35	7000	6	10.4
352906022900	2906-160-42-6A2	160	130	140	106.375	16	133.4	M12	15	70	30	M12	5.5	110	M65x1.5	43	35	7000	6	10.4

Features:

- low profile design
- high rotational speed
- minimal deformation of the workpiece
- low moment of inertia
- high clamping force
- body and cone sleeve made of wear-resistant material
- high clamping precision

Our offer will soon also include RUBBER-FLEX chucks dedicated to work with clamping heads sized 52,65 and 80.

Clamping heads and changing guns are available upon request.



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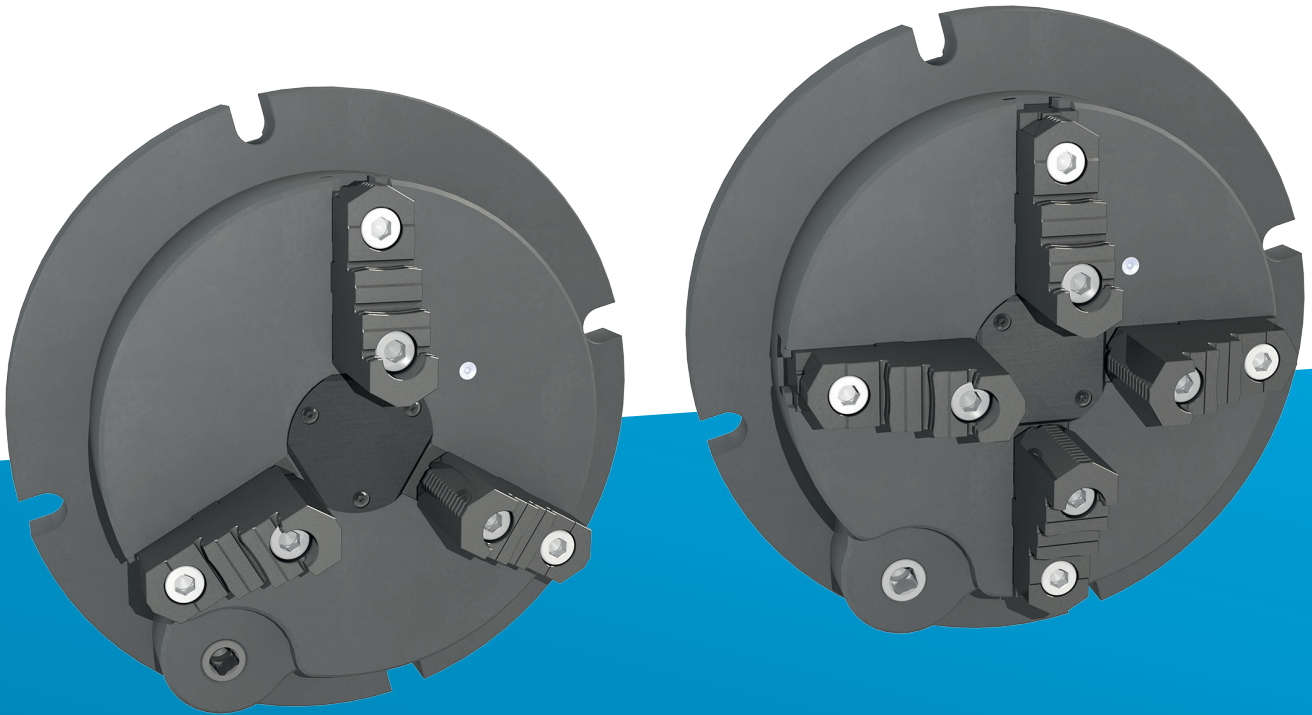
5325 Muhlhauser Road
Hamilton, OH 45011
e-mail: info@bison-america.com
Tel.: +1 513 713 0513

