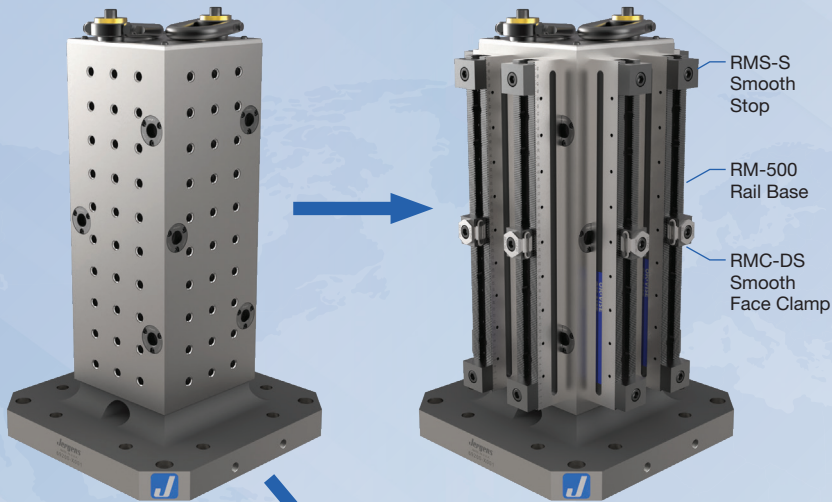


# TOOLING EXAMPLES

4-sided column customized with QLS grid and 20mm Ball-Lock® receivers to accept multiple fixturing devices

## OK-VISE® RM RAIL SYSTEM

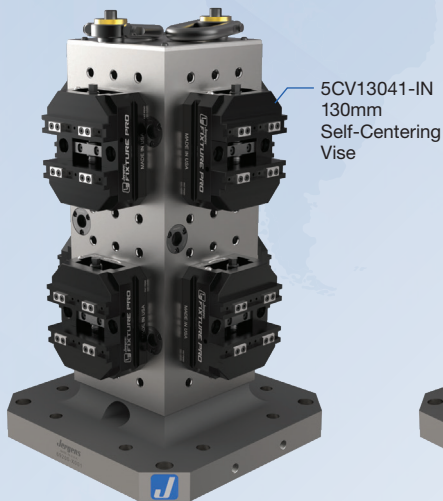


RMS-S  
Smooth  
Stop

RM-500  
Rail Base

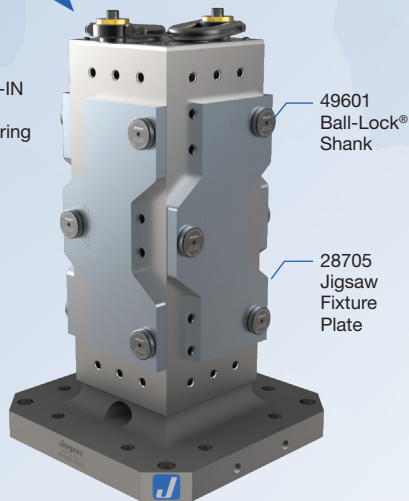
RMC-DS  
Smooth  
Face Clamp

## VICES



5CV13041-IN  
130mm  
Self-Centering  
Vise

## BALL-LOCK® FIXTURE PLATES



49601  
Ball-Lock®  
Shank

28705  
Jigsaw  
Fixture  
Plate



## WORLD HEADQUARTERS

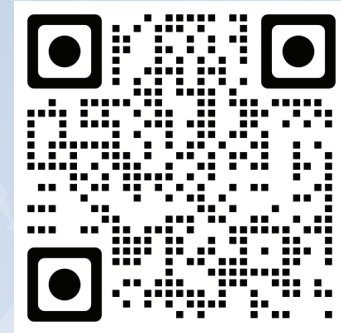
15700 S. WATERLOO ROAD  
CLEVELAND, OH 44110-3898

877.426.2504

JERGENSINC.COM/WORKHOLDING

WORKHOLDING@JERGENSINC.COM

FIND OUR WORKHOLDING PRODUCTS  
AND SUPPORTING INFO ONLINE.



