



SCHUNK **vise automation**

Automation for robots up to 20 kg

Hand in hand for tomorrow

For greater efficiency, productivity, and competitiveness



At a time when efficiency and maximum autonomous machine running time are becoming increasingly important, automated machine loading offers significant benefits for companies of all sizes. Global competitive pressure is increasing, while skilled workers are in short supply everywhere. Increasing variance, ever smaller batch sizes and fluctuating demand also call for optimized processes using the latest technologies. Automated machine tending of machine tools is an important step towards a "Healthy Factory" – a healthy company that makes processes more productive, and, at the same time reduces the burden on people and the environment. SCHUNK will be happy to accompany you on this journey.

Advantages of automated machine loading:

- + Increased productivity**
Automated systems can work around the clock without breaks, increasing production capacity, and reducing setup times and machine downtimes.
- + Cost saving**
Labor costs and rework can be reduced through less manual intervention and precise automation. The employee controls the process, the automation system takes over the work.
- + Improved quality**
Higher process accuracy and repeatability ensure more consistent product quality and reduced defects.
- + Flexibility**
Rapid adaptation to different production requirements and easy integration of new products are possible.
- + Increased competitiveness**
Shorter product throughput times lead to faster delivery times, thereby increasing customer satisfaction.

Your entry into the world of automated machine loading

We support you right from the beginning, and ensure that you understand the automated machine tending 101 and that you can use it in the best possible way. What options are there? Which solution suits your manufacturing process? And what are the advantages of each approach? Together, we will find the right type of automation for your process.

Depending on the workpiece, batch size, manufacturing process and machine, there are six automation types to choose from.



Lean automation

Workpiece variance	●○○○○
Workpiece complexity	●○○○○
Batch size	●○○○○



Vise automation

Workpiece variance	●●●●○
Workpiece complexity	●●●●○
Batch size	●●●●○



Workpiece automation

Workpiece variance	●●●○○
Workpiece complexity	●●○○○
Batch size	●●●●●



Workpiece and pallet automation

Workpiece variance	●●●●○
Workpiece complexity	●●●○○
Batch size	●●●●○



Pallet automation

Workpiece variance	●●●●○
Workpiece complexity	●●●●●
Batch size	●●○○○



Flexible manufacturing system

Workpiece variance	●●●●●
Workpiece complexity	●●●●○
Batch size	●●●○○

Workpiece variance = how many different workpieces are loaded
 Workpiece complexity = how demanding is it to clamp the workpiece

Batch size = quantity of identical workpieces that are produced without interruption

Vise automation

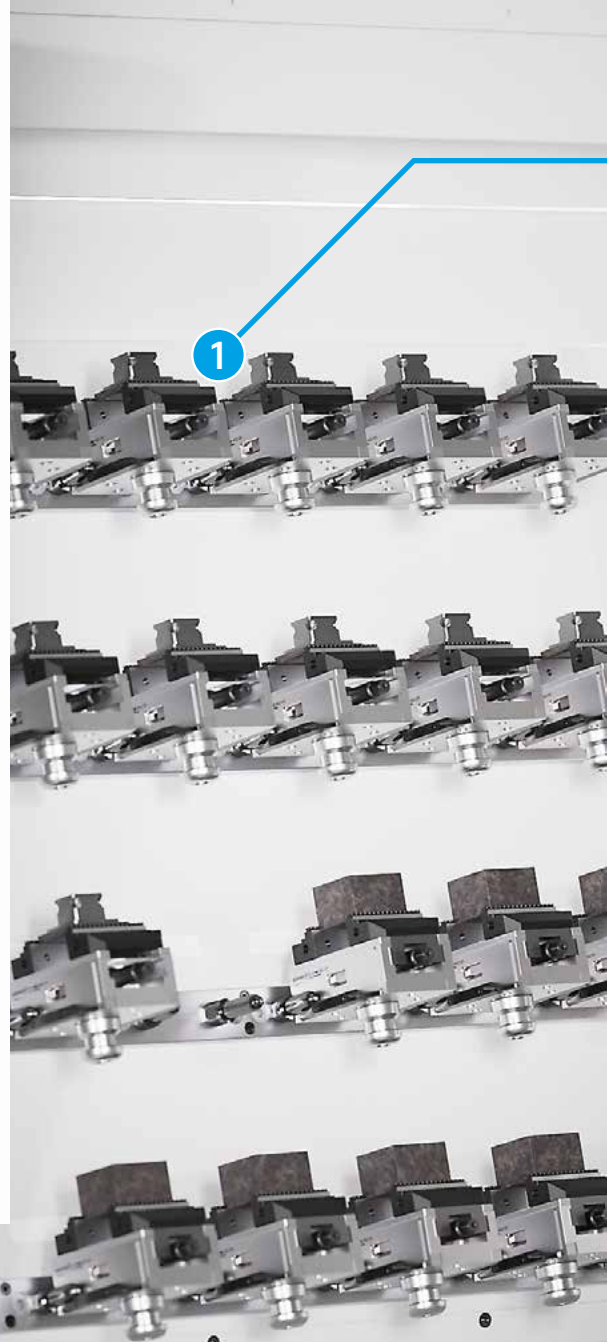


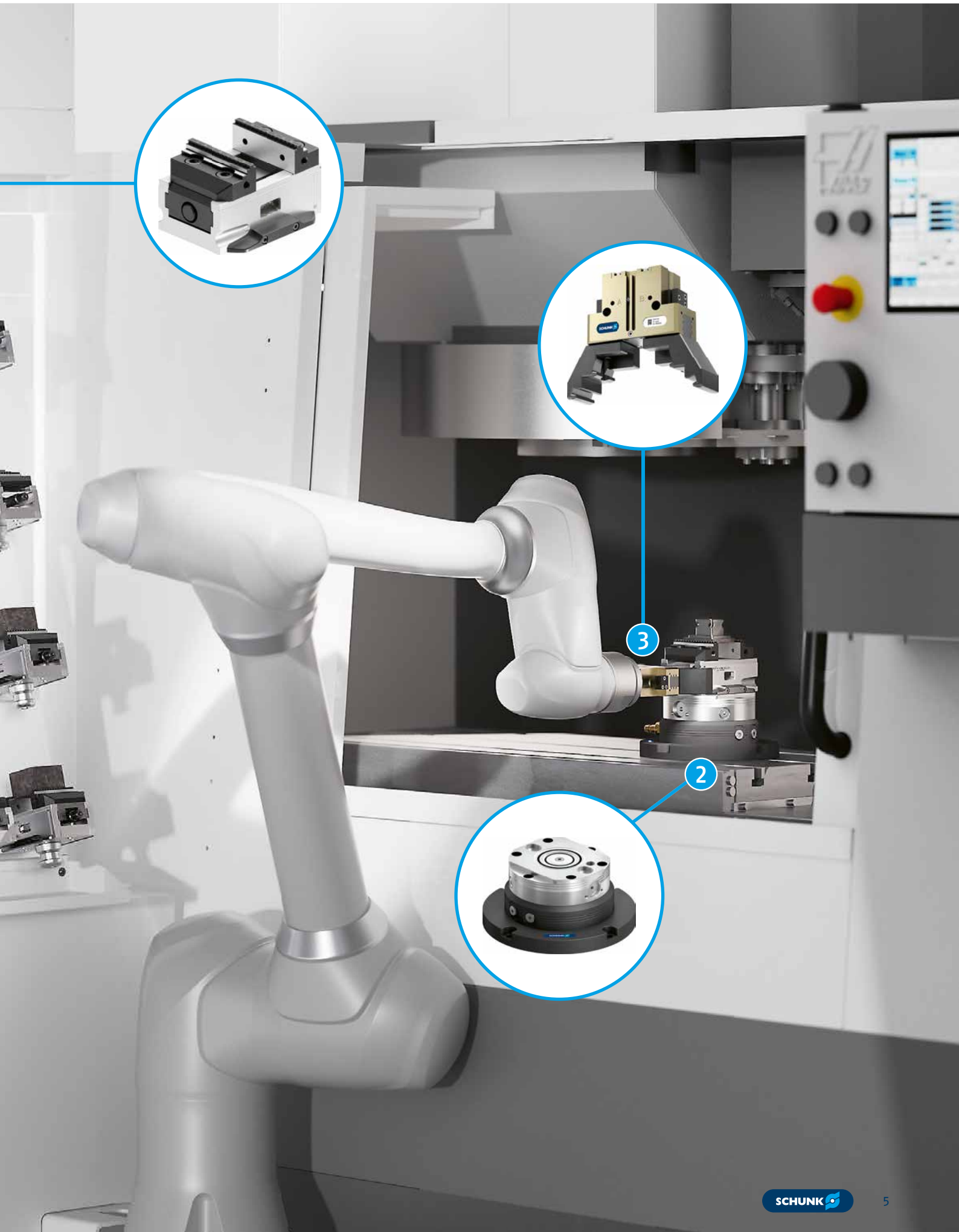
In the field of vise automation, specially designed vises are stored in a storage rack via storage pins. Loading and unloading or re-clamping for machining the sixth side can take place both outside and inside the storage rack. A robot places the vises on a specially designed clamping station in the machine tool using special gripper fingers. After machining, the vise and the workpiece are removed from the machine and placed in the storage rack.

Your advantages:

- + Low investment costs
- + Very high reliability
- + Low complexity
- + Increase in efficiency

- 1 Centric clamping or single-acting vises
- 2 1-way clamping station as console version
- 3 Universal gripper including gripper fingers for vise handling



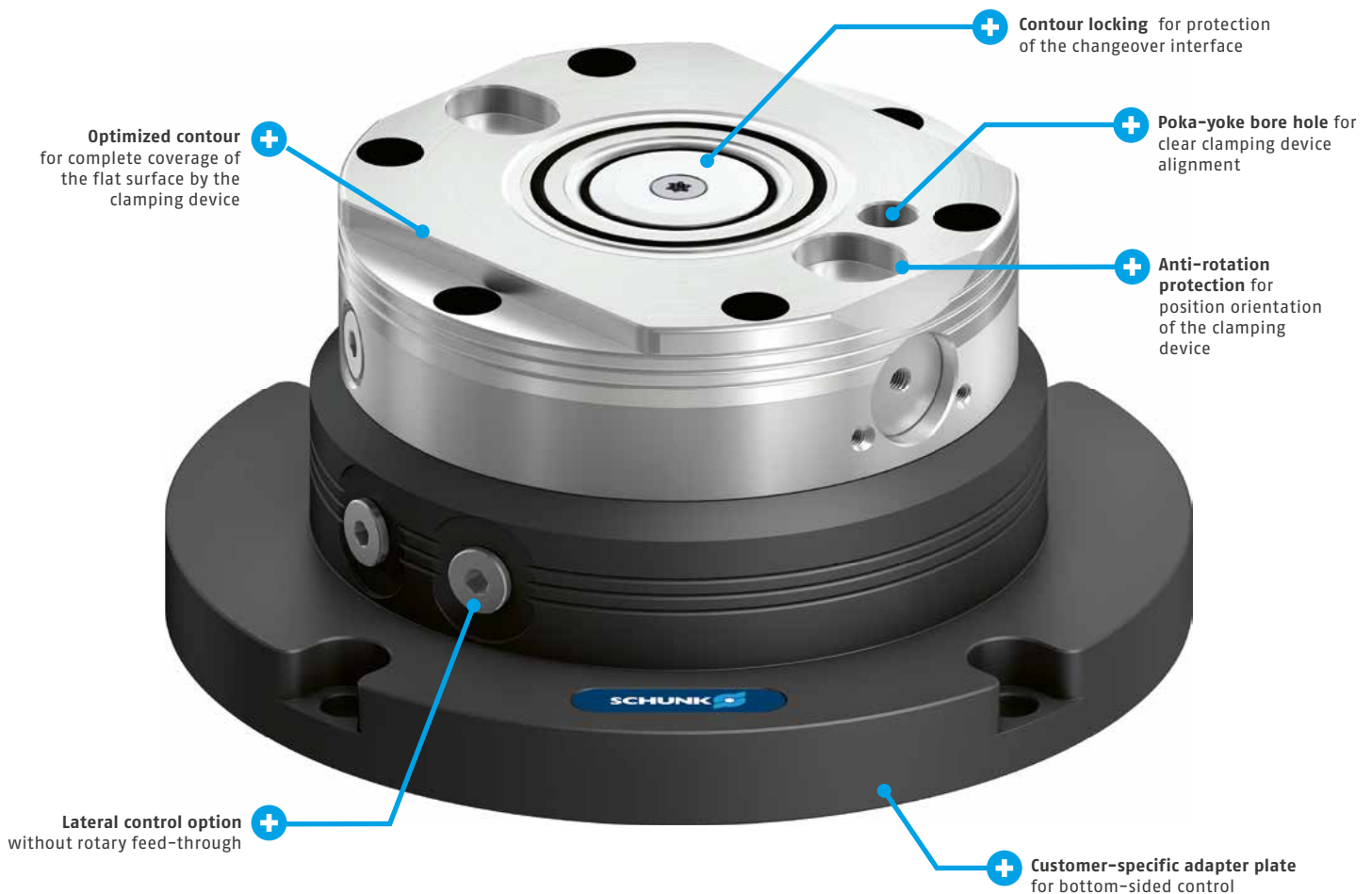


1-way clamping station as console version

Raised clamping device positioning for optimum access to the workpiece

The VERO-S 1-way clamping station forms the basis of the vise automation on the machine table of the machine tool. It enables positioning and clamping in just one operation and, with its high pull-down forces, ensures extremely rigid, reliable clamping of the clamping devices used. Thanks to the connection that is precise to the micron, the vises are inserted and exchanged by the robot with repeat accuracy at any time – for maximum precision, efficiency, and process reliability.

