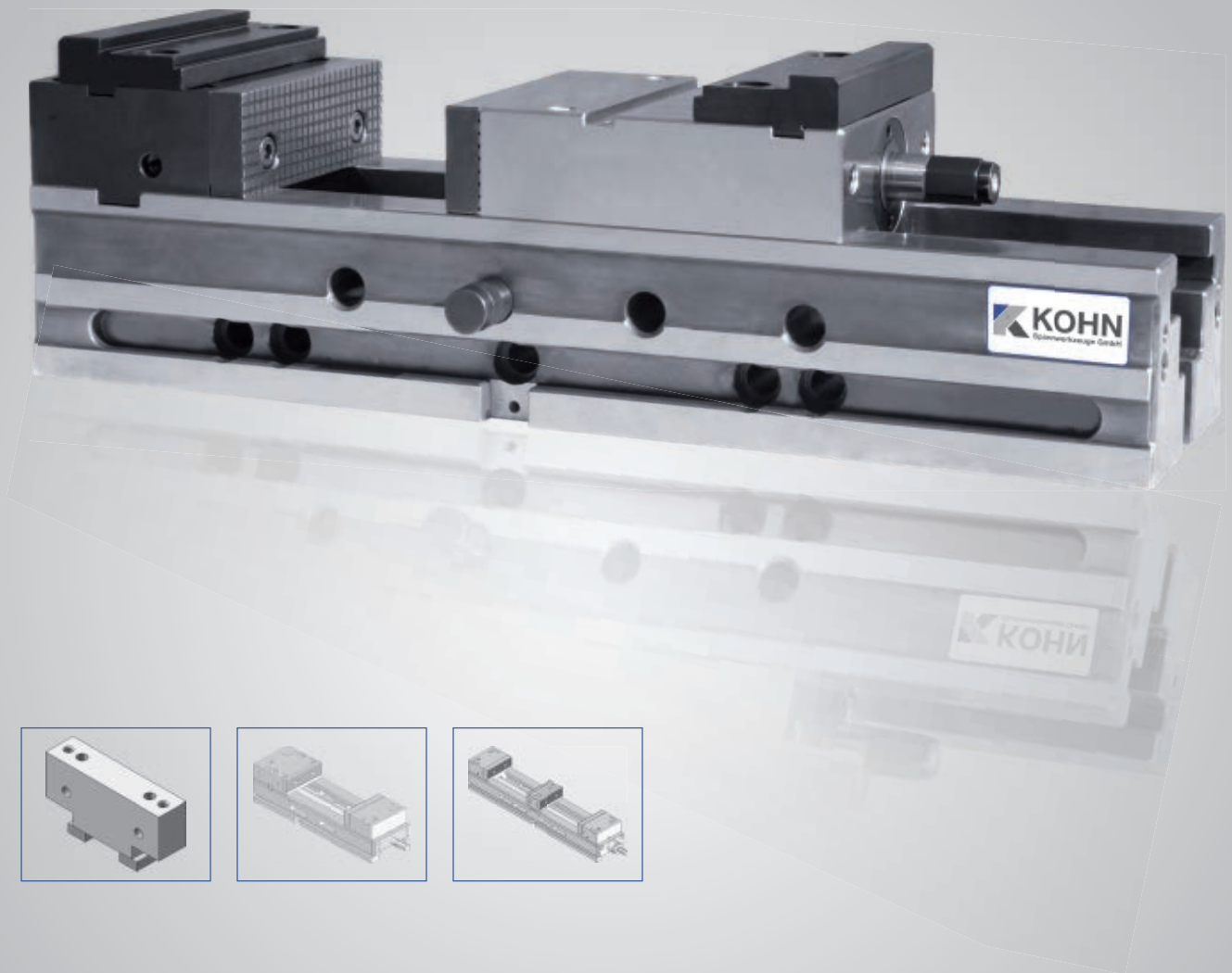


PRODUCT CATALOG



We create tension



PRODUCT CATALOG



TABLE OF CONTENTS

Outline		
	▶ MACHINE VICE NCS	10-23
	▶ ESS SINGLE VICE	24-33
	▶ DSS DOUBLE VICE	34-39
	▶ KORNA RASANT	40-41
	▶ MFS MULTI-FUNCTIONAL VICE	42-53
	▶ ZSS SELF-CENTERING VICE	54-63
	▶ ACCESSORIES	64-75
	▶ VICES FOR AUTOMATION SYSTEMS	76-87
	▶ HWS SELF-CENTERING AND SHAFT VICE	88-95

NCS

ESS

DSS

KORNA RASANT

MFS - MFS

ZSS

ZUBEHÖR

AUTOMATION

HWS

About us

EXPERTISE AND EXPERIENCE

With experience extending over more than 60 years in the production of vices, Kohn today more than ever stands for the highest quality and precision in the development and production of the vices.

We cover the entire process chain. From consulting services, the development, manufacture and installation to customer support services, we always want to support our customers to the best of our abilities.

INNOVATION AND STRUCTURE

Our team-oriented corporate structure integrates development, manufacturing, marketing and sales to the highest degree. Innovations and new products are created in close cooperation with our customers.

STANDARD AND SPECIAL SOLUTIONS

Our extensive standard range offer a wide range of clamping solutions to our customers in the areas of mechanical clamping, mechanical-hydraulic clamping and fully hydraulic clamping. We are also known as a specialist in customer-specific solutions in the market. We see ourselves as problem solvers.

OUR OBJECTIVE

With our products we strive to increase the productivity and competitiveness to our customers at all times. We always want to remind ourselves of the art to listen to what our customer wants. We see this as the main condition for satisfied customers.

We want to inspire our customers with team spirit, motivation and joy. The best advice, top quality, custom solutions and last not least, fast and reliable after-sales service are the focal point of our efforts.

Long-term partnership with our customers and suppliers. Satisfied and motivated employees.

In this respect, the person should always play a key role.

THIS IS WHAT THE KOHN-TEAM STANDS FOR.

About us



EXPERTISE AND EXPERIENCE

INNOVATION AND STRUCTURE

STANDARD AND SPECIAL SOLUTION

OUR OBJECTIVE

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Manager: Heike Kohn

Registrar of companies: District Court Schorndorf

Register number: HRB 281357

Value added tax identification number according to § 27a Value Added Tax Act: DE 164115777

NCS

ESS

DSS

KORNA RASANT

MULTI - MFS

ZSS

ZUBEHÖR

AUTOMATION

HWS

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KOHN SPANNWERKZEUGE GMBH

Our employees



The company



NCS

ESS

DSS

KORNA RASANT

MULTI - MFS

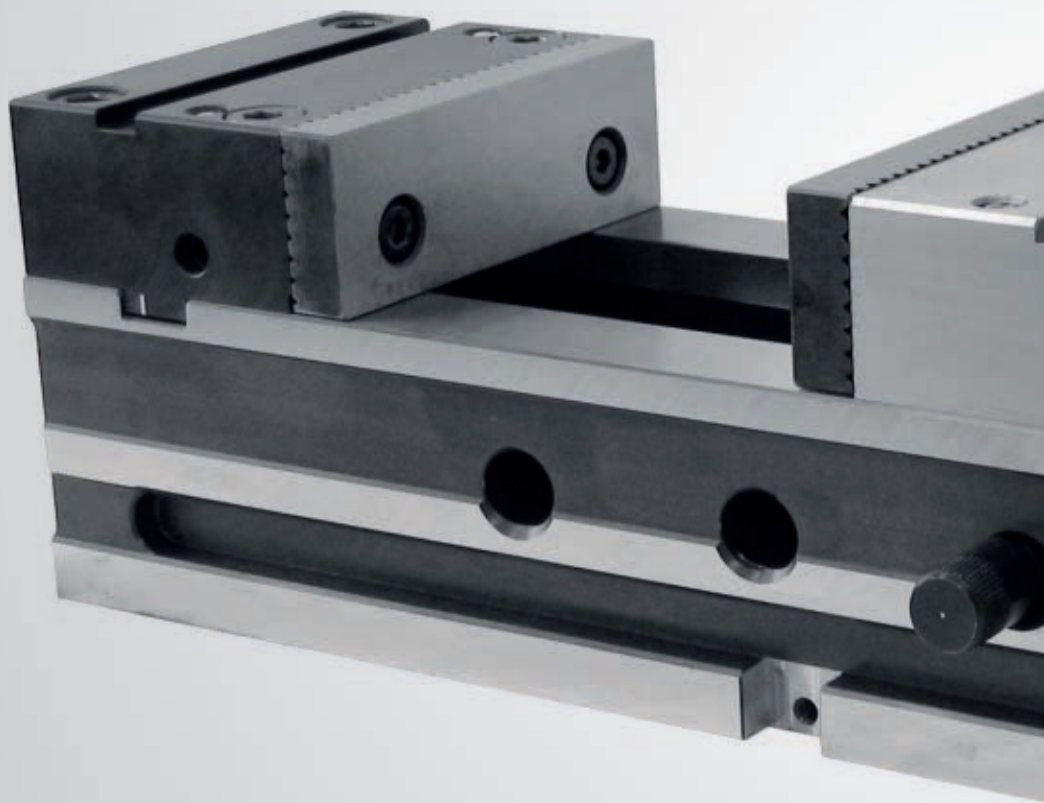
ZSS

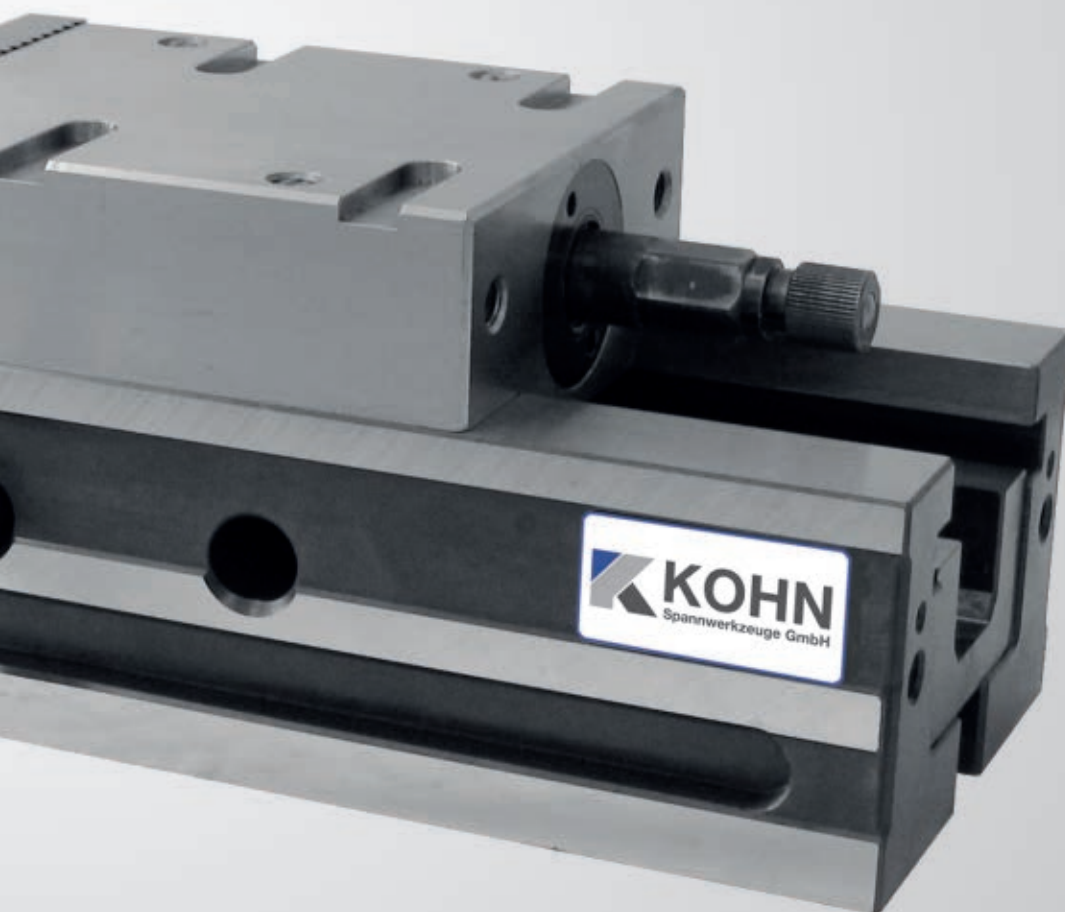
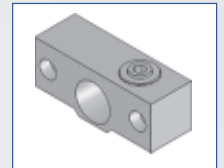
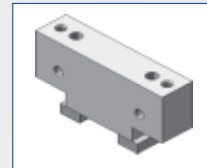
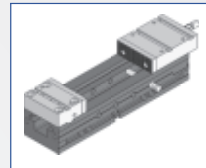
ZUBEHÖR

AUTOMATION

HWS

MACHINE VICE NCS 125





MACHINE VICE NCS 125

DESIGNED AS MECHANICAL-HYDRAULIC (M-HD) AND FULLY HYDRAULIC (HD) DEVICE

NCS M-HD and NCS HD

NCS M-HD UND NCS HD

MODEL

- ▶ Main structure, fixed jaw, case-hardened steel jaws, hardened on all sides
- ▶ Spindle made of high-strength special steel
- ▶ Lateral grooves for quick positioning
- ▶ Three positioning holes Ø 12F7 for 40 mm and 50 mm divisions
- ▶ Fixed jaw is fixed on all levels (x, y, z)
- ▶ Grooves and installation thread to accommodate false jaws and grip bars
- ▶ Use of pull-down quick-change jaws possible
- ▶ Use of rhombic T-shaped tenon blocks as well as change slides for multiple clamps is possible
- ▶ No tools required for assembly
- ▶ Side threads for workpiece stops

NCS 125 M-HD

- ▶ Mechanical-hydraulic power transmission with stroke length limit
- ▶ Max. clamping force of mechanical-hydraulic clamping 40 kN
- ▶ Max. clamping force of mechanical clamping 10 kN
- ▶ Mechanically locked spindle
- ▶ laterally tiltable when the bed length is 470 mm
- ▶ lateral mounting holes for bed length 470 mm

NCS 125 HD

- ▶ Fully hydraulic, hydraulic unit required
- ▶ Clamping force 35 kN at 380 bar

REPEATING ACCURACY

REPEATING ACCURACY

- ▶ The preselected clamping forces achieve a repeat accuracy for the workpiece position of ≤ 0.02 mm
- ▶ The clamping force can be selected with the number of spindle rotations (NCS 125 M-HD)
- ▶ On the NCS 125 HD the clamping force is adjusted by means of the hydraulic pressure that can be adjusted on the hydraulic unit

STANDARD EQUIPMENT

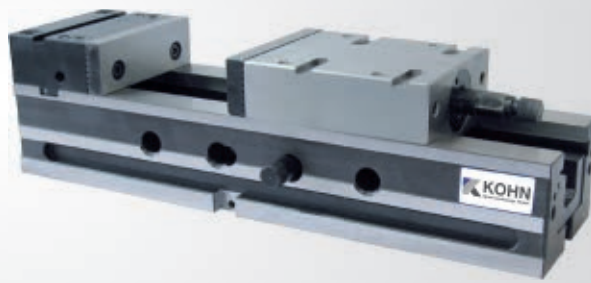
STANDARD EQUIPMENT

- ▶ 2 pcs. reversible screw-in jaws (1 side with longitudinal and cross knurls, 1 side smooth)
- ▶ 1 pcs. Hand crank, hexagonal, two-part

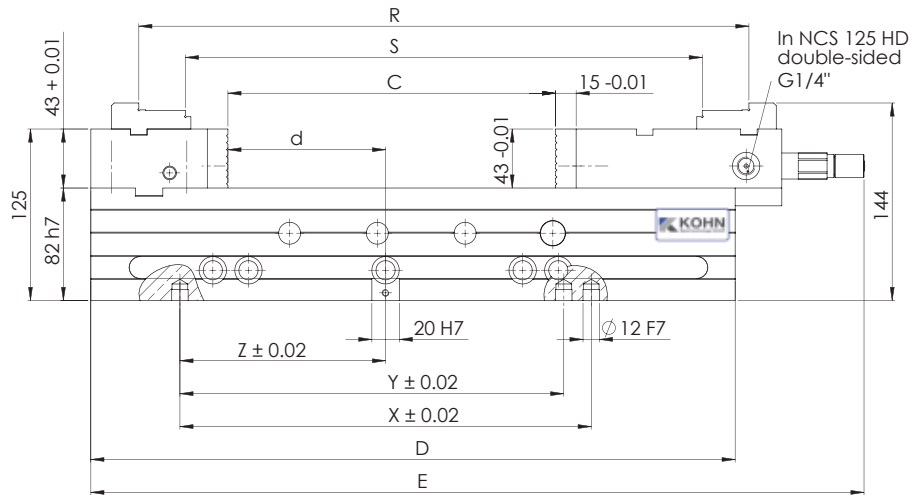
OPTIONS

OPTIONS

- ▶ Drilling pattern and location of the transverse groove (such as zero-point clamping system)
- ▶ Longitudinal groove
- ▶ Bed length up to 1200 mm possible
- ▶ as a double clamping vice with additional slide shoe and available resources (see photo on page 17, above)
- ▶ Laterally tiltable
- ▶ Vertical clamping of the vice
- ▶ Hydraulic Accessories



The Bestseller



Type		NCS 125 M-HD							
		09522	09523	09524	09525	09526	09527	09528	09529
Order-Nr.									
		125/127							
Bed length	D	470	534	598	662	726	790	854	918
Overall length	E	564	628	692	756	820	884	948	1012
	d	115	167	199	231	263	295	327	359
	X	300	400	500	500	500	500	500	500
	Y	280	-	480	480	480	480	480	480
	Z	150	200	250	250	250	250	250	250
Span	C	0-239	0-303	0-367	0-431	0-495	0-559	0-623	0-687
Span	R	131-445	131-509	131-573	131-637	131-701	131-765	131-829	131-893
Span	S	63-377	63-441	63-505	63-569	63-633	63-697	63-761	63-825
Weight	kg	37.6	38	41	44.4	51.2	54.6	58	61.4

Type		NCS 125 HD							
		09532	09533	09534	09535	09536	09537	09538	09539
Order-Nr.									
Bed length	D	470	534	598	662	726	790	854	918
Overall length	E	542	606	670	734	798	862	926	990
	d	115	167	199	231	263	295	327	359
	X	300	400	500	500	500	500	500	500
	Y	280	-	480	480	480	480	480	480
	Z	150	200	250	250	250	250	250	250
Span	C	0-239	0-303	0-367	0-431	0-495	0-559	0-623	0-687
Span	R	131-445	131-509	131-573	131-637	131-701	131-765	131-829	131-893
Span	S	63-377	63-441	63-505	63-569	63-633	63-697	63-761	63-825
Weight	kg	37.7	38.1	41.1	44.5	51.3	54.7	58.1	61.5

Dimensions in mm, other lengths up to 1200 mm, 64 mm divisions

TECHNICAL CHANGES RESERVED

MACHINE VICE NCS 125 WITH TIE ROD SYSTEM

NCS-ZA 125 M-HD

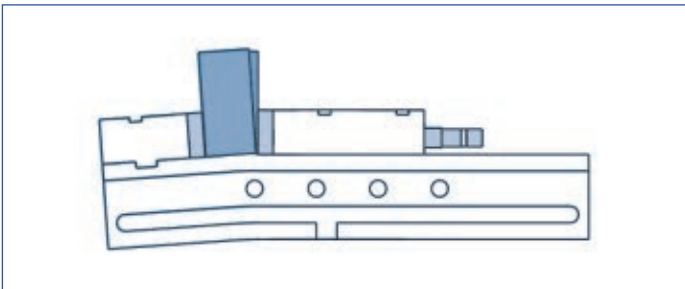
BASED ON A DEVELOPMENT OF THE NCS 125 VICE

The vice NCS is now available with tie rods.

This development of the vice provides significant advantages:

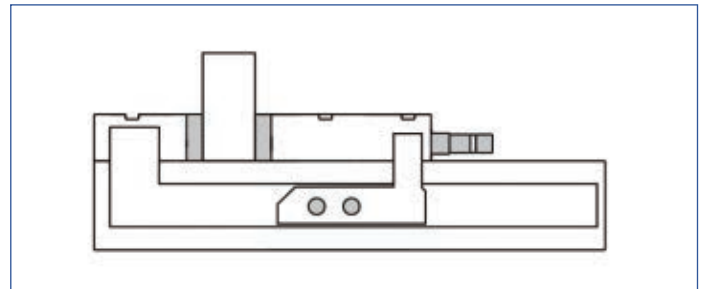
- ▶ At full tension, the fixed jaw of the clamping slide is only deflected in the μ range. Rearing up of the body and distortions of the machine table are reduced significantly. This substantially prevents misalignment of the fixed jaw and thereby the workpiece.
- ▶ The tie-rod that supports the fixed jaw to absorb the entire clamping force substantially improves the repeatability. This ensures that precision components can be produced.
- ▶ The use of pull-down quick-change jaws extends the range of applications of the vice. It is even possible to compensate for existing angular misalignment of the workpieces.

FURTHER DEVELOPMENT

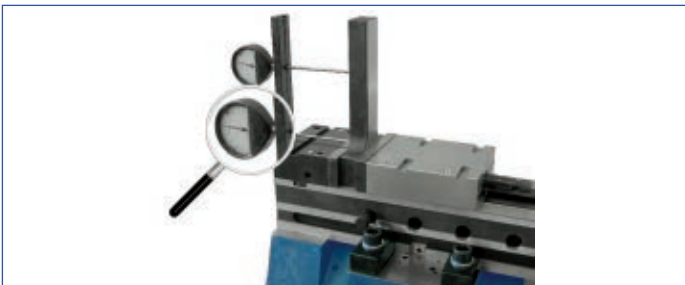


Conventional machine vice

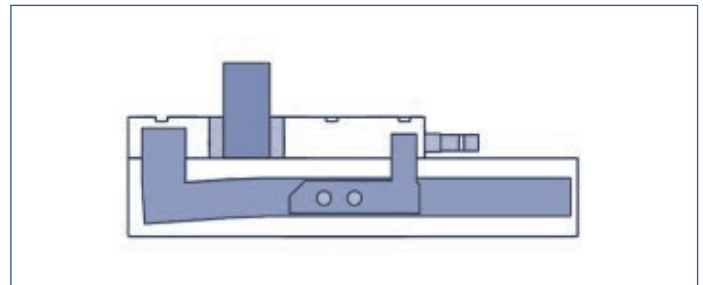
The main body is deformed, the fixed jaw is tilted away



Tie-rod system is slackened

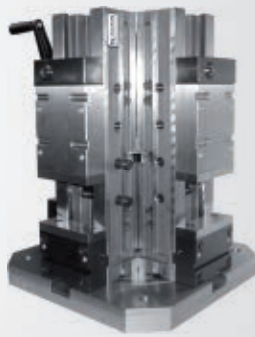


**Additional standard lengths: up to 726 mm
64 mm divisions**

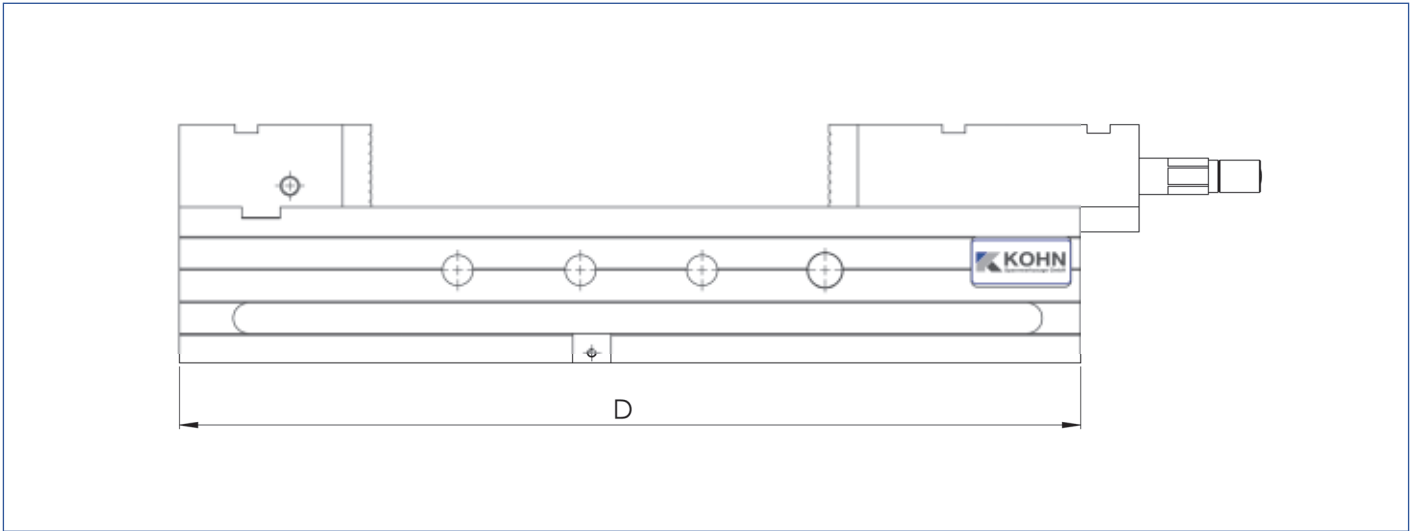


Tie-rod system is tightened

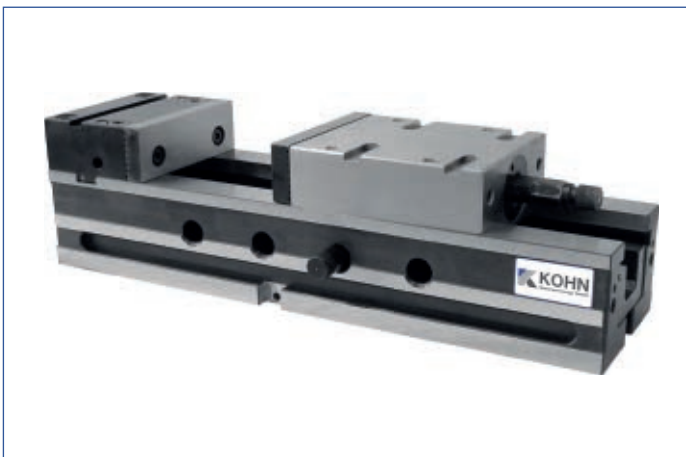
Clamping force is established by the tie rod.
The tie rod can be deformed without tilting the fixed jaw and losing clamping force.



