



## 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

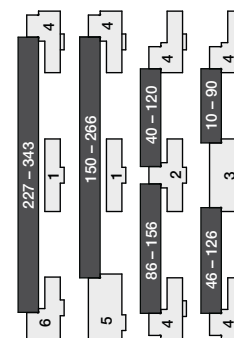
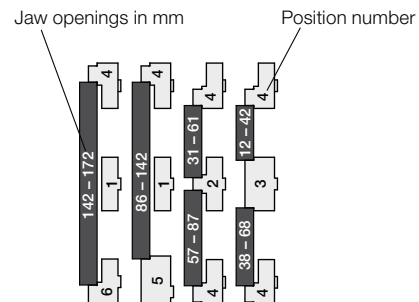
Position	Description	Part no.
1	Guide plate	9.3791.4140
2	Central step jaw 16 mm	9.3791.4111
3	Central step jaw 54 mm	9.3791.4121
4	Reversible step jaw	9.3791.4211
5	Fixed step jaw	9.3791.4341
6	Fixed step jaw	9.3791.4311

#### TS 100 and TS 100 TriStar

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

Position	Description	Part no.
1	Guide plate	9.3791.5140
2	Central step jaw 26 mm	9.3791.5111
3	Central step jaw 86 mm	9.3791.5121
4	Reversible step jaw	9.3791.5211
5	Fixed step jaw	9.3791.5341
6	Fixed step jaw	9.3791.5311
Position	Clamping jaws for jaw inserts	Part no.
2	Central step jaw for 1 jaw insert	9.3791.5711
3	Central step jaw for 2 jaw inserts	9.3791.5721
4	Reversible step jaw for 1 jaw insert	9.3791.5811
5	Fixed step jaw for 1 jaw insert	9.3791.5941
6	Fixed step jaw for 1 jaw insert	9.3791.5911

### Jaw openings

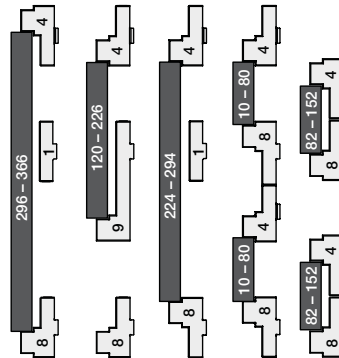


## Clamping jaws and jaw openings Dimensions

### TS 100 and TS 100 TriStar

Design: TS Vector with 2 fixed jaws

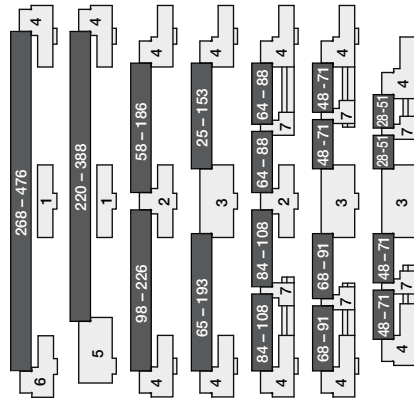
Position	Description	Part no.
1	Guide plate	9.3791.5143
4	Reversible step jaw	9.3791.5211
8	Fixed reversible step jaw	9.3791.5371
9	Fixed step jaw, long	9.3791.5381
Position	Clamping jaws for jaw inserts	
4	Reversible step jaw for 1 jaw insert	9.3791.5811
8	Fixed reversible step jaw for 1 jaw insert	9.3791.5971
9	Fixed step jaw, long, for 1 jaw insert	9.3791.5981



### TS 125 and TS 125 TriStar

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

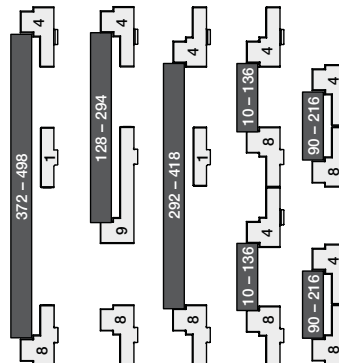
Position	Description	Part no.
1	Guide plate	9.3791.6142
2	Central step jaw 24 mm	9.3791.6151
3	Central step jaw 90 mm	9.3791.6161
4	Reversible step jaw	9.3791.6211
5	Fixed step jaw	9.3791.6351
6	Fixed step jaw	9.3791.6311
7	Floating central jaw	9.3791.6511
Position	Clamping jaws for jaw inserts	
2	Central step jaw for 1 jaw insert	9.3791.6751
3	Central step jaw for 2 jaw inserts	9.3791.6761
4	Reversible step jaw for 1 jaw insert	9.3791.6811
5	Fixed step jaw for 1 jaw insert	9.3791.6951
6	Fixed step jaw for 1 jaw insert	9.3791.6911