The special feature of this clamping station is the installation on the console. This lifts the clamping device off the machine table, thus allowing optimum accessibility and machining from five sides. Another advantage: the laterally offset quick-change pallet module is completely covered by the clamping device – meaning that no chip nests are created and process reliability is guaranteed at all times.



KSC3 vise with automation interface

Precise centric clamping or single-acting vise with extensive range of jaws

Maximum precision with high clamping force and a very flat design at the same time – this is what the KSC3 centric clamping vise and KSC3-K console clamping module stand for. The vises feature an extremely wide range of system and top jaws that is unique on the market, providing it with maximum flexibility. The closed system with optimized chip drainage ensures maximum process reliability. A gripper finger interface has been added to the vises especially for vise automation. With the help of this

interface, the centric clamping and single-acting vises can be inserted into the machine tool and exchanged via a gripper with standardized gripper fingers. In addition, the vises have been extended to include lateral mounting contours for storage in the storage rack and a poka-yoke bore hole, which guarantees correct module alignment on the clamping station.



Gripper finger interface

A gripper finger interface enables the vises to be handled using two standardized gripper fingers.

- **FIN KSC3 80**
Suitable for all vises with a width of 80 mm
- **FIN KSC3 80/125**
Combination finger for all versions



Module overlap

Clean surfaces on the vise and the quick-change pallet module are crucial for smooth automation. For this purpose, the centric clamping and single-acting vises have been optimally matched to the VERO-S modules:

All vises with a width of 80 mm have side wings that reliably cover the modules.

For all vises with a width of 125, the module has been precisely adapted and set to a width of 125 mm.

The result: lasting precision, protection against contamination and maximum process reliability in every application.



Storage pins

The vises are equipped with special mounting contours that allow them to be placed easily in the vise storage racks. The vises can be inserted and exchanged quickly and precisely using the locating pins in the storage rack.

Precise complete machining of the workpiece

Overall, complete machining of the workpiece on all 6 sides leads to more efficient, more cost-effective and higher-quality production, which brings many advantages.



Centric
clamping
vises

OP10: 5-sided machining with centric clamping vise KSC3



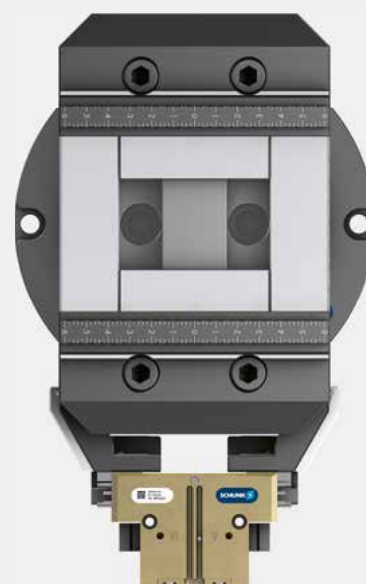
KSC3 80-130-VA

Z-dimension incl. jaws: 173 mm
Clamping range: 0 - 121 mm



KSC3 80-190-VA

Z-dimension incl. jaws: 173 mm
Clamping range: 0 - 185 mm



KSC3 125-160-VA

Z-dimension incl. jaws: 178 mm
Clamping range: 0 - 163 mm

Overview:

- + Symmetrical clamping
- + The workpiece zero point is always centered
- + Very good accessibility for 5-axis milling
- + Particularly suitable for workpieces with dimensioning from the center



**Single-acting
clamping
vises**



**Low
complexity**



**Very high
reliability**



**Low invest-
ment costs**

OP20: 6-sided machining with vise with fixed jaw KSC3-K



KSC3-K 80-130-VA

Z-dimension incl. jaws: 173 mm
Clamping range: 0 – 78 mm



KSC3-K 80-190-VA

Z-dimension incl. jaws: 173 mm
Clamping range: 0 – 138 mm

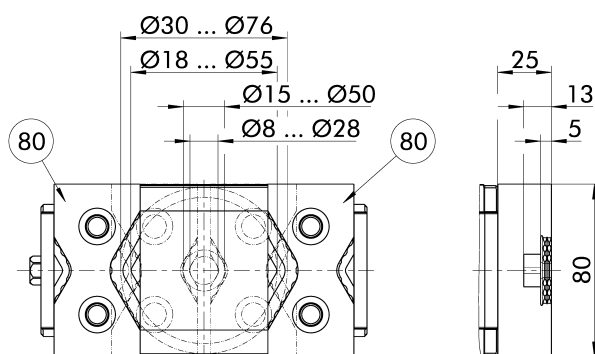
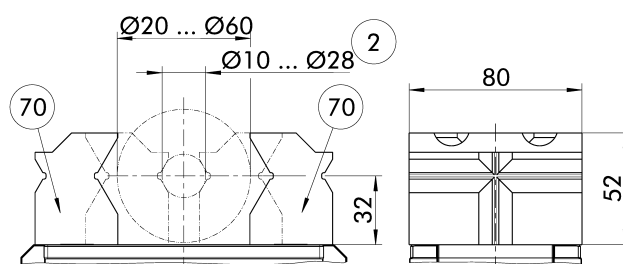
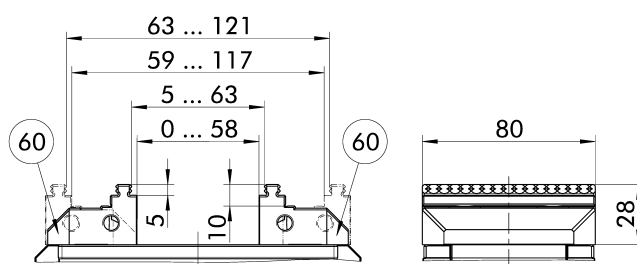
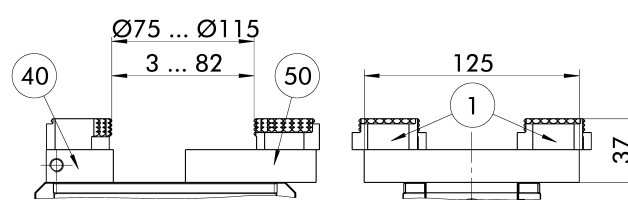
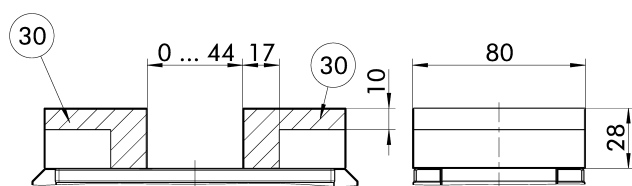
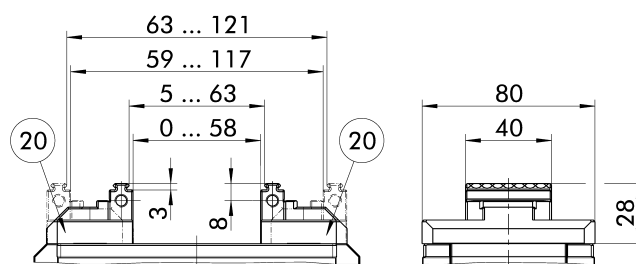
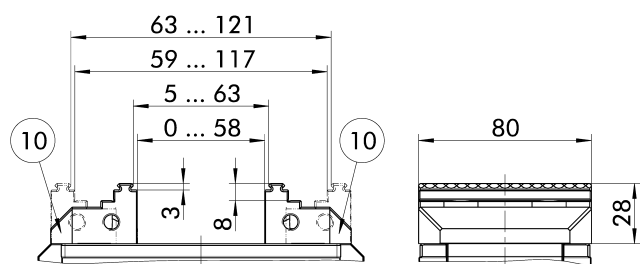


KSC3-K 125-160-VA

Z-dimension incl. jaws: 178 mm
Clamping range: 0 – 139 mm

Overview:

-  Clamping against a fixed jaw
-  The fixed jaw acts as a reference
-  High repeat accuracy
-  Particularly suitable for workpieces with dimensioning from the side



Technical changes reserved.

① 6-way reversal jaw grip (ID 0430803), 6-way reversal jaw carbide grip (ID 1395550)

② Same clamping ranges for vertical clamping

Technical data

Description	ID	Width of the clamping vise [mm]	Max. clamping force [kN]	Max. torque [Nm]	Weight [kg]
KSC3 80-130-VA	1623548	80	25	90	3.1

Scope of delivery

Vise, operating manual; without system jaws

Notes

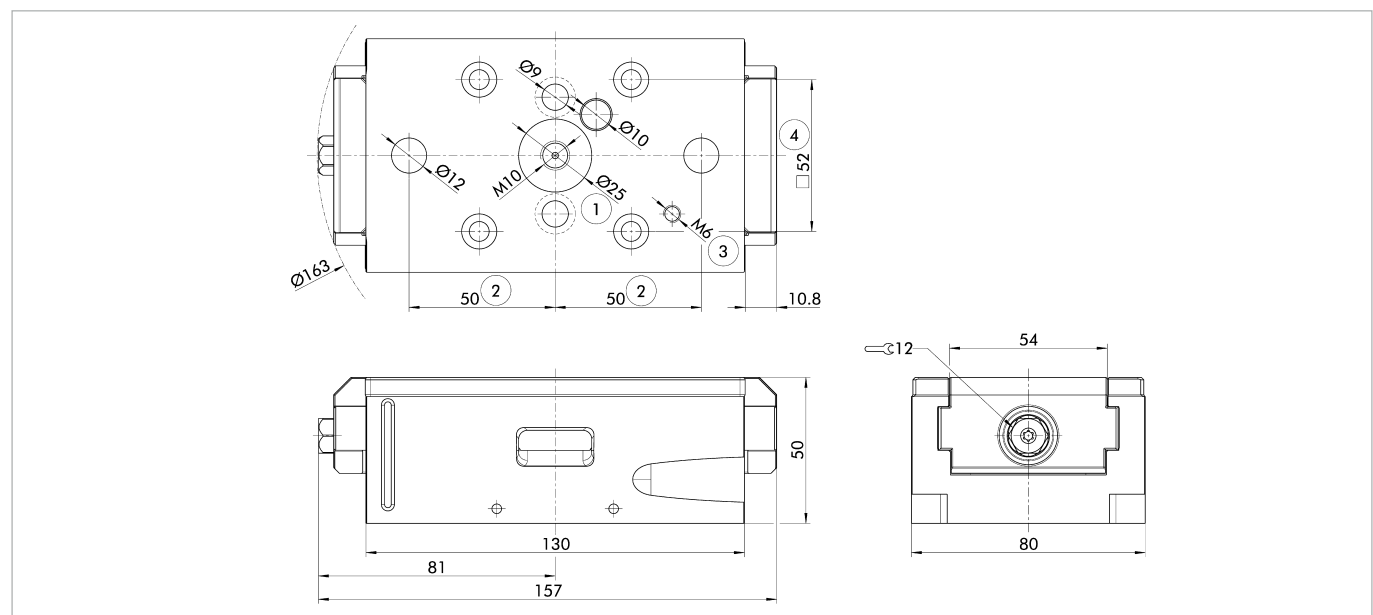
System jaws

The clamping device and the system jaws have to be put together separately for this version.

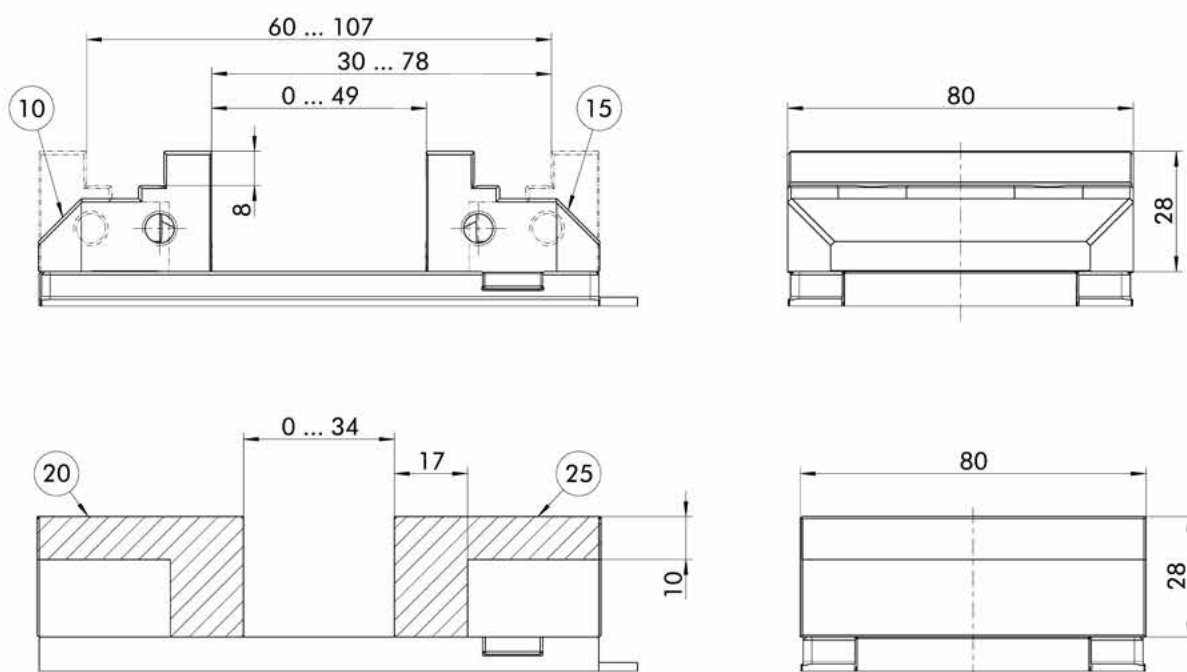
Use of VERO-S

When using VERO-S, a shortened screw must be used in the clamping pin as well as a shortened indexing pin (see accessories).