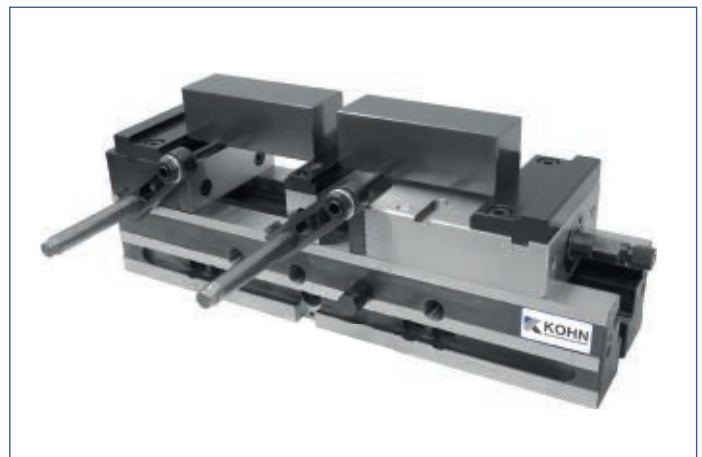
*Highest
repeating accuracy*



Type	NCS-ZA 125 M-HD					
Order No.		09522ZA	09523ZA	09524ZA	09525ZA	09526ZA
Bed length	D	470	534	598	662	726
Weight kg	kg	39,7	40	43	46,5	53,5



NCS ZA 125 M-HD



**NCS 125 M-HD with step jaw
and changing slide**

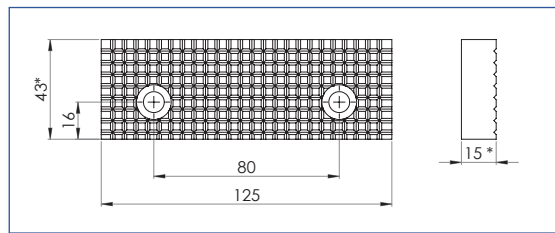
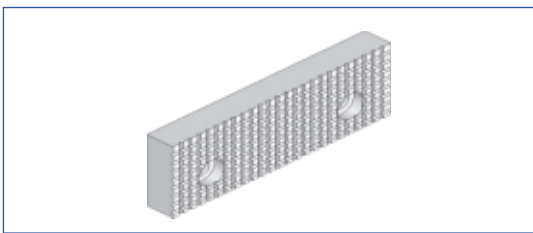
Other data refer to NCS-M HD

TECHNICAL CHANGES RESERVED

ACCESSORIES NCS

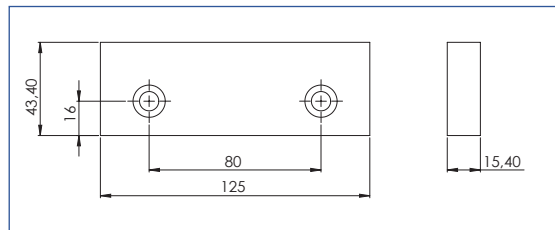
Screw-in jaws, hardened and ground

reversible screw-in jaw (1 Page ribbed longitudinally and transversely, 1 side smooth)



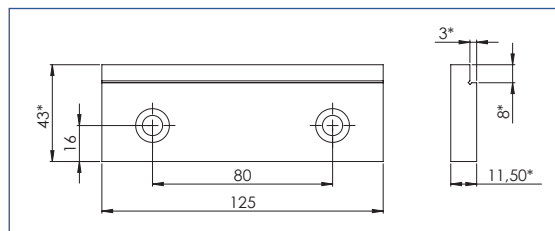
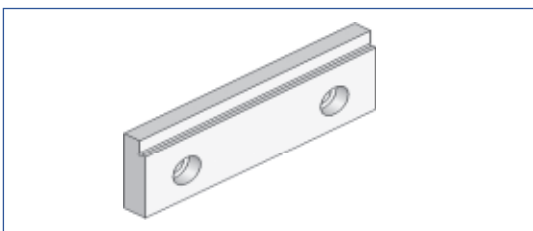
Order No. 09520500

reversible jaw with grinding allowance



Order No. 09520504

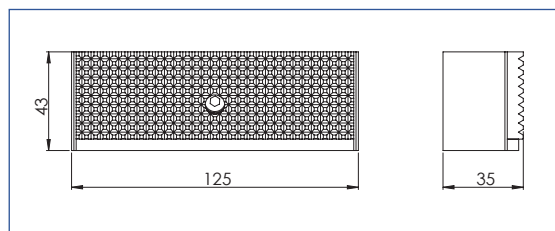
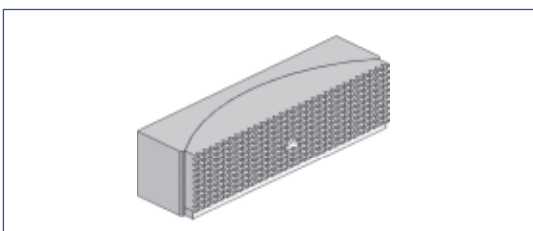
Step jaw



Order No. 09510504

Other models
available upon
request

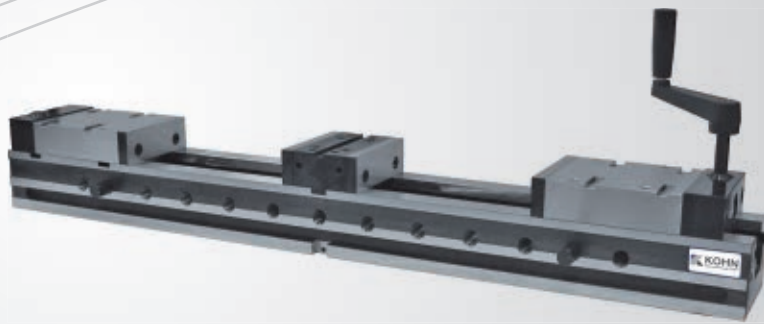
Swing jaw



Order No. 09510001

Dimensions $\pm 0,01$ mm, sizes in mm

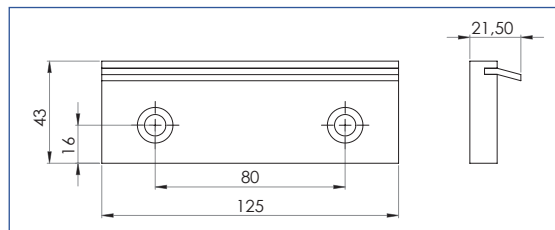
TECHNICAL CHANGES RESERVED



Flexible range
of applications

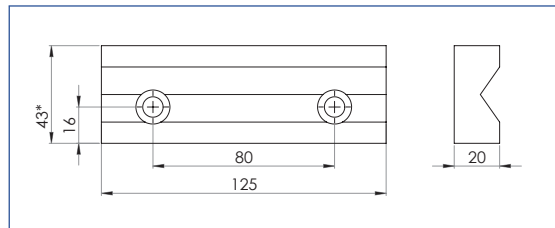
Screw-in jaws, hardened and ground

Pull-down jaw with spring leaf



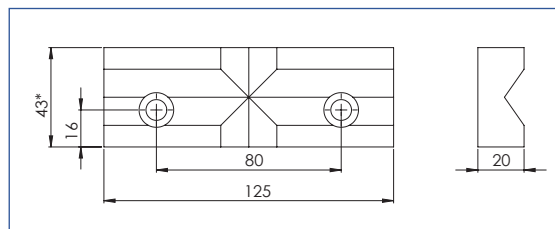
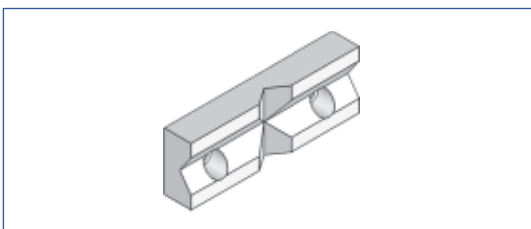
Order No. 09520505

Prismatic jaw clamping range $\varnothing 8 - \varnothing 38$



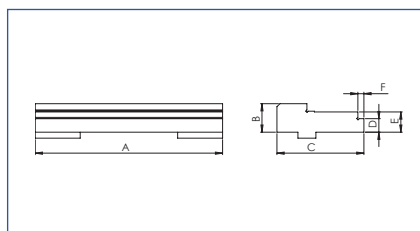
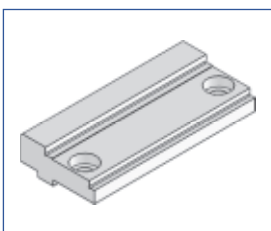
Order No. 09510509

Prismatic jaw clamping range $\varnothing 8 - \varnothing 38$ vertical and horizontal



Order No. 09510509S

Step jaw for clamping slide and fixed jaw



size	Order No.	A	B	C	D*	E*	F
125	08530510	125	19	58	9	14	4

increases the chip area, stretching from long
Workpieces is possible

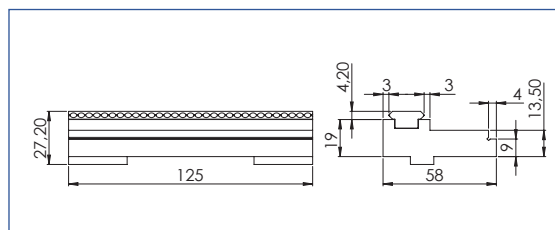
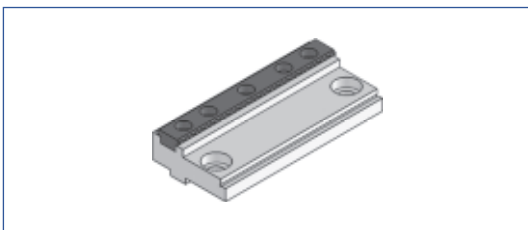
*Dimensions $\pm 0,01$ mm, sizes in mm

TECHNICAL CHANGES RESERVED

ACCESSORIES NCS

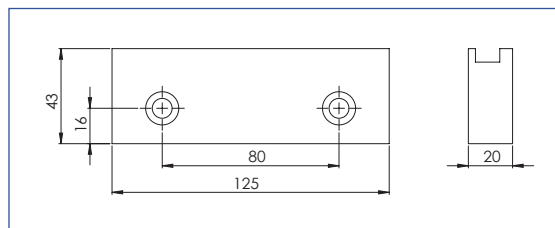
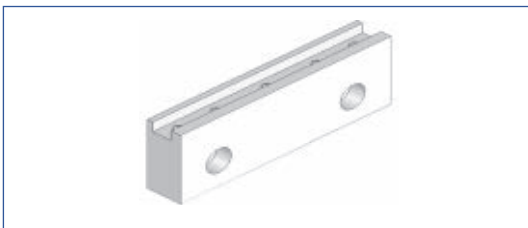
Screw-in jaws, hardened and ground with grip-strips

Step jaw with grip-strip



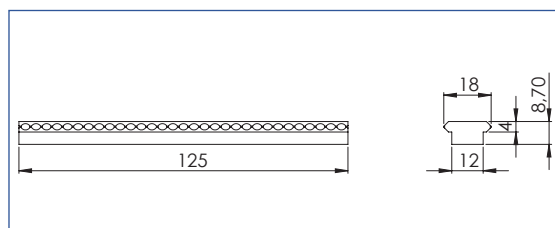
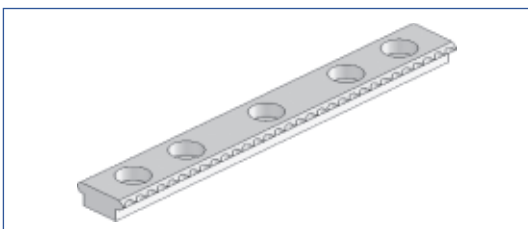
Order No. 02510026

Screw-in jaws with groove for the grip-strip



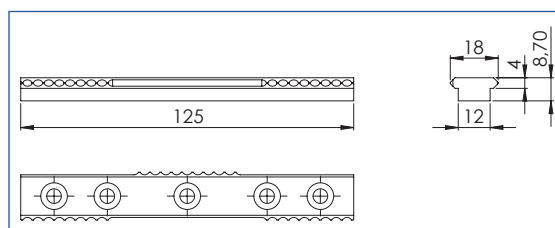
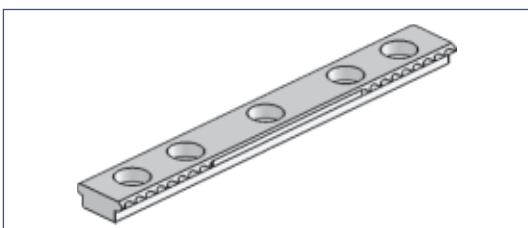
Order No. 09520036

Grip-strip, continuous grip on both sides



Order No. 09520035

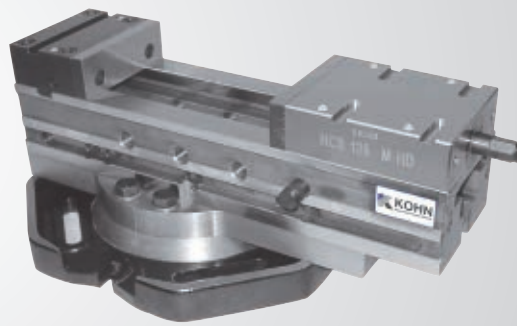
Grip-strip for three-point clamping



Order No. 09520037

Dimensions $\pm 0,01$ mm, sizes in mm

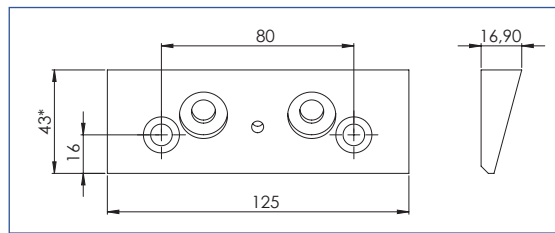
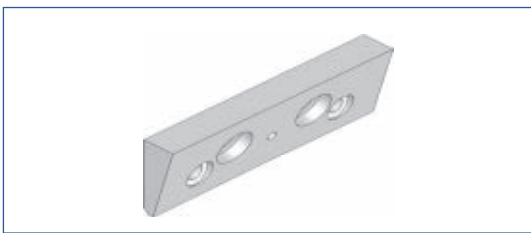
TECHNICAL CHANGES RESERVED



All-round quality

Pull-down quick-change jaws, hardened and ground

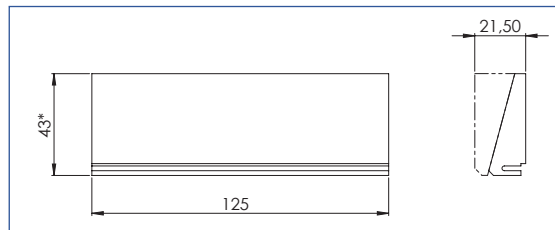
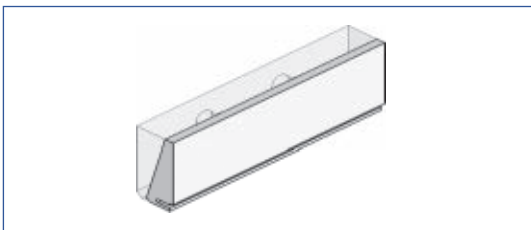
Main jaw



Order No. 09520501

with permanent magnets

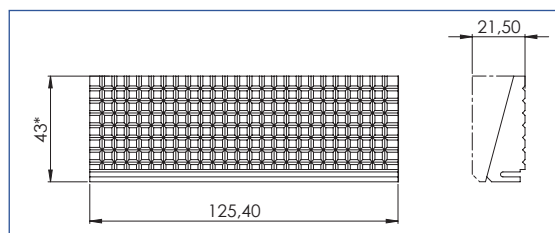
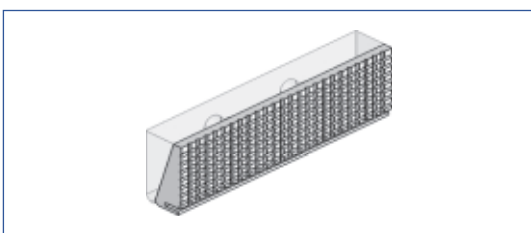
Smooth exchangeable jaw



Order No. 09520502

for machined workpieces

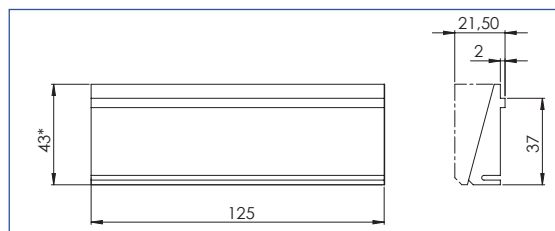
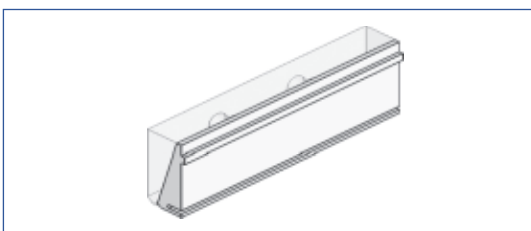
Ribbed exchangeable jaw



Order No. 09520503

for raw work pieces

Line exchangeable jaw



Order No. 09520509

for machined workpieces with angle errors

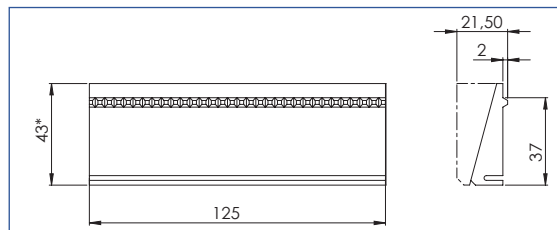
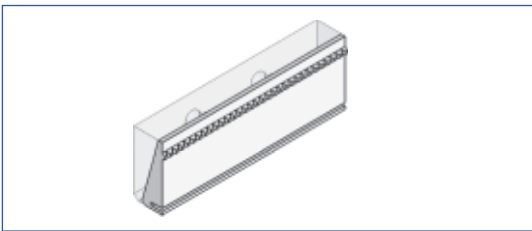
Dimensions ± 0,01 mm, sizes in mm

TECHNICAL CHANGES RESERVED

ACCESSORIES NCS

Pull-down quick-change jaws, hardened and ground

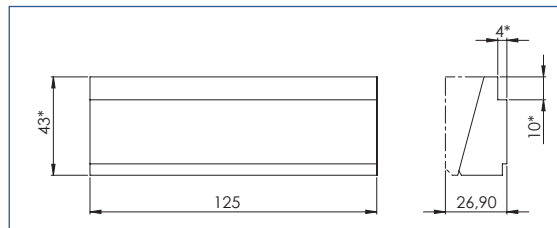
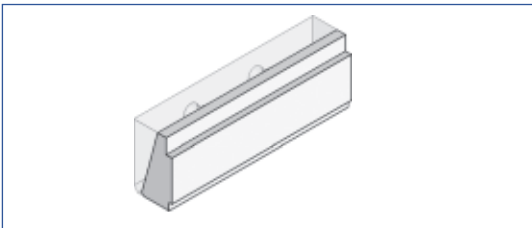
Ribbed line exchangeable jaw



Order No. 09520512

for raw workpieces
with angle errors

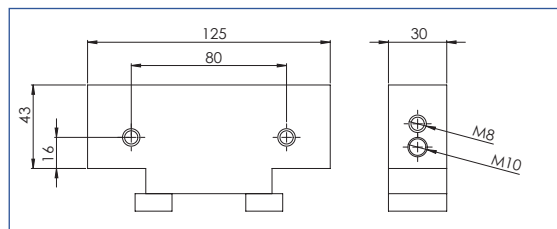
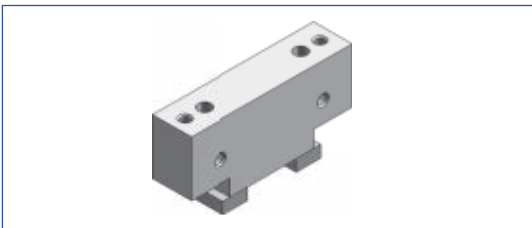
Exchangeable step jaw



Order No. 09520515

Other levels to
customer upon request

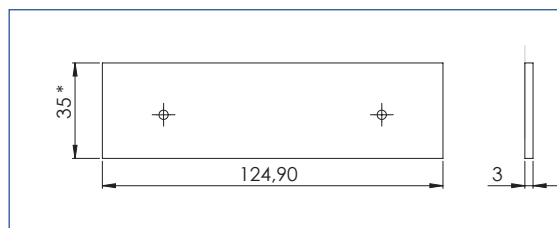
Changeover slider



Order No. 09520030

hardened and
ground

Shim strip for changeover slider nitrified



Order No. 09520031

Possible use as a
stepped jaw

Dimensions $\pm 0,01$ mm, sizes in mm

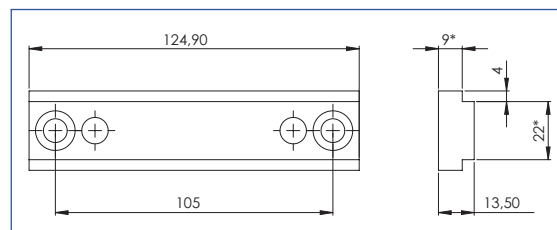
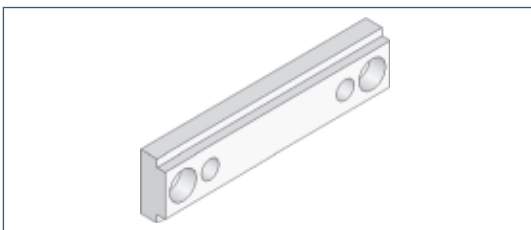
TECHNICAL CHANGES RESERVED



For any position

Other accessories

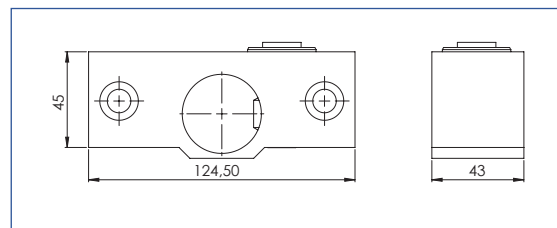
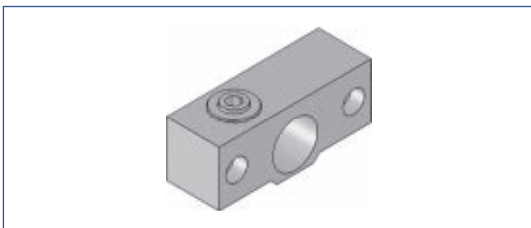
False stepped jaw for changeover slider



Order No. 09520033

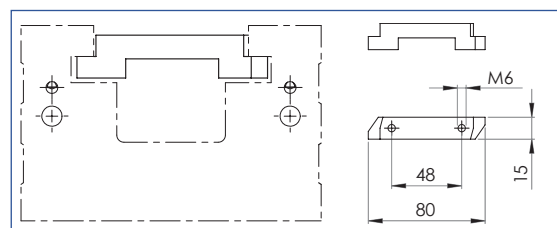
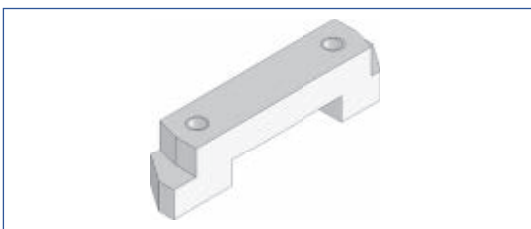
hardened and ground

Angle drive



Order No. 09520800

Rhombic T-shaped tenon blocks



Order No. 09522700

for securely clamping
workpiece material

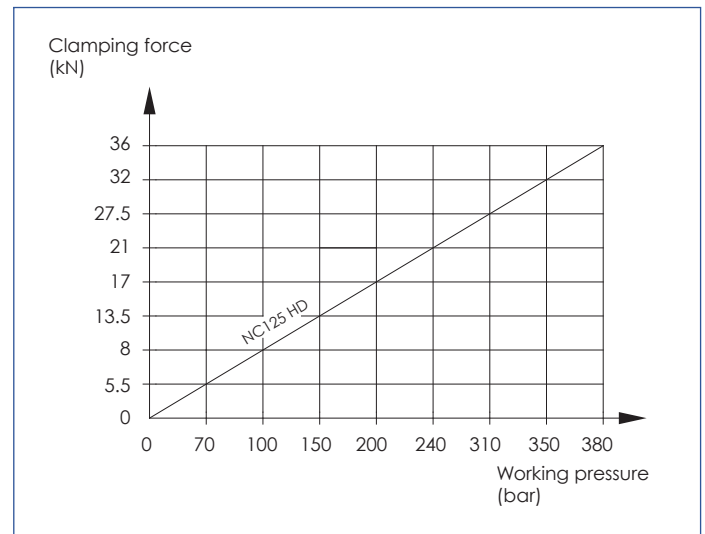
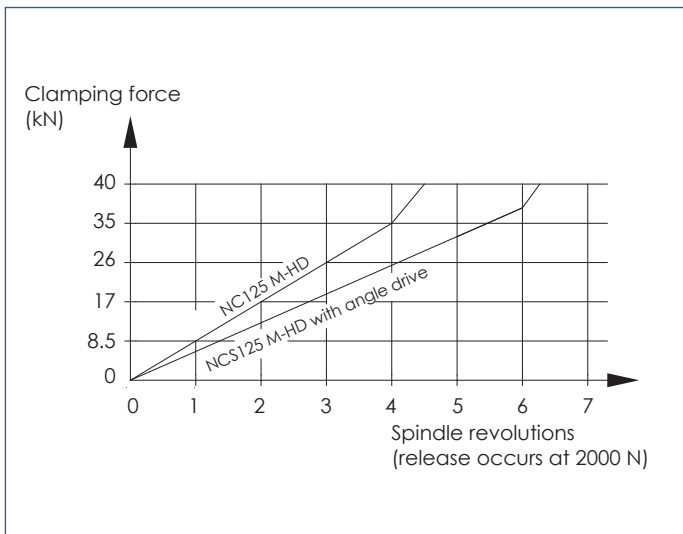
Additional accessories such as Nuts, workpiece stops, clamping irons, see pages 74 + 75.

Dimensions $\pm 0,01$ mm, sizes in mm

TECHNICAL CHANGES RESERVED

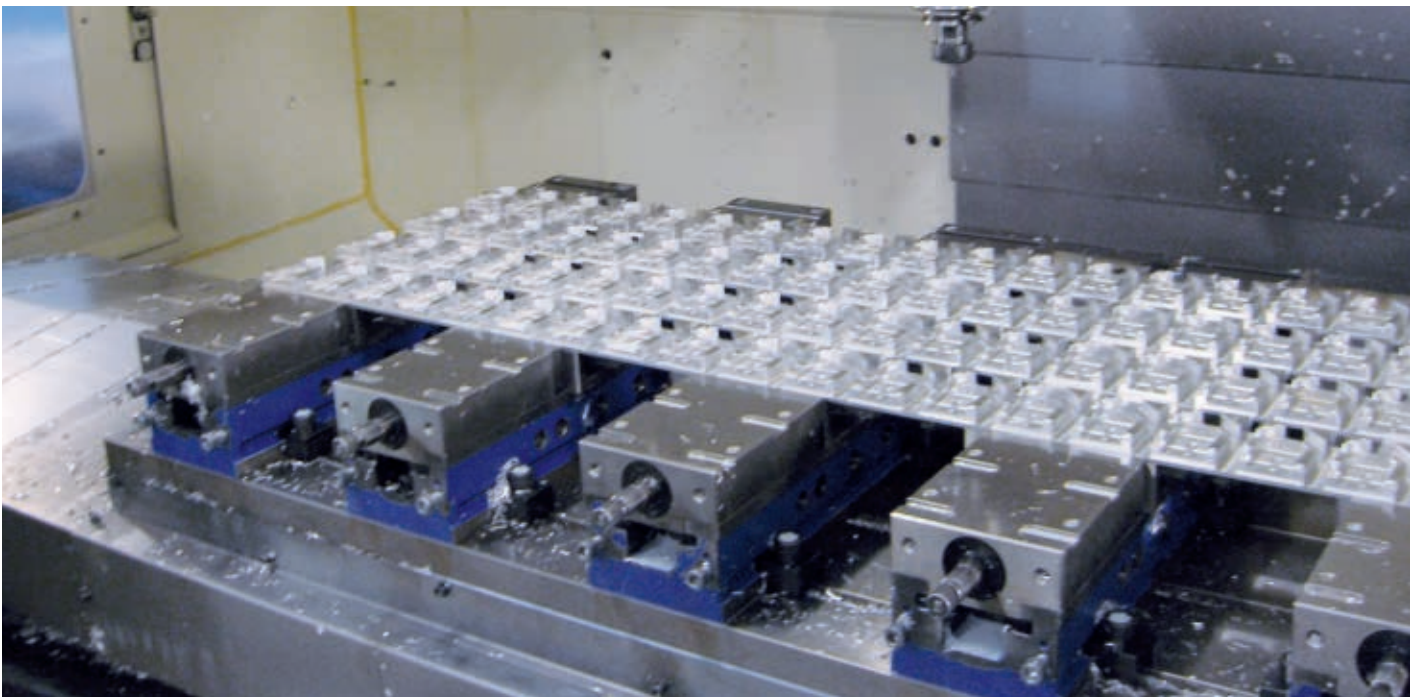
Clamping force diagrams

NCS 125 M-HD und HD



Clamping force diagrams M-HD

Clamping force diagrams HD



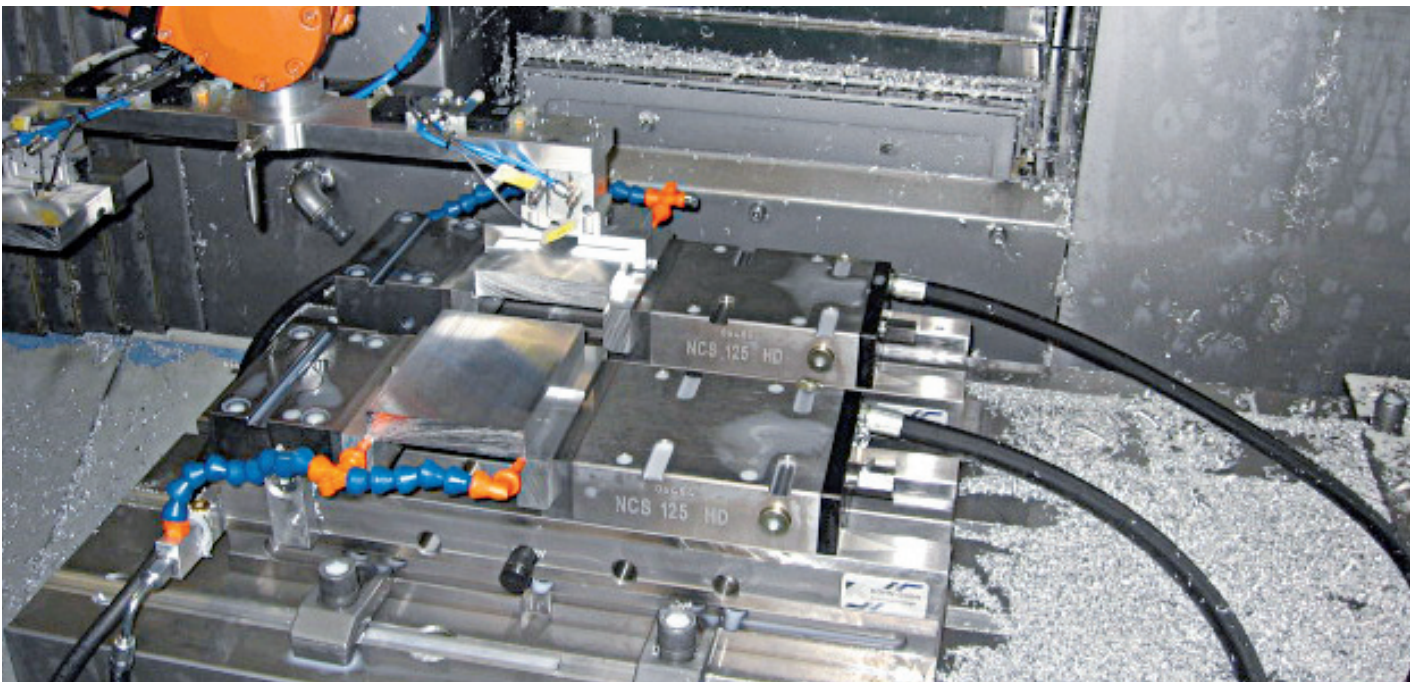


Multi-clamping

NCS in use



NCS 125/990 M-HD as the double vice of special funds and the second clamping jaw slide