DISTRIBUTED BY:



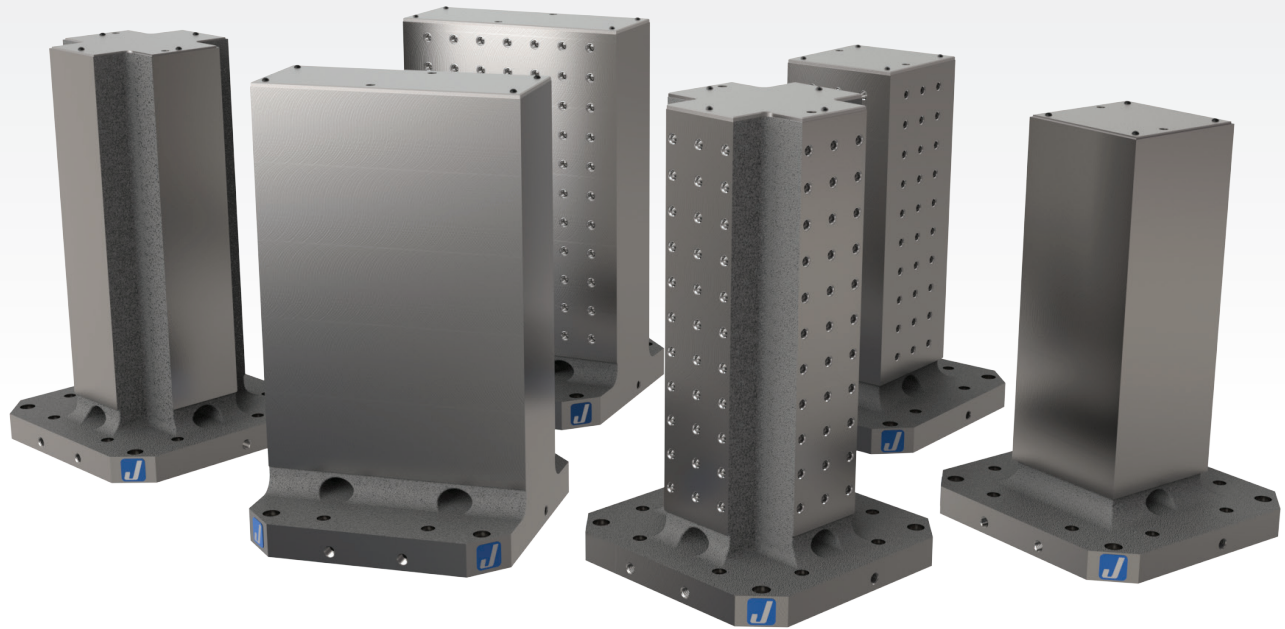
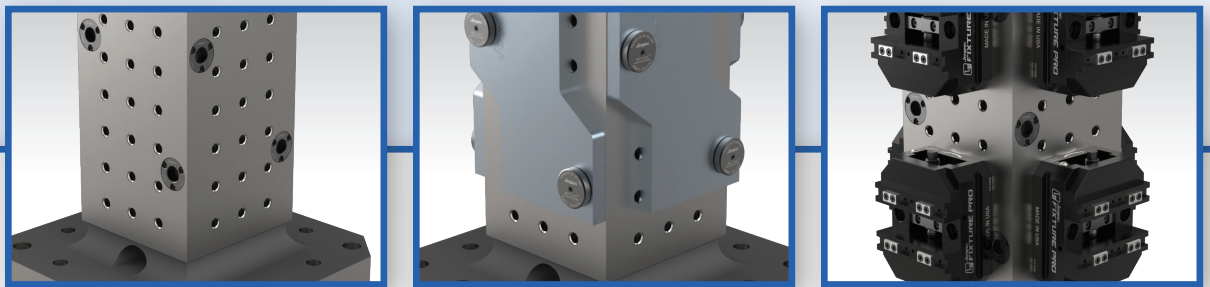
©2022 JERGENS, INC.