Description	Item	Description	ID	Width [mm]	Depth [mm]	Height [mm]	Weight [kg]
Reversible jaw grip	10	SGWB-G3-B 80-40.3-28	0432715	80	40.3	28	0.5
Reversible jaw grip	20	SGWB-G3-B 40-40.3-28	1514379	40	40.3	28	0.4
Aluminum jaw	30	SGAL-B 80-48-28	0432718	80	48	28	0.4
Swivel plate	40	SGP-3 125-76-19	0432720	125	76	19	1.3
Adapter plate	50	SGA-3 125-39-19	0432719	125	39	19	0.7
Reversible jaw grip	60	SGWB-G5-B 80-41.5-28	1514364	80	41.5	28	0.5
Prism jaw	70	SGVA-B 80-38.5-52	1395548	80	52	38.5	1.1
Prism jaw vertical	80	SGVA-B 80-25-40	1468522	80	40	25	0.6



- ① Prepared for NSE3 clamping pins
- ② Prepared for indexing pin
- ③ Poka-yoke bore hole for correct clamping device alignment
- ④ Prepared for GFD-SP mini Ø16 h6 clamping pin



Technical changes reserved.

- ① 6-way reversal jaw grip (ID 0430803), 6-way reversal jaw carbide grip (ID 1395550)

Technical data

Description	ID	Width of the clamping vise [mm]	Max. clamping force [kN]	Max. torque [Nm]	Weight [kg]
KSC3-K 80-130-VA	1629373	80	25	90	2.9

Scope of delivery

Vise, operating manual; without system jaws

Notes

System jaws

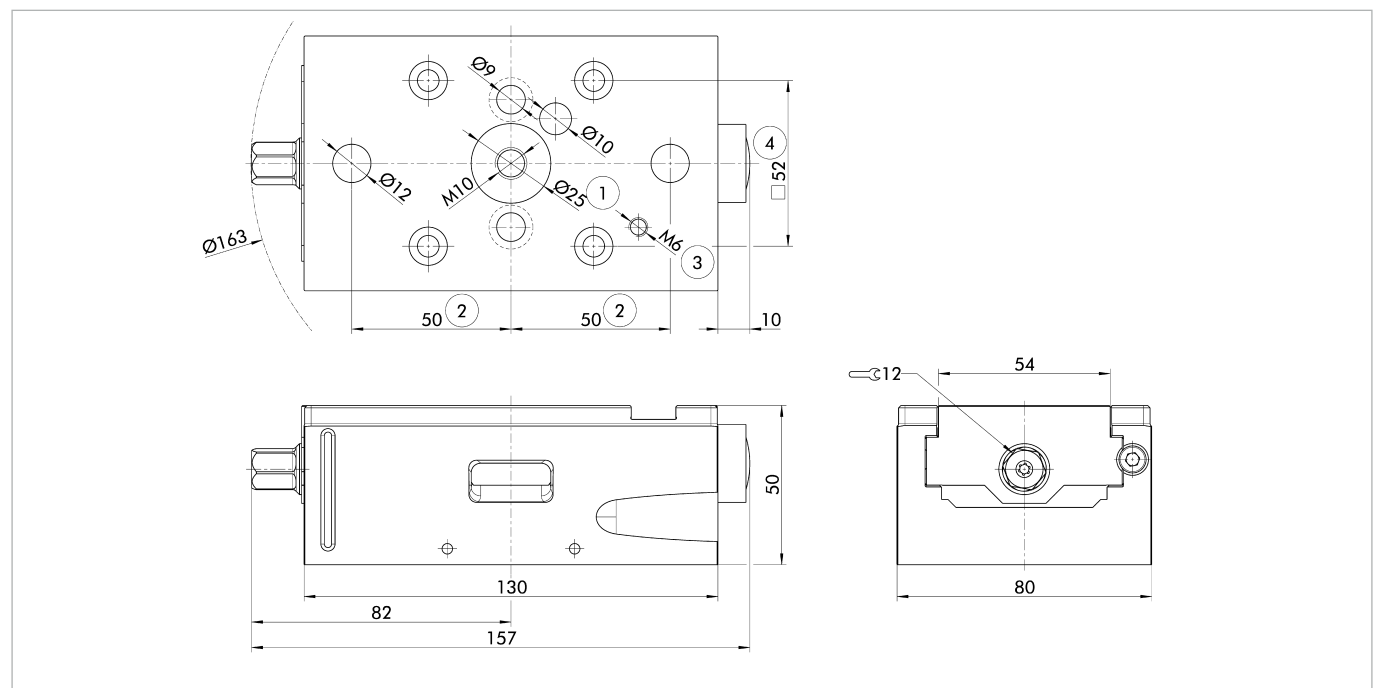
The clamping device and the system jaws have to be put together separately for this version.

Use of VERO-S

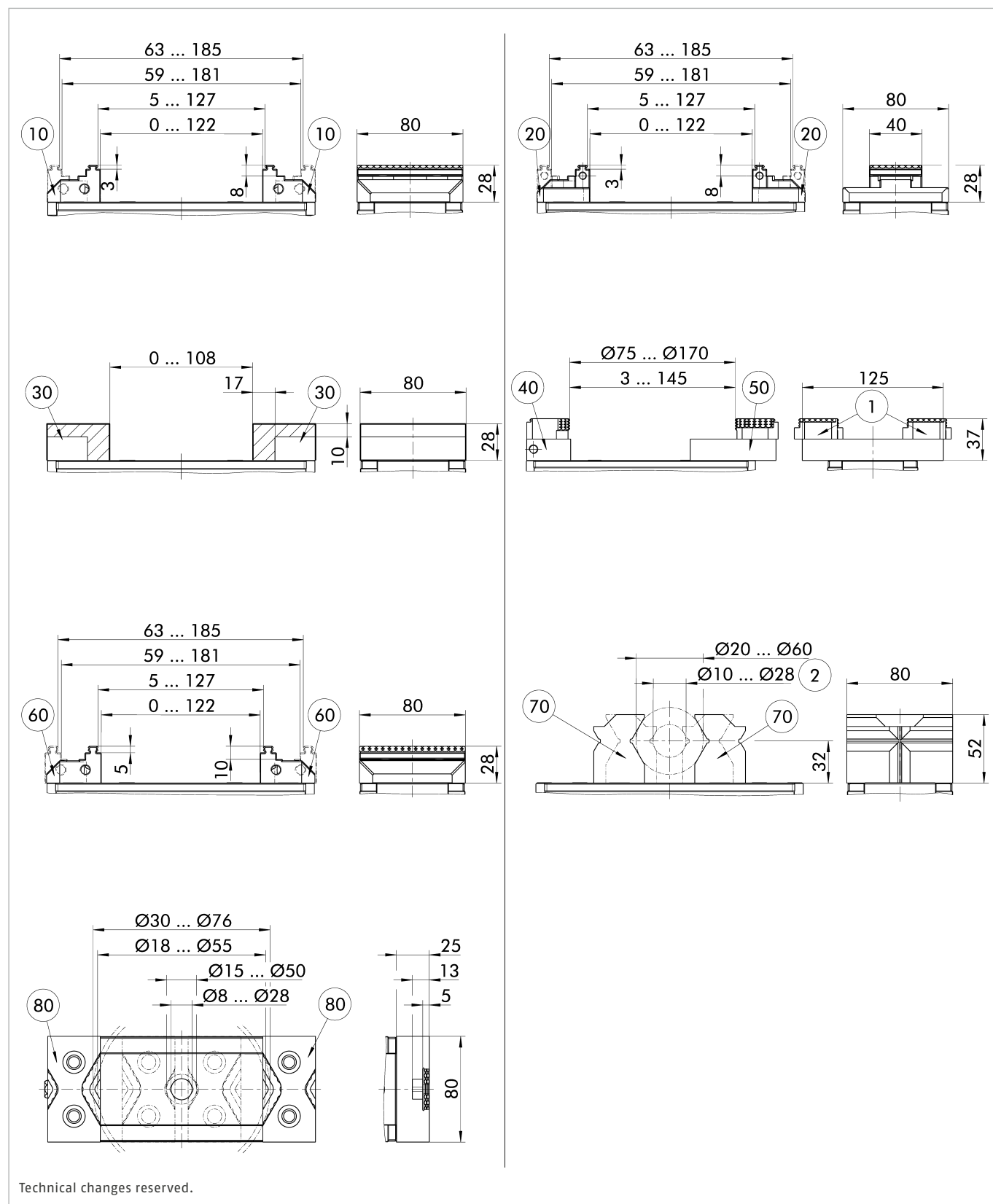
When using VERO-S, a shortened screw must be used in the clamping pin as well as a shortened indexing pin (see accessories).

Suitable system jaws

Description	Item	Description	ID	Width [mm]	Depth [mm]	Height [mm]	Weight [kg]
Reversible jaw smooth	10	SGWB-G3-B 40-40.3-28	1514379	40	40.3	28	0.4
Reversible jaw smooth	15	SGWB-S8-F 80-40-28	1518694	80	40	28	0.5
Aluminum jaw	20	SGAL-B 80-48-28	0432718	80	48	28	0.4
Aluminum jaw	25	SGAL-F 80-48-28	0432733	80	48	28	0.4



- ① Prepared for NSE3 clamping pins
- ② Prepared for indexing pin
- ③ Poka-yoke bore hole for correct clamping device alignment
- ④ Prepared for GFD-SP mini Ø16 h6 clamping pin



① 6-way reversal jaw grip (ID 0430803), 6-way reversal jaw carbide grip (ID 1395550)

② Same clamping ranges for vertical clamping

Technical data

Description	ID	Width of the clamping vise [mm]	Max. clamping force [kN]	Max. torque [Nm]	Weight [kg]
KSC3 80-190-VA	1623561	80	25	90	4.5

Scope of delivery

Vise, operating manual; without system jaws

Notes

System jaws

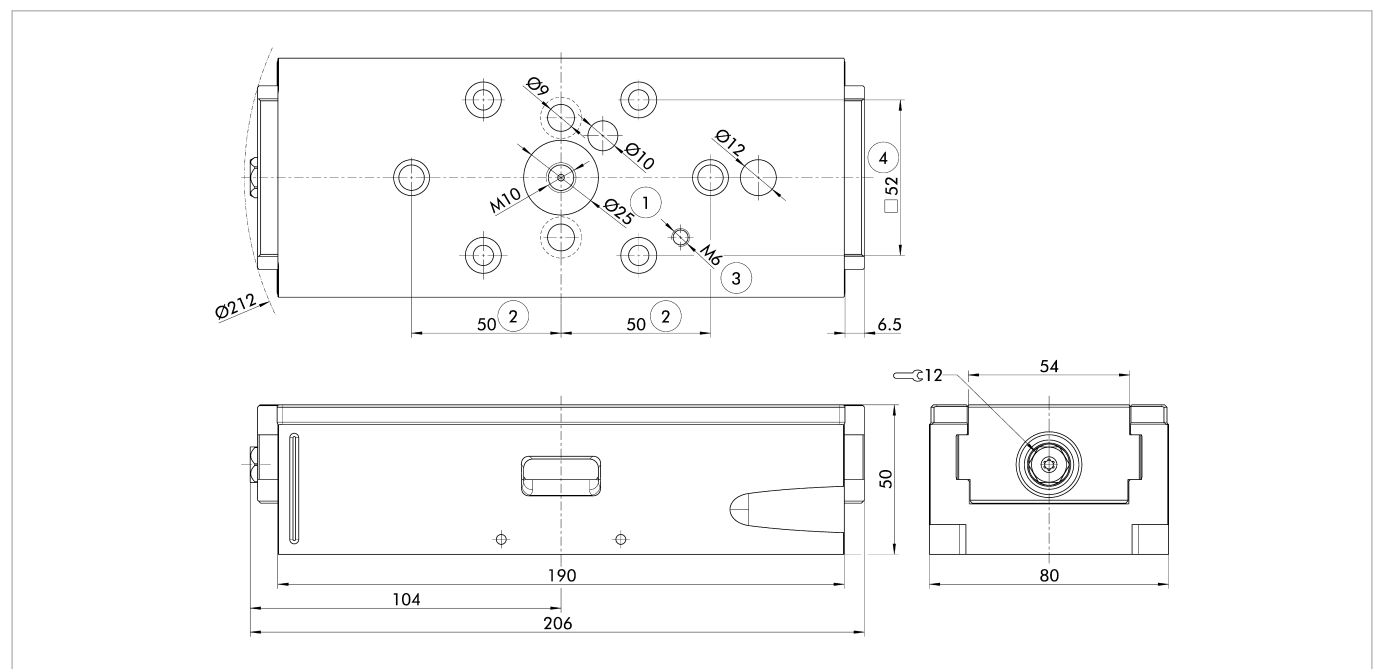
The clamping device and the system jaws have to be put together separately for this version.