NCS

ESS

DSS

KORNA RASANT

MULTI - MFS

ZSS

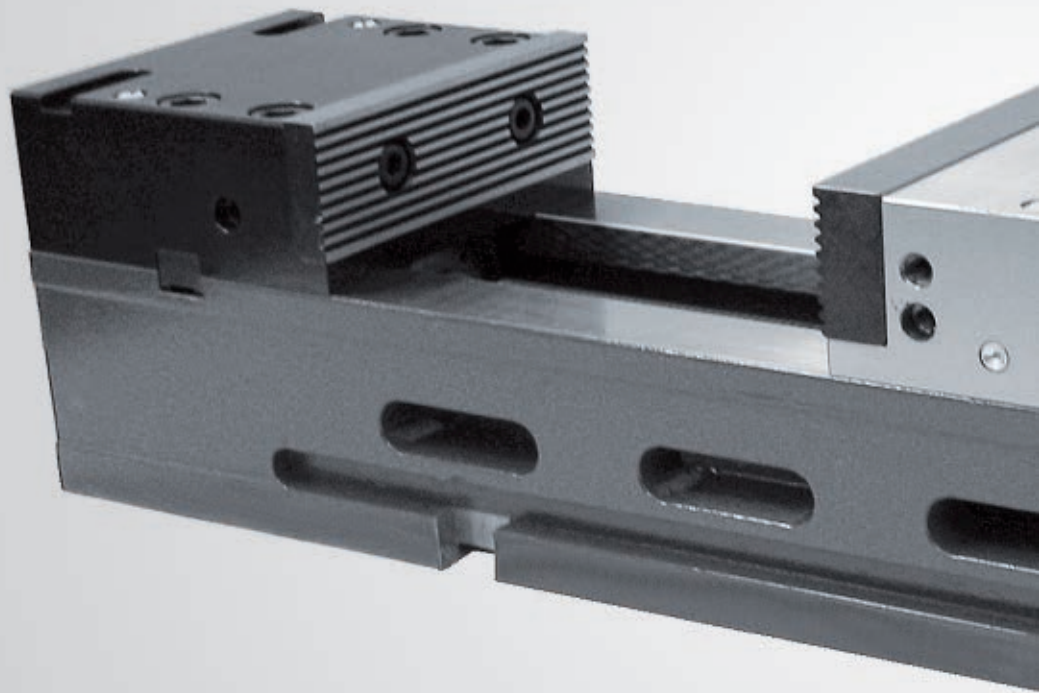
ZUBEHÖR

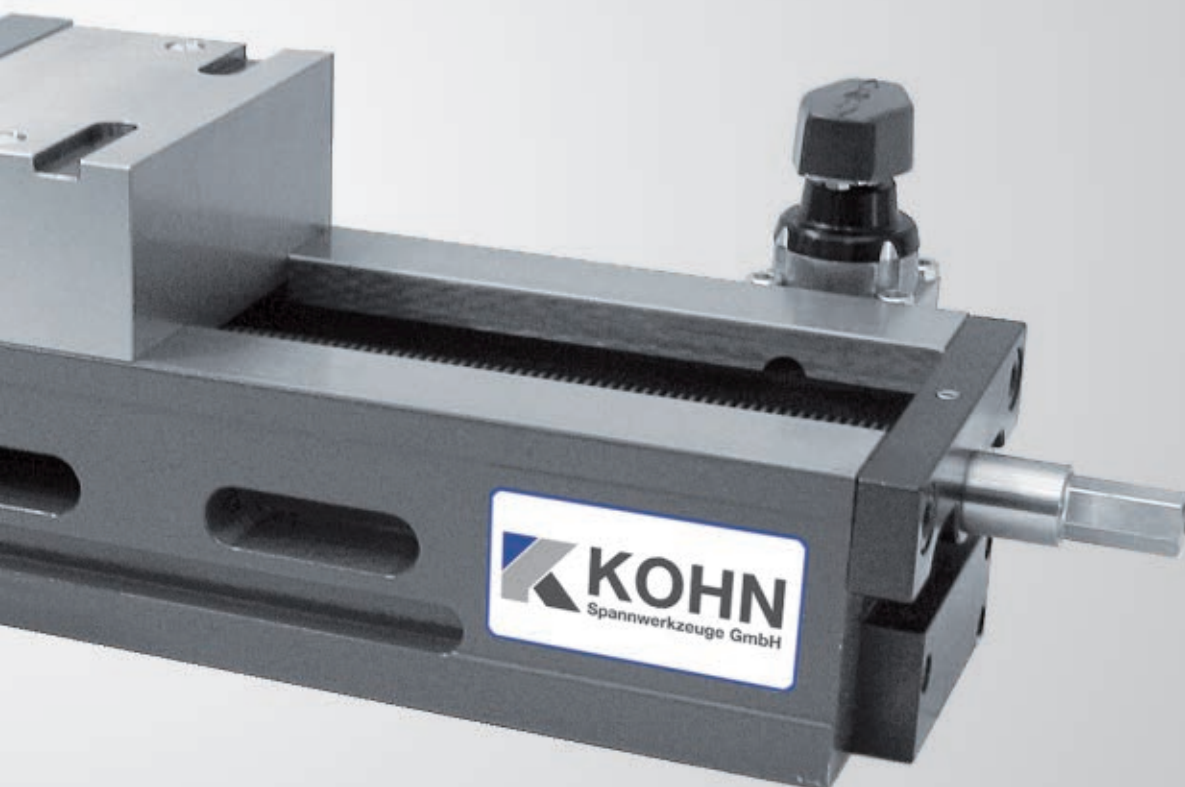
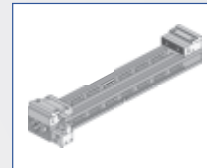
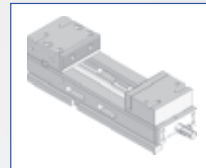
AUTOMATION

HWS

TECHNICAL CHANGES RESERVED

SINGLE VICE ESS-M / EFS-HD
ESS-FV M-HD / ESS-FV HD





SINGLE VICE ESS-M AND EFS-HD

ESS AS MECHANICAL AND HYDRAULIC VERSIONS

ESS-M and EFS-HD

ESS AS MECHANICAL AND HYDRAULIC VERSIONS

- ▶ Main body and jaws made of case-hardened steel, hardened on all sides
- ▶ Spindle made of high-strength special steel
- ▶ One-piece clamping slide and spindle nut
- ▶ Clamping slide with central lubrication (with the exception of size 65)
- ▶ Lateral grooves for quick positioning
- ▶ three positioning holes $\varnothing 12F7$ for 40 mm and 50 mm divisions
- ▶ Fixed jaw is fixed on all levels (x, y, z)
- ▶ Grooves and installation thread to accommodate top step jaws and grip bars (with the exception of size 65)
- ▶ Use of rhombic T-shaped tenon blocks as well as change slides for multiple clamps is possible
 - No tools required for assembly
- ▶ side threads for workpiece stops
- ▶ Excellent chip and coolant discharge

TECHNICAL SPECIFICATIONS

REPEATING ACCURACY

- ▶ The preselected clamping forces achieve a repeat accuracy for the workpiece position of ≤ 0.01 mm
- ▶ The use of a torque wrench is recommended to achieve controlled and reproducible clamping forces (ESS-M)
- ▶ On the EFS-HD the clamping force is adjusted by means of the hydraulic pressure that can be adjusted on the hydraulic unit

REPEATING ACCURACY

STANDARD EQUIPMENT

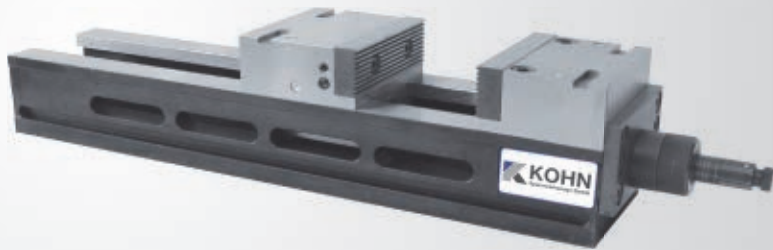
- ▶ 2 pcs. screw-in jaws, knurled longitudinally (for jaw width 125: 1 pcs. reversible screw-in jaw with 1 side knurled / 1 side smooth and 1 pcs. screw-in jaw knurled longitudinally)
- ▶ 1 pcs. hand crank hexagonal

STANDARD EQUIPMENT

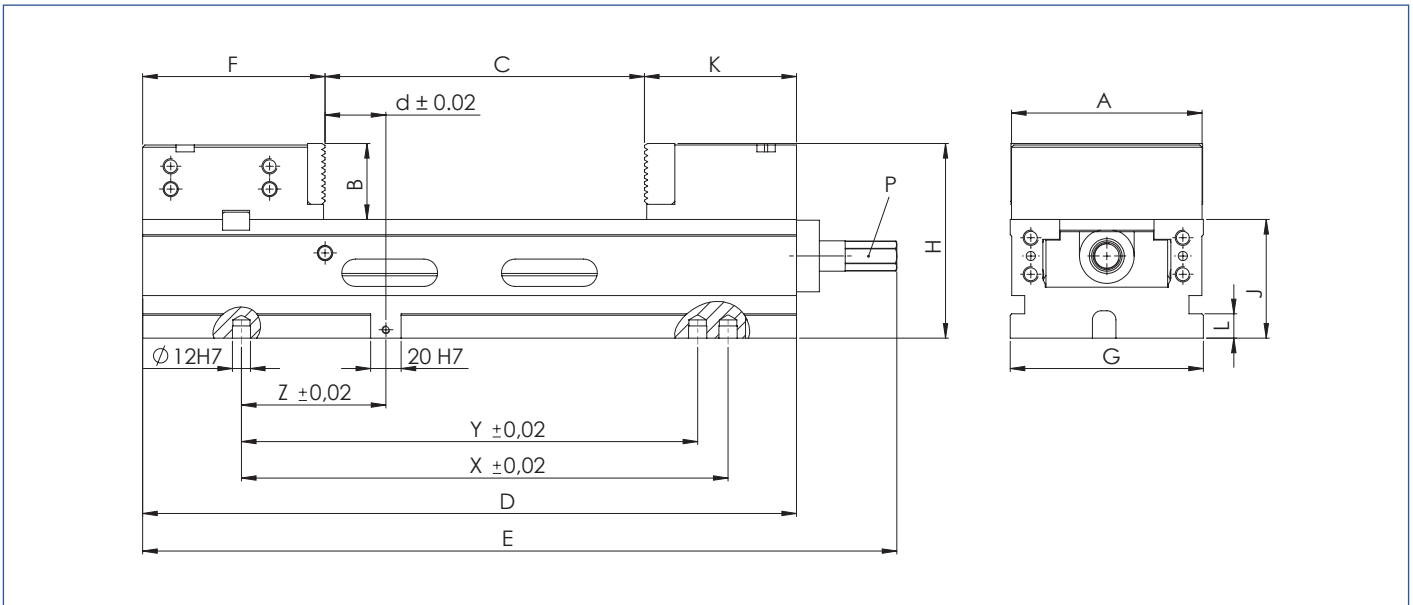
OPTIONS

- ▶ Drilling pattern and location of the transverse groove (such as zero-point clamping system)
- ▶ Longitudinal groove
- ▶ Quick-adjustment spindle for rapid moves (adjustments) of the clamping slide (only possible when EFS-HD, not for vertical clamping)
- ▶ Bed length up to 1200 mm
- ▶ laterally tiltable
- ▶ vertical clamping of the vice

OPTIONS



Simple but good



Type		ESS-M and EFS-HD			
Jaw width	A	65	80	100	125
Order No. mechanical		01211	01311	01411	01511
Order No. hydraulic		–	01331	01431	01531
Clamping depth	B	25	32	44	50
Span	C	99	173	180	210
Bed length	D	220	300	360	430
Overall length	E	260	345	415	495
Fixed jaw	F	65,5	63,5	100	120
Base width	G	78	84	104	127
Overall height	H	63	100	122	128
Bed height	J h7	38	68	78	78
Clamping slide length	K	55,5	63,5	80	100
	L	10	12	14	16
Hexagon	P	10	12	14	17
	d	20	20	40	40
	X	150	150	300	300
	Y	120	120	280	280
	Z	50.5	0	120	95
Span with step jaw		–	212-268	272-328	262-329
Clamping stroke	mm	–	4-5	4-5	4-5
Clamping force mechanical	kN/Nm	15/40	20/48	25/64	35/115
Clamping force hydraulic	kN/380 bar	–	15	20	30
Weight	kg	5	11,5	21	36

Dimensions in mm

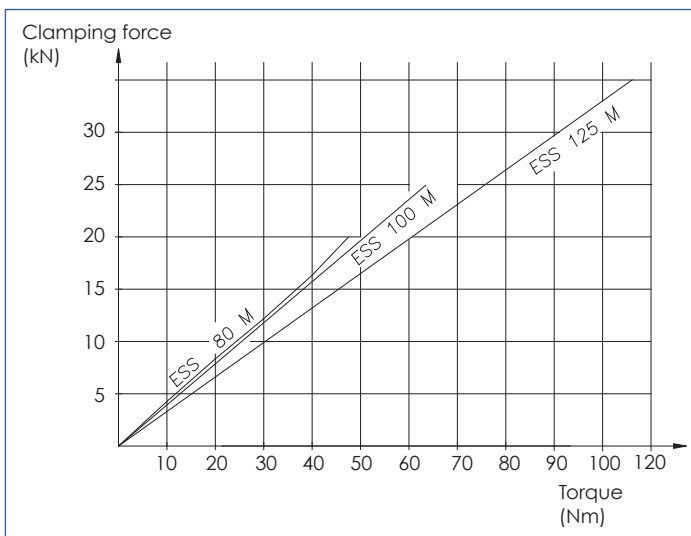
Note: Back mounting dimensions see pages 66-72

TECHNICAL CHANGES RESERVED

SINGLE VICE ESS-M AND EFS-HD ESS AS MECHANICAL AND HYDRAULIC VERSIONS

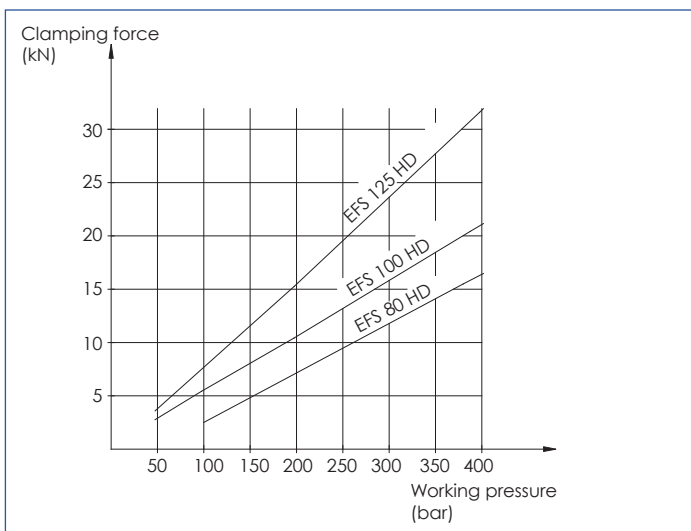
Clamping force diagrams

ESS 80 M, ESS 100 M, ESS 125 M

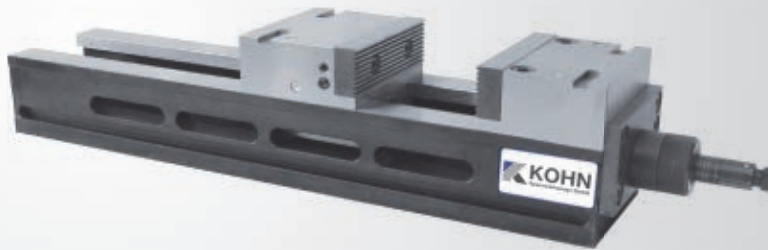


Clamping force diagram M

EFS 80 HD, EFS 100 HD, EFS 125 HD



Clamping force diagrams HD



Simple operation
„fixed jaw in front“

SINGLE VICE ESS-FV M-HD AND ESS-FV HD

ESS-FV M-HD WITH MECHANICAL-HYDRAULIC BOOSTER
FULLY HYDRAULIC DESIGN OF THE ESS-FV HD

ESS-FV M-HD and ESS-FV HD

ESS-FV M-HD AND ESS-FV HD

- ▶ Fixed jaw on the operator side
Perfect for machine tools with a large Y-traverse path
- ▶ Main body and jaws made of case-hardened steel, hardened on all sides
- ▶ Spindle made of high-strength special steel
- ▶ One-piece clamping slide and spindle nut
- ▶ Clamping slide with central lubrication
- ▶ Lateral grooves for quick positioning
- ▶ three positioning holes $\varnothing 12F7$ for 40 mm and 50 mm divisions
- ▶ Grooves and installation thread to accommodate false jaws and grip bars
- ▶ Use of rhombic T-shaped tenon blocks as well as change slides for multiple clamps is possible
- ▶ No tools required for assembly
- ▶ side threads for workpiece stops
- ▶ Excellent chip and coolant discharge

The clamping force for the ESS-FV M-HD is adjusted by means of marking rings, on the ESS-FV HD the clamping force is adjusted via the hydraulic pressure.

REPEATING ACCURACY

- ▶ The preselected clamping forces achieve a repeat accuracy for the workpiece position of ≤ 0.02 mm

STANDARD EQUIPMENT

- ▶ 2 pcs. reversible screw-in jaws (1 side smooth, 1 side knurled)
- ▶ 1 pcs. hand crank hexagonal

OPTIONS

- ▶ Drilling pattern and location of the transverse groove (such as zero-point clamping system)
- ▶ Longitudinal groove
- ▶ Quick-adjustment spindle for rapid moves (adjustments) of the clamping slide (only possible with ESS-FV HD, not for vertical clamping)
- ▶ Bed length up to 1200 mm, according to customer requirements
- ▶ laterally tiltable
- ▶ vertical clamping of the vice

TECHNICAL SPECIFICATIONS

REPEATING ACCURACY

STANDARD EQUIPMENT

OPTIONS

NCS

ESS

DSS

KORNA RASANT

MULTI - MFS

ZSS

ZUBEHÖR

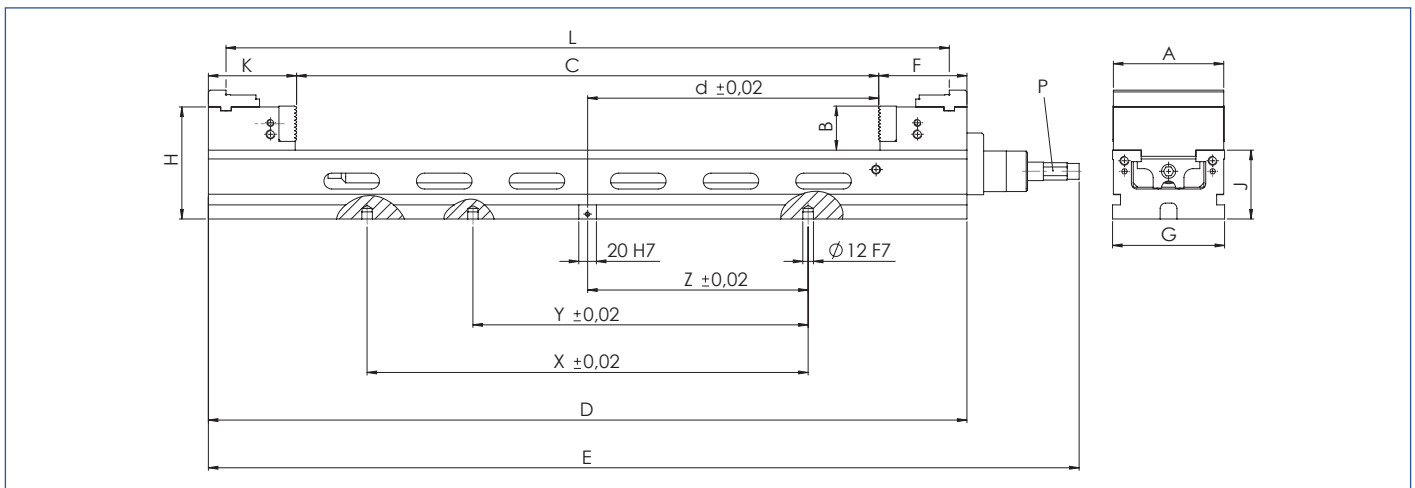
AUTOMATION

HWS

TECHNICAL CHANGES RESERVED

SINGLE VICE ESS-FV M-HD

ESS-FV M-HD



Type	ESS-FV M-HD									
Jaw width	A	125					160			
Order No.		01520-FV	01521-FV	01522-FV	01523-FV	01524-FV	01620-FV	01621-FV	01622-FV	01623-FV
Clamping depth	B	50					54			
Bed length	D	430	500	560	680	740	600	750	900	1050
Overall length	E	545	615	675	795	855	701	851	1001	1151
Span	C	230	300	360	480	540	325	475	625	775
Fixed jaw	F	100					146.5			
Base width	G	127					162			
Overall height	H	128					144			
Bed height	J h7	78					90			
Clamping slide	K	100					126			
false jaws	L	390	460	520	640	700	529	679	829	979
Hexagonal connection SW	P	17					17			
	d	115	150	180	240	270	153.5	228.5	303.5	378.5
	X	300	400	400	500	500	400	500	500	500
	Y	280	-	-	480	480	-	480	480	480
	Z	150	200	200	250	250	200	250	250	250
Mechanical clamping force	kN	38					47.5			
Weight	kg	35	39	42	47	50	68	78	88	98

Dimensions in mm

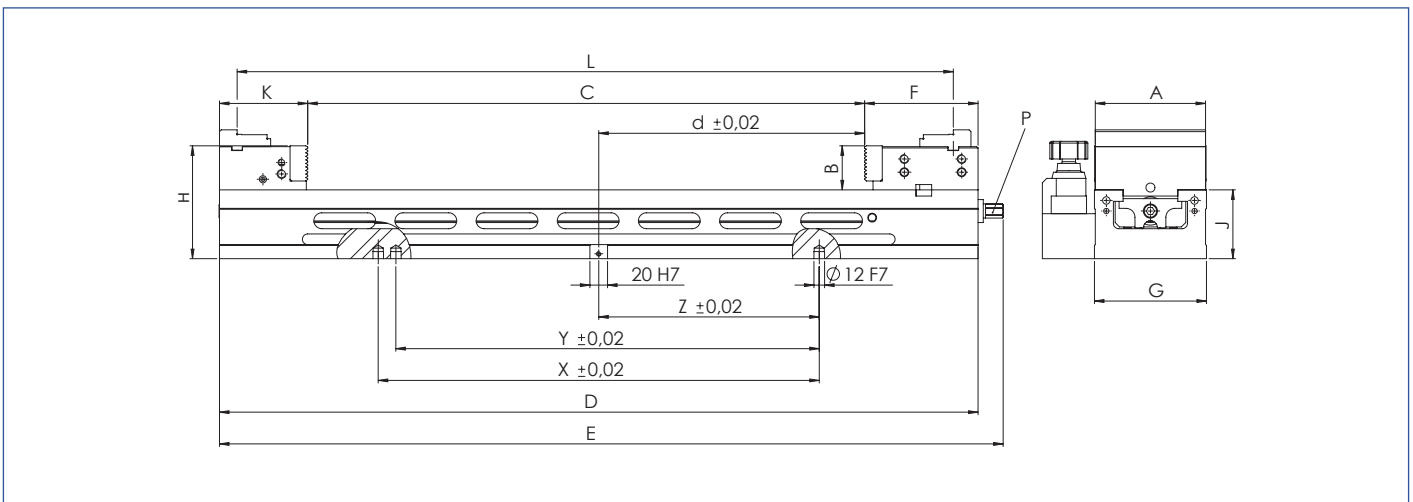
Standard version: ESS-FP 125 in bed length 430 mm. All other sizes on request!



Quick to set up and short retooling times

SINGLE VICE ESS-FV HD

ESS-FV HD



Type		ESS-FV HD									
Jaw width	A	125					160				
Order No.		01530-FV	01531-FV	01532-FV	01533-FV	01534-FV	01630-FV	01631-FV	01632-FV	01633-FV	
Clamping depth	B	50					54				
Bed length	D	430	500	560	680	740	600	750	900	1050	
Overall length	E	477	547	607	727	787	647	797	947	1097	
Span	C	230	300	360	480	540	325	475	625	775	
Fixed jaw	F	100					146.5				
Base width	G	127					162				
Overall height	H	128					144				
Bed height	J h7	78					90				
Clamping slide	K	100					126				
false jaws	L	390	460	520	640	700	529	679	829	979	
Hexagonal connection SW	P	14					17				
	d	115	150	180	240	270	153.5	228.5	303.5	378.5	
	X	300	400	400	500	500	400	500	500	500	
	Y	280	-	-	480	480	-	480	480	480	
	Z	150	200	200	250	250	200	250	250	250	
Clamping stroke		4					4				
Hydraulic clamping force	kN/380 bar	30					55				
Weight kg		46	51	55	63	67	72	82	93	103	

Dimensions in mm

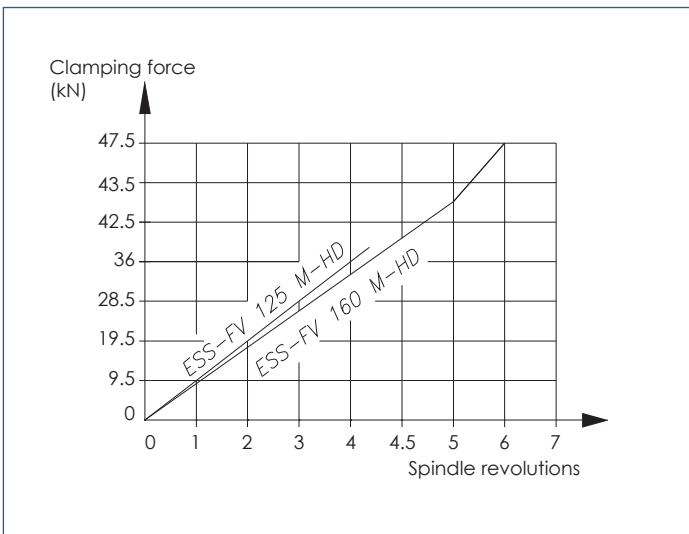
Standard version: ESS-FP 125 in bed length 430 mm. All other sizes on request!

TECHNICAL CHANGES RESERVED

SINGLE VICE ESS-FV M-HD AND ESS-FV HD

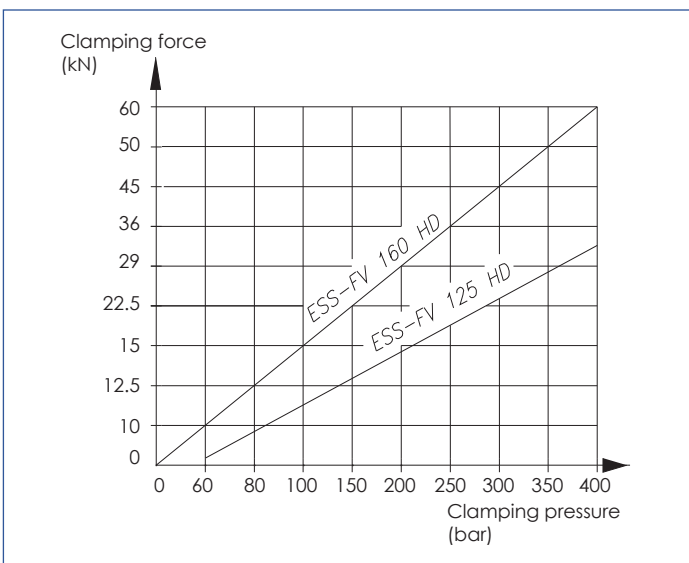
Clamping force diagrams

ESS-FV 125 M-HD, ESS-FV 160 M-HD



Clamping force diagram ESS-FV M-HD

ESS-FV 125 HD, ESS-FV 160 HD



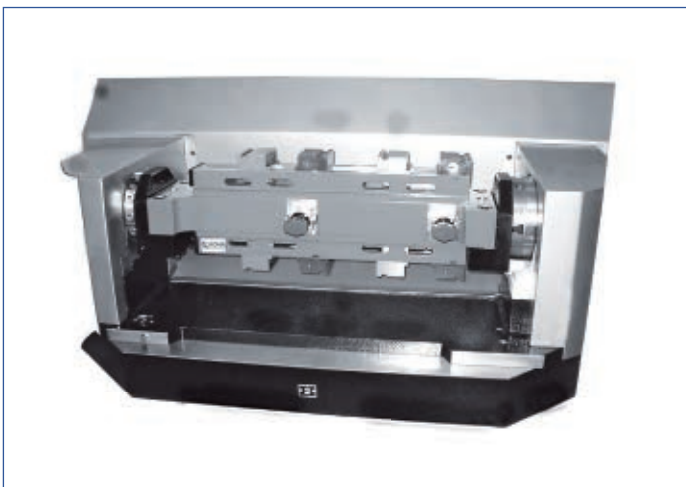
Clamping force diagram ESS-FV HD



Large and powerful

ESS as special-purpose solution

Applications



EFS 100 HD with 2 clamping stations on the bridge for 4 Axis (twin spindle)



EFS 125/490 HD on base with swing-Grippbacken



EFS 125/500 HD with quick adjustment



EFS 80 + 125 HD in a fully automated operation with robot loading

NCS

ESS

DSS

KORNA RASANT

MULTI - MFS

ZSS

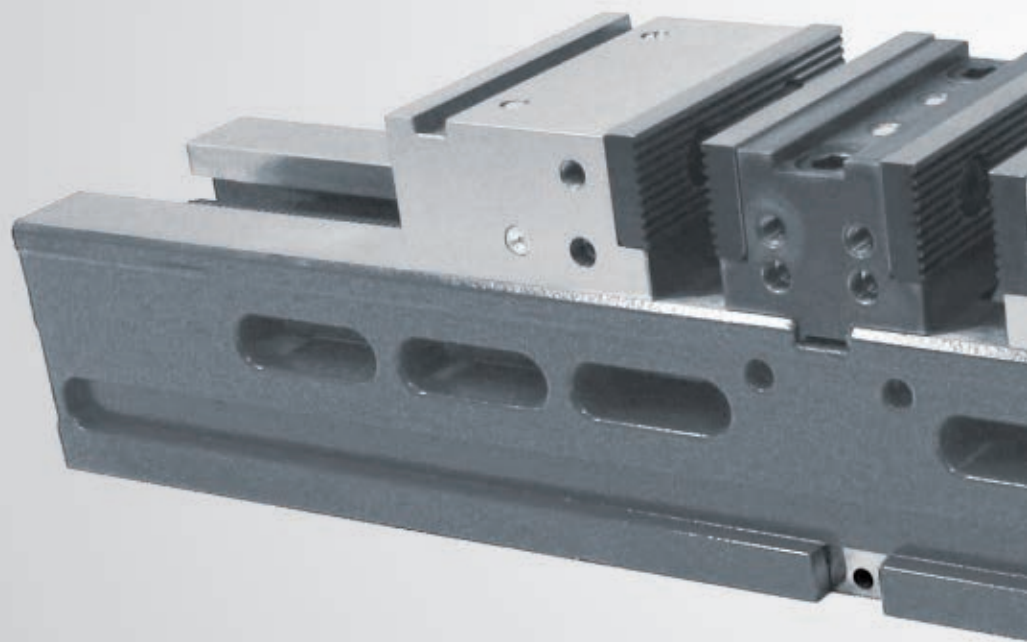
ZUBEHÖR

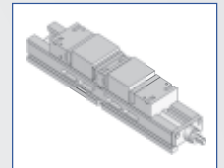
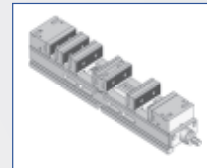
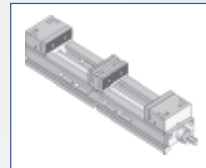
AUTOMATION

HWS

TECHNICAL CHANGES RESERVED

DSS-M DUAL VICE





DSS-M DOUBLE VICE IN MECHANICAL MODEL

DSS-M

DSS-M DOUBLE VICE

MODEL

The double vice simultaneously applies clamping force from two sides against the center jaw.
The support of the spindle can be used to initially clamp the first workpiece (secure positioning against the workpiece stop).