NEW

BISON

9416
9417

Self-Centering Milling Fixture



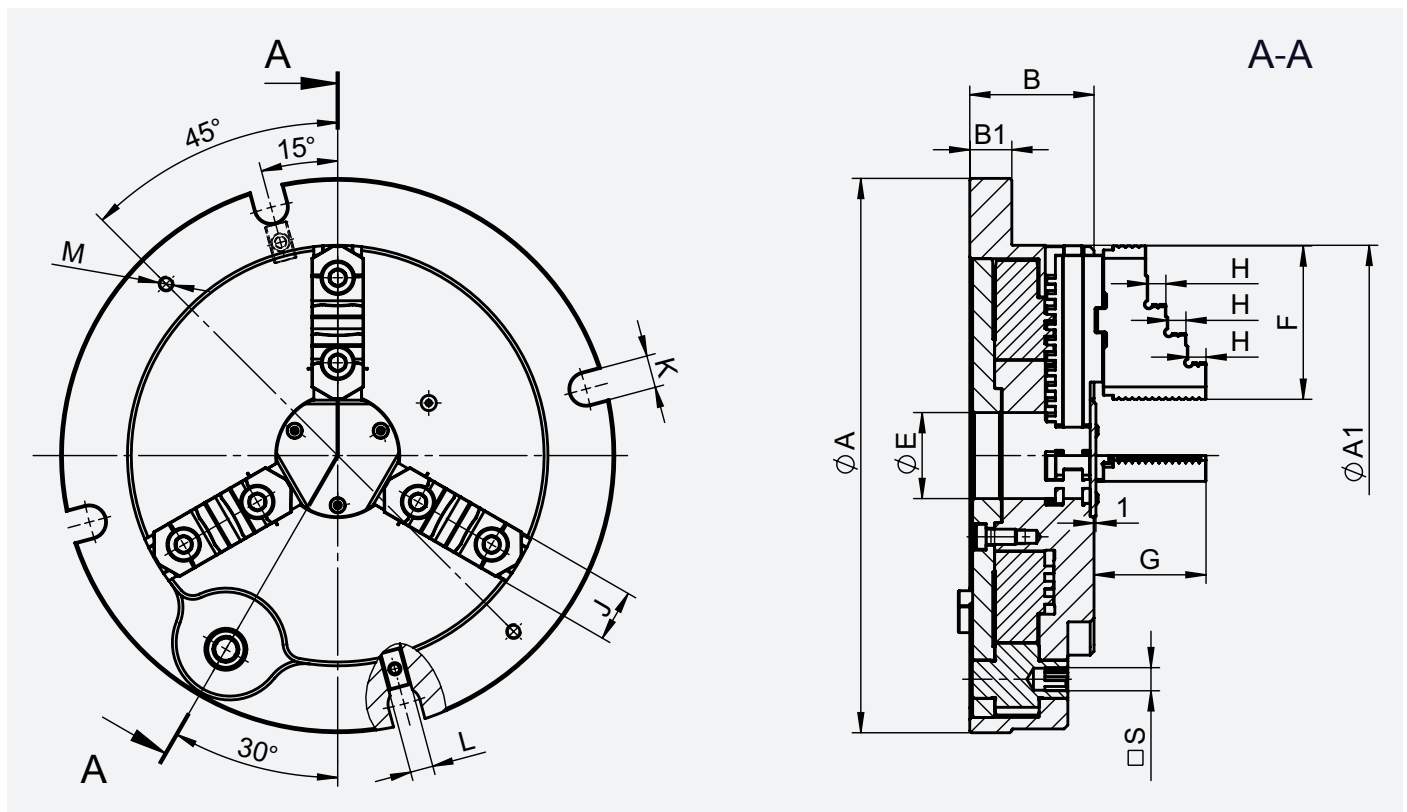
The unmatched advantage of our milling fixtures is their wide clamping range and long jaw travel, which allows for clamping workpieces of various sizes without the need for changing the jaws or for storing a large number of jaws in different sizes.

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Features:

- A milling fixture in the form of a scroll lathe chuck with 2-piece jaws, integrated with the base.
- Depending on the adaptation, it can be used on milling machine tables, T-towers, drill tables, or surface grinders.
- It has a mechanism drive from the front of the fixture, you can use a standard wrench with a spring or a ratchet knob with a cap.
- The fixture is sealed against chips, the center by a cover, and the guides by extra teeth on the jaw.
- It has two locating keys and 4 recesses for fastening screws to be fixed to the table/tower/pallet. It is possible to attach it by the flange of the fixture with toe clamps to the machine table.
- The fixture is low profile, which is an advantage for machine tools with a short Z-axis travel, because it does not limit the machine's movements like a chuck with a base.
- When the profile is as low as possible, standard 3200 soft jaw can be used and shaped accordingly.