Use of VERO-S

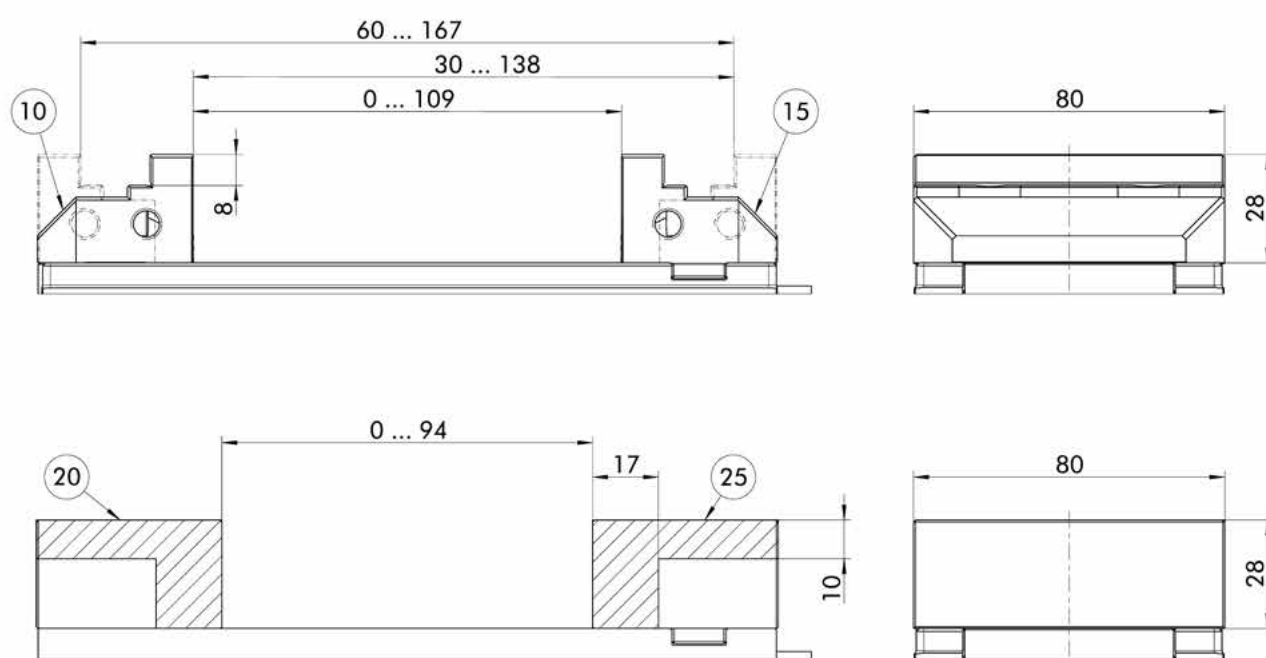
When using VERO-S, a shortened screw must be used in the clamping pin as well as a shortened indexing pin (see accessories).

Suitable system jaws

Description	Item	Description	ID	Width [mm]	Depth [mm]	Height [mm]	Weight [kg]
Reversible jaw grip	10	SGWB-G3-B 80-40.3-28	0432715	80	40.3	28	0.5
Reversible jaw grip	20	SGWB-G3-B 40-40.3-28	1514379	40	40.3	28	0.4
Aluminum jaw	30	SGAL-B 80-48-28	0432718	80	48	28	0.4
Swivel plate	40	SGP-3 125-76-19	0432720	125	76	19	1.3
Adapter plate	50	SGA-3 125-39-19	0432719	125	39	19	0.7
Reversible jaw grip	60	SGWB-G5-B 80-41.5-28	1514364	80	41.5	28	0.5
Prism jaw	70	SGVA-B 80-38.5-52	1395548	80	52	38.5	1.1
Prism jaw vertical	80	SGVA-B 80-25-40	1468522	80	40	25	0.6



- ① Prepared for NSE3 clamping pins
- ② Prepared for indexing pin
- ③ Poka-yoke bore hole for correct clamping device alignment
- ④ Prepared for GFD-SP mini Ø16 h6 clamping pin



Technical changes reserved.

- ① 6-way reversal jaw grip (ID 0430803), 6-way reversal jaw carbide grip (ID 1395550)

Technical data

Description	ID	Width of the clamping vise [mm]	Max. clamping force [kN]	Max. torque [Nm]	Weight [kg]
KSC3-K 80-190-VA	1629374	80	25	90	4.4

Scope of delivery

Vise, operating manual; without system jaws

Notes

System jaws

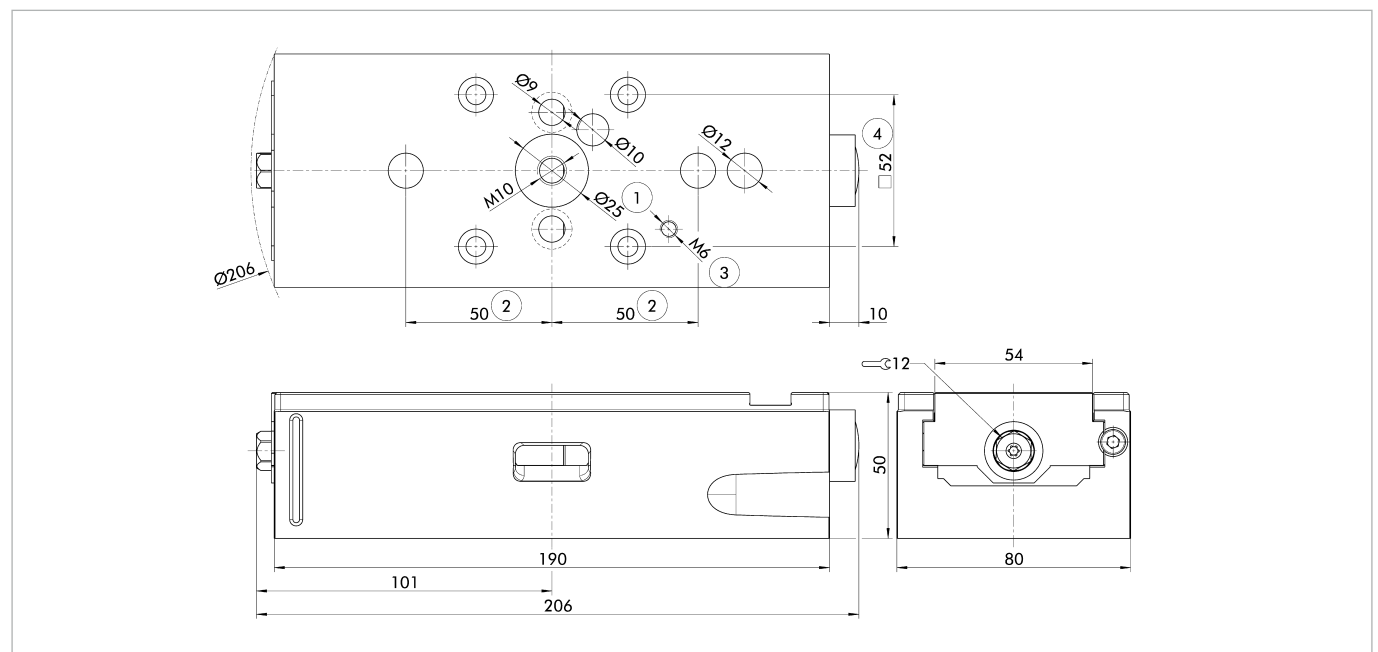
The clamping device and the system jaws have to be put together separately for this version.

Use of VERO-S

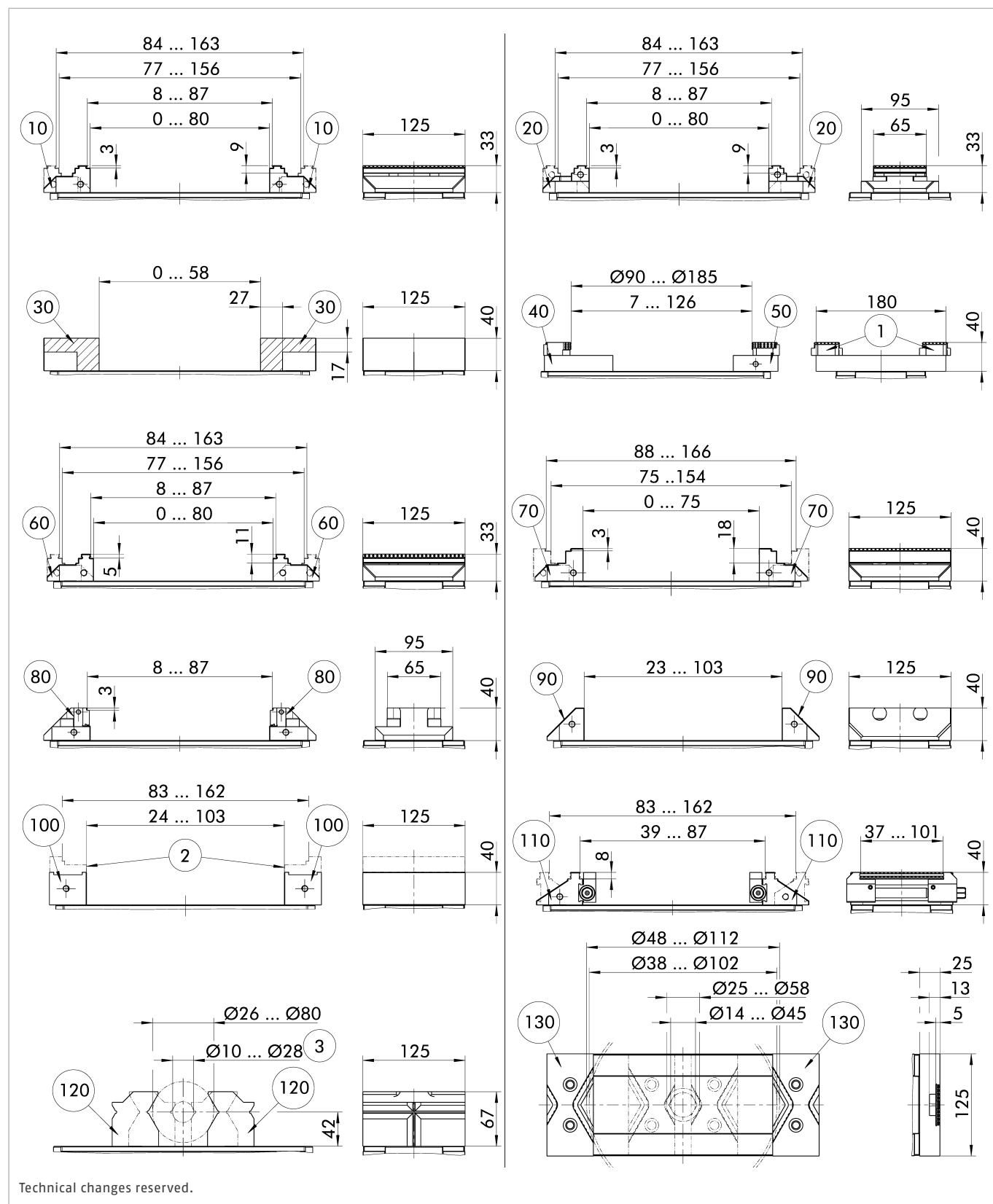
When using VERO-S, a shortened screw must be used in the clamping pin as well as a shortened indexing pin (see accessories).

Suitable system jaws

Description	Item	Description	ID	Width [mm]	Depth [mm]	Height [mm]	Weight [kg]
Reversible jaw smooth	10	SGWB-G3-B 40-40.3-28	1514379	40	40.3	28	0.4
Reversible jaw smooth	15	SGWB-S8-F 80-40-28	1518694	80	40	28	0.5
Aluminum jaw	20	SGAL-B 80-48-28	0432718	80	48	28	0.4
Aluminum jaw	25	SGAL-F 80-48-28	0432733	80	48	28	0.4



- ① Prepared for NSE3 clamping pins
- ② Prepared for indexing pin
- ③ Poka-yoke bore hole for correct clamping device alignment
- ④ Prepared for GFD-SP mini Ø16 h6 clamping pin



Technical changes reserved.