During subsequent clamping operations, both clamping stations must be occupied.

Workpiece dimensions may differ by ± 2 mm (i.e. compensation by the spindle bearing)

- ▶ Main body and jaws made of case-hardened steel, hardened on all sides
- ▶ Spindle made of high-strength special steel
- ▶ One-piece clamping slide and spindle nut
- ▶ same tension on both tie points
- ▶ Clamping slide with central lubrication (with the exception of size 65)
- ▶ Lateral grooves for quick positioning
- ▶ three positioning holes $\varnothing 12F7$ for 40 mm and 50 mm divisions
- ▶ Center jaw is fixed on all levels (x, y, z)
- ▶ Grooves and installation thread to accommodate false jaws and
- ▶ and grip bars (with the exception of size 65, optionally available on the DSS 80 for the center jaw)
- ▶ Using pull-down quick change jaws available for size 125 mm
- ▶ Use of rhombic T-shaped tenon blocks as well as change slides for multiple clamps is possible
→ No tools required for assembly
- ▶ side threads for workpiece stops
- ▶ Excellent chip and coolant discharge

REPEATING ACCURACY

REPEATING ACCURACY

- ▶ The preselected clamping forces achieve a repeat accuracy for the workpiece position of ≤ 0.01 mm
- ▶ The use of a torque wrench is recommended to achieve controlled and reproducible clamping forces

STANDARD EQUIPMENT

STANDARD EQUIPMENT

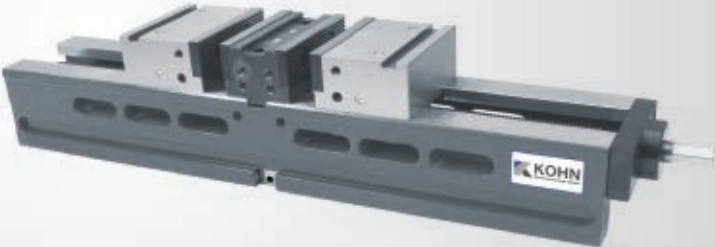
- ▶ 1 pcs. hand crank hexagonal
- ▶ for jaw widths of 65, 80, 100 mm
- ▶ 4 pcs. screw-in jaws, longitudinally knurled
- ▶ for a jaw width of 125 mm
- ▶ 2 pcs. reversible screw-in jaws (1 side knurled, 1 side smooth)
- ▶ 2 pcs. screw-in jaws, longitudinally knurled

OPTIONS

OPTIONS

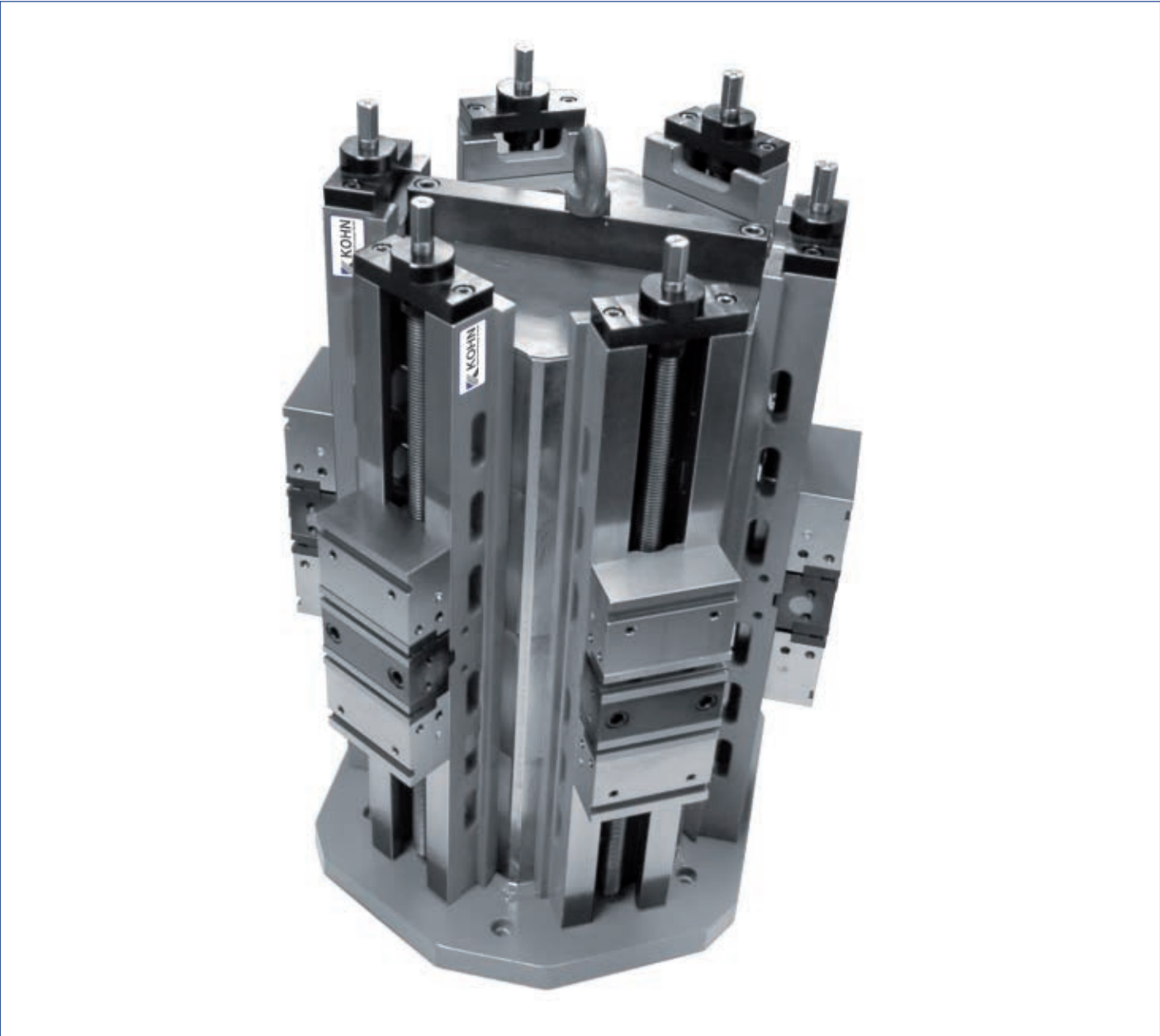
- ▶ Drilling pattern and location of the transverse groove (such as zero-point clamping system)
- ▶ Longitudinal groove
- ▶ Bed length up to 1200 mm
- ▶ laterally tiltable
- ▶ vertical clamping of the vice

Doubled efficiency



DSS as a special solution

DSS to 6-fold clamping body

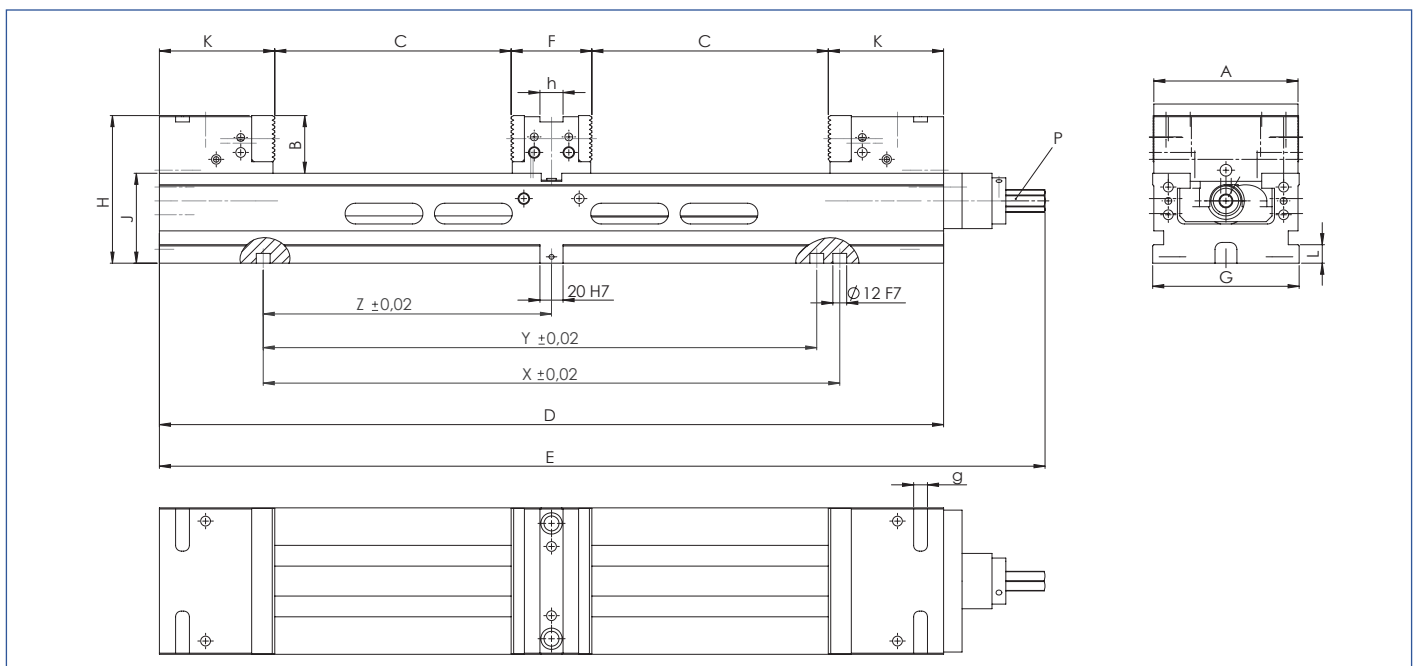


NCS
ESS
DSS
KORNA RASANT
MULTI - MFS
ZSS
ZUBEHÖR
AUTOMATION
HWS

TECHNICAL CHANGES RESERVED

DSS-M DOUBLE VICE AS MECHANICAL MODEL

Type	DSS-M															
Jaw width	A	65			80				100				125			
Order No.		02211	02212	02213	02311	02312	02313	02314	02411	02412	02413	02414	02511	02512	02513	02514
Clamping depth	B	25			32				44				50			
Span	C	74	99	124	76	96	116	136	115	140	165	190	145	175	205	235
Bed length	D	300	350	400	340	380	420	460	450	500	550	600	560	620	680	740
Overall length	E	360	410	460	410	450	490	530	530	580	630	680	650	710	770	830
Fixed jaw	F±0,02	40			50				50				70			
Base width	G	78			84				104				127			
Overall height	H	63			100				122				128			
Base width	J h7	38			68				78				78			
Overall height	K	55,5			63,5				80				100			
	L	10			12				14				16			
Hexagon	P	10			12				14				17			
	X	200	200	300	200	300	300	300	300	400	400	400	400	500	500	500
	Y	-	-	280	-	280	280	280	280	-	-	-	-	480	480	480
	Z	100	100	150	100	150	150	150	150	200	200	200	200	250	250	250
	g	-			10				10				12			
	h	-			20				20				20			
Clamping force	kN/Nm	10/50			15/70				20/130				30/180			
Weight	kg	6,3	6,5	6,7	18	19	20	21	31	32	33	34	48	51	53	55



Dimensions in mm

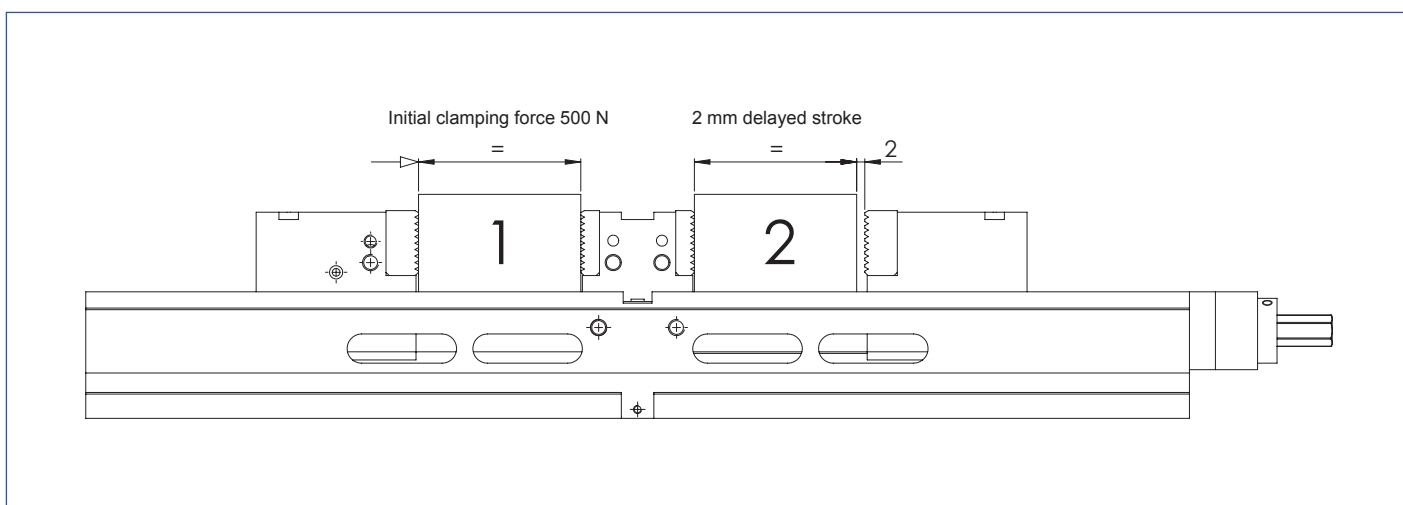
TECHNICAL CHANGES RESERVED



Safe clamping

DSS-M

The delayed stroke favors fixed clamping when it is used on vertical situations

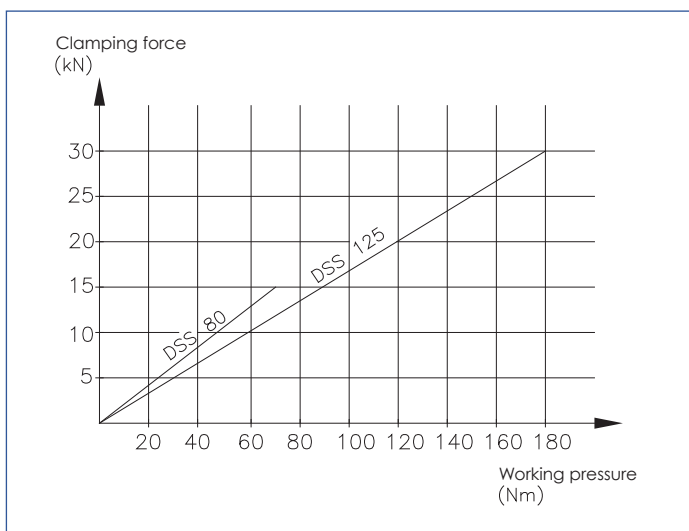


Workpiece 1: clamped with an initial force of 500 N

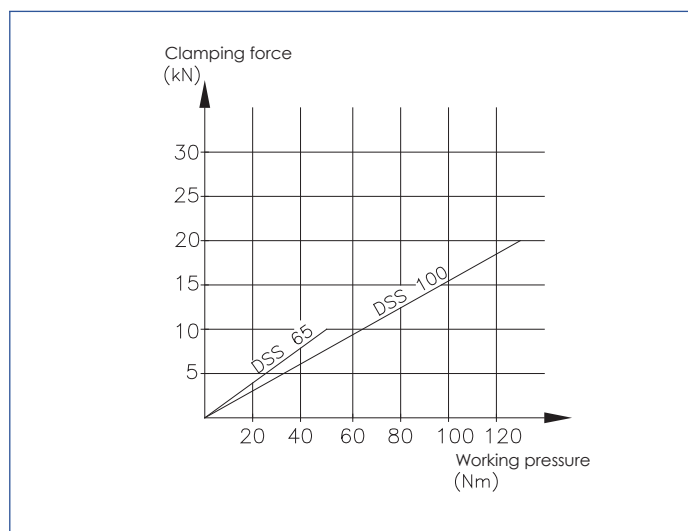
Workpiece 2: has not been clamped by the jaws and can be positioned

Clamping force diagrams

DSS 80 M, DSS 125 M



DSS 65 M, DSS 100 M



TECHNICAL CHANGES RESERVED

MACHINE VICE KORNA RASANT

KORNA RASANT

DESCRIPTION KORNA RASANT

- ▶ Jaw width 80 mm
- ▶ 2-stage clamping range 0-62 / 60 - 120 mm
- ▶ max. Span of 255 mm by using top step jaws
- ▶ Clamping force at 7 bar 1400 daN
- ▶ 4 mm clamping stroke
- ▶ Body and jaws of hardened steel, hardened on all sides
- ▶ precise regulation of clamping force of compressed air
- ▶ Longitudinal and transverse grooves for quick positioning on the machine table
- ▶ rapid opening and closing the cocking slide
- ▶ high clamping and repeatability
- ▶ exactly been preserved dimensions allow the use of multiple clamps
- ▶ closed hydraulic system through check valve refillable

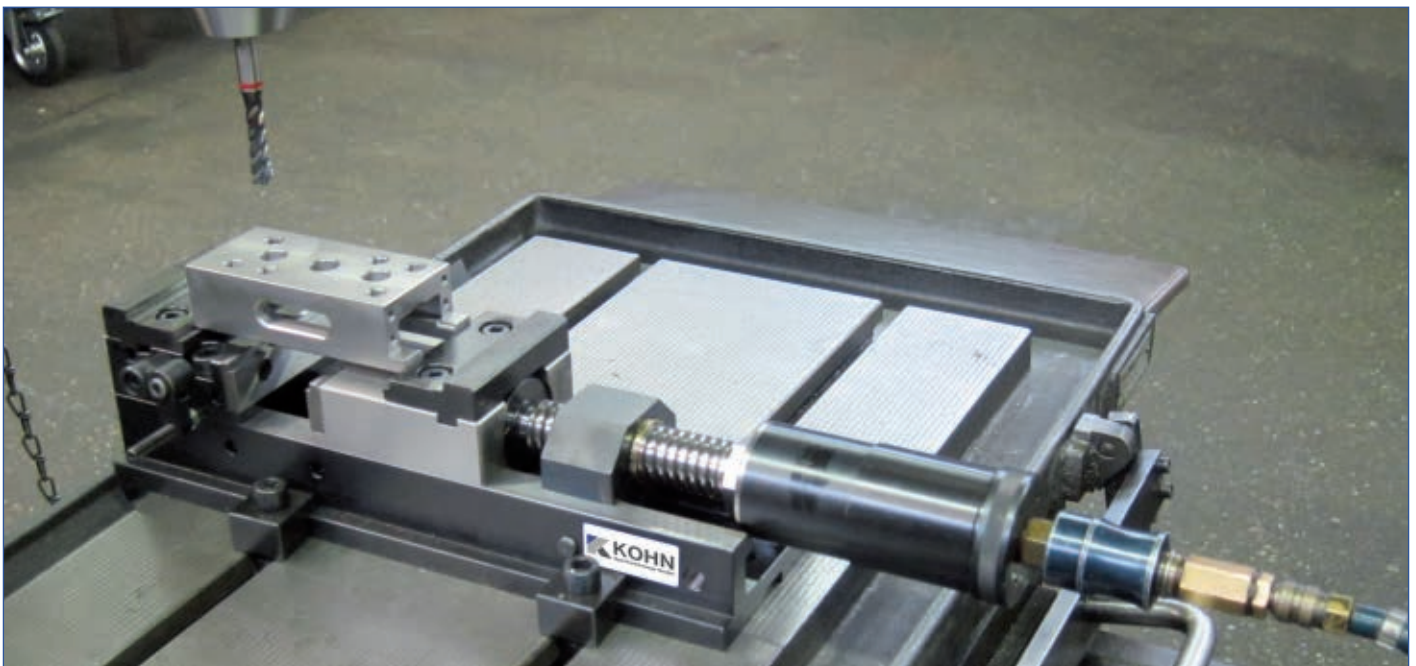
Korna Rasant is particularly suitable:

- ▶ for the mass production of drills
- ▶ for the single and serial production of lightweight milling
- ▶ as building blocks for the automation of all conventional control valves

DESCRIPTION

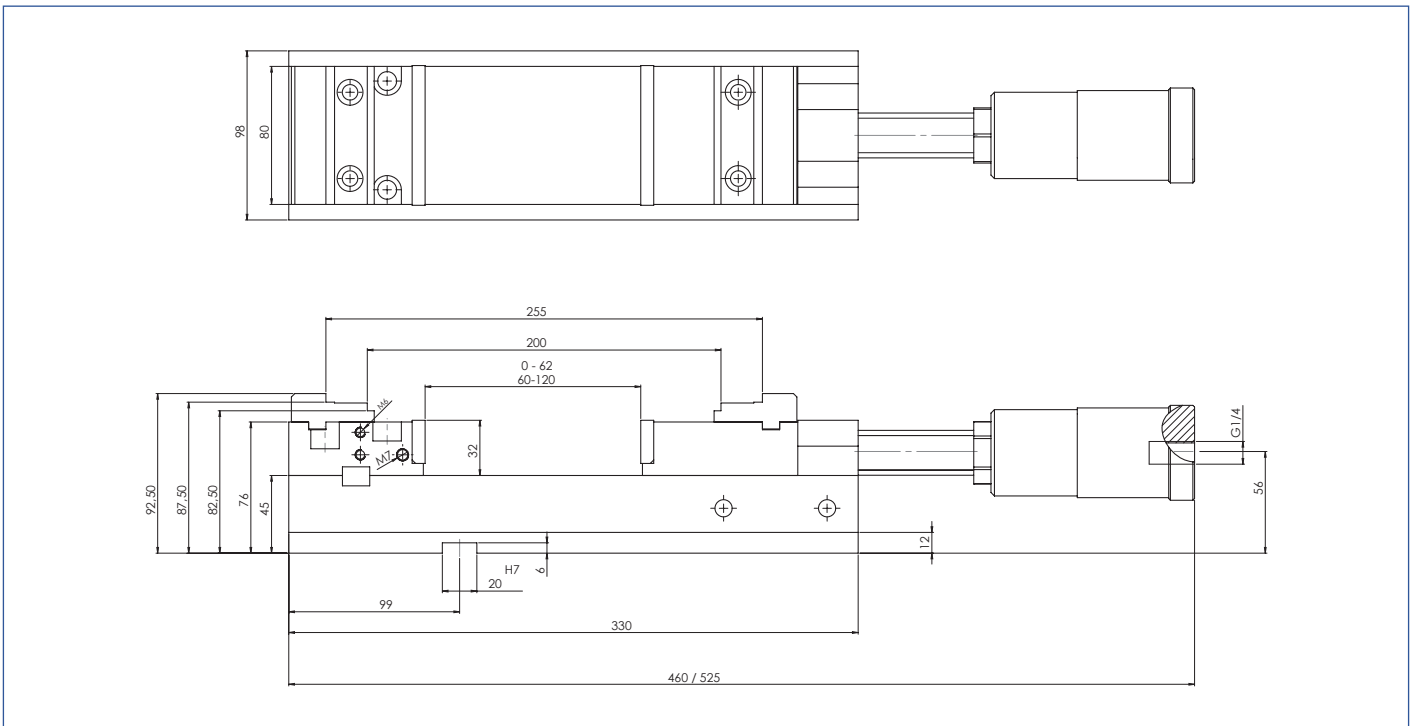
Basic equipment: 2 pcs screw-on, serrated lengthwise, longitudinal and transverse slots 20 H7

Accessories Pages 66-75, size 80



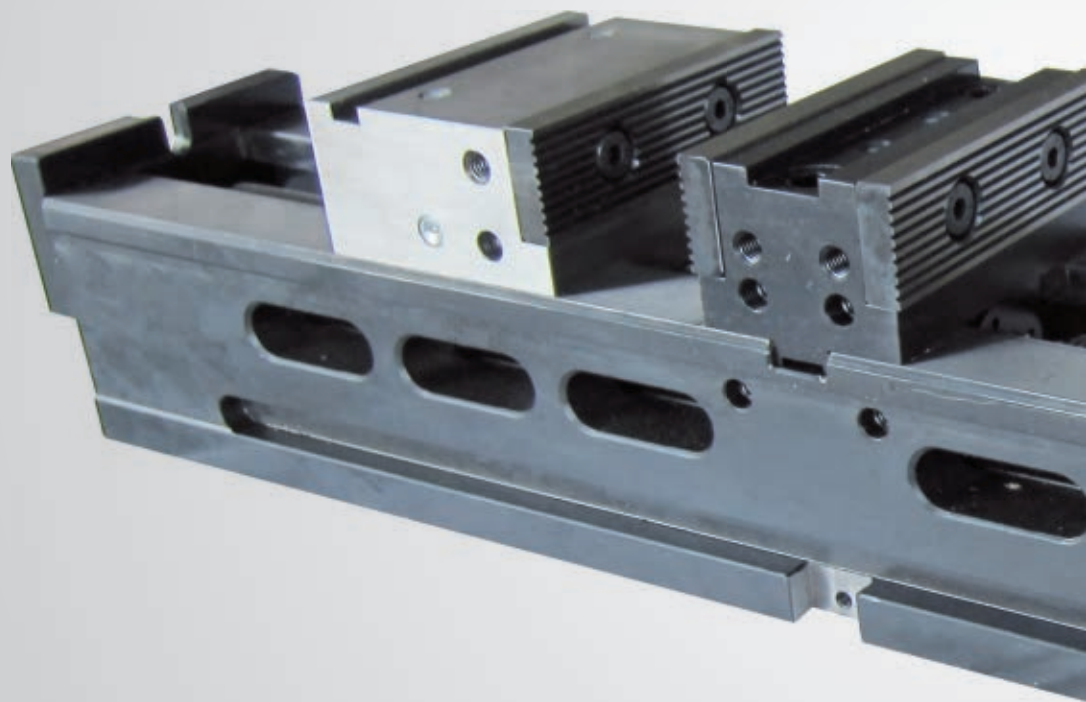
KORNA RASANT REDUCES TO A MINIMUM CLAMPING TIMES

Technical drawing

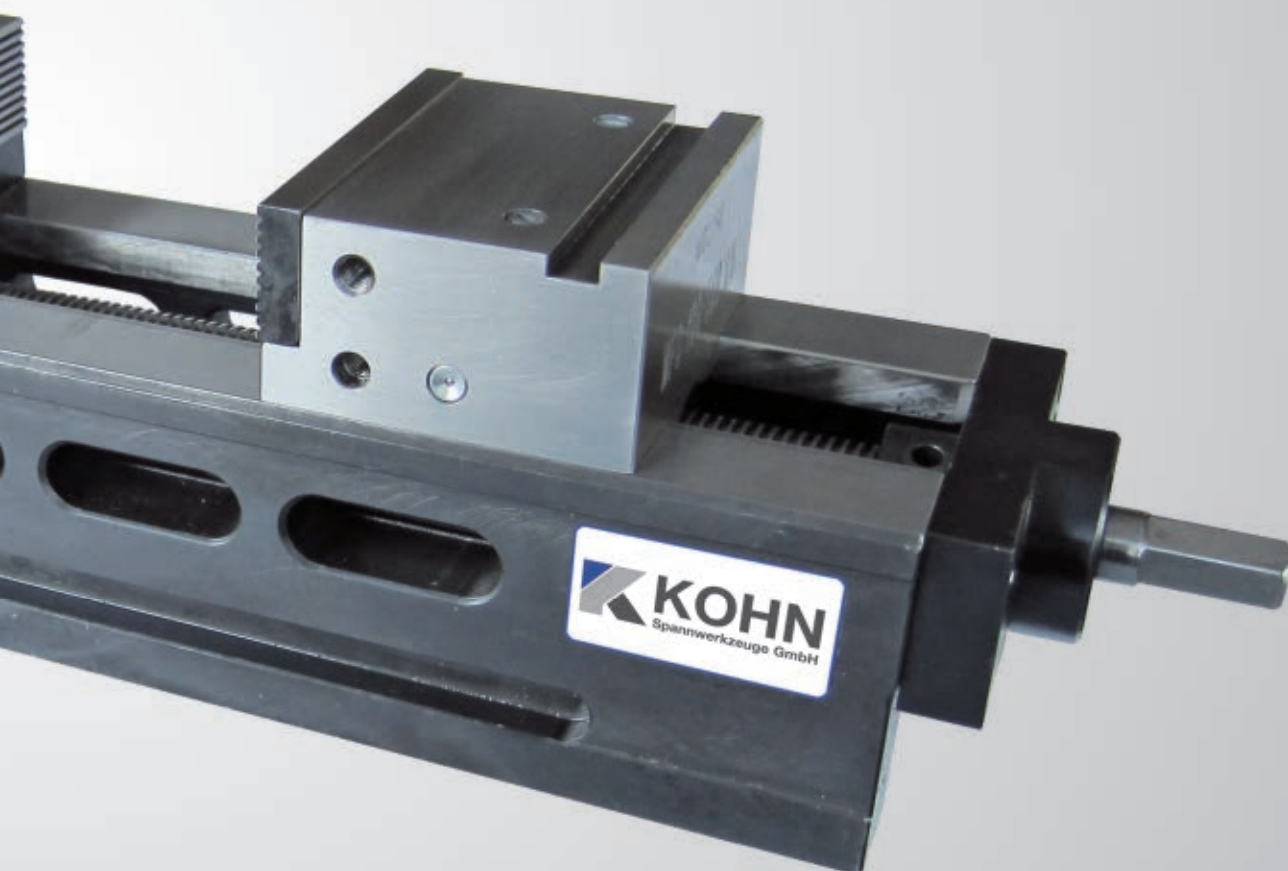


TECHNICAL CHANGES RESERVED

MULTI-VICE MFS



We create tension



MULTI-VICE MFS

AS MECHANICAL MODEL (MK) AND AS FULLY HYDRAULIC (HD) VERSION

MFS-MK and MFS-HD

MODEL

MFS-MK AND MFS-HD

The „MULTI among the vices“ is a sophisticated extension of our standard series DSS (double vice) and ESS (single vice)