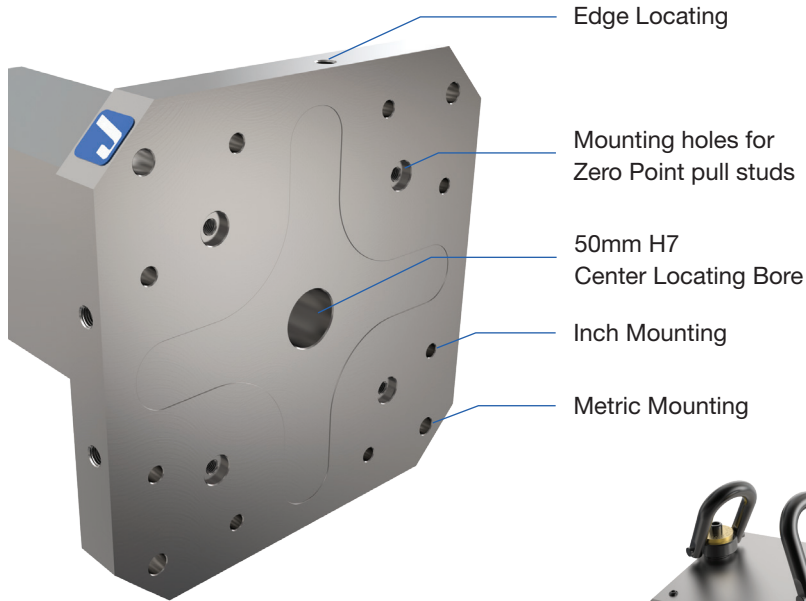


# CAST IRON TOOLING COLUMNS

MAXIMUM RIGIDITY FOR HORIZONTAL MACHINING APPLICATIONS



## STANDARD FEATURES



Edge Locating

Mounting holes for Zero Point pull studs

50mm H7 Center Locating Bore

Inch Mounting

Metric Mounting



### MADE IN U.S.A.

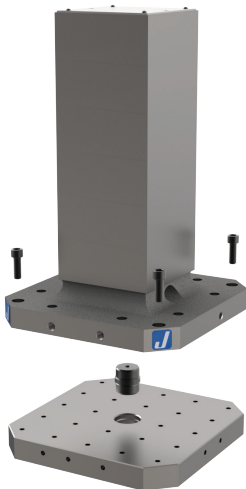
- Rigid single piece construction
- Stress Relieved Class 40 Cast Iron
- Base and sides milled flat, perpendicular, and parallel within .001"/ft.
- Includes mounting holes for popular 400mm and 500mm pallets

Custom sizes and configurations available upon request

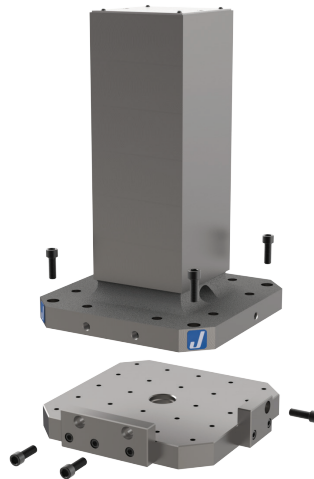
#### Included Hardware

- Top Coverplate
- (2) Jergens center pull hoist rings

## VERSATILE STANDARD MOUNTING OPTIONS



Direct mount with center pin locating (DIN Mounting)



Direct mount with edge locating (JIS Mounting)

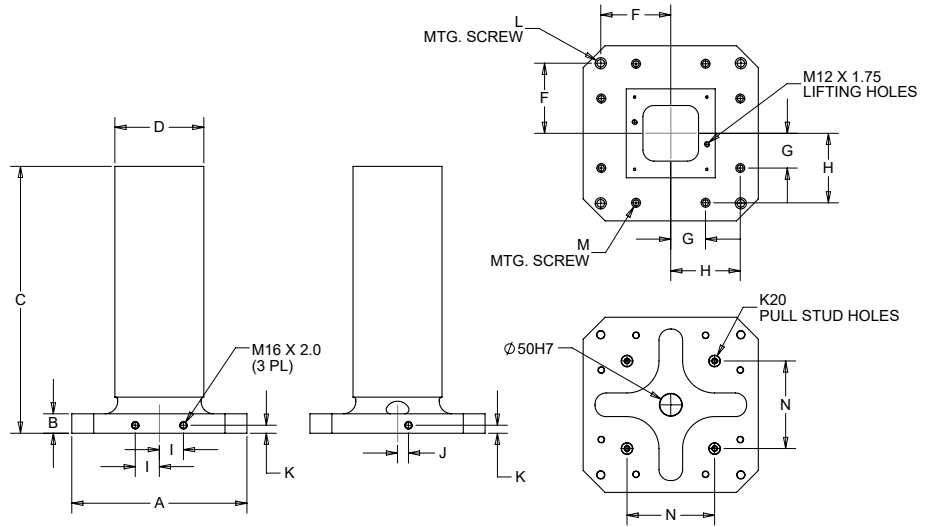
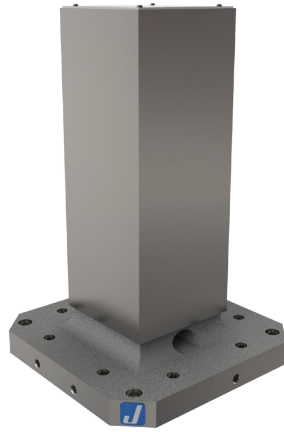