① 6-way reversal jaw grip (ID 0430803), 6-way reversal jaw carbide grip (ID 1395550)

② Smooth jaw VS (ID 0430416)

③ Same clamping ranges for vertical clamping

Technical data

Description	ID	Width of the clamping vise [mm]	Max. clamping force [kN]	Max. torque [Nm]	Weight [kg]
KSC3 125-160-VA	1623563	125	35	100	6.3

Scope of delivery

Vise, operating manual; without system jaws

Notes

System jaws

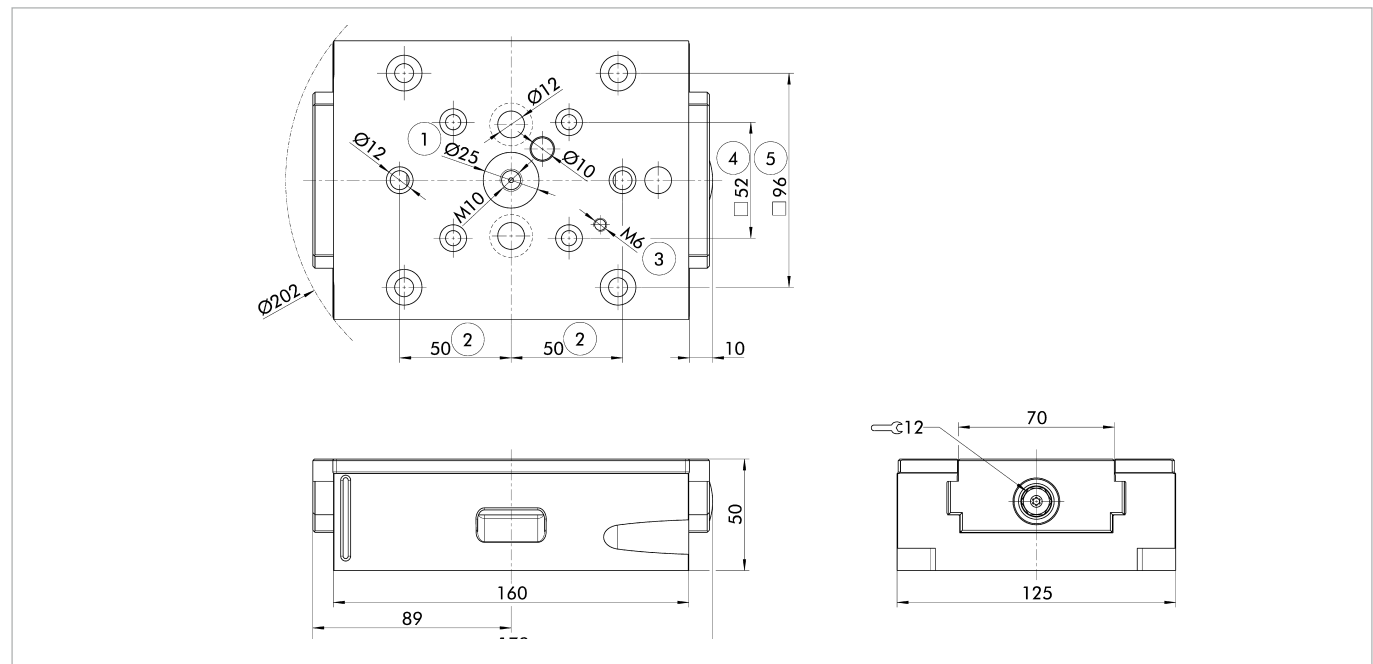
The clamping device and the system jaws have to be put together separately for this version.

Use of VERO-S

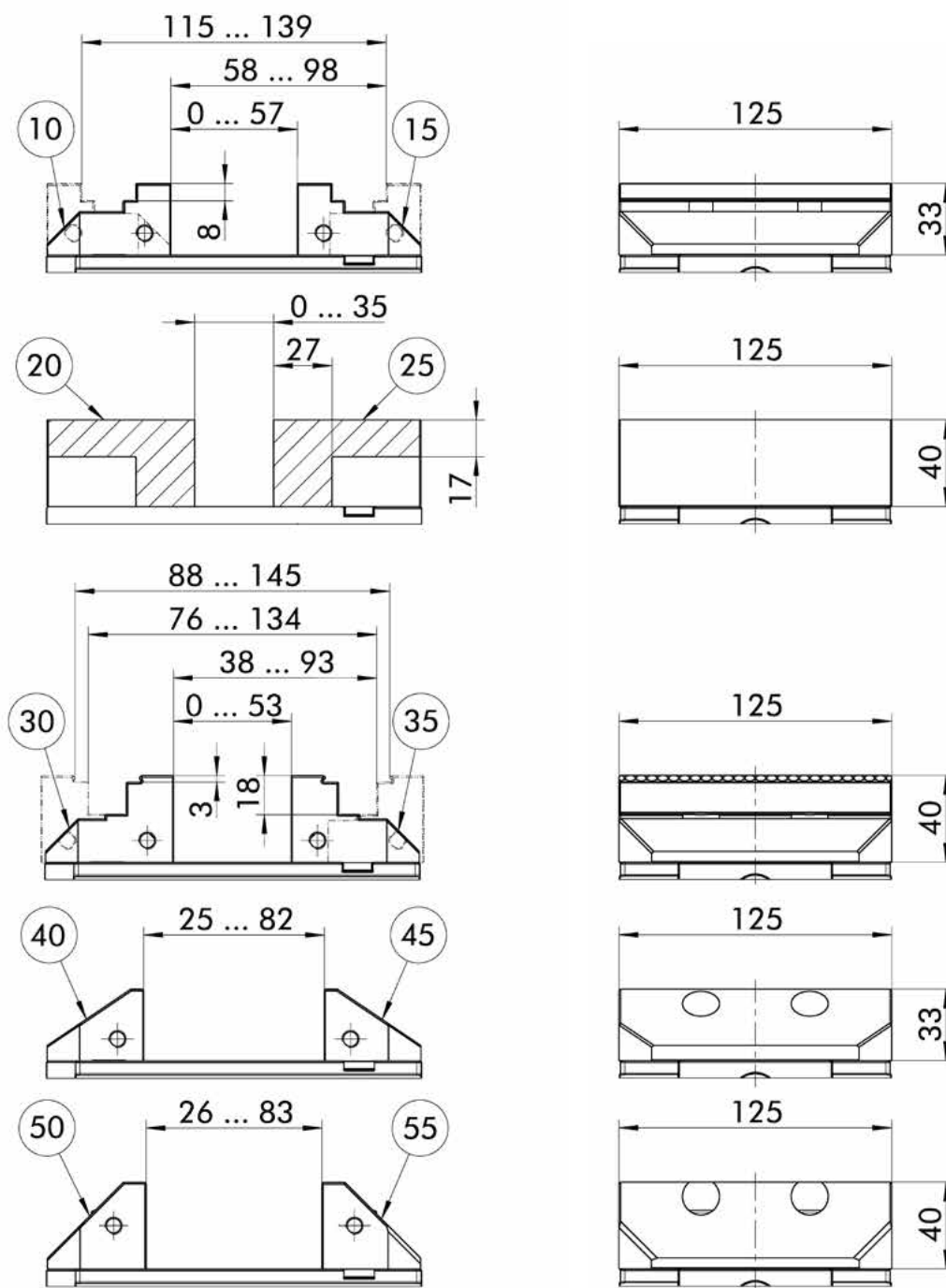
When using VERO-S, a shortened screw must be used in the clamping pin as well as a shortened indexing pin (see accessories).

Suitable system jaws

Description	Item	Description	ID	Width [mm]	Depth [mm]	Height [mm]	Weight [kg]
Reversible jaw grip	10	SGWB-G3-B 125-57-33	0432474	125	57	33	1.3
Reversible jaw grip	20	SGWB-G3-B 65-57-33	1514380	65	57	33	0.9
Aluminum jaw	30	SGAL-B 125-68-40	0432469	125	68	40	1
Swivel plate	40	SGP-3 180-95-22	0432470	180	95	22	2.8
Adapter plate	50	SGA-3 180-62-22	0432471	180	62	22	1.7
Reversible jaw grip	60	SGWB-G5-B 125-57-33	1514365	125	57	33	1.2
Reversible jaw	70	SGWB-G3-B 125-59-40	0430387	125	59	40	1.7
5-axis jaw	80	SG5A-B 65-57-40	0432473	65	57	40	1
5-axis jaw	90	SG5A-B 125-45.5-40	0432472	125	45.5	40	1.1
Combi jaw	100	SGK-B 125-45.5-40	0432468	125	45.5	40	1.6
6-way jaw system	110	SG6F 125-57-40	0432485	125	57	40	3.9
Prism jaw	120	SGVA-B 125-57-67	1395549	125	67	57	3.2
Prism jaw vertical	130	SGVA-B 125-25-57	1468523	125	57	25	1.3



- ① Prepared for NSE3 clamping pins
- ② Prepared for indexing pin
- ③ Poka-yoke bore hole for correct clamping device alignment
- ④ Prepared for GFD-SP mini Ø16 h6 clamping pin
- ⑤ Prepared for GFD-SP mini Ø20 h6 clamping pin



Technical changes reserved.

- ① 6-way reversal jaw grip (ID 0430803), 6-way reversal jaw carbide grip (ID 1395550)

Technical data

Description	ID	Width of the clamping vise [mm]	Max. clamping force [kN]	Max. torque [Nm]	Weight [kg]
KSC3-K 125-160-VA	1629375	125	35	100	6.4

Scope of delivery

Vise, operating manual; without system jaws

Notes

System jaws

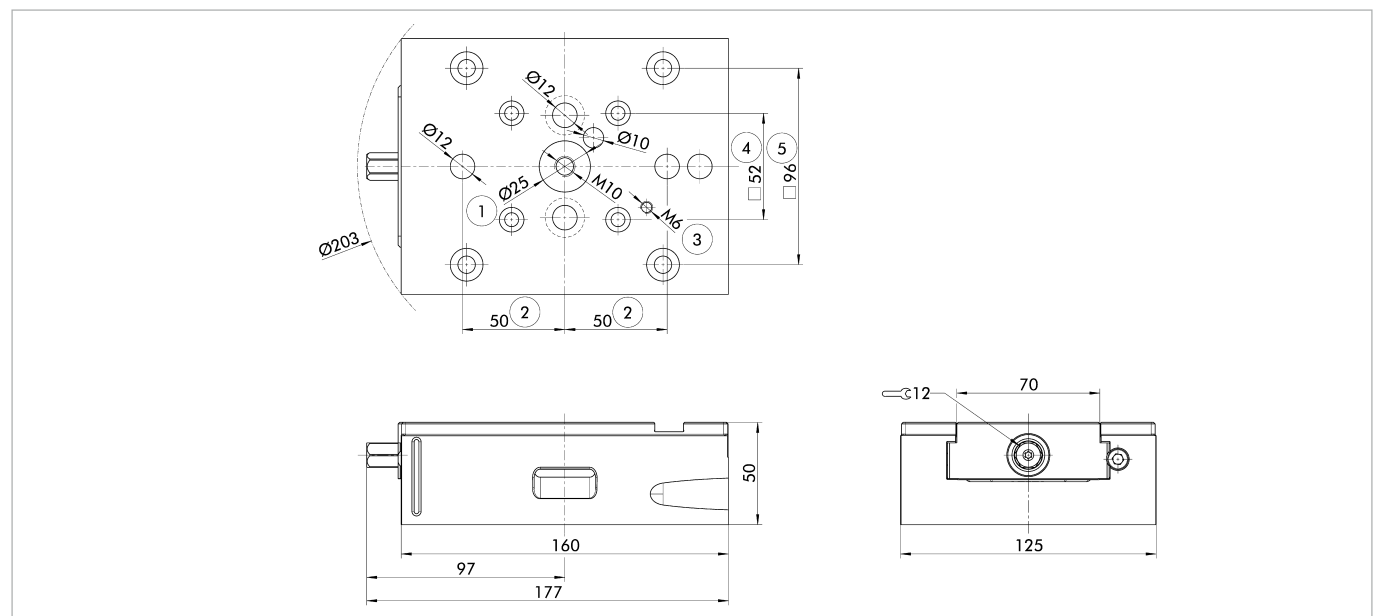
The clamping device and the system jaws have to be put together separately for this version.

Use of VERO-S

When using VERO-S, a shortened screw must be used in the clamping pin as well as a shortened indexing pin (see accessories).