- ▶ enables multifunctional use
- ▶ Accepts differently sized workpieces (asymmetric clamping ranges, two independent spindles)
- ▶ rapid changeover to accept different sizes of workpieces
- ▶ Identical clamping force at both clamping points
- ▶ Clamping operation from one side
- ▶ Main body and jaws made of case-hardened steel, hardened on all sides
- ▶ Spindle made of high-strength special steel
- ▶ One-piece clamping slide and spindle nut
- ▶ Clamping slide with central lubrication
- ▶ Lateral grooves for quick positioning
- ▶ three positioning holes \varnothing 12F7 for 40 mm and 50 mm divisions
- ▶ Center jaw is fixed on all levels (x, y, z)
- ▶ Grooves and installation thread to accommodate **top step jaws** and grip bars
- ▶ Use of pull-down quick-change jaws possible for the sizes 125 mm and 160 mm
- ▶ Use of rhombic T-shaped tenon blocks as well as change slides for multiple clamps is possible
 - No tools required for assembly
- ▶ side threads for workpiece stops
- ▶ Excellent chip and coolant discharge

MFS-MK

- ▶ mechanical operation
- ▶ Span adjustment by means of cam-plate locking

MFS-HD

- ▶ Fully hydraulic operation (HD-unit required)
- ▶ Reverse stroke by means of pneumatic cushion (no permanent connection required)

REPEATING ACCURACY

REPEATING ACCURACY

- ▶ The preselected clamping forces achieve a repeat accuracy for the workpiece position of ≤ 0.01 mm
- ▶ The use of a torque wrench is recommended to achieve controlled and reproducible clamping forces (MFS-MK)
- ▶ On the NCS 125 HD the clamping force is adjusted by means of the hydraulic pressure that can be adjusted on the * hydraulic unit



*Multi-talented all-rounder
among the vices*

MFS-MK and MFS-HD

STANDARD EQUIPMENT MFS-MK

MFS 100 MK:

- ▶ 4 pcs. screw-in jaws, longitudinally knurled
- ▶ 1 pcs. hand crank, 1 pcs. handrail, 1 pcs. spacing plate with 2 pcs locking screws

MFS 125 MK:

- ▶ 2 pcs. reversible screw-in jaws (1 side knurled, 1 side smooth)
- ▶ 2 pcs. screw-in jaws, longitudinally knurled
- ▶ 1 pcs. hand crank, 1 pcs. handrail, 1 pcs. spacing plate with 2 pcs locking screws

STANDARD

STANDARD EQUIPMENT MFS-HD

MFS 80/100 HD:

- ▶ 4 pcs. screw-in jaws, longitudinally knurled
- ▶ 1 pcs. spacing plate with setscrew, 1 pcs. hand crank
- ▶ 1 pcs. ball valve

MFS 125 HD:

- ▶ 2 pcs. reversible screw-in jaws
- ▶ 2 pcs. screw-in jaws, longitudinally knurled
- ▶ 1 pcs. spacing plate with setscrew, 1 pcs. hand crank
- ▶ 1 pcs. ball valve

STANDARD

OPTIONS

- ▶ Drilling pattern and location of the transverse groove in the bottom part (such as zero-point clamping system)
- ▶ Longitudinal groove
- ▶ Bed length up to 1200 mm possible
- ▶ laterally tiltable
- ▶ vertical clamping of the vice

OPTIONS

NCS

ESS

DSS

KORNA RASANT

MULTI - MFS

ZSS

ZUBEHÖR

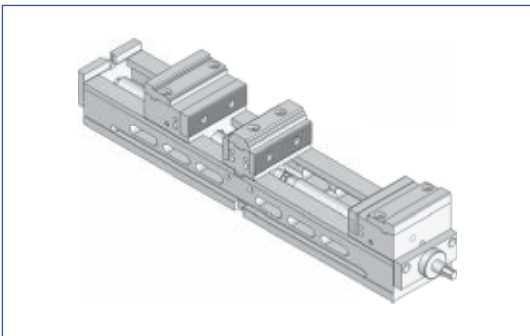
AUTOMATION

HWS

TECHNICAL CHANGES RESERVED

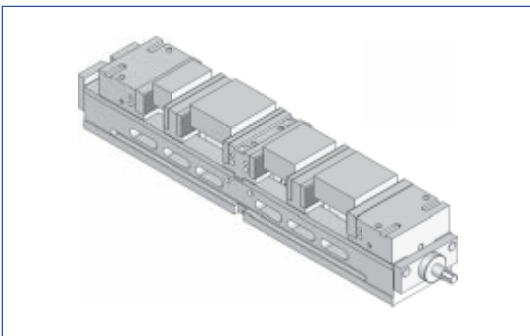
MFS-MK and MFS-HD

Operation as DOUBLE VICE



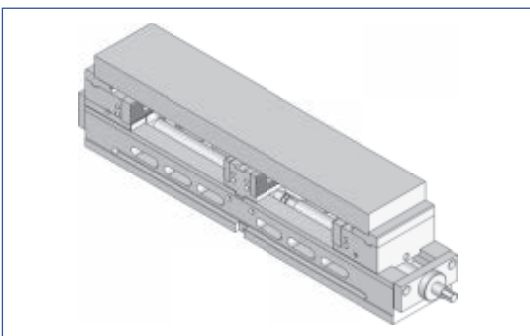
- ▶ simple and extremely rapid movement of the clamping slide allows clamping of the similarly sized and different sized workpieces
- ▶ Clamping slides may be moved together or individually to adjust the clamping range

Operation as MULTI-CLAMP



- ▶ Rapid installation of changeover sliders enable more work pieces to be clamped
- ▶ No tools required for assembly

Operation as SINGLE-CLAMP

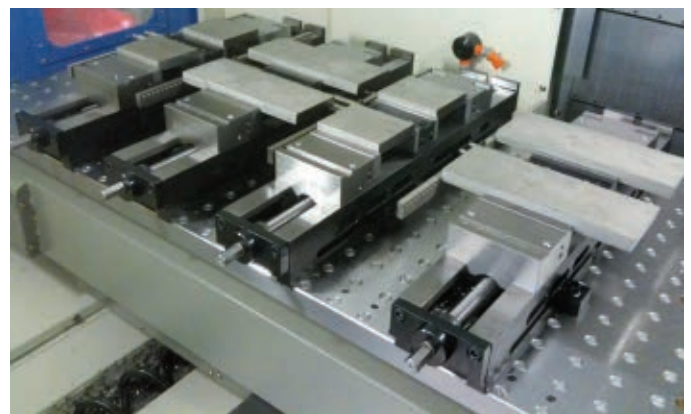
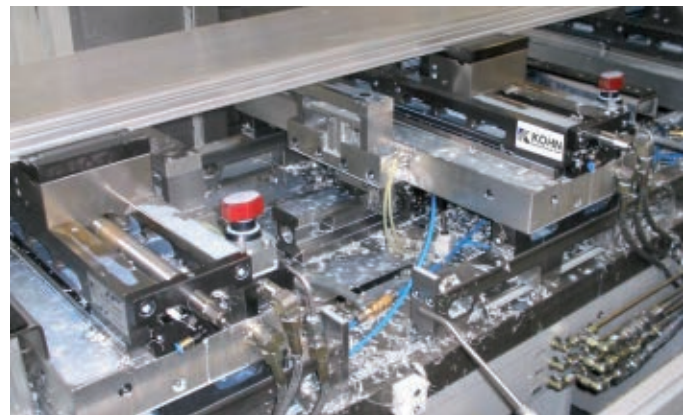
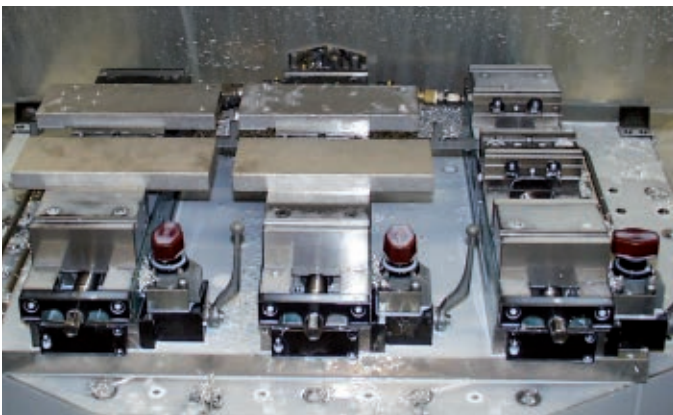
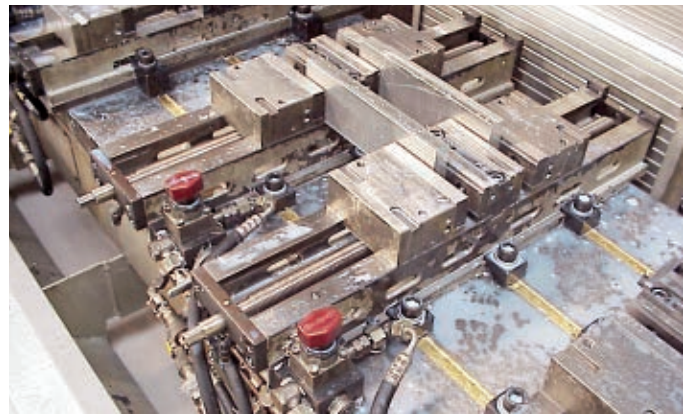
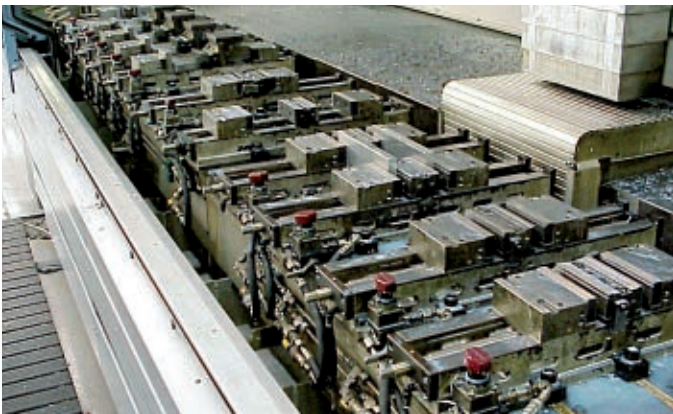


- ▶ Divided into three different sized clamping ranges
- ▶ after removal of the center jaw, the rear clamping slide serves as a fixed jaw
- ▶ by attaching false step-jaws to the fixed jaw and the movable clamping slide, large or long workpieces (e.g., plates, strips, ...) may be clamped



*unbeatable
multi- and economically*

MFS as special-purpose solution



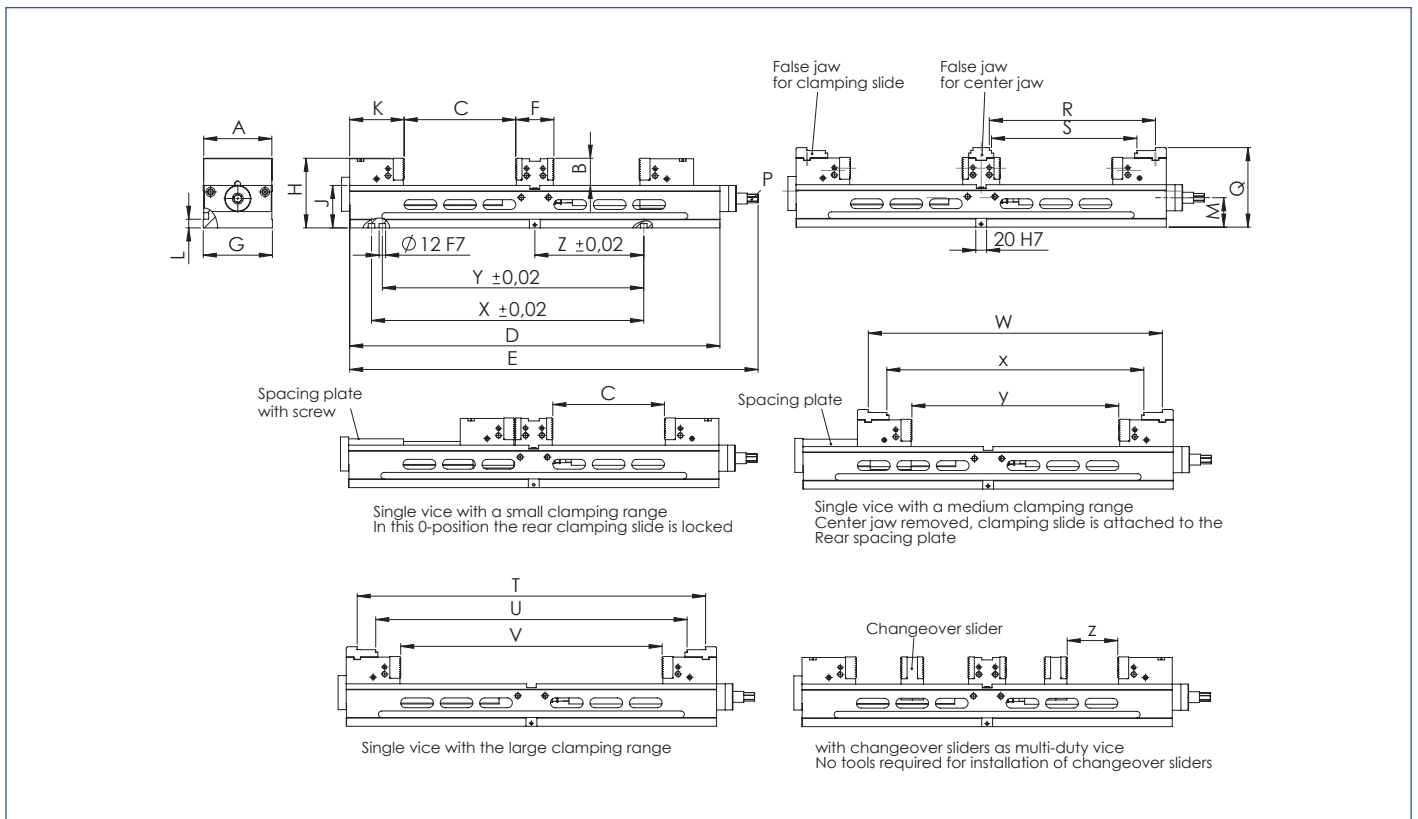
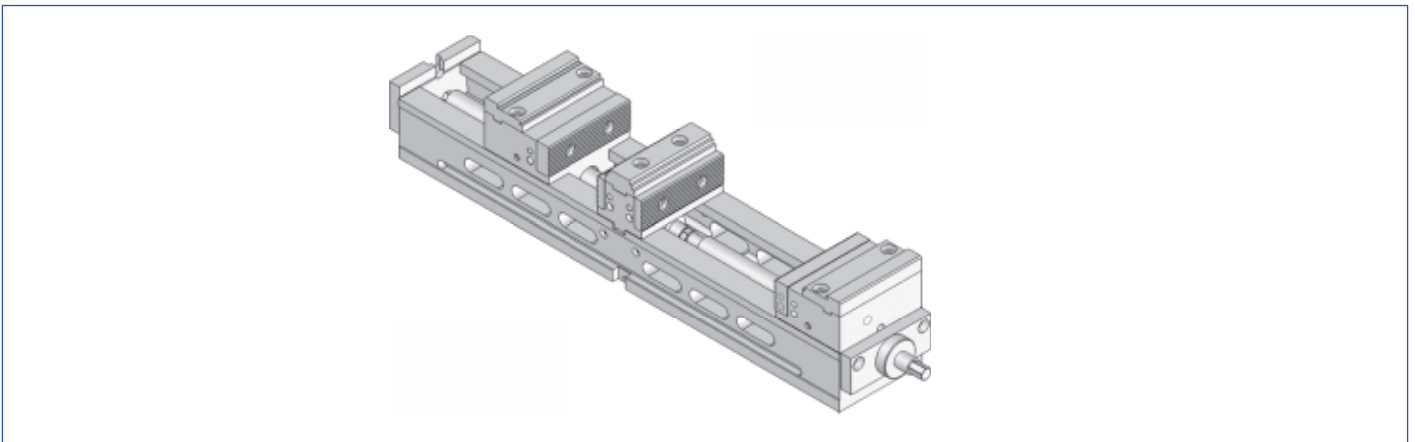
- NCS
- ESS
- DSS
- KORNA RASANT
- MULTI - MFS**
- ZSS
- ZUBEHÖR
- AUTOMATION
- HWS

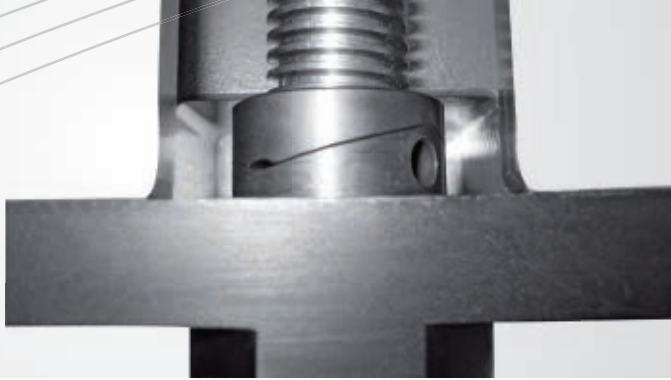
TECHNICAL CHANGES RESERVED

MULTI-VICE MFS-MK AS MECHANICAL MODEL

MFS-MK

Image of the MFS-MK





Easy conversion by
disk cam

Type	MFS-MK									
Jaw width	A	100				125				
Order No.		08481	08482	08483	08484	08580	08581	08582	08583	08584
Clamping depth	B	44				50				
Bed length	D	450	500	550	600	500	560	620	680	740
Overall length	E	535	585	635	685	564	645	705	765	825
Fixed jaw	F±0.02	60				70				
Total width	G	104				126				
Overall height	H	122				128				
Bed height	Jh6	78				78				
Clamping slide	K	80				100				
Metal clamping flange	L	14				16				
Hexagonal connection SW	P	14				17				
	Q	137,5				146				
	X	300	300	400	400	400	400	500	500	500
	Y	280	280	-	-	-	-	480	480	480
	Z	150	150	200	200	200	200	250	250	250
Span	C	0-113	0-138	0-163	0-188	0-113	0-143	0-173	0-203	0-233
Span	R	84-195	84-220	84-245	84-270	102-213	102-243	102-273	102-303	102-333
Span	S	52-163	52-188	52-213	52-238	64-175	64-205	64-235	64-265	64-295
Span	T	416	466	516	566	458	518	578	638	698
Span	U	249-360	274-410	299-460	324-510	279-390	309-450	339-510	369-570	399-630
Span	V	177-288	202-338	227-388	252-438	187-298	217-358	247-418	277-478	307-538
	W	316	366	416	466	358	418	478	538	598
	x	149-260	174-310	199-360	224-410	179-290	209-350	239-410	269-470	299-530
	y	77-188	102-238	127-288	152-338	87-198	117-258	147-318	177-378	207-438
	z	0-39	0-51	0-64	0-76	0-36	0-51	0-66	0-81	0-96
Weight	kg	31	32	33	34	46	48	51	53	55
Clamping force	kN/Nm	20/72				35/120				

Note: See chapter accessories for Jaw connecting dimensions

MFS-MK

The operation of the vice is a purely mechanical.

This vice has two spindles that are decoupled by cam-plate locking, meaning that the clamping range may be **convenient** adjusted forward and back separately from the operating side.

TECHNICAL SPECIFICATIONS

Dimensions in mm

TECHNICAL CHANGES RESERVED

MULTI-VICE MFS-HD
FULLY HYDRAULIC MODEL

MFS-HD

Image of the MFS-HD

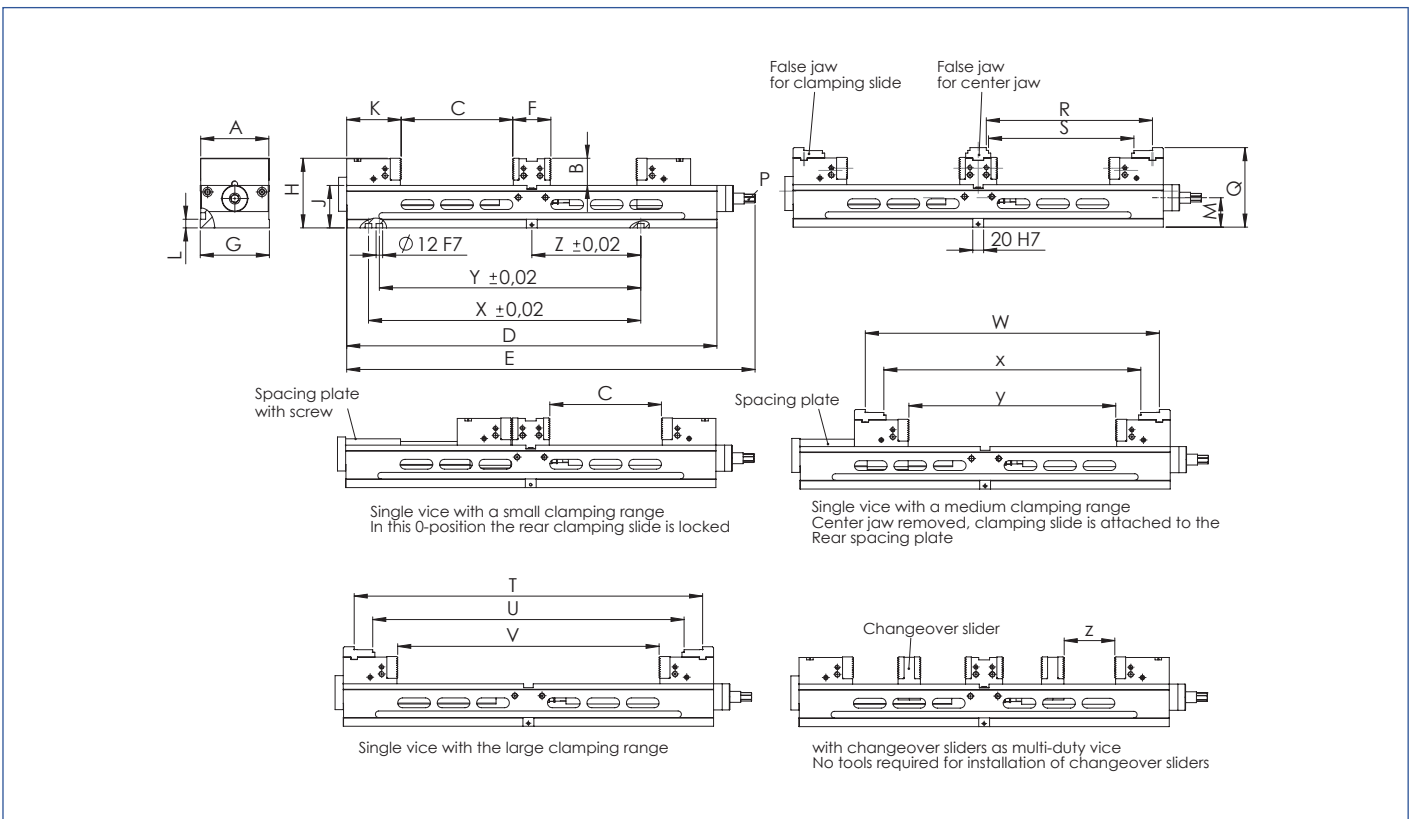
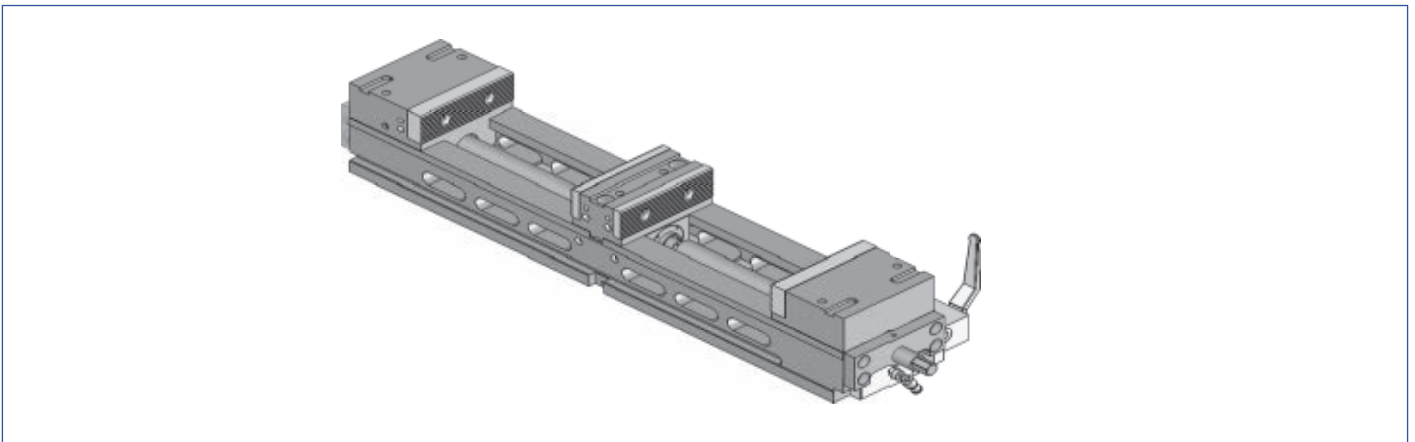
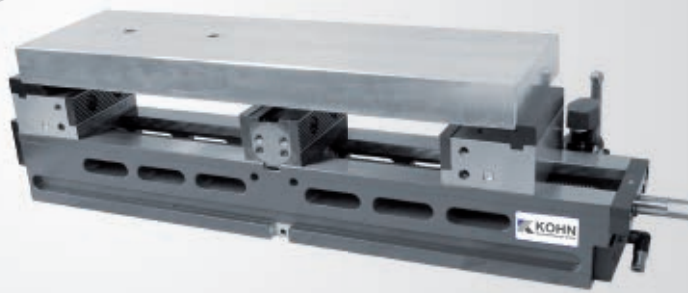


Image of the MFS-HD

TECHNICAL CHANGES RESERVED



Rapid and fully hydraulic
tool change and clamping

Type	MFS-HD											
	A	80		100				125				160
Order No.		08333	08334	08431	08432	08433	08434	08531	08532	08533	08534	08631
Clamping depth	B	32		44				50				54
Bed length	D	420	460	450	500	550	600	560	620	680	740	750
Overall length	E	504	544	535	585	635	685	645	705	765	825	764
Fixed jaw	F±0.02	60		60				70				90
Total width	G	84		104				127				161
Overall height	H	100		122				128				144
Bed height	Jh7	68		78				78				90
Clamping slide	K	63.5		80				100				126
Metal clamping flange	L	12		14				16				16
Hexagonal connection SW	P	12		14				14				19
	Q	115.5		137.5				146				167
	X	300	300	300	300	400	400	300	400	500	500	500
	Y	280	280	280	280	-	-	280	-	480	480	480
	Z	150	150	150	150	200	200	150	200	250	250	250
Span	C	0-116	0-136	0-113	0-138	0-163	0-188	0-143	0-173	0-203	0-233	0-204
Span	R	69-185	69-205	84-195	84-220	84-245	84-270	102-243	102-273	102-303	102-333	125-329
Span	S	37-153	37-173	52-163	52-188	52-213	52-238	64-205	64-235	64-265	64-295	85-289
Span	T	388	428	416	466	516	566	518	578	638	698	698
Span	U	175-332	215-372	249-360	274-410	299-460	324-510	309-450	339-510	369-570	399-630	220-628
Span	V	136-293	197-333	177-288	202-338	277-388	252-438	217-358	247-418	277-478	307-538	294-498
Span	W	211-328	232-368	316	366	416	466	418	478	538	598	394-598
Span	x	155-272	176-312	149-260	174-310	199-360	224-410	209-350	239-410	269-470	299-530	324-528
Span	y	116-233	137-273	77-188	102-238	127-288	152-338	117-258	147-318	177-378	207-438	194-398
Span	z	0-43	0-53	0-39	0-51	0-64	0-76	0-51	0-66	0-81	0-96	-
Weight	kg	20	21	31	32	33	34	48	51	53	55	83
Clamping force	kN bar	15 380		20 380				30 380				60 400

Additional bed lengths (D) upon request

TECHNICAL SPECIFICATIONS

MFS-HD

The operation of the vice requires a hydraulic pump or a pressure booster delivering a pressure of up to 400 bar. The maximum operating pressure of the vice is 380 bar. The clamping force is adjusted via the hydraulic pressure. The return stroke is produced by an air cushion that can be filled by way of a valve. No permanent connection necessary, but this is possible.