ZPS mount with K20 pull studs and 4 module subplate



# SQUARE COLUMNS

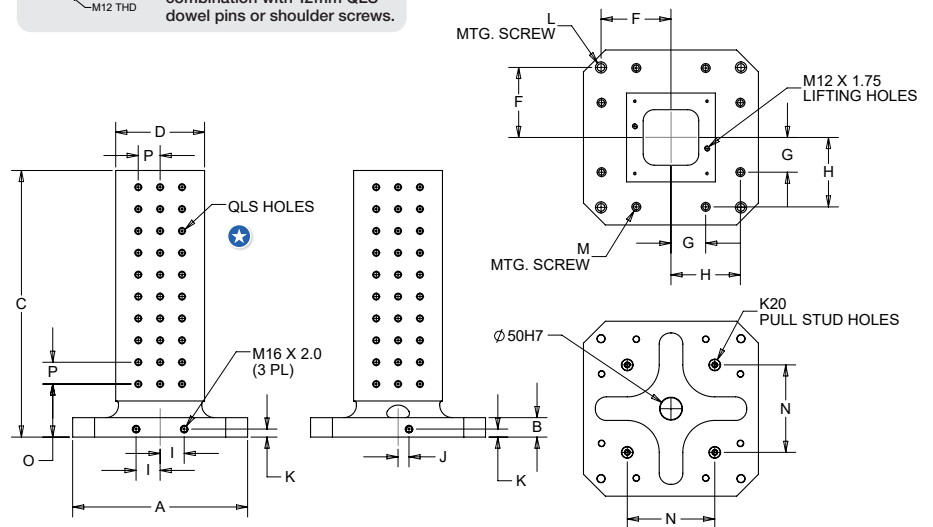
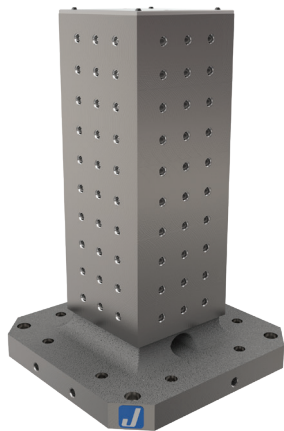
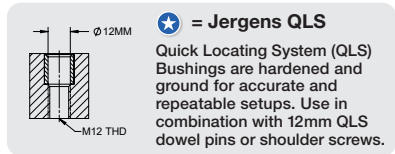
## BLANK FACE



Part Number	A (mm)	B (in)	C (in)	D (in)	F (in)	G (in)	H (in)	I (in)	J (in)	K (in)	L	M	N (in)	Weight lb (kg)
69200	400	1.75	24.00	8.00	6.30	3.125	6.25	2.165	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	335 (152)
69230	500	1.75	30.00	12.00	7.874	4.00	8.00	2.953	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	635 (288)

## QLS GRID

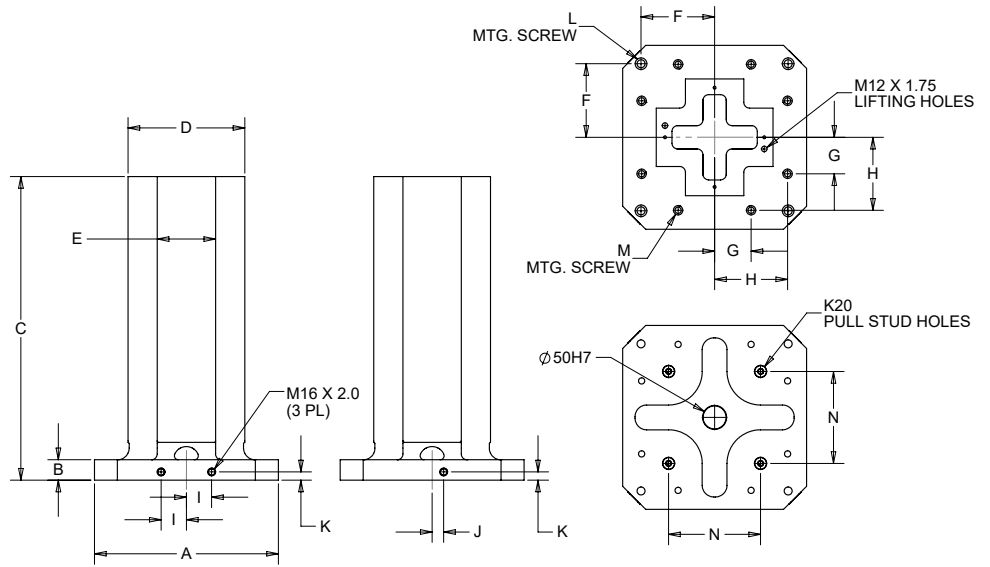
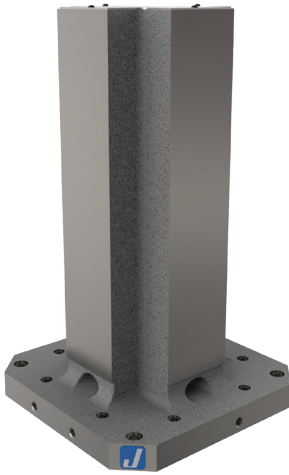
- Includes grid of tapped holes with hardened bushings (5BS1216) installed for locating
- 50mm X 50mm Grid Spacing