Suitable system jaws

Description	Item	Description	ID	Width [mm]	Depth [mm]	Height [mm]	Weight [kg]
Reversible jaw smooth	10	SGWB-G3-B 65-57-33	1514380	65	57	33	0.9
Reversible jaw smooth	15	SGWB-S8-F 125-57-33	1518692	125	57	33	1.3
Aluminum jaw	20	SGAL-B 125-68-40	0432469	125	68	40	1
Aluminum jaw	25	SGAL-F 125-68-40	0432492	125	68	40	1.1
Reversible jaw	30	SGWB-G3-B 125-59-40	0430387	125	59	40	1.7
Reversible jaw	35	SGWB-G3-F 125-59-40	1586742	125	59	40	1.7
5-axis jaw	40	SG5A-B 125.44.5-33	1374779	125	44.5	33	0.9
5-axis jaw	45	SG5A-F 125-44.5-33	1374779	125	44.5	33	0.9
5-axis jaw	50	SG5A-B 125-45.5-40	0432472	125	45.5	40	1.1
5-axis jaw	55	SG5A-F 125-45.5-40	1551488	125	45.5	40	1.1



- ① Prepared for NSE3 clamping pins
- ② Prepared for indexing pin
- ③ Poka-yoke bore hole for correct clamping device alignment
- ④ Prepared for GFD-SP mini Ø16 h6 clamping pin
- ⑤ Prepared for GFD-SP mini Ø20 h6 clamping pin

Clamping station

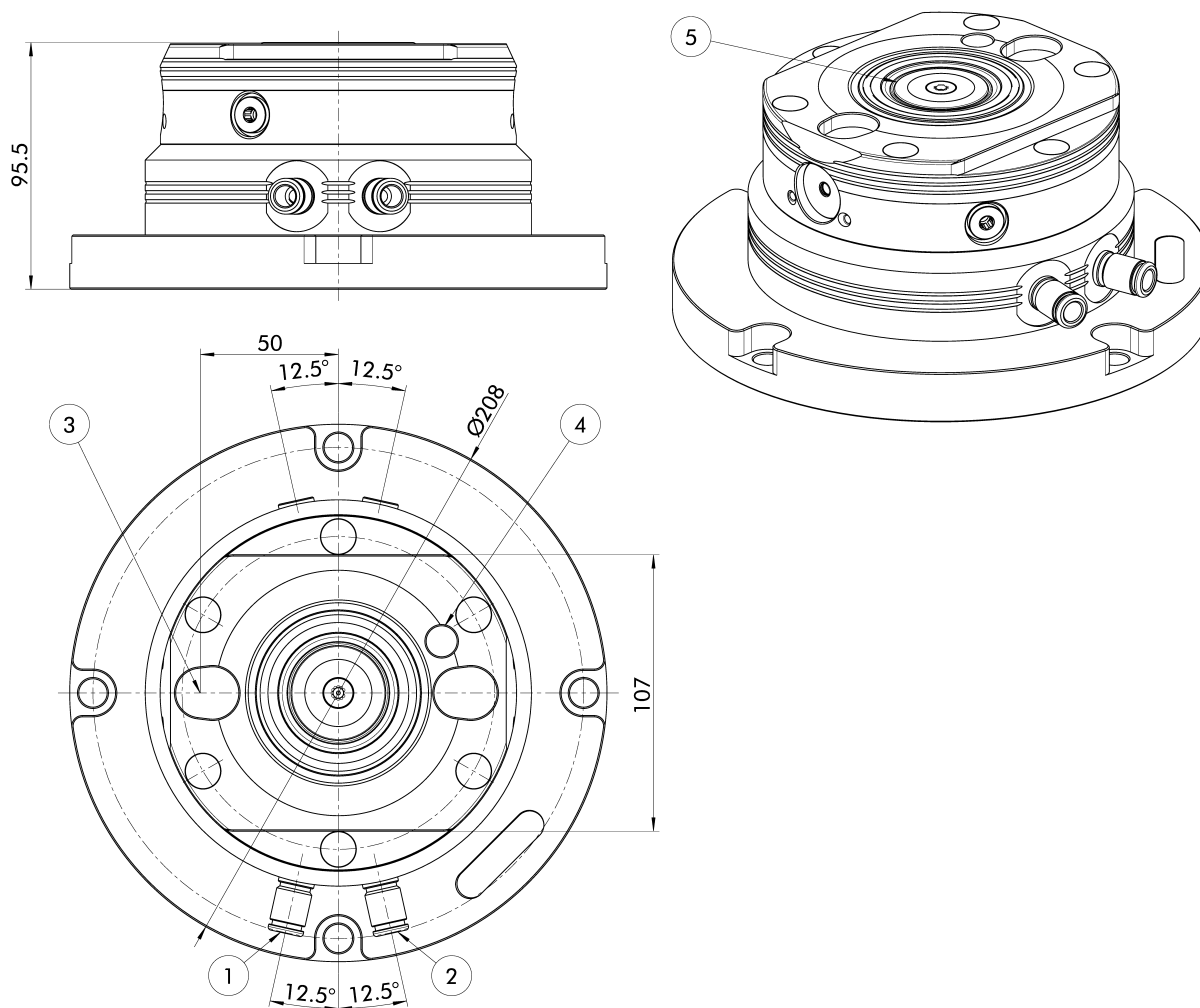
1-way clamping station with anti-rotation protection and turbo function

Scope of delivery

Clamping station, sealing nipple, pneumatic plug connections, dust protection caps, operating manual; without clamping pin, without indexing pin, without cylindrical clamps

Technical data

Description	ID	Pull-down force [kN]	Pull-down force with turbo [kN]	Unlocking pressure [bar]	Repeat accuracy [mm]	Weight [kg]
NSL3 Ø208-2V1	1621657	8	28	6	< 0.005	11



Technical changes reserved.

- ① Air connection – module open
- ② Air connection – turbo function
- ③ Fitting groove for positional alignment of the clamping device
- ④ Poka-yoke bore hole for correct clamping device alignment
- ⑤ Integrated cone seal by default

Gripper fingers

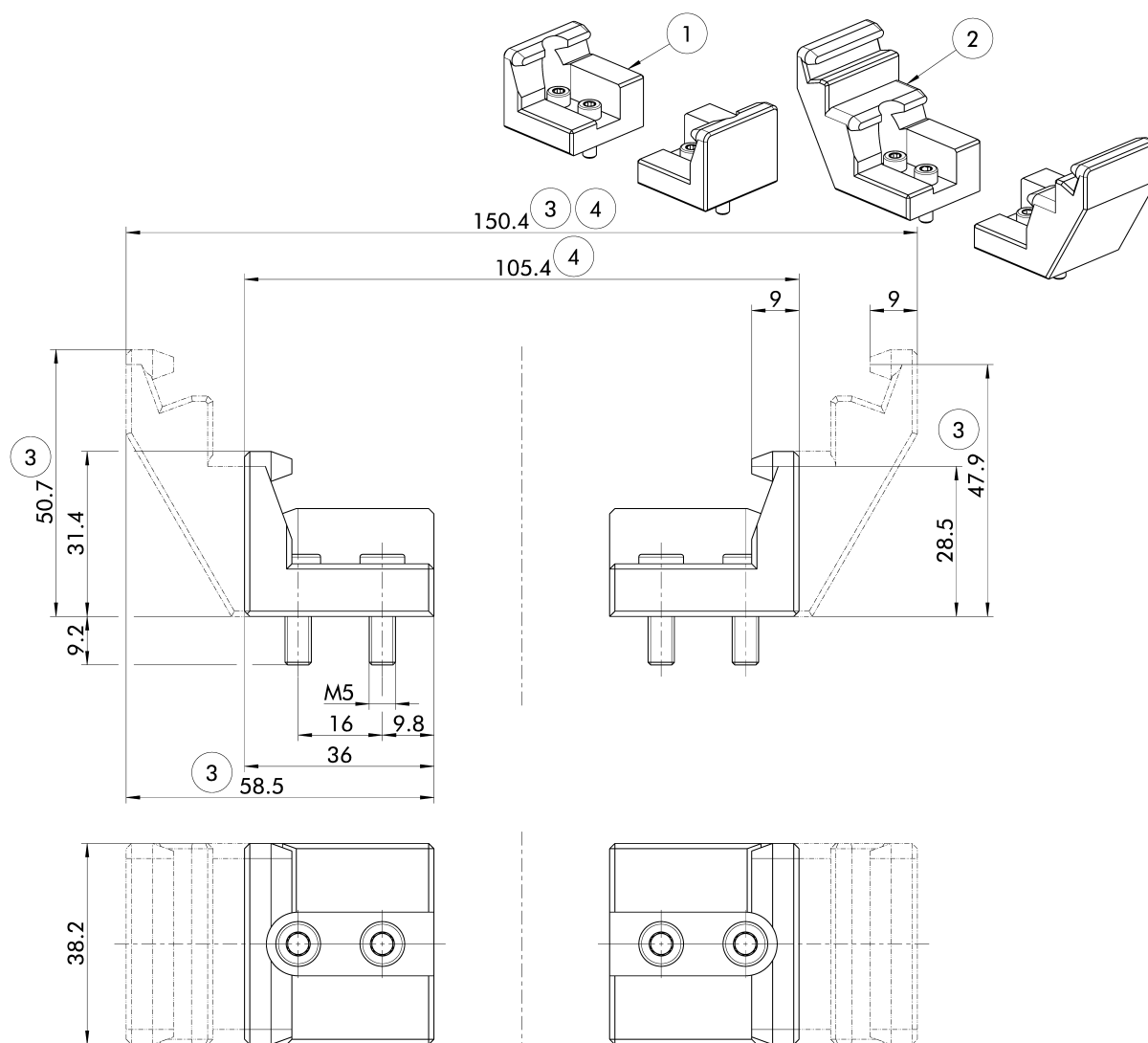
Gripper fingers especially for holding the KSC3 vises
Suitable for universal gripper PGN-plus-P 80-1

Scope of delivery

Gripper fingers

Technical data

Description	ID	Weight [kg]	Recommended gripper	Gripper ID
FIN KSC3 80	1634882	0.6	PGN-plus-P 80-1-AS	318522
FIN KSC3 80/125	1627791	0.8	PGN-plus-P 80-1-AS	318522



Technical changes reserved.

① Gripper finger FIN KSC3 80

② Gripper finger FIN KSC3 80/125

③ Dimension only valid for gripper fingers FIN KSC3 80/125

④ Max. opening width of gripper fingers in combination with PGN-plus-P 80-1-AS (ID 318522)

System jaws

Reversible jaw, soft grip

Design with movable jaw
With a special 5 mm grip step on both sides to enable clamping of soft materials such as aluminum or plastic.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGWB-SG5-B 80-40.3-28		1514366
KSC3 125-160-VA	SGWB-SG5-B 125-57-33		1514367

Reversible jaw grip

Design with movable jaw
With grip step 3 mm (up to 22 HRC) and a smooth clamping surface on both sides.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGWB-G3-B 80-40.3-28	W-80-1	0432715
KSC3 125-160-VA	SGWB-G3-B 125-57-33		0432474

Reversible jaw carbide grip

Design with movable jaw
With carbide grip step 3 mm (up to 58 HRC) and smooth clamping surface on both sides.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGWB-CG3-B 80-40-28		1514368
KSC3 125-160-VA	SGWB-CG3-B 125-57-33		1514374

Reversible jaw grip

Design with movable jaw
With grip step 5 mm (up to 22 HRC) and a smooth clamping surface on both sides.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGWB-G5-B 80-41.5-28		1514364
KSC3 125-160-VA	SGWB-G5-B 125-57-33		1514365

Reversible jaw carbide grip

Design with movable jaw
With carbide grip step 5 mm (up to 58 HRC) and smooth clamping surface on both sides.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGWB-CG5-B 80-40-28		1514375
KSC3 125-160-VA	SGWB-CG5-B 125-57-33		1514376

Reversible jaw with embossed profile

Design with movable jaw
With a special grip step on both sides for clamping pre-embossed workpieces simply and securely.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGWB-GL-B 80-40-28		1514377
KSC3 125-160-VA	SGWB-GL-B 125-57-33		1514378

Reversible jaw

Design with movable jaw
One side with grip step 3 mm (up to 22 HRC), one side 40 mm high with smooth clamping surface and threads for mounting top jaws.



Suitable for	Description	Interface	ID
KSC3 125-160-VA	SGWB-G3-B 125-59-40	W-125-1	0430387

Reversible jaw

Design with fixed jaw
One side with grip step 3 mm (up to 22 HRC), one side 40 mm high with smooth clamping surface and threads for mounting top jaws.



Suitable for	Description	Interface	ID
KSC3-K 125-160	SGWB-G3-F 125-59-40	W-125-1	1586742

Reversible jaw grip

Design with movable jaw
Reduced jaw width.
With grip step 3 mm (up to 22 HRC) and a smooth clamping surface on both sides.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGWB-G3-B 40-40.3-28		1514379
KSC3 125-160-VA	SGWB-G3-B 65-57-33		1514380

Reversible jaw carbide grip

Design with movable jaw
Jaw width 40 mm, with carbide grip step 3 mm (up to 58 HRC) and a smooth clamping surface on both sides.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGWB-CG3-B 40-40.3-28		1414567
KSC3 125-160-VA	SGWB-CG3-B 65-57-33		1414568

Aluminum jaw

Design with movable jaw
Used for rework at the customer site e.g. for incorporating contours or special shapes.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3-K 80-130-VA			
KSC3 80-190-VA			
KSC3-K 80-190-VA	SGAL-B 80-48-28		0432718
KSC3 125-160-VA			
KSC3-K 125-160-VA	SGAL-B 125-68-40		0432469

Aluminum jaw

Design with fixed jaw
Used for rework at the customer site e.g. for incorporating contours or special shapes.