We also offer customer specific solutions.

The entire clamping system is designed to suit particular requirements.

It will be clarified in advance all the questions such as:

- ▶ Control and monitoring of the vices (operation on electric push button, foot switch, Hand-way poppet valve or M-function of the machine)
- ▶ Interpretation of the hydraulic unit with control cabinet according to their assigned tasks (Aggregate in a simple, 1-pass or multi-circuit design)
- ▶ Clamping and release of one or several vices individually and / or jointly, ...

COMPLETE SOLUTIONS

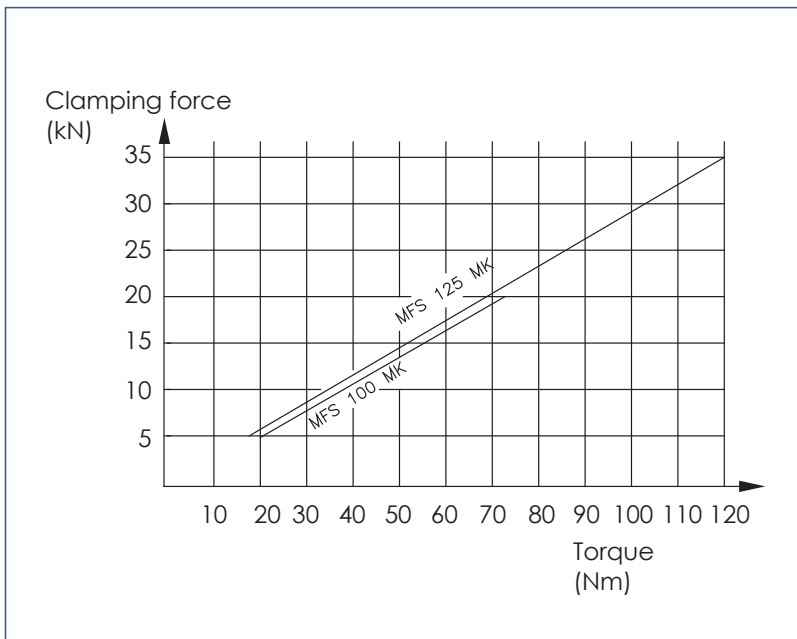
Dimensions in mm

TECHNICAL CHANGES RESERVED

MULTI-VICE MFS AS MECHANICAL (MK) AND FULLY HYDRAULIC (HD) VERSION

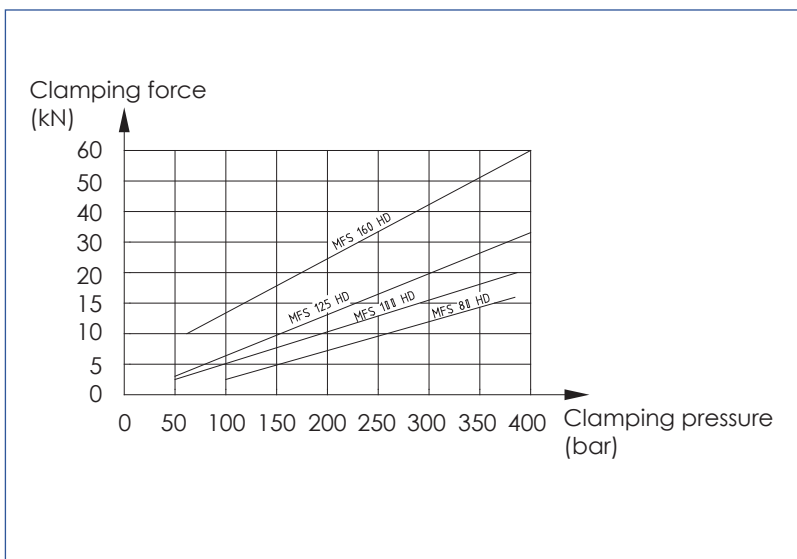
Clamping force diagrams

MFS-MK

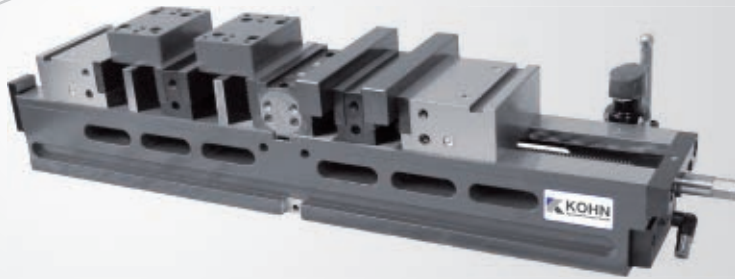


Clamping force diagram MK

MFS-HD



Clamping force diagram HD

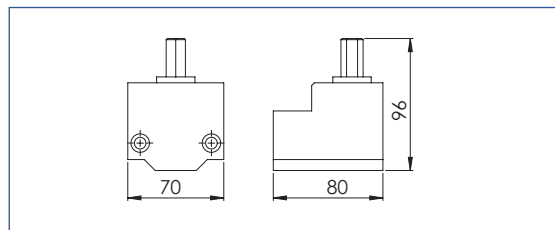
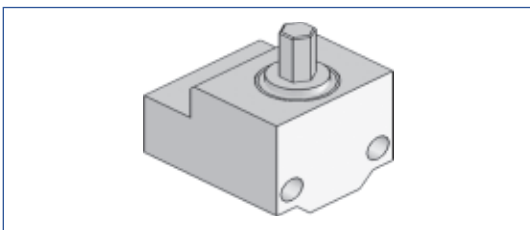


Flexibility like no other unit

MULTI-VICE MFS FULLY HYDRAULIC (HD) VERSION

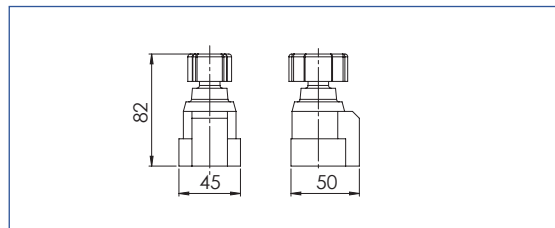
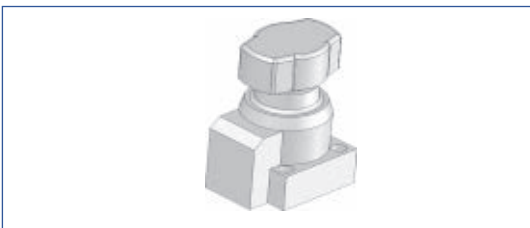
HD-accessories

Angle drive



Order No.	for type
08330800	MFS 80 HD
08430800	MFS 100 HD
08530800	MFS 125 HD

Hand-seat valve



Order No.	for type
10054050	D 3-1 R
10054053	VP 1 Z

Mechanical operation directly on the vice. The design of the hand-seat valve matches the application

Special combination wrench (ratchet)



Order No.	for type	SW
08330013	MFS 80	SW9
08430013	MFS 100	SW10
08530013	MFS 125	SW14

- ▶ Hydraulic unit with switchboard
- ▶ HD threaded joints
- ▶ HD hoses
- ▶ quick-disconnect connectors, etc. available upon request

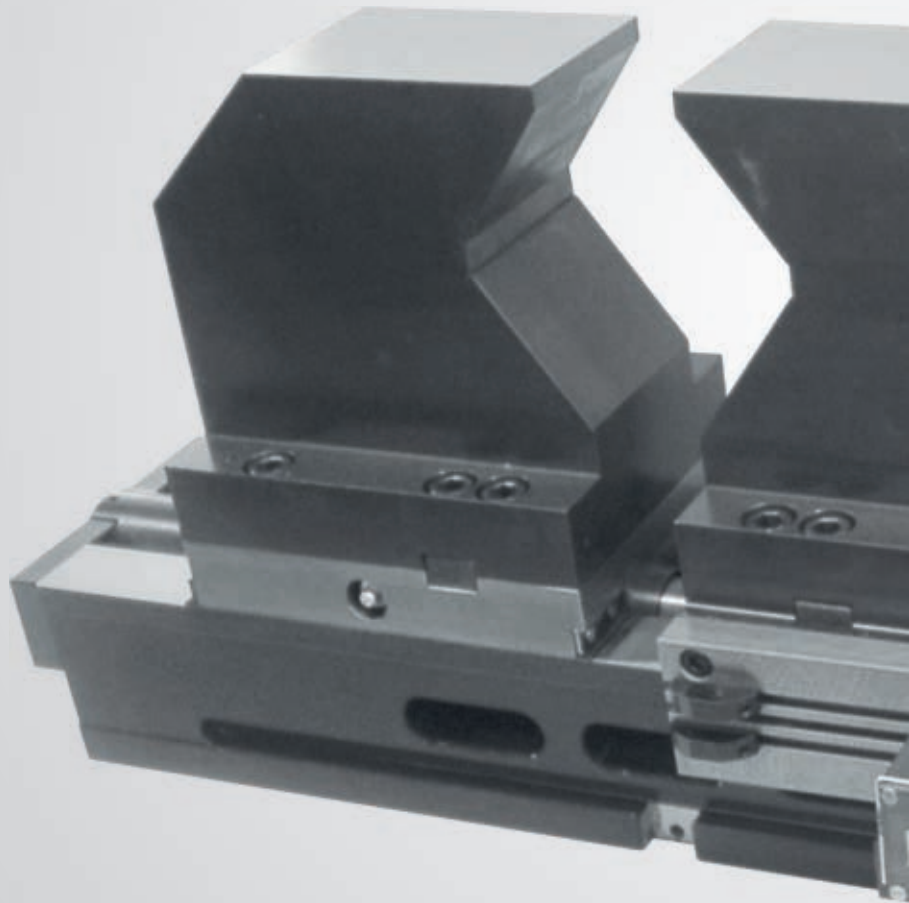


For additional accessories see pages 66-75

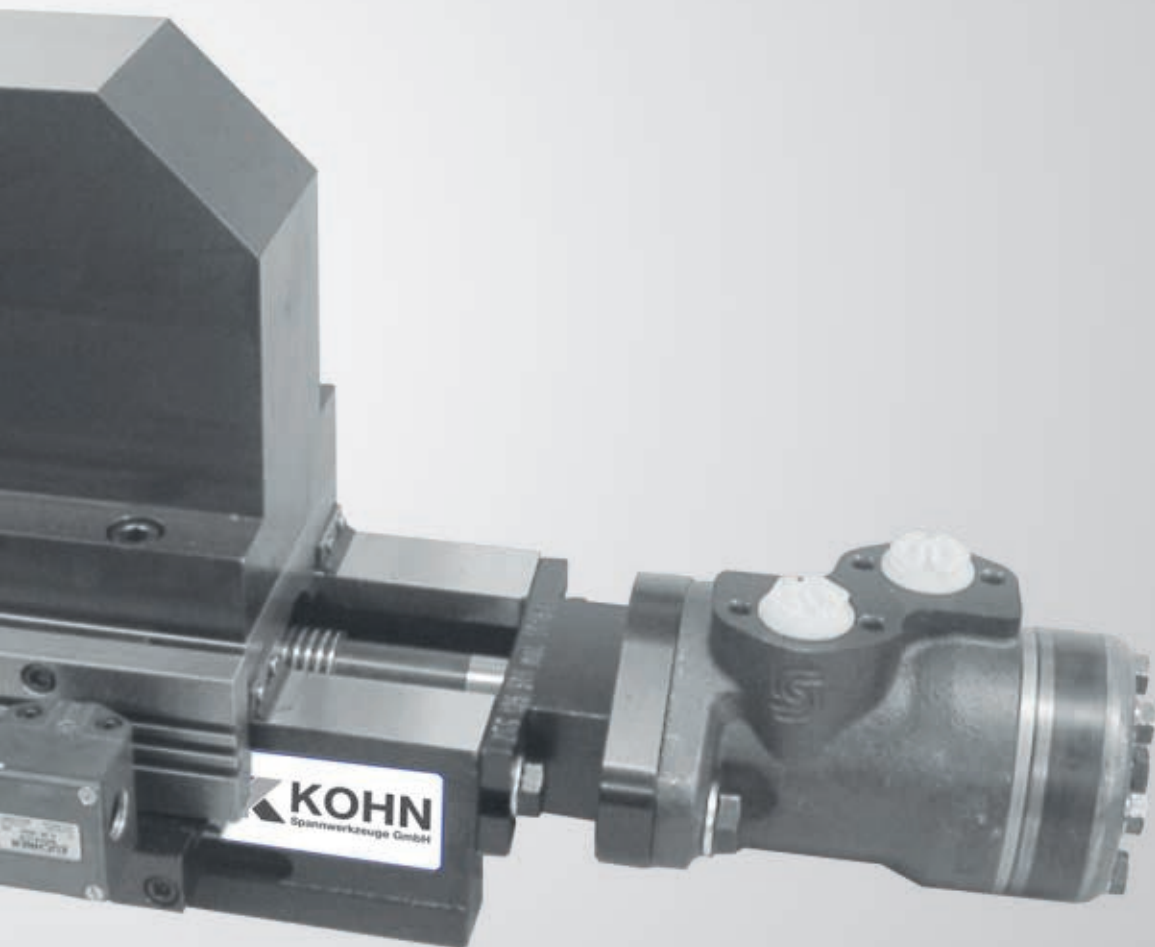
Dimensions in mm

TECHNICAL CHANGES RESERVED

SELF-CENTERING VICE ZSS



We create tension



SELF-CENTERING VICE ZSS MECHANICAL MODEL (M) WITH MOTOR (MOT.)

ZSS

ZSS-M AND ZSS-MOT.

- ▶ Main body and jaws made of case-hardened steel, hardened and ground on all sides
- ▶ Spindle hardened and ground
- ▶ One-piece clamping slide and spindle nut
- ▶ Clamping slide and spindle with central lubrication
- ▶ Lateral grooves for quick positioning
- ▶ three positioning holes $\varnothing 12F7$ for 40 mm and 50 mm divisions
- ▶ Fixed jaw is fixed on all levels (x, y, z)
- ▶ Grooves and installation thread to accommodate false jaws
- ▶ Reversible jaws provide for a large clamping range
- ▶ side threads for workpiece stops
- ▶ Excellent chip and coolant discharge

PRODUCT FEATURES

CENTERING ACCURACY

- ▶ With the same clamping range ± 0.015 mm
- ▶ For the entire clamping range within ± 0.02 mm
- ▶ The use of a torque wrench is recommended to achieve controlled and reproducible clamping forces

CENTERING ACCURACY

STANDARD EQUIPMENT

- ▶ 2 pcs. standard prismatic jaws
- ▶ 1 pcs. hand crank hexagonal

STANDARD EQUIPMENT

OPTIONS

- ▶ Special jaws on request
- ▶ Drilling pattern in the bottom part according to customer requirements (such as zero-point clamping system)
- ▶ Alignment of the center of the workpiece center with respect to the positioning groove $20H7 \pm 0.02$ mm
- ▶ Alignment of two vices to achieve the same center point ± 0.02 mm
- ▶ Longitudinal groove 20H7
- ▶ Powered by a hydraulic motor (Hydraulic unit required)

OPTIONS

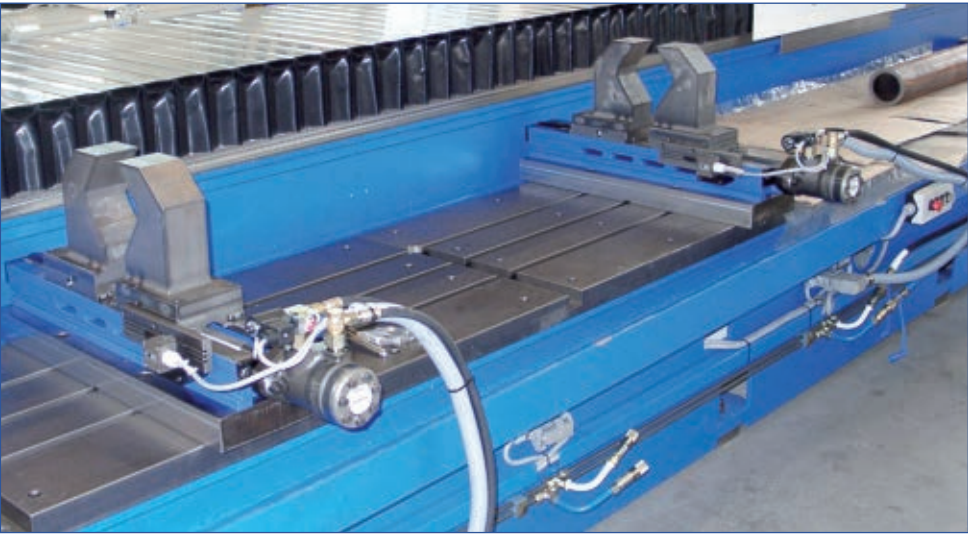
*strongly in
Special solutions*



ZSS as special-purpose solution



ZSS in mechanical design



ZSS hydraulic motor



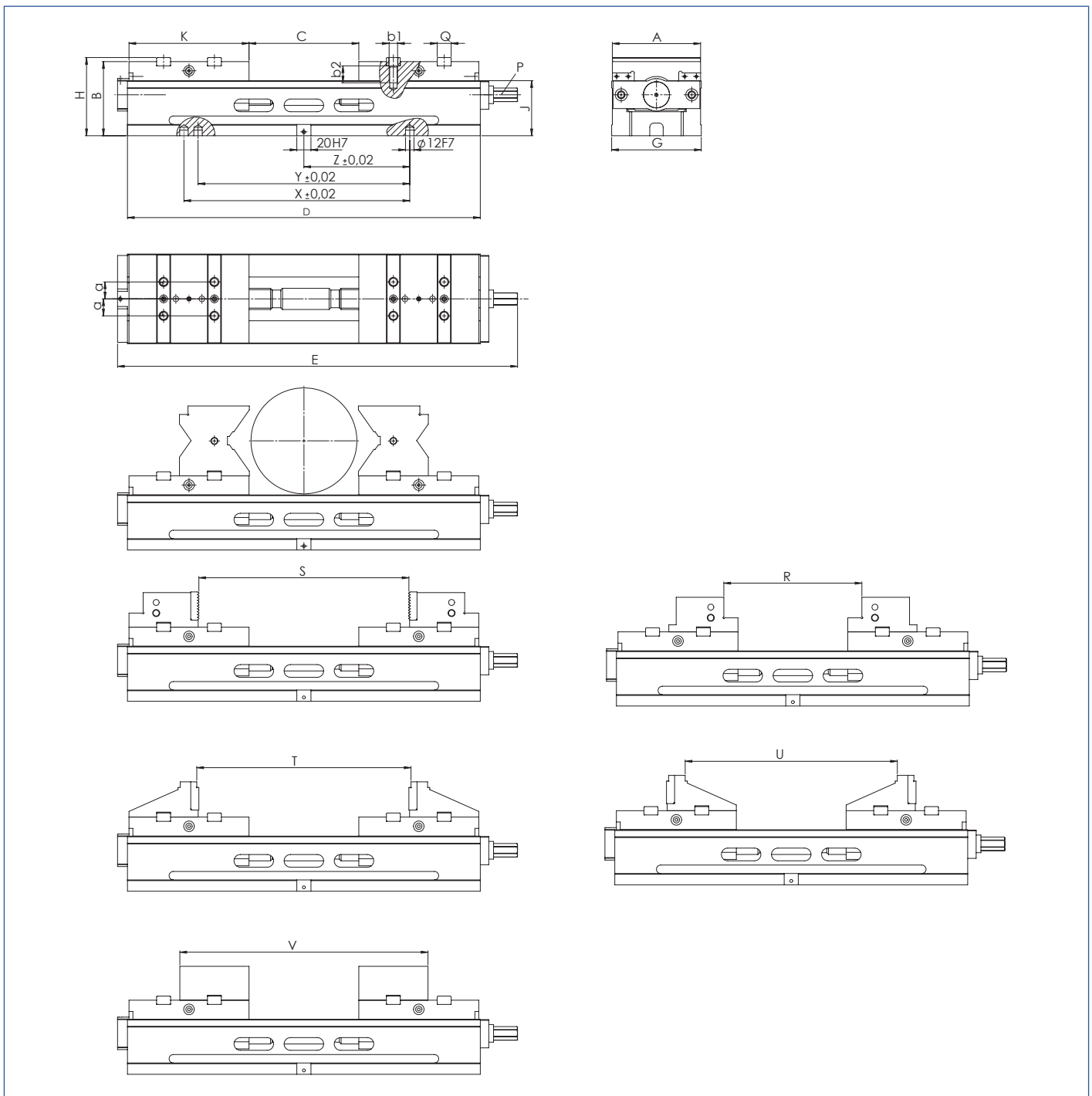
ZSS in vertical use

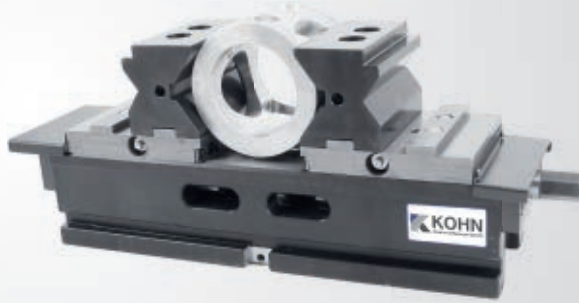
NCS
ESS
DSS
KORNA RASANT
MULTI - MFS
ZSS
ZUBEHÖR
AUTOMATION
HWS

TECHNICAL CHANGES RESERVED

SELF-CENTERING VICE ZSS MECHANICAL MODEL (M) AND MOTOR DRIVEN (MOT.)

Engineering drawing





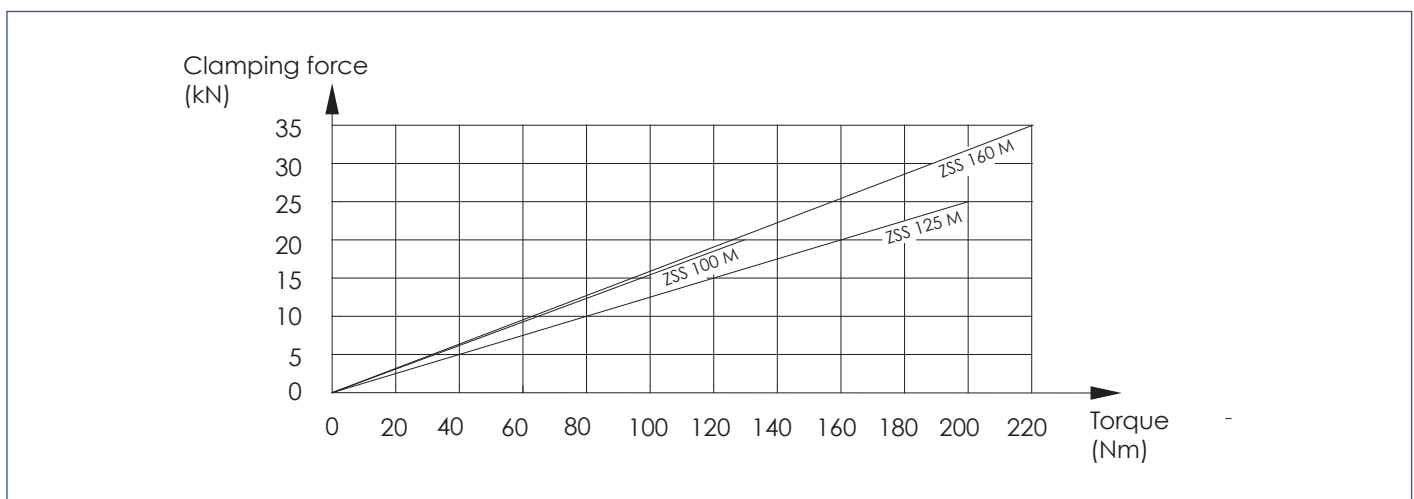
Precisely centered

SELF-CENTERING VICE ZSS MECHANICAL MODEL (M) AND MOTOR DRIVEN (MOT.)

ZSS Technical specifications

Type	ZSS			
	A	100	125	160
Jaw width				
Order No.		03411A	03511A	03611
	B-0.03	96	105	125
Bed length	D	350	500	650
Overall length	E	408	567	733
Total width	G	104	127	162
	H	102	105	131
Bed height	J h7	78	78	90
Clamping slide	K	118	170	200
Hexagonal connection SW	P	17	17	17
	Q	20g6	19.8H7	20H7
	a	16	24	67.5
	b1	M12	M12	M12
	b2	19	20	20
	x	300	300	500
	y	280	280	480
	z	150	150	250
With prismatic jaws clamping range		Ø 20-100	Ø 30-150	Ø 85-240
Span	C	114	160	250
Span	R	32-252	42-342	-
Span	S	0-219	0-300	-
Span	T	8-225	8-306	-
Span	U	86-306	147-447	-
Span	V	118-336	198-500	-
Weight	kg	26.4	53.5	82
Clamping force	kN/Nm	20/130	25/200	35/220

Clamping force diagram ZSS M



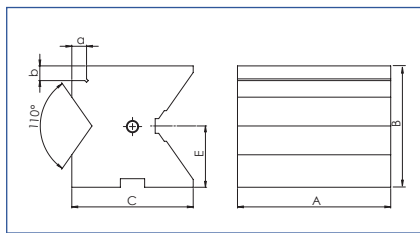
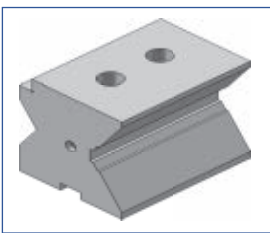
Dimensions in mm

TECHNICAL CHANGES RESERVED

SELF-CENTERING VICE ZSS MECHANICAL MODEL (M) WITH MOTOR (MOT.)

ZSS accessories

Prismatic jaws as standard*

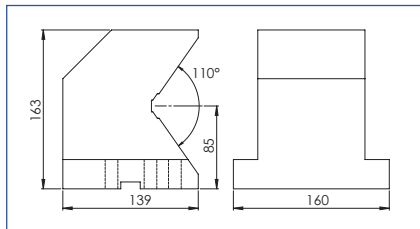
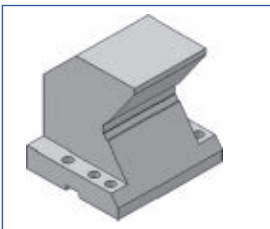


	A	B	C	E	a	b	Order No.
Size 100	100	68	58	34	10	10	03410500
Size 125	125	99	99	50	12	12	03510500

Clamping diameter

	Zone 1	Zone 2
Size 100	Ø 20-56	Ø 35-100
Size 125	Ø 30-80	Ø 52-150

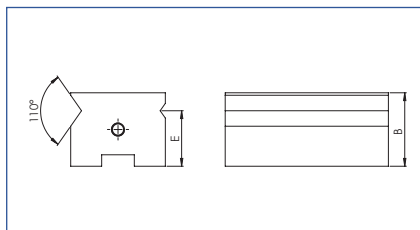
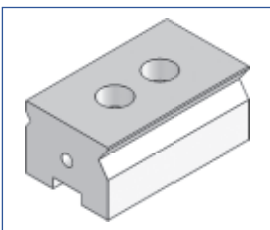
Prismatic jaw ZSS 160*



Clamping diameter Ø 85-240 mm

Order No. 03610002

Prismatic jaw Ø 6-32*



	B	E	Order No.
Size 100	45	34	03410501

Prismatic jaw Ø 6-32*

	Zone 1	Zone 2
Size 100	Ø 6-14	Ø 12-32

Clamping diameter

* hardened and ground
Dimensions in mm

TECHNICAL CHANGES RESERVED

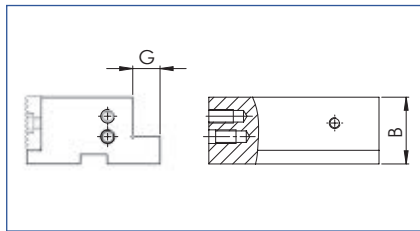
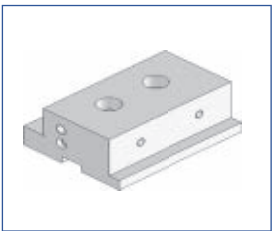


For a diverse range of parts

SELF-CENTERING VICE ZSS MECHANICAL MODEL (M) WITH MOTOR (MOT.)