### TS 125 and TS 125 TriStar

Design: TS Vector with 2 fixed jaws

Position	Description	Part no.
1	Guide plate	9.3791.6143
4	Reversible step jaw	9.3791.6211
8	Fixed reversible step jaw	9.3791.6371
9	Fixed step jaw, long	9.3791.6381
Position	Clamping jaws for jaw inserts	
4	Reversible step jaw for 1 jaw insert	9.3791.6811
8	Fixed reversible step jaw for 1 jaw insert	9.3791.6971
9	Fixed step jaw, long, for 1 jaw insert	9.3791.6981



## Accessories Clamping jaws and clamping jaws for jaw inserts

### 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							9.3791.4140
TS 100	96	100	16							9.3791.5140
TS 125	100	125	19							9.3791.6142

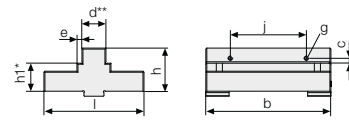


**Position 1: Guide plates for Vector  
Design with 2 fixed jaws**

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	72	100	16							9.3791.5143
TS 125	78	125	19							9.3791.6143

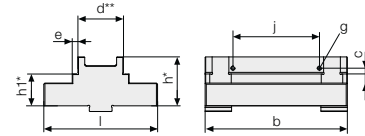
**Position 2: Central step jaws**

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	28	16	5	16	5	M4x6	50	9.3791.4111
TS 100	96	100	40	25	5	26	5	M4x6	60	9.3791.5111
TS 125	100	125	43	28	5	24	5	M4x6	76	9.3791.6151



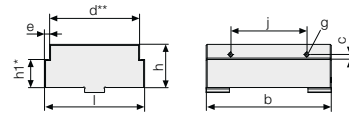
**Position 2: Central step jaws for 1 jaw insert**

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	96	100	40	25	5	34	3	M4x6	60	9.3791.5711
TS 125	100	125	43	28	5	40	5	M4x6	76	9.3791.6751



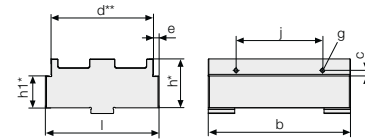
**Position 3: Central step jaws**

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	28	16	5	54	5	M4x6	50	9.3791.4121
TS 100	96	100	40	25	5	86	5	M4x6	60	9.3791.5121
TS 125	100	125	43	28	5	90	5	M4x6	76	9.3791.6161



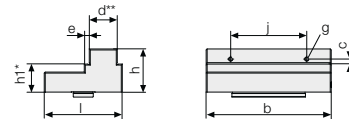
**Position 3: Central step jaws for 2 jaw inserts**

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	96	100	40	25	5	90	3	M4x6	60	9.3791.5721
TS 125	100	125	43	28	5	90	5	M4x6	76	9.3791.6761



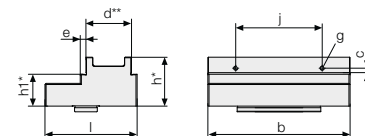
**Position 4: Reversible step jaws**

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	48,5	80	28	16	5	18	5	M4x6	50	9.3791.4211
TS 100	72	100	40	25	5	26	5	M4x6	60	9.3791.5211
TS 125	78	125	43	28	5	28	5	M4x6	76	9.3791.6211



**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	9.3791.5811
TS 125	81	125	43	28		40	5	M4x6	76	9.3791.6811

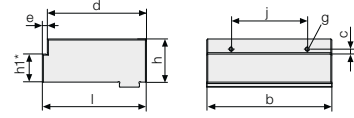


\* Tolerance ±0.01 mm  
\*\* Tolerance ±0.02 mm

## Accessories Clamping jaws and clamping jaws for jaw inserts

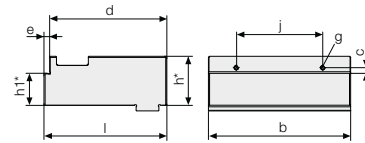
### Position 5: Fixed step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	71	80	28	16	5	66	5	M4x6	50	9.3791.4341
TS 100	88	100	40	25	5	83	5	M4x6	60	9.3791.5341
TS 125	104	125	43	28	5	99	5	M4x6	76	9.3791.6351



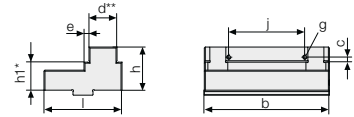
### Position 5: Fixed step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	90	100	40	25	5	85	5	M4x6	60	9.3791.5941
TS 125	108	125	43	28	5	103	5	M4x6	76	9.3791.6951



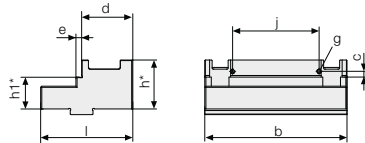
### Position 6: Fixed step jaws used for a large clamping range