Suitable for	Description	Interface	ID
KSC3-K 80-130-VA			
KSC3-K 80-190-VA	SGAL-F 80-48-28		0432733
KSC3-K 125-160-VA	SGAL-F 125-68-40		0432492

Steel jaw

Design with movable jaw
Used for rework at the customer site e.g. for incorporating contours or special shapes.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3-K 80-130-VA			
KSC3 80-190-VA			
KSC3-K 80-190-VA	SGS-B 80-48-28		1367467
KSC3 125-160-VA			
KSC3-K 125-160-VA	SGS-B 125-68-40		1452569

Steel jaw

Design with fixed jaw
Used for rework at the customer site e.g. for incorporating contours or special shapes.



Suitable for	Description	Interface	ID
KSC3-K 80-130-VA			
KSC3-K 80-190-VA	SGS-F 80-48-28		1561216
KSC3-K 125-160-VA	SGS-F 125-68-40		1559434

Swivel plate

Used – in combination with adapter plates and 6-way reversible jaws – to clamp bulky workpieces.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGP-3 125-76-19	W-38	0432720
KSC3 125-160-VA	SGP-3 180-95-22	W-38	0432470

Adapter plate

Used – in combination with swivel plates and 6-way reversible jaws – to clamp bulky workpieces.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGA-3 125-39-19	W-38	0432719
KSC3 125-160-VA	SGA-3 180-62-22	W-38	0432471

Reversible jaw smooth

Design with movable jaw
Ground steps, for precise OP20 machining.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGWB-S4-B 80-40.3-28		1497516
KSC3 80-130-VA			
KSC3-K 80-130-VA			
KSC3 80-190-VA			
KSC3-K 80-190-VA	SGWB-S8-B 80-40-28		1518693
KSC3 125-160-VA	SGWB-S6-B 125-57-33		1497517
KSC3 125-160-VA			
KSC3-K 125-160-VA	SGWB-S8-B 125-57-33		1518691

Reversible jaw smooth

Design with fixed jaw
Ground steps, for precise OP20 machining.



Suitable for	Description	Interface	ID
KSC3-K 80-130-VA			
KSC3-K 80-190-VA	SGWB-S8-F 80-40-28		1518694
KSC3-K 125-160-VA	SGWB-S8-F 125-57-33		1518692

5-axis jaw

Design with movable jaw
One side equipped with a smooth clamping surface and threads for mounting top jaws.



Suitable for	Description	Interface	ID
KSC3 125-160-VA			
KSC3-K 125-160-VA	SG5A-B 125-44.5-33		1374778
KSC3 125-160-VA			
KSC3-K 125-160-VA	SG5A-B 125-45.5-40	W-125-1	0432472

5-axis jaw

Design with fixed jaw
One side equipped with a smooth clamping surface and threads for mounting top jaws.



Suitable for	Description	Interface	ID
KSC3-K 125-160-VA	SG5A-F 125-44.5-33		1374779
KSC3-K 125-160-VA	SG5A-F 125-45.5-40	W-125-1	1551488

Vise automation

Jaws

5-axis jaw

Design with movable jaw
Jaw width 65 mm, including reversible jaw with grip step 3 mm.



Suitable for	Description	Interface	ID
KSC3 125-160-VA	SG5A-B 65-57-40	W-65-1	0432473

Combi jaw

Designed with movable jaw
One side prepared for mounting top jaws.
VS-top jaws can also be installed additionally.



Suitable for	Description	Interface	ID
KSC3 125-160-VA	SGK-B 125-45.5-40	W-125-1 W-125-3	0432468

6-way jaw system

Jaw set for clamping the workpiece from six sides, resulting in a significant increase in clamping force.



Suitable for	Description	Interface	ID
KSC3 125-160-VA	SG6F 125-57-40		0432485

Prism jaw

Design with movable jaw
For the horizontal and vertical clamping of round materials.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGVA-B 80-38.5-52		1395548
KSC3 125-160-VA	SGVA-B 125-57-67		1395549

Prism jaw vertical

Design with movable jaw
For vertical clamping of round workpieces.
With grip step 5 mm (up to 22 HRC) and a smooth clamping surface on both sides.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGVA-B 80-25-40		1468522
KSC3 125-160-VA	SGVA-B 125-25-57		1468523

Central jaw grip

Floating version for clamping of two workpieces in one set-up. Both sides are prepared for mounting spring plates or top jaws.



Suitable for	Description	Interface	ID
KSC3 80-130-VA			
KSC3 80-190-VA	SGM-G3 80-16-28		1474205
KSC3 80-130-VA			
KSC3 80-190-VA	SGM-G3 80-24-28		1474206
KSC3 125-160-VA	SGM-G3 125-16-33		1474207
KSC3 125-160-VA	SGM-G3 125-26-33		1474208

Top jaws

6-way reversible jaw

With five grip steps as well as a coated clamping surface.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBG-6W 38-38-18	38.5	18	38.2	W-38	0430803

6-way reversible jaw

With five carbide grip steps as well as a smooth clamping surface.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBCG-6W 38-38-18	38.5	18	38.2	W-38	1395550

Profiled jaw

For increasing the friction between jaw and workpiece without clamping impressions.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBD 125-40-11.5	125	40	11.5	W-125-1	1373349

Hewn jaw

For increasing the friction between jaw and workpiece with minimal clamping impressions.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBC 125-40-12.5	125	40	12.5	W-125-1	1373268

Ground jaw

With a completely ground clamping surface.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBP 125-40-11.5	125	40	11.5	W-125-1	1373278

Soft jaw

Hardenable jaws for rework at the customer site, e.g. for incorporating contours or special shapes.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBW 125-40-20	125	40	20	W-125-1	1373288

Stepped jaw

With ground step 8 mm.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS 125-40-11.5-8	125	40	11.5	W-125-1	1373327

Stepped jaw

With ground step 17 mm.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS 125-40-11.5-17	125	40	11.5	W-125-1	0430413

Stepped jaw

With coated step 5 mm.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-W 80-28-10-5	80	28	10	W-80-1	1395509
GBS-W 125-40-11.5-5	125	40	11.5	W-125-1	0430414

Stepped jaw

With grip step 3 mm and ground step 18 mm.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-G3 125-40-21.5-18	125	40	21.5	W-125-1	0430415
GBS-G3 125-40-24-18	125	40	24	W-125-1	1322989

Stepped jaw

With a special 5 mm "soft" grip step. For embossed clamping of soft materials such as plastic or aluminum.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-SG5 125-40-11.5	125	40	11.5	W-125-1	1393552

Stepped jaw

With grip step 3 mm. For embossed clamping of unhardened materials up to 22 HRC.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-G3 80-28-10	80	28	10	W-80-1	1326805
GBS-G3 125-40-11.5	125	40	11.5	W-125-1	1373331

Vise automation

Jaws

Stepped jaw

With grip step, 5 mm.
For embossed clamping of unhardened materials up to 22 HRC.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-G5 125-40-11.5	125	40	11.5	W-125-1	1373334
GBS-G5 65-22-8	65	22	8	W-65-1	1465122

Stepped jaw

With grip step, 8 mm.
For embossed clamping of unhardened materials up to 22 HRC.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-G8 125-40-11.5	125	40	11.5	W-125-1	1373338

Stepped jaw

With carbide grip step, 3 mm.
For embossed clamping of hardened materials up to 58 HRC.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-CG3 125-40-11.5	125	40	11.5	W-125-1	1395524

Stepped jaw

With carbide grip step, 5 mm.
For embossed clamping of hardened materials up to 58 HRC.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-CG5 125-40-11.5	125	40	11.5	W-125-1	1424000

Stepped jaw

With a special 3 mm grip step.
For clamping pre-embossed materials and workpieces.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-GL3 125-40-11.5	125	40	11.5	W-125-1	1395577

Stepped jaw with T-slot

With grip step, 3 mm.
T-slot for mounting the positioning strip.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-G3-T 125-40-17.5	125	40	17.5	W-125-1	0430248

Stepped jaw with T-slot

With grip step, 5 mm.
T-slot for mounting the positioning strip.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-G5-T 125-40-17.5	125	40	17.5	W-125-1	0430247

Stepped jaw with T-slot

With grip step, 8 mm.
T-slot for mounting the positioning strip.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-G8-T 125-40-17.5	125	40	17.5	W-125-1	0430237

Positioning bar

To suit all stepped jaws with T-slot.



Description	Width mm	Height mm	Depth mm	Interface	ID
GPL 125-32-13.5	125	32	13.5	W-125-1	0430238

Grip jaw

For embossed clamping of unhardened materials up to 22 HRC.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBG 125-40-11.5	125	40	11.5	W-125-1	1373284

Chuck jaw with locating pins

Retractable locating pins for quickly adjusting the jaw to the respective workpiece.



Description	Width mm	Height mm	Depth mm	Interface	ID
GPS 125-40-17	125	40	16.7	W-125-1	1509316

Prism jaw ground

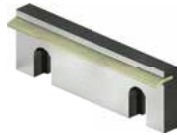
For precise clamping of round workpieces.
100 = Ø11 – Ø41 mm.
125 = Ø14 – Ø48 mm.
160 = Ø16 – Ø60 mm.



Description	Width mm	Height mm	Depth mm	Interface	ID
GVA 125-40-17.5	125	40	17.5	W-125-1	1373344

Spring plate pull-down jaw

For an active jaw pull-down function with a light clamping impression on the workpiece for more precise machining results.



Description	Width mm	Height mm	Depth mm	Interface	ID
GFA 125-40-11.5	125	40	11.5	W-125-1	1373304

Spring steel sheet pull-down jaw

For an active jaw pull-down function without clamping impressions on the workpiece for more precise machining results.



Description	Width mm	Height mm	Depth mm	Interface	ID
GFB 80-24-9	80	24.3	9	W-80-1	0432736
GFB 125-39-10	125	39	10	W-125-1	0430192

Precision pull-down jaw

For an active jaw pull-down function without clamping impressions on the workpiece for more precise machining results.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBN-P 125-40-25	125	40	25	W-125-1	0430147

Soft jaw

Jaw for rework by the customer.
Height = 22 mm.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBW 65-22-20	64	22	20	W-65-1	0490567

Reversible grip jaw

Reversible jaw with grip step 3 mm in vertical direction and 5 mm in horizontal direction.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBG-W 65-22-8	65	22	8	W-65-1	0430729

Prism jaw ground

For precise clamping of round workpieces.
Height = 22 mm.



Description	Width mm	Height mm	Depth mm	Interface	ID
GVA 65-22-15	65	22	15	W-65-1	0430707

Universal stepped jaw

Versatile stepped jaw with ground step.



Description	Width mm	Height mm	Depth mm	Interface	ID
GPE 80-28-10-5	80	28	10	W-80-1	0432721
GPE 65-22-8-3	65	22	8	W-65-1	0430704

Smooth jaw VS

Horizontally usable jaw with enlarged clamping range and ground step.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBE-VS 125-19-45	125	19	45	W-125-3	0430416

Grip jaw VS

Horizontally usable jaw with enlarged clamping range and 3 mm grip step.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBG-VS 125-17-40	125	17	40	W-125-3	0430417

Accessories

Clamping force tester

For measuring the jaw's clamping force of stationary clamping devices.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	IFT SST Set	1475766

Standard clamping pin

Clamping pin for positive connection with NSE3 clamping modules.
With shortened fastening screw.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	SPA 40-K	0432369

Indexing pin

Used as an anti-rotation protection for VERO-S modules with V1 anti-rotation protection.



Suitable for	Description	ID
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	IXB V1-K	0432371

Torque wrench 10 – 100 Nm

Serves for applying a defined torque.
With 1/2" square drive.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	GSH-D 10-100	0432477

Operating lever with joint

For convenient clamping range presetting.
With 1/2" square drive.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	GSH-G 1/2"	0432478

Hexagonal insert size 12

Suitable for 1/2" square drive.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	GSK-I SW12-1/2"	0432479

Center plug

For threads in the base body.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	GVSS M10x12	1323002

Workpiece stop

For stop thread M8.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	GWSA M8-23	1645258

Workpiece stop, magnetic, small

For quick and easy attachment to system jaws or vises.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	GWSA-M 60 x 15	1391293

Workpiece stop, magnetic, large

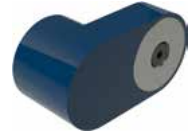
For quick and easy attachment to system jaws or vises.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	GWSA-M 115 x 15	1391331

Extension

As an accessory for the magnetic workpiece stops.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA		
KSC3 125-160-VA		
KSC3-K 125-160-VA	GWSA-V Ø68 x 30	1394477

Set of workpiece supports

Set of workpiece supports – width 80 mm

Suitable for system jaws H = 28 mm with grip level 3 mm.
Heights = 5, 10, 15, 20, and 22 mm.



Suitable for	Description	ID
KSC3 80-130-VA		
KSC3-K 80-130-VA		
KSC3 80-190-VA		
KSC3-K 80-190-VA	GWU-S grip 80-28	1394225

Set of workpiece supports – width 125 mm

Suitable for system jaws H = 33 mm with grip level 3 mm.
Heights = 8, 12, 20, 25, and 27 mm.



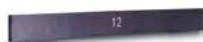
Suitable for	Description	ID
KSC3 125-160-VA		
KSC3-K 125-160-VA	GWU-S grip 125-33	1394227

Workpiece supports

Workpiece supports – width 80 mm

In different heights.