9416

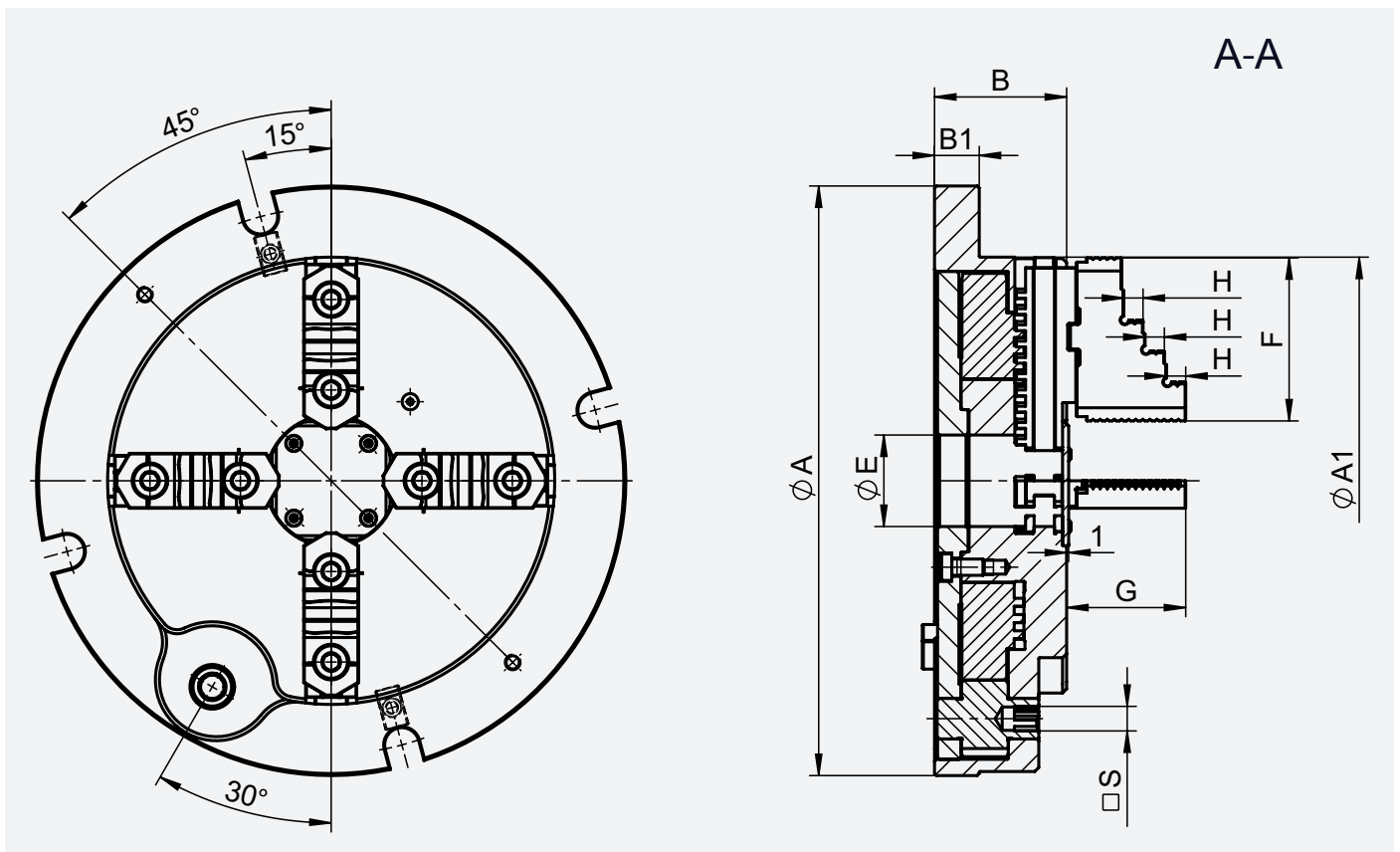


Code No.	Type	Ø A	Ø A1	B	B1	Ø E	F	G	H	J	K	L	M	□ S	n x J	Weight [kg]
7-640-0630	9416-160 FM US	237	175	52	17	32	67	51	8,5	25	17	12	-	9	3	12.3
7-640-0830	9416-200 FM US	290	220	65	22	45	80	58.6	9,5	27	17	12	-	11	3	23.5
7-640-1030	9416-250 FM US	350	275	73	22	57	95	63.6	12	32.5	20	18	M8	14	3	37.8
7-640-1230	9416-315 FM US	405	335	80	24	80	110	71.4	13	37	20	18	M8	14	3	58.4

Standard accessories:

- "T" wrench
- 1/2" ratchet with internal square
- □ S to 1/2" adapter
- eye bolt (only 250 and 315) -2 pcs.