Part Number	A (mm)	B (in)	C (in)	D (in)	F (in)	G (in)	H (in)	I (in)	J (in)	K (in)	L	M	N (in)	O (in)	P (in)	QLS Grid	Weight lb (kg)
69201	400	1.75	24.00	8.00	6.30	3.125	6.25	2.165	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	4.767	1.9685	10 X 3	329 (149)
69231	500	1.75	30.00	12.00	7.874	4.00	8.00	2.953	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	4.814	1.9685	13 X 5	622 (282)

## CROSS COLUMNS

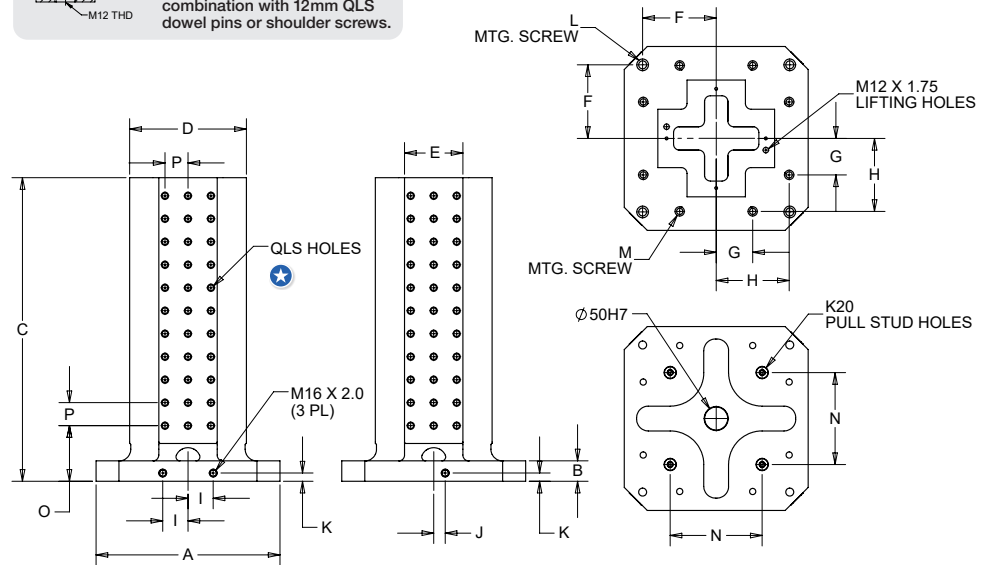
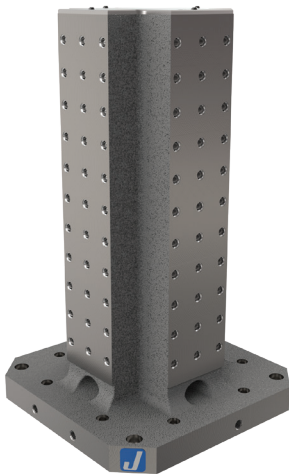
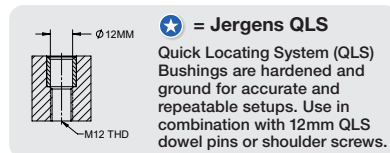
### BLANK FACE



Part Number	A (mm)	B (in)	C (in)	D (in)	E (in)	F (in)	G (in)	H (in)	I (in)	J (in)	K (in)	L	M	N (in)	Weight lb (kg)
69210	400	1.75	26.00	10.00	5.00	6.30	3.125	6.25	2.165	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	460 (209)
69240	500	1.75	30.00	12.50	6.00	7.874	4.00	8.00	2.953	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	705 (320)

### QLS GRID

- Includes grid of tapped holes with hardened bushings (5BS1216) installed for locating
- 50mm X 50mm Grid Spacing