ZSS accessories

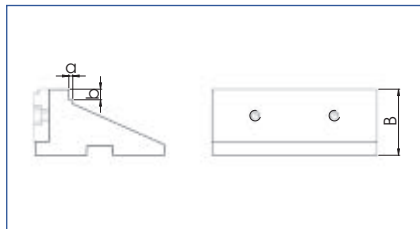
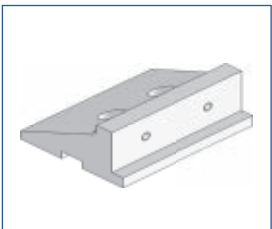
Step jaw with längsgeriffelter Einschraubbacke*



	B	G	Order No.
Size 100	44	15	03410502
Size 125	50	20	03510502

More matching screw see pages 66-69

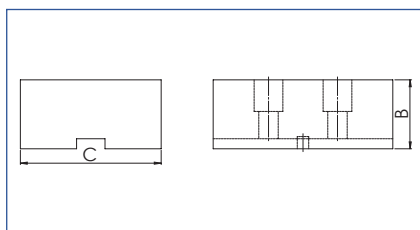
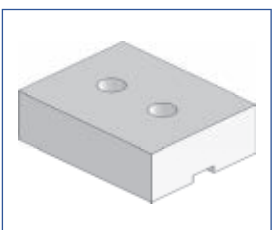
Step jaw with längsgeriffelter Einschraubbacke *



	B	a	b	Order No.
Size 100	44	3	5	03410510
Size 125	50	3	8	03510510

More matching screw see pages 66-69

Jaw blank of aluminum



	B	C	Order No.
Size 100	44	58	03410505
Size 125	48	98	03510505

Jaws delivered in sets (= 2 pcs.)

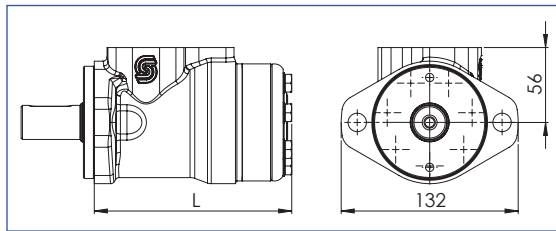
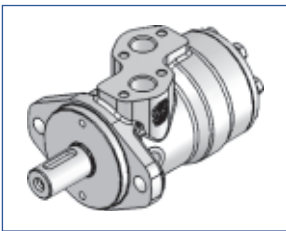
* hardened and ground
Dimensions in mm

TECHNICAL CHANGES RESERVED

SELF-CENTERING VICE ZSS MOT. WITH MOTOR

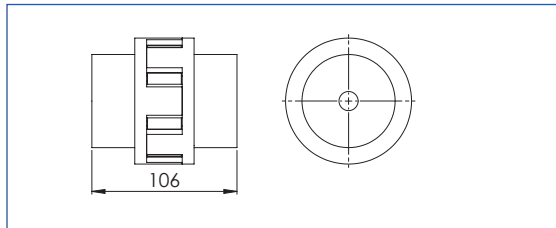
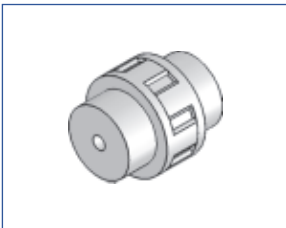
ZSS mot.-Accessories

OMP-Hydraulic motor



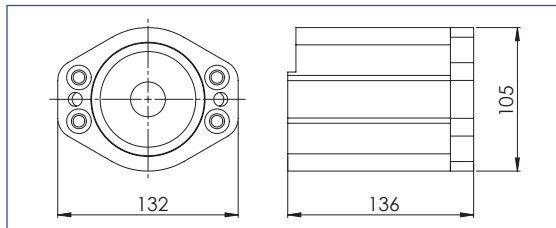
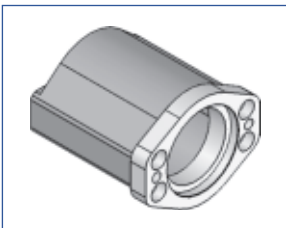
OMP	80	100	125	160
Order No.	10051001	10052001	10052002	10053001
L	135	137,5	141	145,5

Elastic clutch



Order No. K60404202

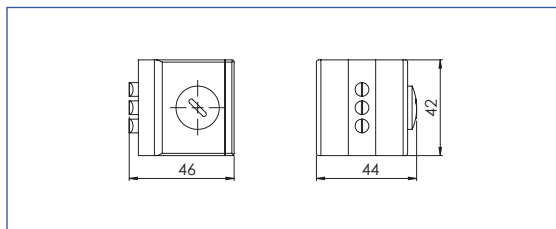
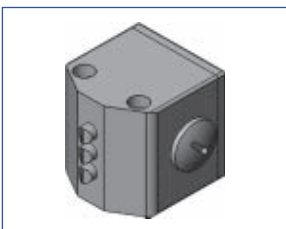
ZSS 125 clutch body complete



Order No. 03550004

Size 160 upon request

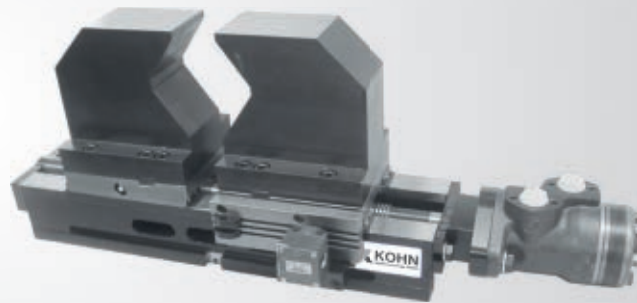
Multiple limit switches



Order No. K201500

Dimensions in mm

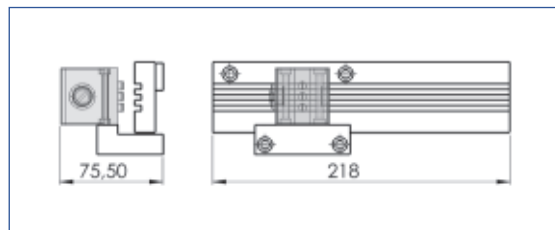
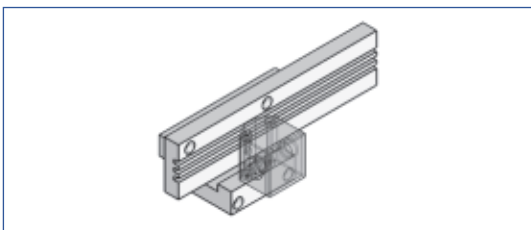
TECHNICAL CHANGES RESERVED



SELF-CENTERING VICE ZSS MOT. WITH MOTOR

ZSS mot.-accessories

Mounting kit for position monitoring, complete



Order No. 03550005

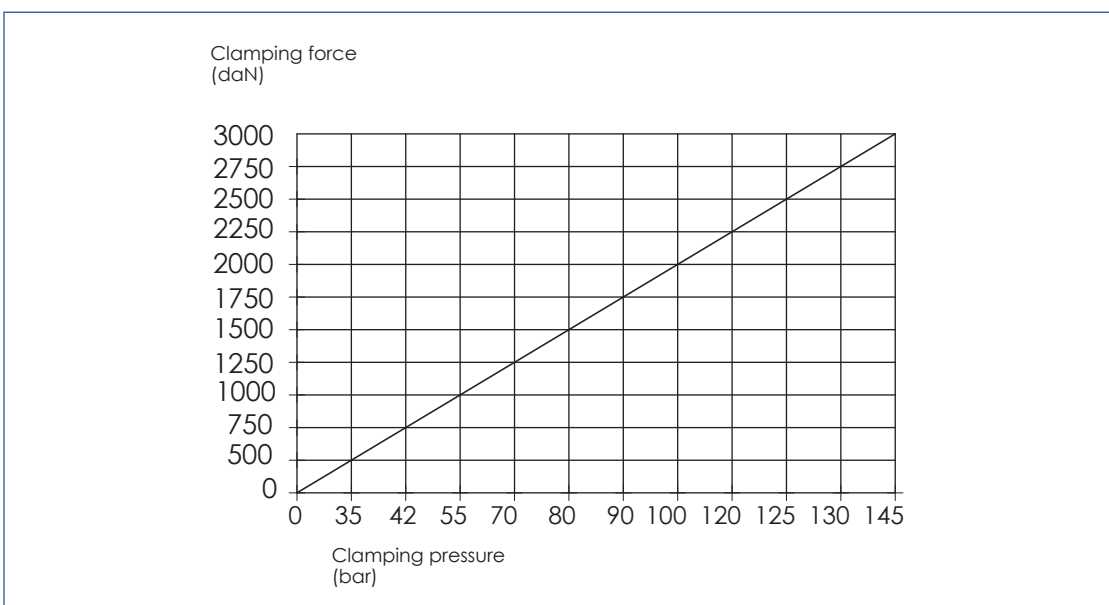
consisting of:

- ▶ Mounting plate for multiple limit switches
- ▶ Groove-array
- ▶ Distance plate for groove-array
- ▶ 2 pcs. cams

Note: To operate the motor is a hydraulic unit Zentrierspannstocks necessary!

ZSS mot with air motor on request

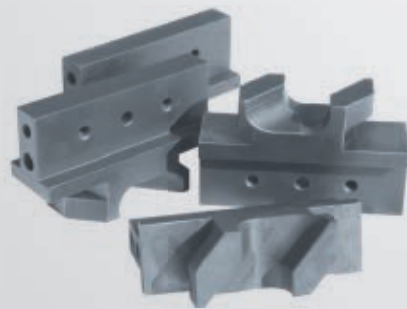
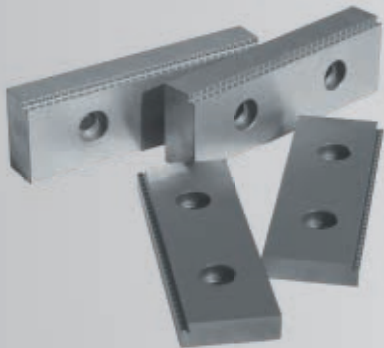
Clamping force diagram of ZSS 125 mot with OMP 125 engine



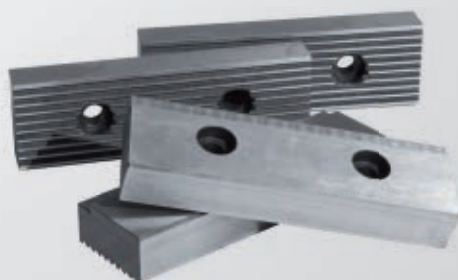
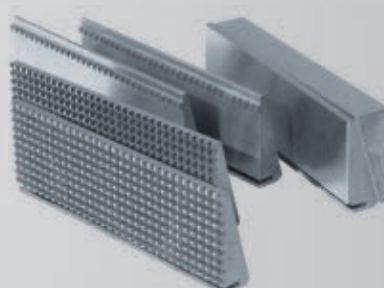
Dimensions in mm

TECHNICAL CHANGES RESERVED

ACCESSORIES



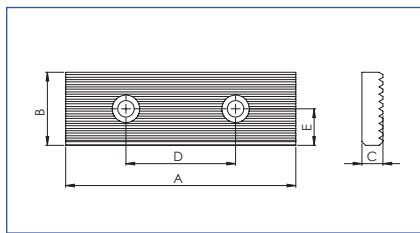
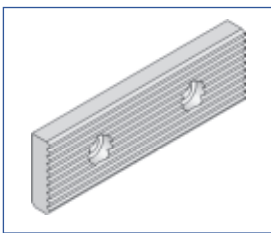
*Accessories to cover
any application*



ACCESSORIES

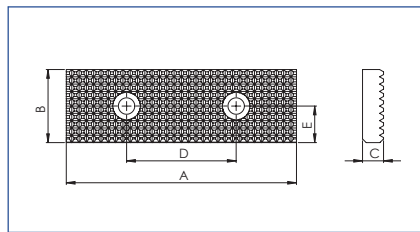
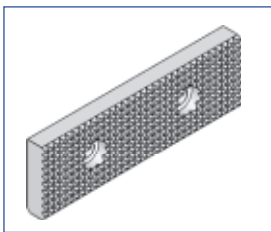
Screw-in jaws

Screw-in jaws, longitudinally knurled



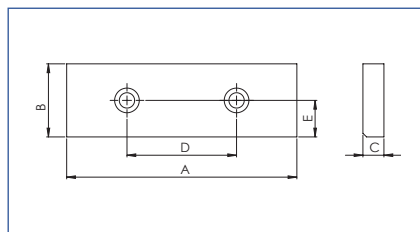
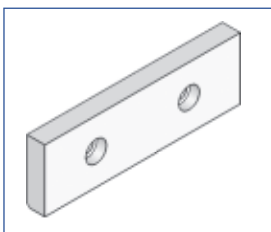
Size	Order No.	A	B*	C*	D	E
65	02210500	66	20	7,5	34	10
80	02310500	81	25	7,5	38	12,5
100	02410500	101	30	9,5	43	15
125	02510500	126	40	11,5	60	20
160	02610500	160	44	14,5	80	22

Screw-in jaws, knurled longitudinally and crosswise



Size	Order No.	A	B*	C*	D	E
65	02210501	66	20	7,5	34	10
80	02310501	81	25	7,5	38	12,5
100	02410501	101	30	9,5	43	15
125	02510501	126	40	11,5	60	20
160	02610501	160	44	14,5	80	22

Screw-in jaws smooth



Size	Order No.	A	B*	C*	D	E
65	02210502	66	20	7,5	34	10
80	02310502	81	25	7,5	38	12,5
100	02410502	101	30	9,5	43	15
125	02510502	126	40	11,5	60	20
160	02610502	160	44	14,5	80	22

*Dimensions ± 0.01 mm, sizes in mm

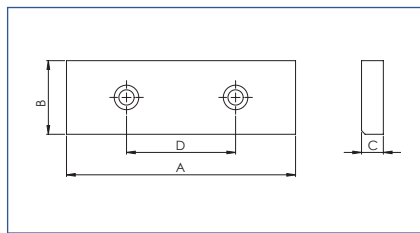
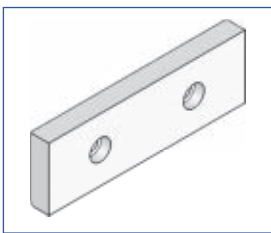
TECHNICAL CHANGES RESERVED



One solution
for any application

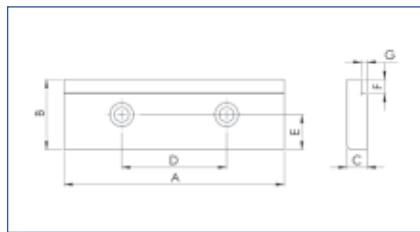
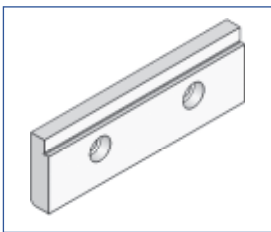
Screw-in jaws

reversible jaw with grinding allowance



Size	Order No.	A	B	C	D	E
65	02210503	66	20,5	8	34	10,2
80	02310503	81	25,5	8	38	12,7
100	02410503	101	30,5	10	43	15,2
125	02510503	126	40,5	12	60	20,2
160	02610503	160	44,5	15	80	22,2

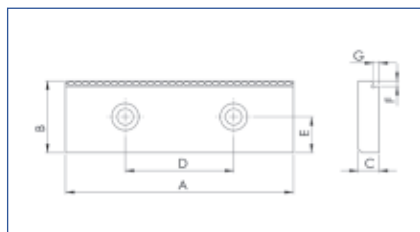
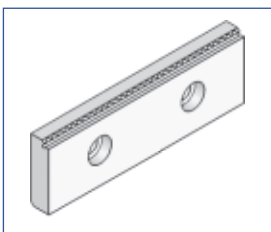
Step jaw



Size	Order No.	A	B*	C*	D	E	F*	G*
65	02210504	66	20	7,5	34	10	4	3
80	02310504	81	25	7,5	38	12,5	4	3
100	02410504	101	30	9,5	43	15	5	3
125	02510504	126	40	11,5	60	20	8	3
160	02610504	160	44	15	80	22	10	3

Other levels to customer upon request

Grip step jaw



Size	Order No.	A	B	C	D	E	F	G
80	02310511	81	25	7.5	25	12.5	3	3
100	02410511	101	30	9.5	43	15	3	3
125	02510511	126	40	11.5	60	20	3	3
160	02610511	160	44	14.5	80	22	3	3

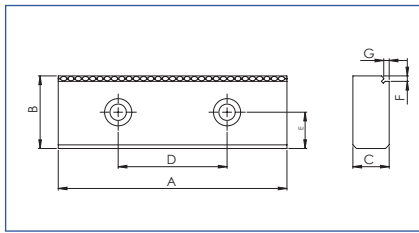
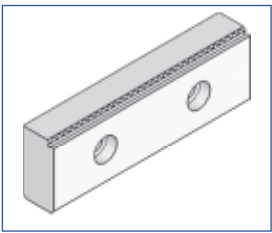
*Dimensions ± 0.01 mm, sizes in mm

TECHNICAL CHANGES RESERVED

ACCESSORIES

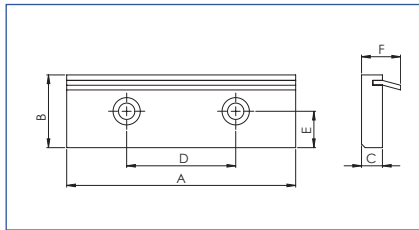
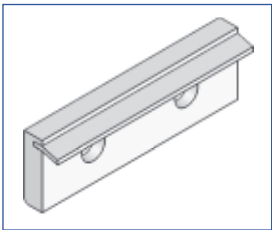
Screw-in jaws

Reversible screw-in jaw 1 side smooth, one side with grip step (for the clamping slide)



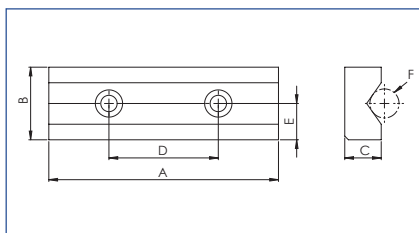
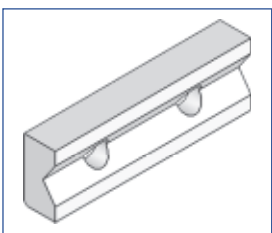
Size	Order No.	A	B*	C*	D	E	F*	G*
125	08510511	126	40	20	60	20	3	3

Pull-down jaw with spring leaf for unprocessed workpieces



Size	Order No.	A	B	C	D	E	F	G
65	02210505	66	20	7.5	34	10	17.5	3
80	02310505	81	25	7.5	38	12.5	17.5	3
100	02410505	101	30	9.5	43	15	19.5	3
125	02510505	125	40	11.5	60	20	21.5	3
160	02610505	161	44	14.5	80	22	24.5	3

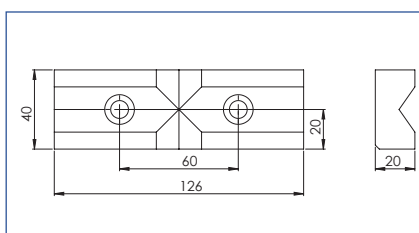
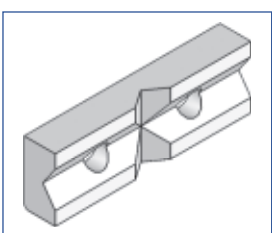
Prismatic jaw



Size	Order No.	A	B*	C*	D	E	F
65	02210509	66	20	12,5	34	10	5-25
80	02310509	81	25	12,5	38	12,5	5-25
100	02410509	101	30	14,5	43	15	7-34
125	08530509	126	40	20	60	20	8-38

Prism with 110 °

Prismatic jaw clamping range Ø 8-38 horizontal and vertical



Size 08530509V

Prisms with 110 °

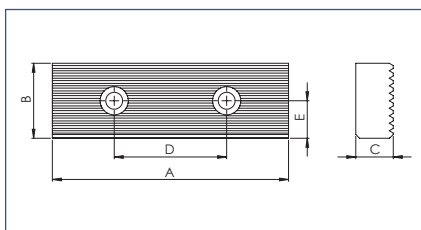
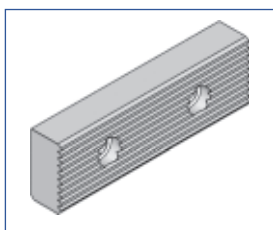
Other sizes available on request
*Dimensions ± 0.01 mm, sizes in mm

One solution
for any application

ACCESSORIES

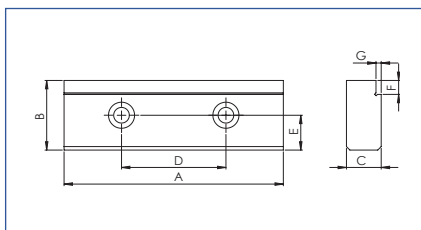
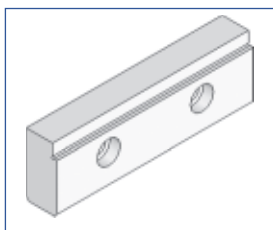
Screw-in jaws

Reversible screw-in jaws 1 side knurled, 1 side smooth



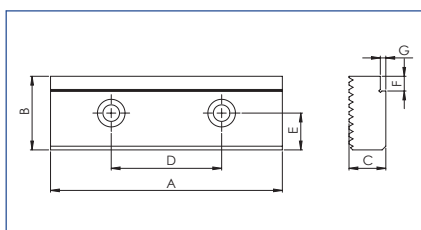
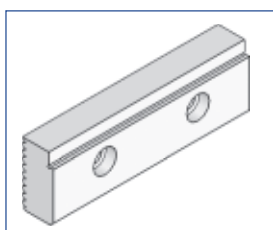
Size	Order No.	A	B*	C*	D	E
125	08530500	126	40	20	60	20

Reversible screw-in jaw 1 side with step, 1 side smooth



Size	Order No.	A	B*	C*	D	E	F*	G*
125	08530504	126	40	20	60	20	8	3

Reversible screw-in jaws 1 side with step, 1 side knurled



Size	Order No.	A	B*	C*	D	E	F*	G*
125	08530506	126	40	20	60	20	8	3

Other levels to customer upon request

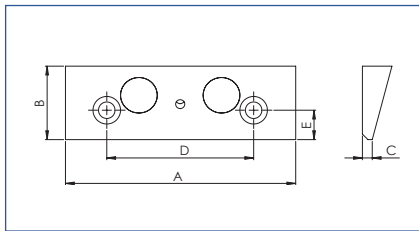
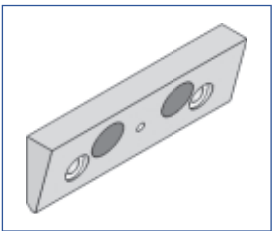
*Dimensions ± 0.01 mm, sizes in mm

TECHNICAL CHANGES RESERVED

ACCESSORIES

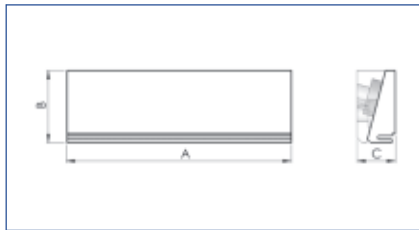
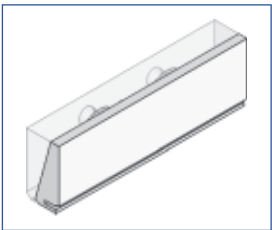
Pull-down quick-change jaws, hardened and ground

Main jaw with two permanent magnets



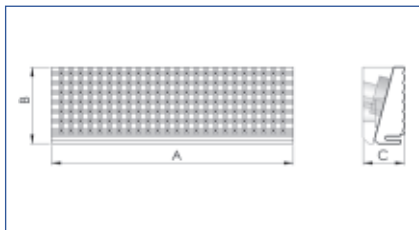
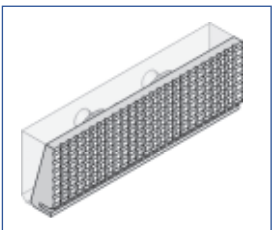
Order No.	A	B*	C	D	E
08520502	125	40	6	80	16

Smooth exchangeable jaw for processed workpieces



Order No.	A	B*	C
08520505	125	40	21

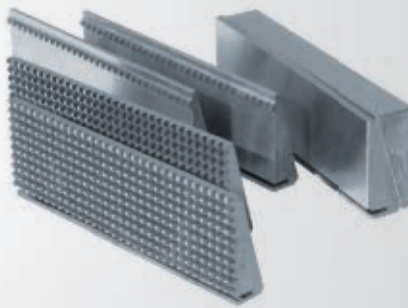
Knurled exchangeable jaw for unprocessed workpieces



Order No.	A	B*	C
08520508	125	40	21

*Dimensions ± 0.01 mm, sizes in mm

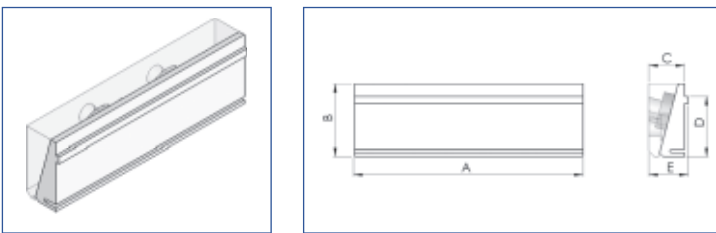
TECHNICAL CHANGES RESERVED



With pull-down
for best clamping

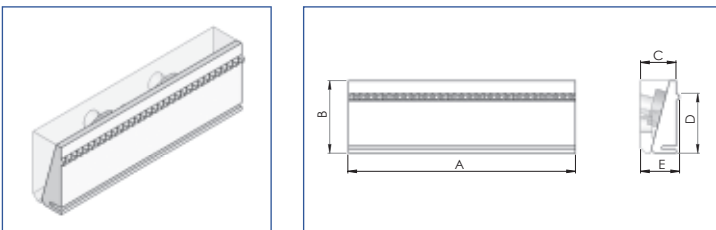
Pull-down quick-change jaws, hardened and ground

Line exchangeable jaw for processed workpieces with angle errors



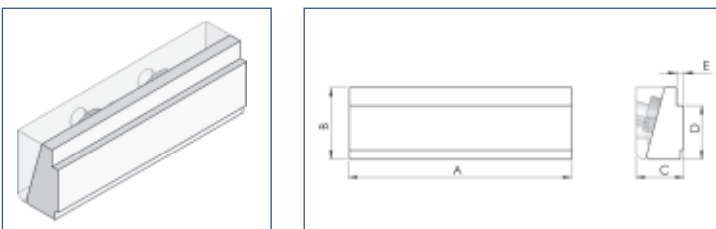
Order No.	A	B*	C	D	E
08520511	125	40	21	33	2

Knurled line exchangeable jaw for unprocessed workpieces with angle errors



Order No.	A	B*	C	D	E
08520514	125	40	21	33	2

Exchangeable step jaw



Order No.	A	B*	C	D*	E*
08520517	125	40	27	30	4

Other levels to customer upon request

*Dimensions ± 0.01 mm, sizes in mm

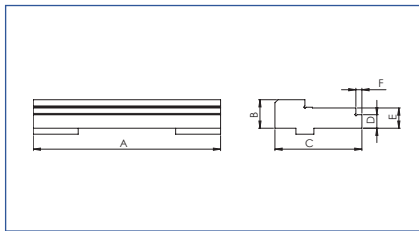
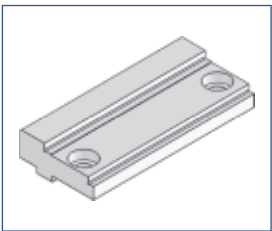
TECHNICAL CHANGES RESERVED

ACCESSORIES

OTHER ACCESSORIES

False stepped jaw and changeover slider, hardened and ground

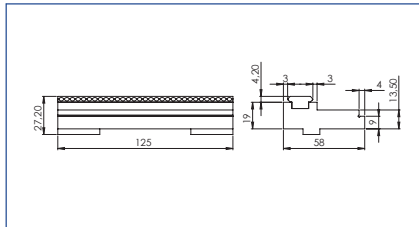
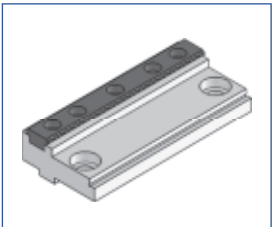
False stepped jaw for clamping slide and fixed jaw



Size	Order No.	A	B	C	D*	E*	F
80	08330510	80	16,5	48	6,5	11,5	4
100	08430510	100	16,5	48	6,5	11,5	4
125	08530510	125	19	58	9	14	4
160	08630510	160	26	64	12	17	4

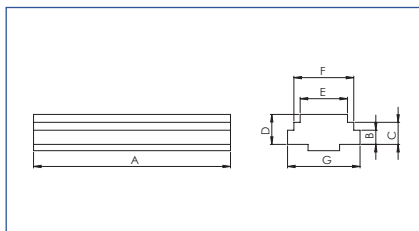
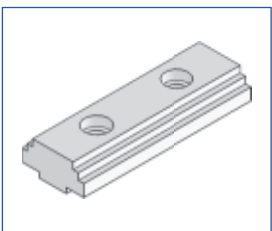
increases the clamping range to accommodate long workpieces

False stepped jaw with grip bar



Order No. 02510026

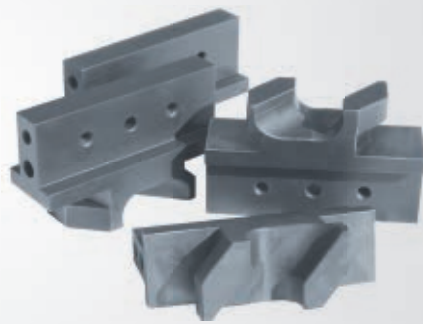
False stepped jaw for the center jaw



Size	Order No.	A	B*	C*	D	E*	F*	G
80	08330520	80	6,5	11,5	16,5	18	26	34
100	08430520	100	6,5	11,5	16,5	24	32	40
125	08530520	125	9	14	19	30	38	46
160	08630520	160	12	17	26	44	52	60

*Dimensions ± 0.01 mm, sizes in mm

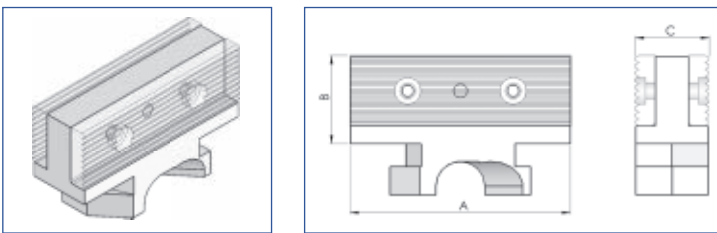
TECHNICAL CHANGES RESERVED



Set-up, multi-clamping
and reproducible clamping
made easy

Changeover slider and rhombic T-shaped tenon blocks

Changeover slider for multi-clamping

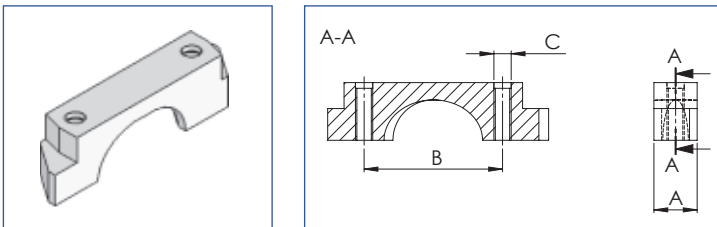


Size	Order No.	A±0,02	B	C±0,02
80	02310030	80	32	30
100	02410030	100	44	36
125	02510030	125	50	42
160	02610030	160	54	52

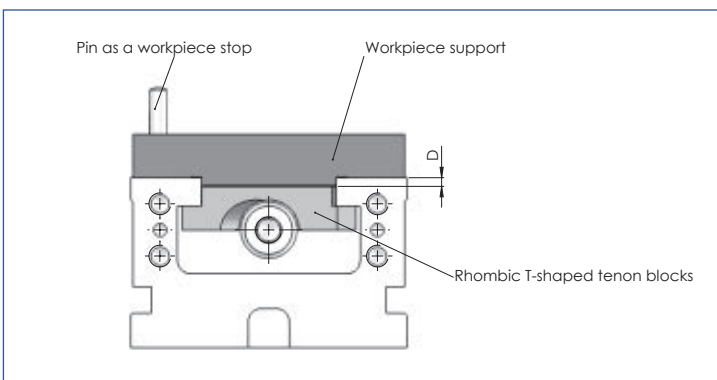
without screw-in jaws

Changeover sliders enable multi-clamping.
No tools required for assembly.