9417

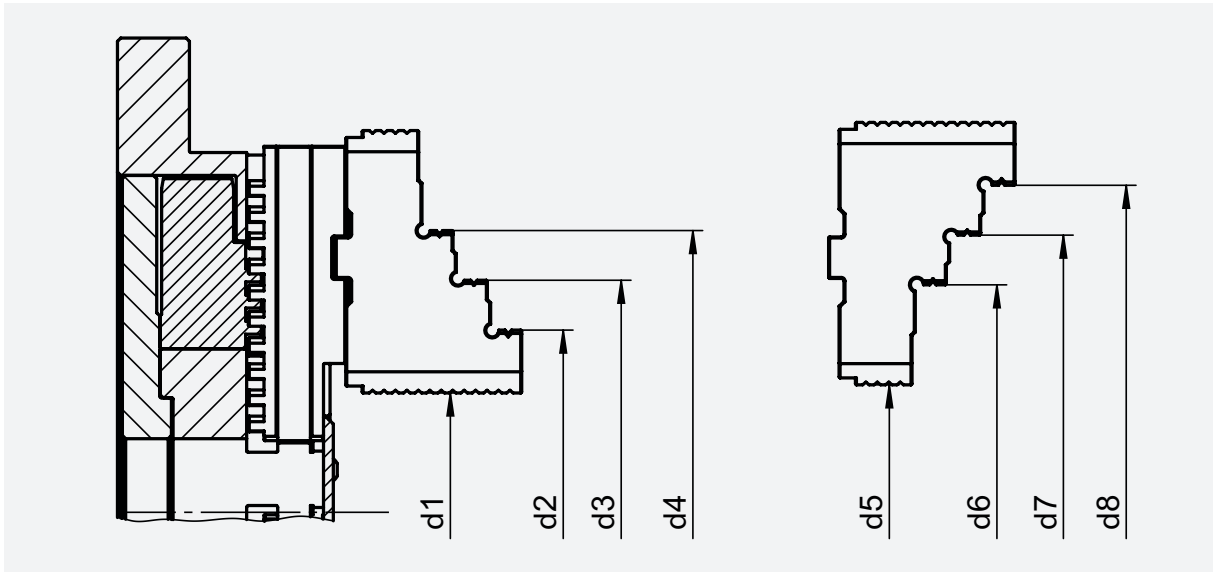


Code No.	Type	Ø A	Ø A1	B	B1	Ø E	F	G	H	J	K	L	M	□ S	n x J	Weight [kg]
7-640-0640	9417-160 FM US	237	175	52	17	32	67	51	8.5	25	17	12	-	9	4	12.7
7-640-0840	9417-200 FM US	290	220	65	22	45	80	58.6	9.5	27	17	12	-	11	4	24.1
7-640-1040	9417-250 FM US	350	275	73	22	57	95	63.6	12	32.5	20	18	M8	14	4	38.6
7-640-1240	9417-315 FM US	405	335	80	24	80	110	71.4	13	37	20	18	M8	14	4	59.6

Standard accessories:

- "T" wrench
- 1/2" ratchet with internal square
- □ S to 1/2" adapter
- eye bolt (only 250 and 315) -2 pcs.