1 set = 2 pieces



Suitable for	Description	Height mm	ID
KSC3 80-130-VA	GWU-M 80-5	5	1465960
KSC3-K 80-130-VA			
KSC3 80-190-VA			
KSC3-K 80-190-VA			
KSC3 80-130-VA	GWU-M 80-10	10	1465956
KSC3-K 80-130-VA			
KSC3 80-190-VA			
KSC3-K 80-190-VA			
KSC3 80-130-VA	GWU-M 80-15	15	1460327
KSC3-K 80-130-VA			
KSC3 80-190-VA			
KSC3-K 80-190-VA			
KSC3 80-130-VA	GWU-M 80-20	20	1411113
KSC3-K 80-130-VA			
KSC3 80-190-VA			
KSC3-K 80-190-VA			
KSC3 80-130-VA	GWU-M 80-22	22	1411114
KSC3-K 80-130-VA			
KSC3 80-190-VA			
KSC3-K 80-190-VA			

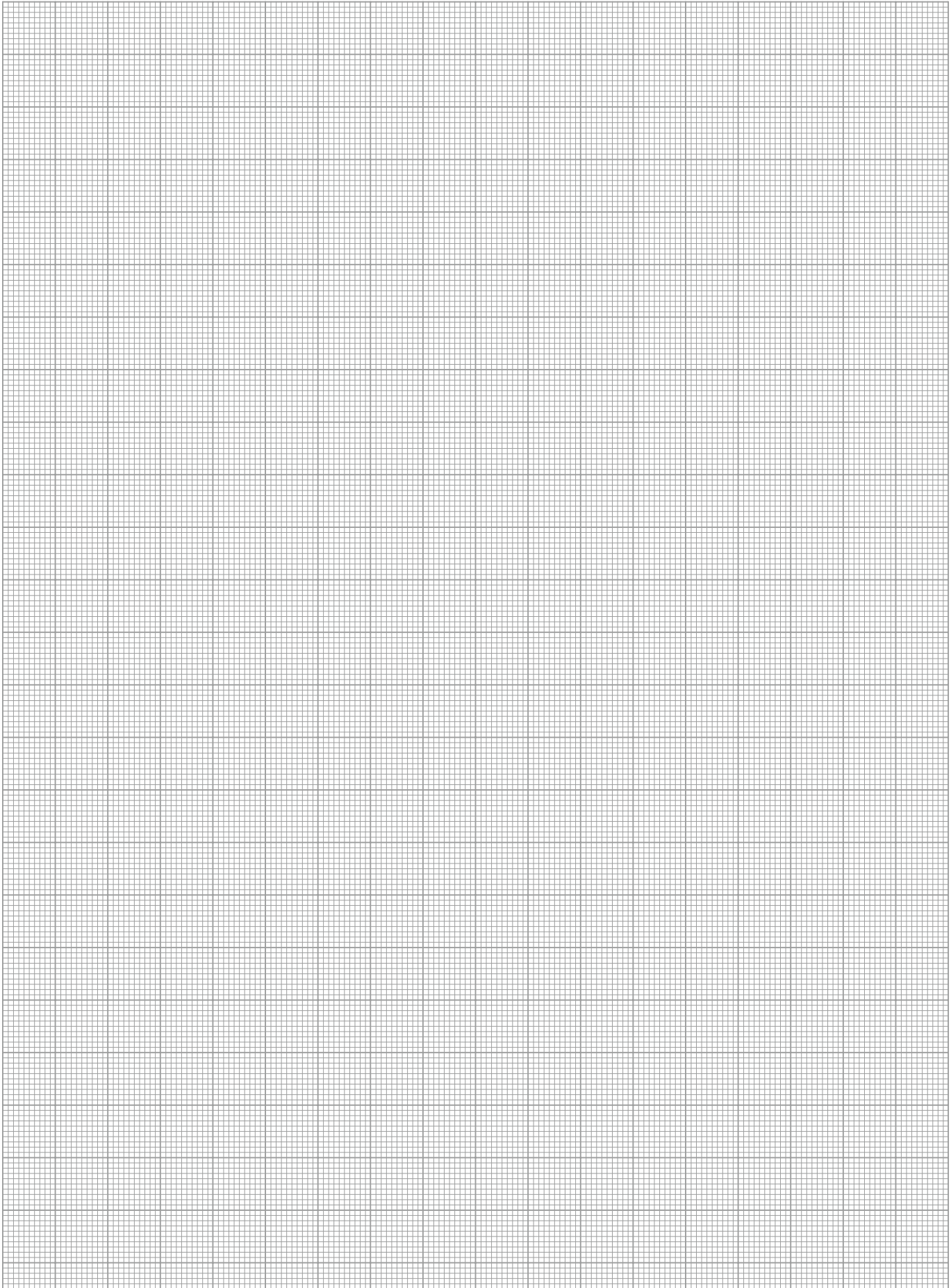
Workpiece supports – width 125 mm

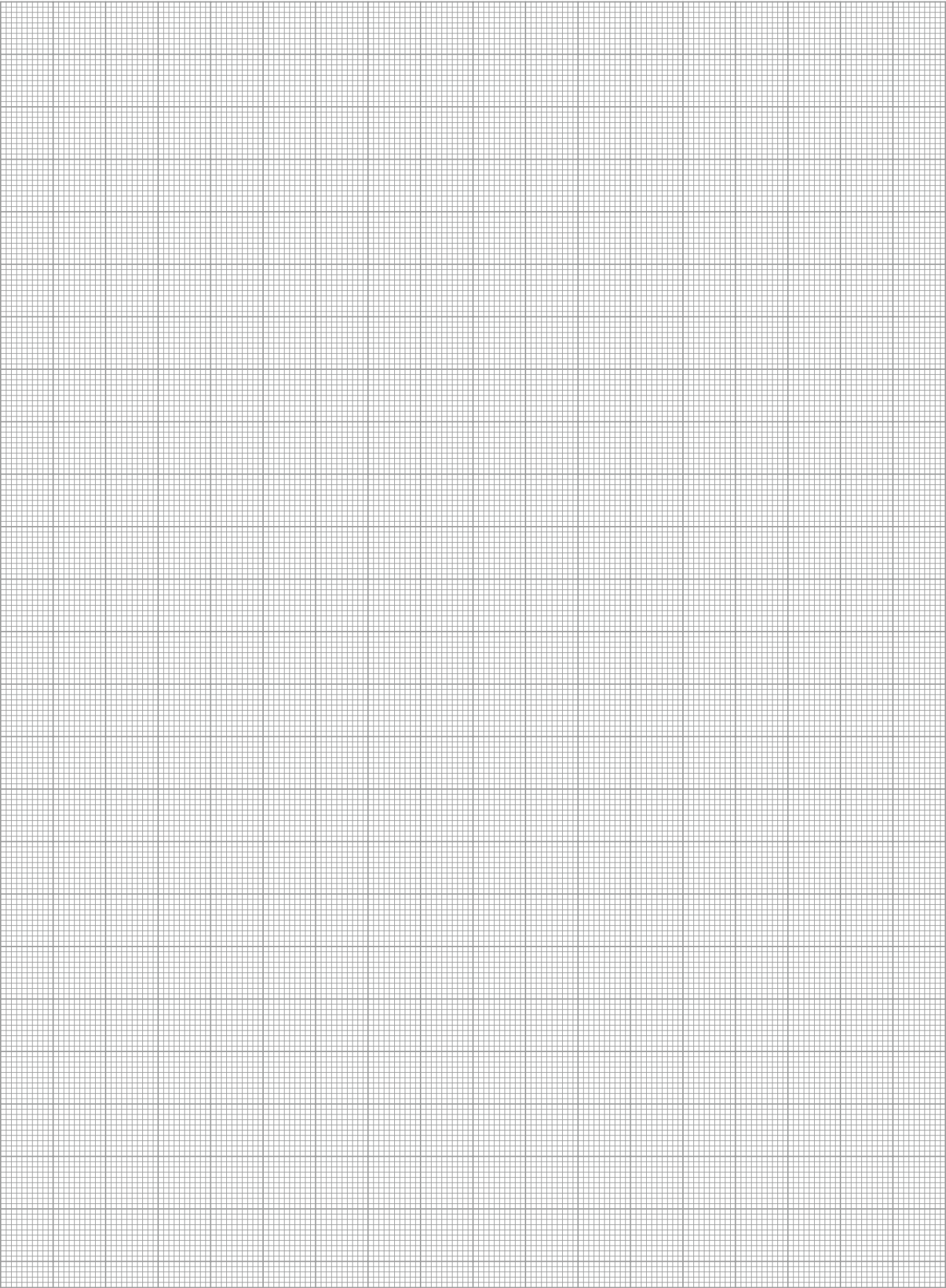
In different heights.

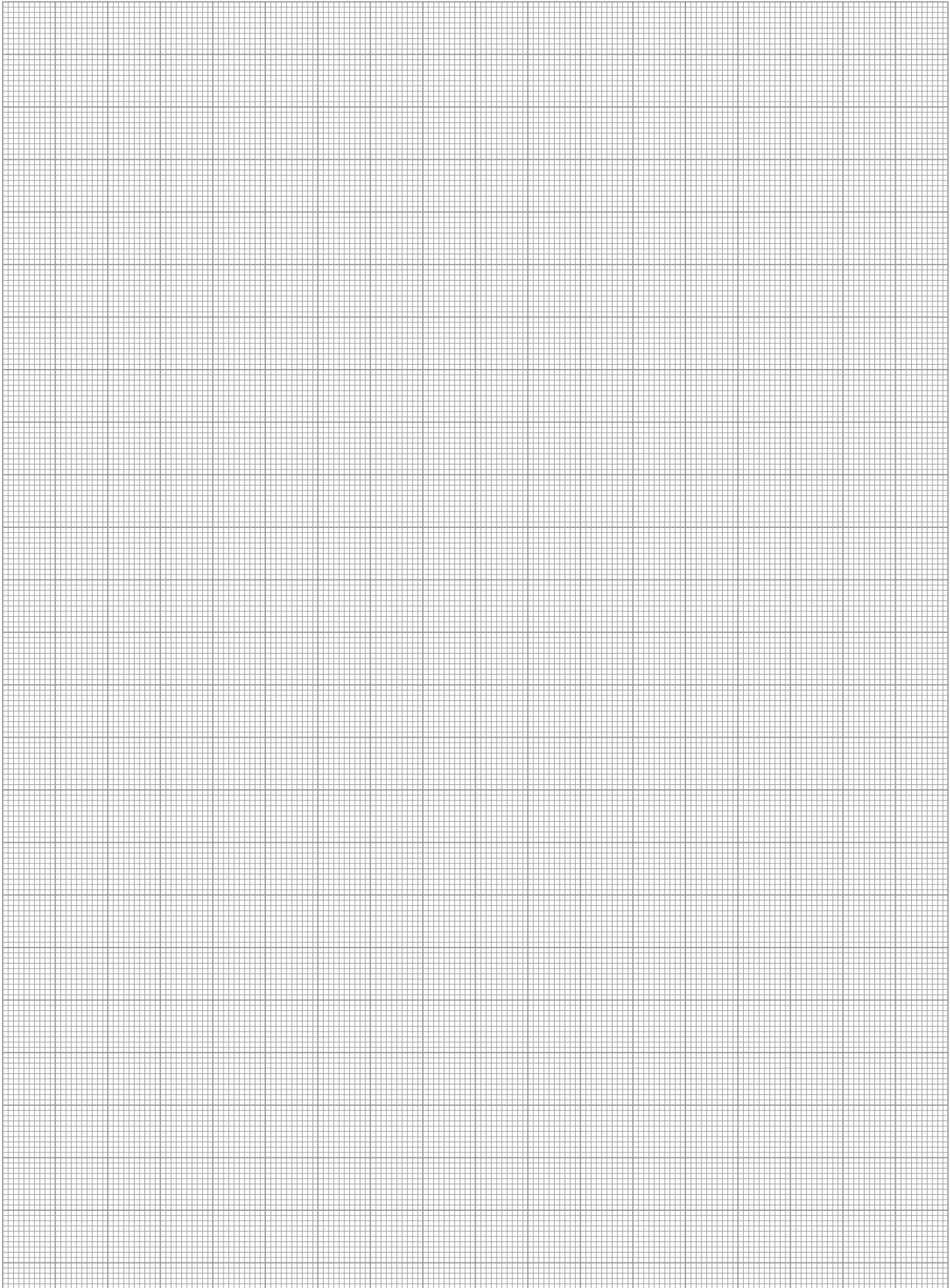
1 set = 2 pieces



Suitable for	Description	Height mm	ID
KSC3 125-160-VA	GWU-M 125-8	8	1450266
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-9	9	1462567
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-10	10	1411328
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-12	12	1447369
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-15	15	1411350
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-20	20	1452308
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-22	22	1457551
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-23	23	1411380
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-25	25	1484475
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-27	27	1461008
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-30	30	1411387
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-31	31	1484477
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-32	32	1411398
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-33	33	1484478
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-34	34	1484480
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-35	35	1411391
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-36	36	1429618
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-37	37	1411395
KSC3-K 125-160-VA			
KSC3 125-160-VA	GWU-M 125-38	38	1429615
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