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	49	80	28	16	5	15	5	M4x6	50	9.3791.4311
TS 100	72	100	40	25	5	26	5	M4x6	60	9.3791.5311
TS 125	78	125	43	28	5	28	5	M4x6	76	9.3791.6311



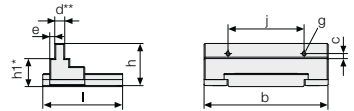
### Position 6: Fixed step jaws for 1 jaw insert

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	80	100	40	25	5	34	5	M4x6	60	9.3791.5911
TS 125	88	125	43	28	5	40	5	M4x6	76	9.3791.6911



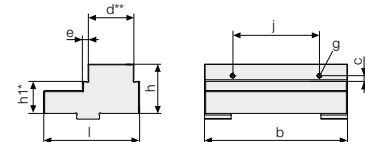
### Position 7: Floating central jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	50/80	124	43	28	5	10	5	M4x6	76	9.3791.6511



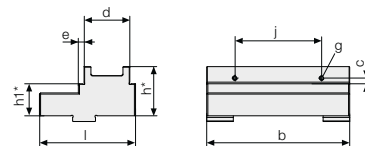
### Position 8: Fixed reversible step jaws

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	72	100	40	25	5	26		M4x6	60	9.3791.5371
TS 125	78	125	43	28	5	28		M4x6	76	9.3791.6371



### 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	9.3791.5971
TS 125	88	125	43	28	5	40	5	M4x6	76	9.3791.6971



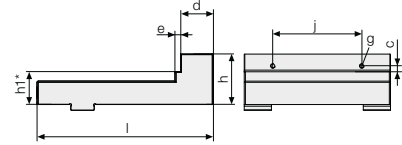
\* Tolerance ±0.01 mm  
\*\* Tolerance ±0.02 mm

## Accessories

### Clamping jaws and clamping jaws for jaw inserts

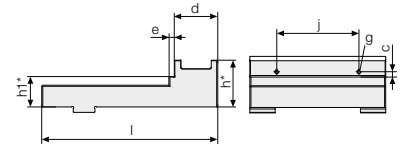
#### Position 9: Fixed step jaws, long for TS Vector

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	142	100	40	25	5	34	5	M4x6	60	9.3791.5381
TS 125	164	125	43	28	5	40	5	M4x6	76	9.3791.6381



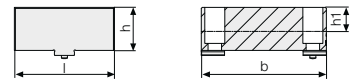
#### Position 9: Fixed step jaws, long for 1 jaw insert for TS Vector

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 100	142	100	40	25	5	34	5	M4x6	60	9.3791.5981
TS 125	164	125	43	28	5	40	5	M4x6	76	9.3791.6981



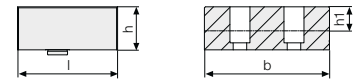
#### Central jaws, soft

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	64	80	35	21						9.3791.4411
TS 100	96	100	40	23						9.3791.5411
TS 125	100	125	43	24						9.3791.6411



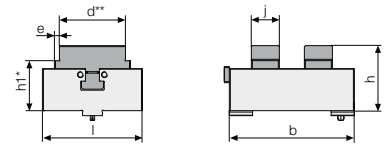
#### Reversible jaws, soft

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 80	56	80	35	21						9.3791.4421
TS 100	84	100	40	23						9.3791.5421
TS 125	100	125	43	24						9.3791.6421



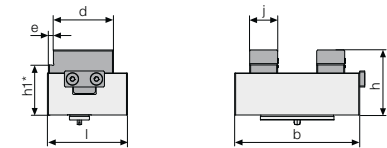
#### SlimFlex central jaws with inserts

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	100	125	65	50		66	5		28	9.3791.6173



#### SlimFlex clamping jaws with inserts

Type	l	b	h	h1	c	d	e	g	j	Part no.
TS 125	80	125	65	50			5		28	9.3791.6273



\* Tolerance ±0.01 mm  
\*\* Tolerance ±0.02 mm

## Accessories for operation

#### Torque wrench



Type	Part no.	Torque [Nm]
TS 80	9.3583.7010	5– 60
TS 100	9.3792.6610	20–120
TS 125	9.3792.6610	20–120

#### Socket for torque wrench



Type	Part no.	SW
TS 80	1.3124.0021	12
TS 100	1.3124.0020	14
TS 125	1.3124.0017	17

#### Allen wrench for clamping jaws and jaw inserts



Type	Part no.	SW
TS 100	1.6911.0003	8
TS 125	1.6911.0005	10

## Accessories Interchangeable 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	rolled / cast / forged	drawn	sawn	milled	ground
Steel, e.g. C45, 20 Mn Cr 5, 31 Cr Mo V9		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

Description	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

Description	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

Description	Part no. for reversible step jaws	Part no. 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