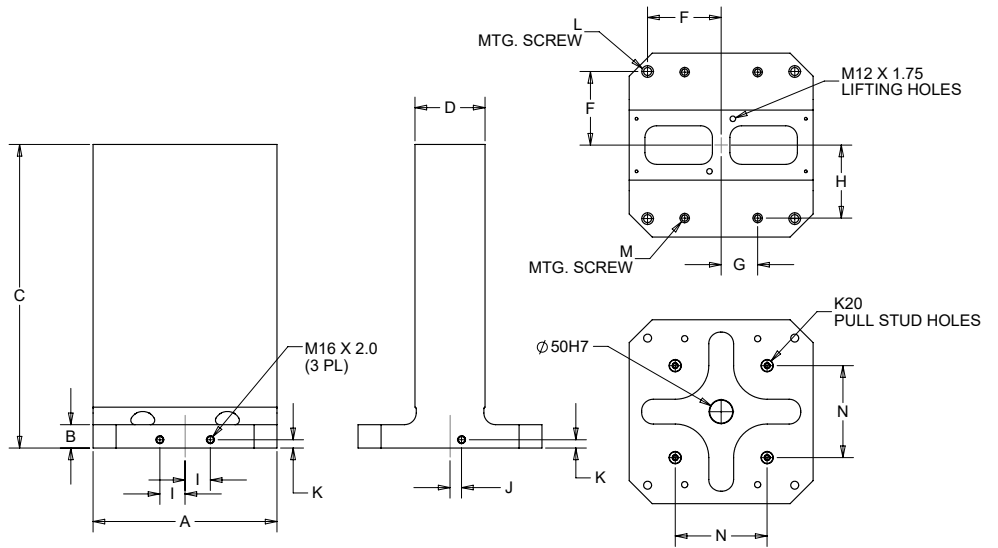
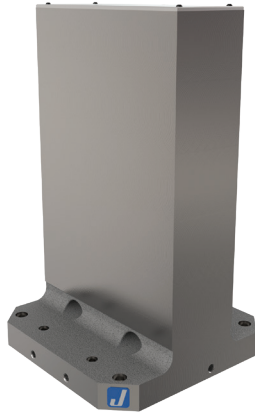


Part Number	A (mm)	B (in)	C (in)	D (in)	E (in)	F (in)	G (in)	H (in)	I (in)	J (in)	K (in)	L	M	N (in)	O (in)	P (in)	QLS Grid	Weight lb (kg)
69211	400	1.75	26.00	10.00	5.00	6.30	3.125	6.25	2.165	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	4.767	1.9685	11 X 3	452 (205)
69241	500	1.75	30.00	12.50	6.00	7.874	4.00	8.00	2.953	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	4.814	1.9685	13 X 3	697 (316)



# RECTANGULAR COLUMNS

## BLANK FACE

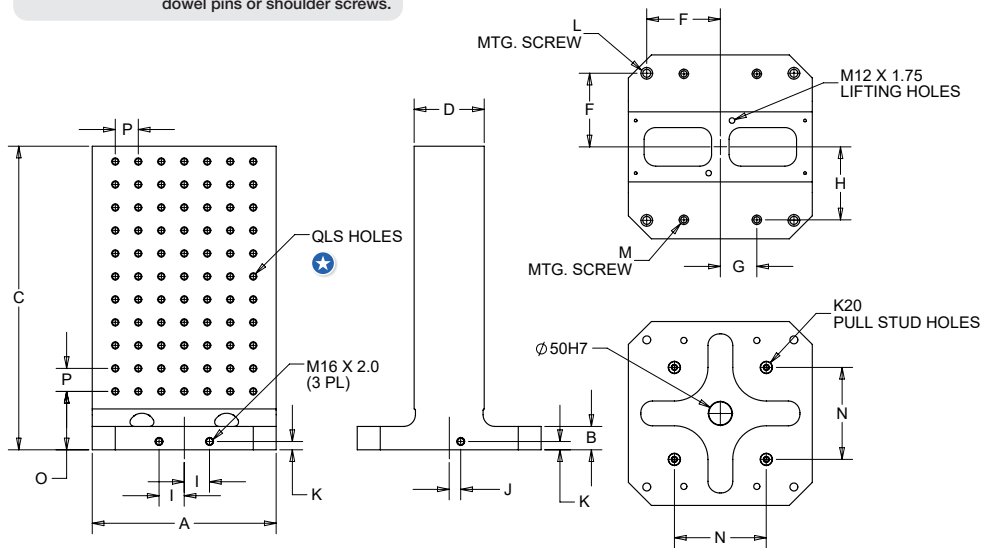


Part Number	A (mm)	B (in)	C (in)	D (in)	F (in)	G (in)	H (in)	I (in)	J (in)	K (in)	L	M	N (in)	Weight lb (kg)
69220	400	1.75	26.00	6.00	6.30	3.125	6.25	2.165	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	505 (229)
69250	500	1.75	30.00	8.00	7.874	4.00	8.00	2.953	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	790 (359)

## QLS GRID

- Includes grid of tapped holes with hardened bushings (5BS1216) installed for locating
- 50mm X 50mm Grid Spacing

★ = Jergens QLS  
Quick Locating System (QLS) Bushings are hardened and ground for accurate and repeatable setups. Use in combination with 12mm QLS dowel pins or shoulder screws.