Clamping range



Type	d1	d2	d3	d4	d5	d6	d7	d8
9416-160 FM US	32÷62.5	67÷96	93÷122.5	115÷145	38÷68.5	90÷120	114÷144	142÷161
9417-160 FM US	36÷62	70.5÷96,5	96.5÷121	119÷145	42÷67	94÷119	118÷146	146÷161
9416-200 FM US 9417-200 FM US	42÷73	82.5÷113	112.5÷143	142÷173	47÷78	109÷140	140÷171	170÷201
9416-250 FM US 9417-250 FM US	59÷98.5	106.5÷145	142÷180.5	177÷216	66÷105.5	140÷179	177÷216	213÷252
9416-315 FM US 9417-315 FM US	105÷166.5	156.5÷217	199÷259	241÷302	82÷144	169÷230	212÷273	255÷316



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NEW

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1941

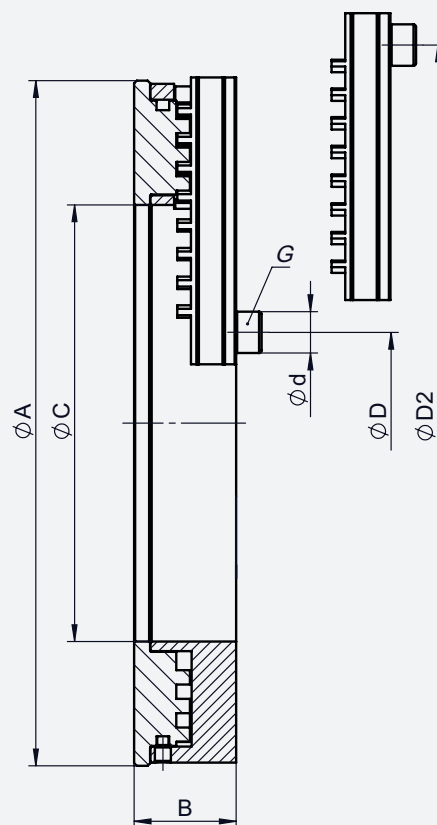
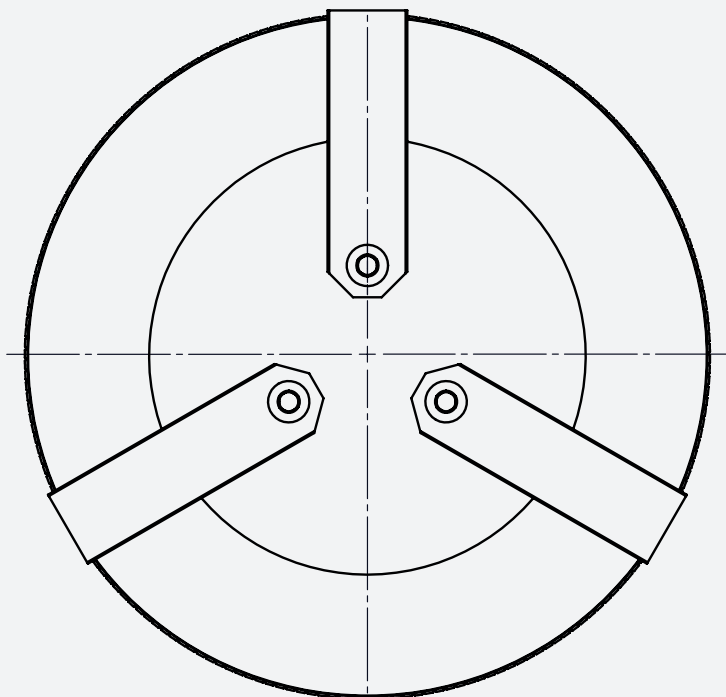
Jaw Tightening Attachment For 3-Jaw Lathe Chucks



Jaw tightening attachment 1941 for wide range of reversible stepless jaws. It is used for tightening jaws mounted in the chuck for turning or grinding of clamping surfaces of lathe chuck jaws, or for setting the required range for the for the clamping jaws. It's entirely made of steel, which ensures longevity, rigidity, and wear resistance.

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Code No.	Type	ØA	B	ØC	ØD	ØD2	Ød	G	Weight [kg]
391941020400	1941-125-0	153	28.5	112	50-115	150-215	8.5	M5	1.8
391941040800	1941-200-1	176	32	112	35-125	170-260	13	M8	3.4
391941050000	1941-250-2	215	32	137	70-140	215-285	13	M8	5.2
391941051200	1941-250-3	244	32	164	100-175	240-315	13	M8	6.1
391941060100	1941-315-4	290	32	210	145-215	290-360	13	M8	7.5
391941070300	1941-400-5	342	32	262	160-270	330-440	16	M10	9.2



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