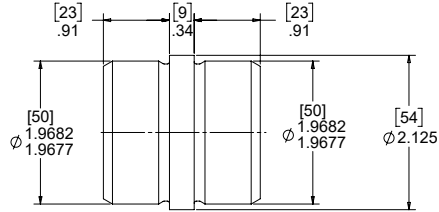
Part Number	A (mm)	B (in)	C (in)	D (in)	F (in)	G (in)	H (in)	I (in)	J (in)	K (in)	L	M	N (in)	O (in)	P (in)	QLS Grid	Weight lb (kg)
69221	400	1.75	26.00	6.00	6.30	3.125	6.25	2.165	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	4.767	1.9685	11 X 7	494 (224)
69251	500	1.75	30.00	8.00	7.874	4.00	8.00	2.953	0.984	0.709	5/8" (M16)	1/2" (M12)	7.874	4.814	1.9685	13 X 9	780 (354)

## COLUMN ACCESSORIES

### CENTER LOCATING PIN



- Locates a tooling column to center of machine pallet in DIN style mounting applications
- 4140 Steel
- Rc 38-42 thru hardened



Part Number	Weight lb (kg)
5LP505055	1.8 (0.82)

### REPLACEMENT HOIST RING



- M12 x 1.75 Thread
- 1,050 kg capacity

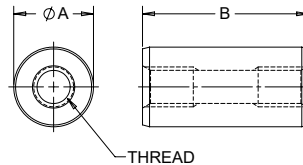
Part Number	Weight lb (kg)
23462	2.42 (1.1)

### QLS DOWEL PINS



- Locator pin for accurately positioning fixtures on QLS grid
- Low carbon Steel
- Case hardened
- Compatible with 5BS series QLS bushings

Part Number	A Nominal (mm)	A Actual (in)	B (mm)	Thread	Weight lb (kg)
5LP1220	12	.4720 / .4717	20	M6 X 1.0	0.03 (.014)
5LP1225	12	.4720 / .4717	25	M6 X 1.0	0.04 (.018)
5LP1230	12	.4720 / .4717	30	M6 X 1.0	0.05 (.023)



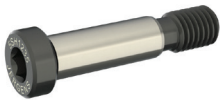
### QLS HOLE PLUG



- Brass
- Includes O-Ring
- M12 x 1.75 Thread

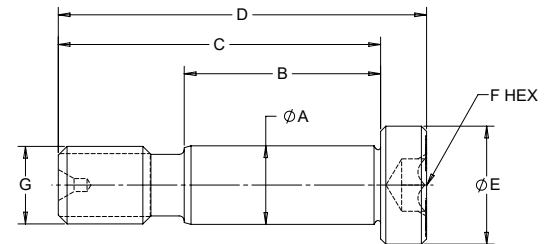
Part Number	Weight lb (kg)
5PL30002	0.05 (0.023)

### QLS SHOULDER SCREWS



- Dual purpose design provides both locating and fastening function when mounting fixtures and vises to QLS grid
- Ideal when space and grid locations are limited
- 4140 Steel
- Rc 40-45 thru hardened
- Low profile head
- Compatible with 5BS series QLS bushings

Part Number	A Nominal (mm)	A Actual (in)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G	Thread	Weight lb (kg)
5SH1220	12	.4720 / .4717	20	40	47	18	8	M12 X 1.75	0.09 (.04)	
5SH1225	12	.4720 / .4717	25	45	52	18	8	M12 X 1.75	0.10 (.045)	
5SH1230	12	.4720 / .4717	30	50	57	18	8	M12 X 1.75	0.11 (.05)	
5SH1235	12	.4720 / .4717	35	55	62	18	8	M12 X 1.75	0.12 (.054)	
5SH1240	12	.4720 / .4717	40	60	67	18	8	M12 X 1.75	0.13 (.06)	
5SH1245	12	.4720 / .4717	45	65	72	18	8	M12 X 1.75	0.14 (.064)	
5SH1250	12	.4720 / .4717	50	70	77	18	8	M12 X 1.75	0.15 (.07)	

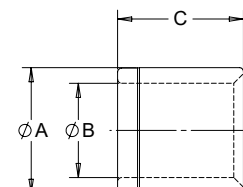


### QLS BUSHINGS



- Install in fixtures or grid plates to serve as precision locating holes that accept 12mm QLS Dowel Pins or Shoulder Screws
- 52100 Steel
- Rc 58-62 thru hardened
- Space saving thin wall design
- All QLS grid columns include 5BS1216 bushings installed

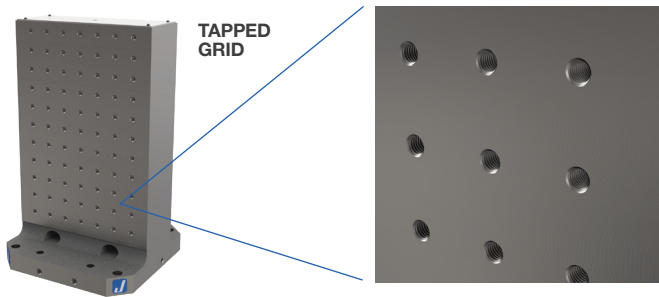
Part Number	A Nominal (mm)	A Actual (in)	B Nominal (mm)	B Actual (in)	C (mm)	Weight lb (kg)
5BS1210	16	.6299 / .6296	12	.4727 / .4723	10	0.01 (.005)
5BS1212	16	.6299 / .6296	12	.4727 / .4723	12	0.02 (.009)
5BS1216	16	.6299 / .6296	12	.4727 / .4723	16	0.02 (.009)
5BS1232	16	.6299 / .6296	12	.4727 / .4723	32	0.05 (.023)



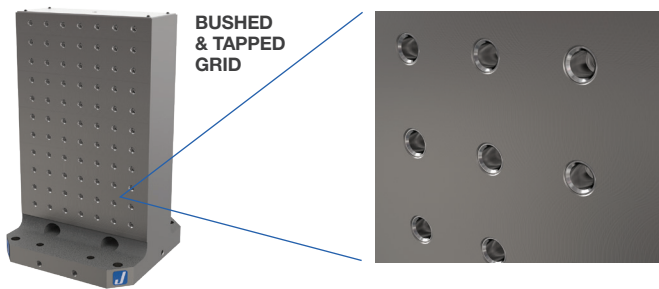


## CUSTOMIZED OPTIONS

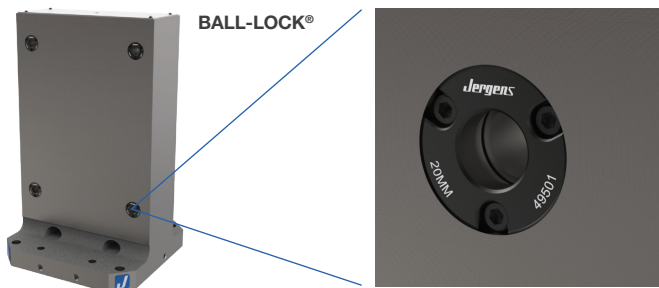
Jergens tooling columns are fully customizable to provide the optimum workholding solution for your unique application. Incorporate one of our industry leading “Quick-Change” systems for maximum productivity. Contact our Technical Sales Engineering Team to request a quote for your custom configuration or project.



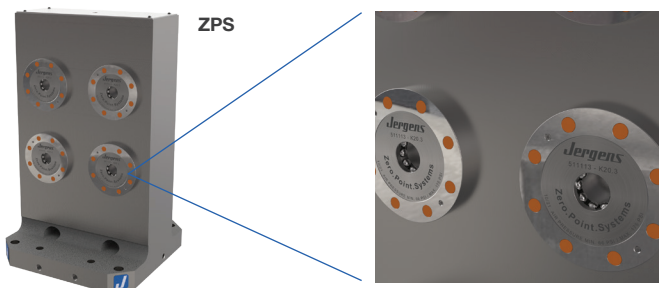
A grid pattern of drilled and tapped holes designed to meet your application needs provides a flexible surface for mounting assorted fixture plates, workholding devices, and top-tooling. Jergens can accommodate most thread sizes and holes spacings



Adding precision bushings to each hole allows for accurate positioning with dowel pins or shoulder screws. Jergens QLS grid pattern provides fast and accurate mounting for a wide range of standard top tooling from our popular Fixture-Pro® and Quick-Loc™ product lines



Ball-Lock® is Jergens most popular quick change system. Adding receiver bushings to the face of a column provides a method of quickly and accurately locating fixtures onto column surfaces. Reducing set-up time, fixtures can often be exchanged in less than a minute and positioned with repeatability of +/- .0005" (.013mm)



Fix, Position, and Clamp in a Single Step with Jergens' Zero-Point Mounting System. This revolutionary technology cuts set-up time by up to 90% by combining fixing, positioning and clamping in a single operation. Available with either pneumatic or hydraulic release, these positive locking locating modules allow operators to quickly change out large and small machine fixtures with extreme accuracy and minimal effort. The ZPS system is repeatable to within .0002" (0.005mm).