Rhombic T-shaped tenon blocks for secure fastening of workpiece materials



Size	Order No.	A	B	C	D
65	02210700	8	25	M4	4
80	02310700	10	34	M5	4,5
100	02410700	12	37	M5	3,5
125	02510700	15	48	M6	3,5
160	02610700	18	75	M6	4



Sample applications

Dimensions in mm

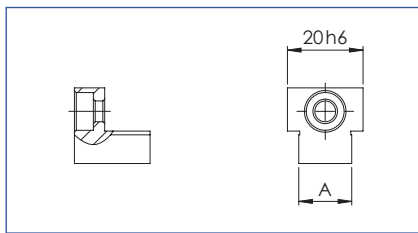
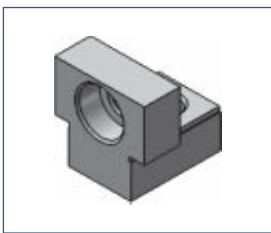
TECHNICAL CHANGES RESERVED

ACCESSORIES

OTHER ACCESSORIES

Tenon block and workpiece stop

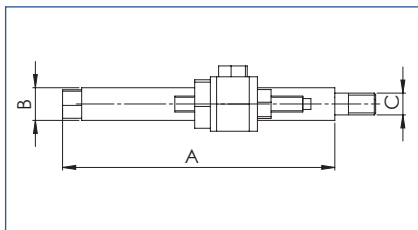
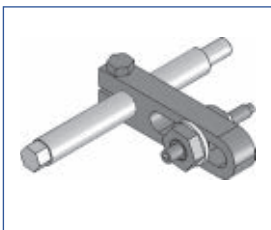
Tenon block



for quick and accurate
positioning of the vice
on the machine table

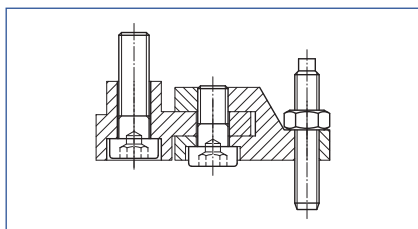
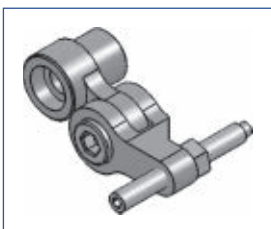
Order No.	A
01310800	14 h6
01310801	18 h6
01310802	20 h6
01310803	22 h6

The workpiece stop is attached to the service



Size	Order No.	A	B	C
65	02210701	65	8	M6
80	02310701	80	10	M7
100	02410701	100	12	M8
125	02510701	125	16	M10

The joint stop is attached to the center jaw or the clamping slide



Size	Order No.	Thread
80	02310709	M6
100/125	02510709	M8
160	09520709	M10

*Dimensions ± 0.01 mm, sizes in mm

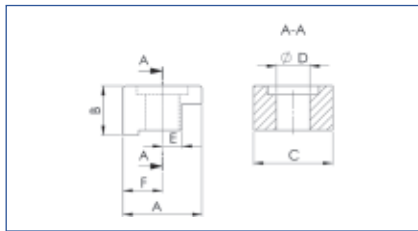
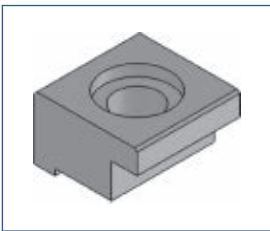
TECHNICAL CHANGES RESERVED

For every requirement



Metal clamp and torque wrench

Metal clamp to attach the vice to the machine table



Size	Order No.	A	B	C	D	E	F
65	02210710	30	16	23	11	7	16
80	02310710	30	20	28	11	7	14
100	02410710	35	20	32	13	8	18
125	02510710	40	25	38	17	10	20

Irons suitable for clamping vices with jaw width 125 mm



consisting of 4 each

**Clamps
Nut for T-slot
fixing screw**

**Note: For larger bed lengths
other quantities required!**

Order No.	Order No.
Table-Nut 14	09540900
Table-Nut 18	09540901
Table-Nut 22	09540902
Table-Nut 20	09540903

Torque wrench 1/2"



Torque wrench 1/2"

Nut driver inserts

Torque wrench with 20-200 Nm adjustment (with left and right selector / clamping and release) for a controlled clamping force during tightening. The torque is set by turning the lever at the end of the handle.

Order No.	Order No.
	10100007

Size	Order No.
SW 10	10100006
SW 12	10100005
SW 14	10100004
SW 17	10100008

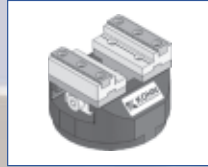
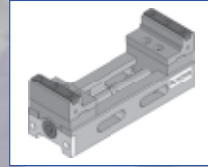
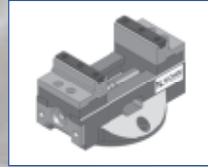
*Dimensions ± 0.01 mm, sizes in mm

TECHNICAL CHANGES RESERVED



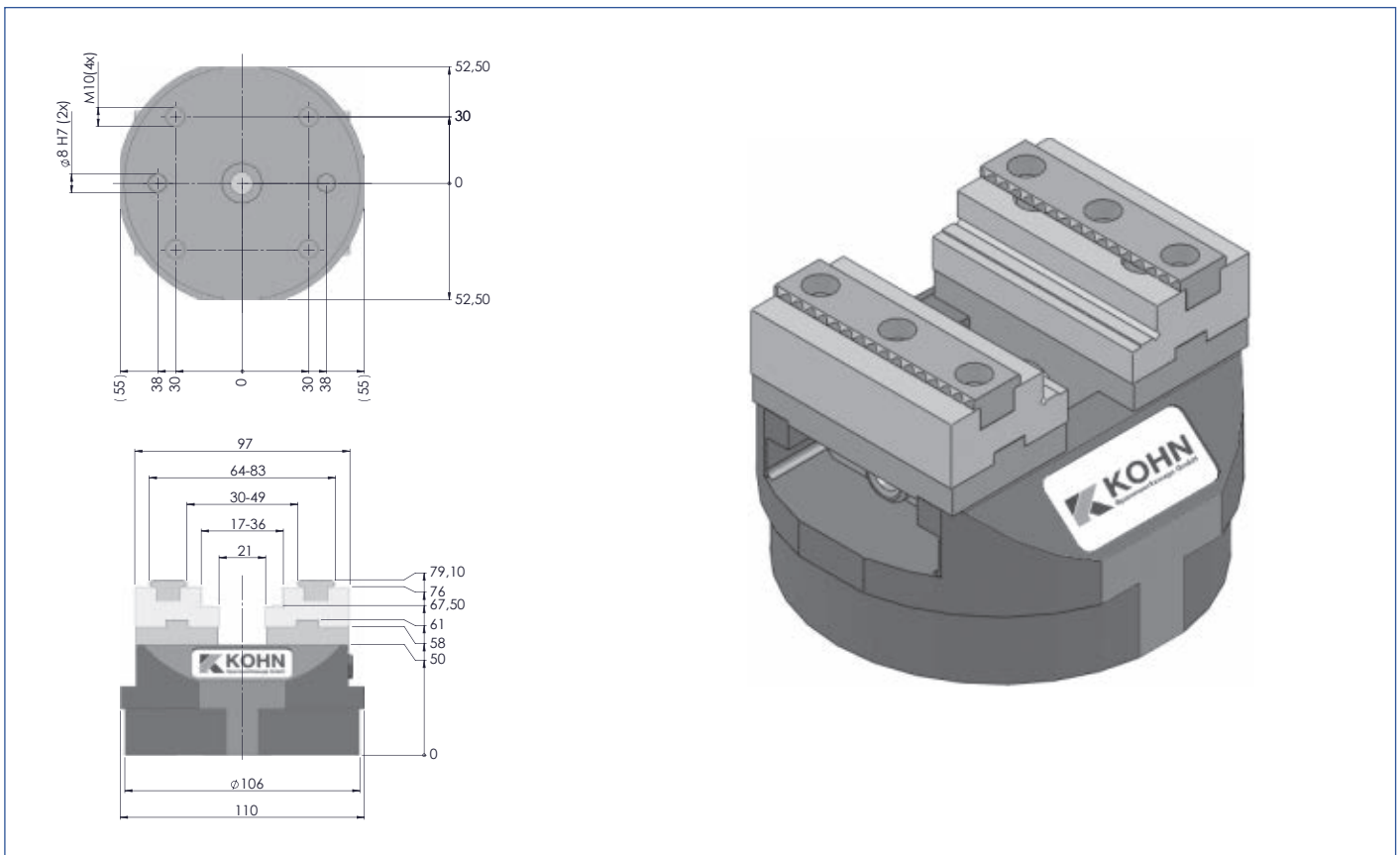
**MACHINE VICES FOR
WORKPIECE AUTOMATION**

We create tension



MACHINE VICES FOR WORKPIECE AUTOMATION

ZSS 65 / 100 M (mechanically)



DESCRIPTION ZSS 65/100 M

- ▶ Body and hardened steel jaws, hardened and ground on all sides
- ▶ Spindle made of special steel
- ▶ Clamping bolt and the nut in one piece
- ▶ 4 x M10 and 2 x Ø 8 H7 to attach to the adapter plate and fixing
- ▶ Zentrierspannstock integrated range of zero-point clamping system
- ▶ arbitrary zero point clamping systems (eg Hirschmann, Erowa, ...) can be realized
- ▶ Centering accuracy ± 0.1 mm
- ▶ Weight: 3,3 kg

DESCRIPTION

Basic equipment: 2 pcs top step jaws with Grippeleiste

Order No. 03211

Option: adjustable to ± 0.03 mm

Other shoes available on request!



Compact and small

Figures and elasticity graph

ZSS 65 M



ZSS 65 M in the standard version

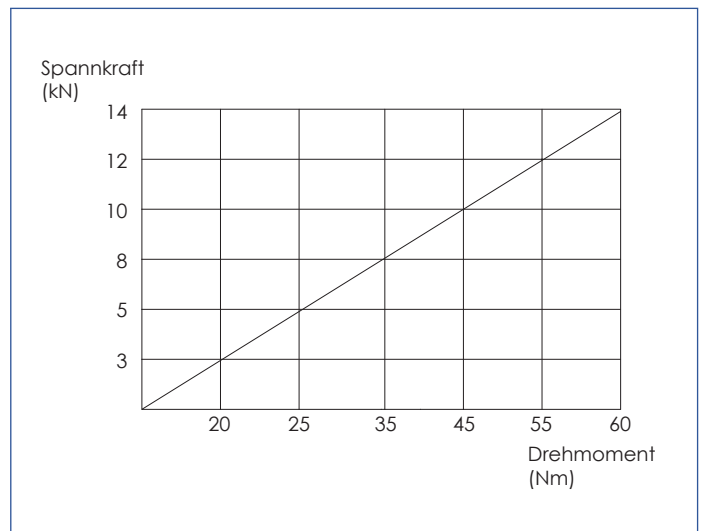


ZSS 65 M with special jaws

ZSS 65 M im Einsatz



ZSS 65 M with step jaw and Grippleiste



Clamping force diagram ZSS 65 M

Dimensions in mm

TECHNICAL CHANGES RESERVED

SELF-CENTERING VICE ZSS 80 M UNIVERSAL AND THE WORKPIECE AUTOMATION

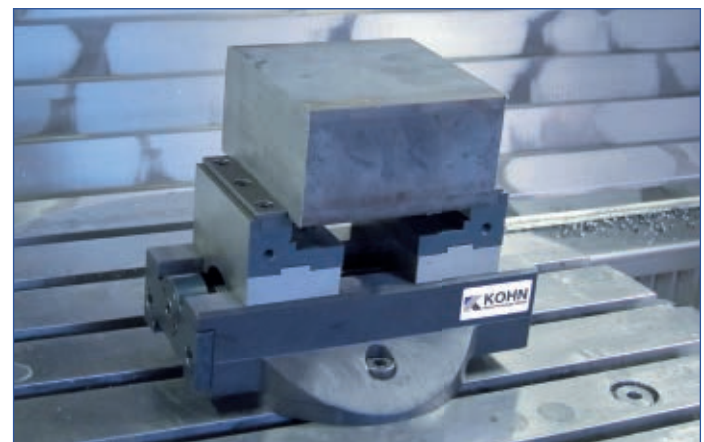
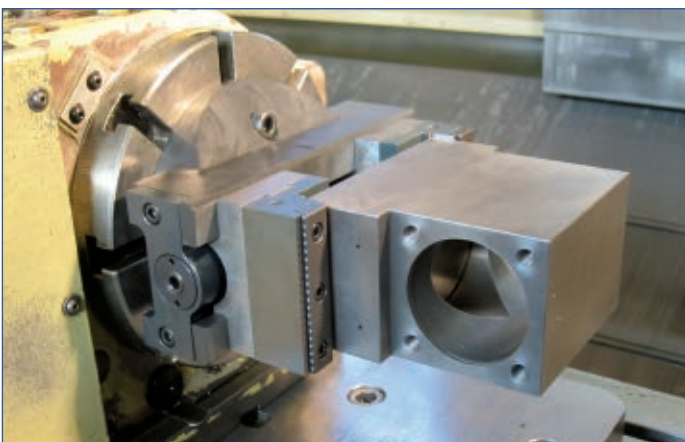
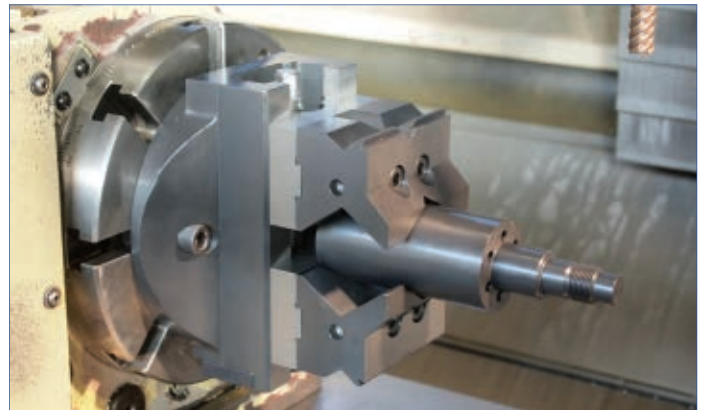
ZSS 80 M UNI

DESCRIPTION ZSS 80 M UNI (MECHANICALLY)

- ▶ Body and hardened steel jaws, hardened and ground on all sides
- ▶ Spindle made of special steel
- ▶ Clamping bolt and the nut in one piece
- ▶ Zentrierspannstock integrated range offers universal application
- ▶ arbitrary zero point clamping systems (eg Hirschmann, Erowa, ...) can be realized
- ▶ Dividing possible inclusion on
- ▶ can be directly mounted on the machine table
- ▶ suitable for 5-axis machines
- ▶ large range with a small vice
- ▶ Back extensive range offers many different edits
- ▶ Centering accuracy ± 0.02 mm

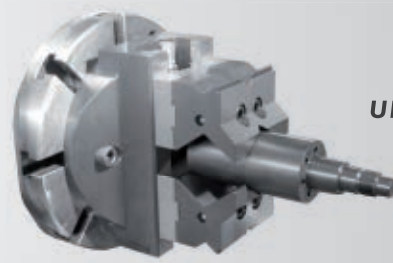
DESCRIPTION

Basic equipment: 2 pcs top step jaws with Grippleiste, a crank-handle



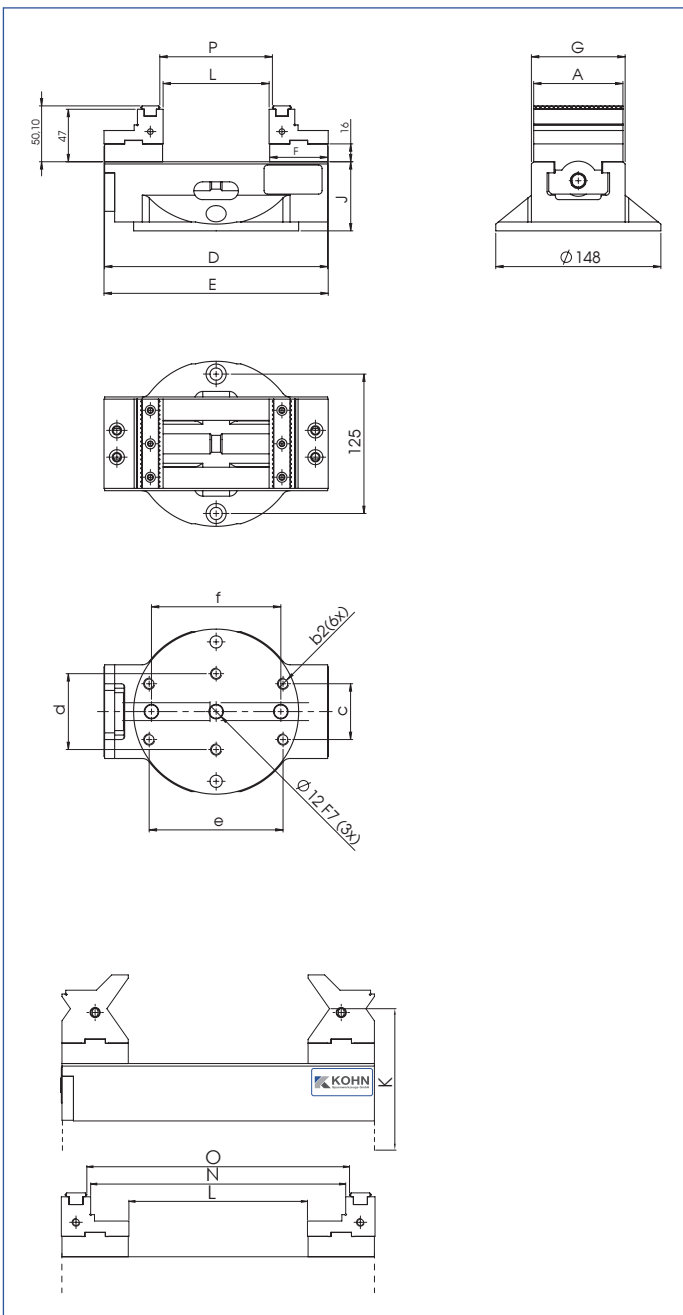
ZSS 80 M UNI on dividing

ZSS 80 M UNI on the machine table



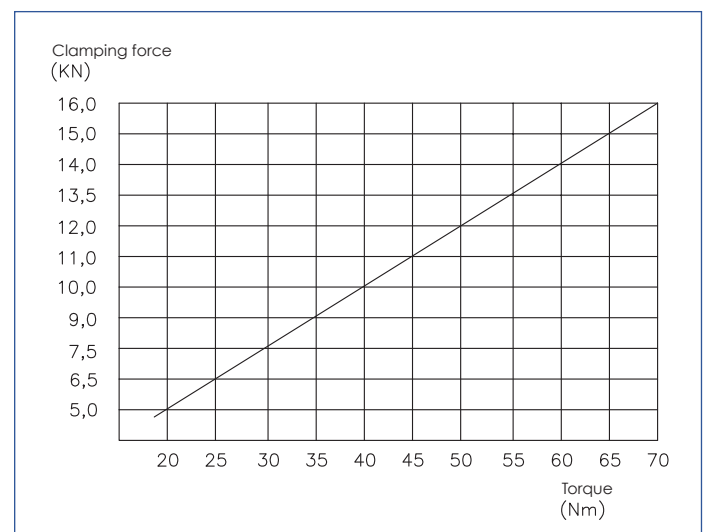
universal and stable

Technical drawing ZSS 80 M UNI



Type		ZSS M universal	
Jaw width	A	80	
Order No.		Z3310	Z3311
bed length	D	170	200
total length	E	171	201
cocking lever	F	52	52
total width	G	84	84
bed height	Jh7	62	62
top center	K	105	105
Hexagon		12	12
	b2	M10	M10
	c	50	50
	d	68	68
	e	120	120
	f	116	116
clamping range	L	1-64	1-94
	N	124	154
	O	130	160
	P	70	100
centering		± 0.02	± 0.02
weight	kg	8.3	8.8

Clamping force diagram ZSS 80 M UNI



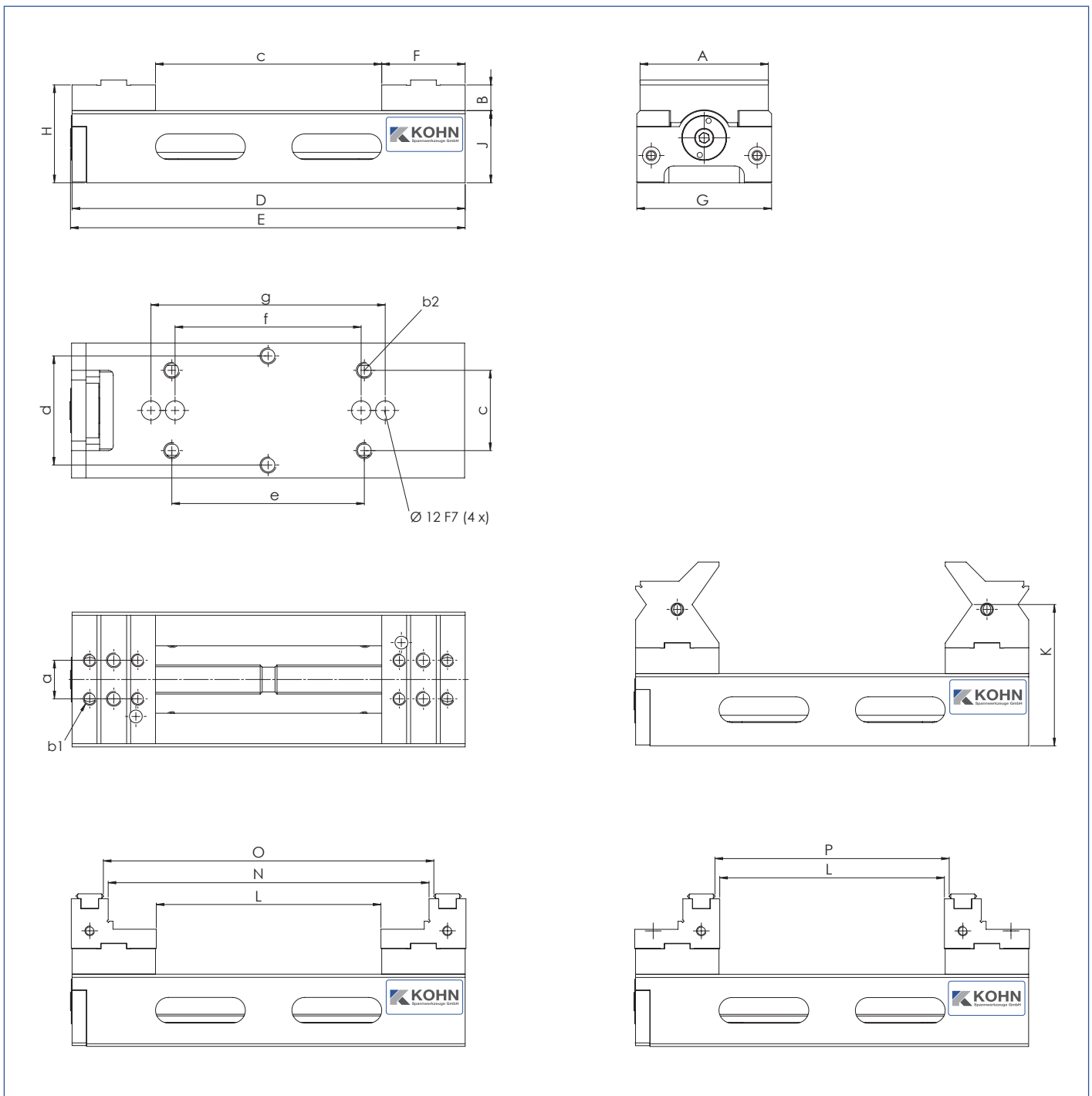
See pages 85-87 range back
Other bed lengths on request

Dimensions in mm

TECHNICAL CHANGES RESERVED

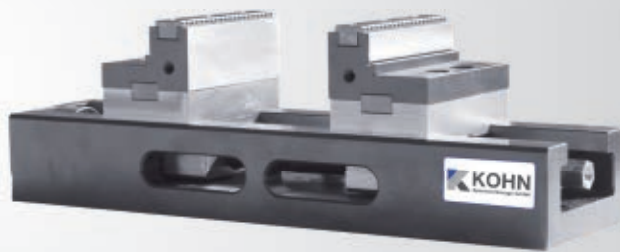
MACHINE VICES FOR WORKPIECE AUTOMATION SELF-CENTERING VICE ZSS M (MECHANICALLY)

Technical drawing



Dimensions in mm

TECHNICAL CHANGES RESERVED



Compact and strong

MACHINE VICES FOR WORKPIECE AUTOMATION SELF-CENTERING VICE ZSS M (MECHANICALLY)

ZSS

Type	ZSS					
	A	80			125	
Order No.		03311000200	0331S2450001	0331S3150001	0351S2450001	0351S3150001
Chucking	B	16	16	16	17	17
Span	C	96	141	211	113	183
Bed length	D	200	245	315	245	315
Total length	E	217	246	316	246	316
Cocking lever	F	52	52	52	66	66
Foot width	G	84	84	84	127	127
Total height	H	61	61	61	79	79
Bed height	Jh7	45	45	45	62	62
Top center	K	88	88	88	-	-
Prism jaw clamping range						
Hexagon		12	12	12	17	17
	a	24	24	24	32	32
	b1	M8	M8	M8	M8	M8
	b2	M10	M10	M10	M10	M10
	c	50	50	50	50	50
	d	68	68	68	68	68
	e	120	120	120	120	120
	f ± 0.02	116	116	116	116	116
	g ± 0.02	-	146	146	146	146
	L	95	140	210	112	182
	N	155	200	270	200	270
	O	161	206	276	206	276
	P	101	146	216	118	188
Centering		± 0.02	± 0.02	± 0.02	± 0.02	± 0.02
Weight	kg	5.4	5.5	6.7	12.7	15.5

Other bed lengths are available upon request

Basic features: Without shoes, a crank-handle

Dimensions in mm

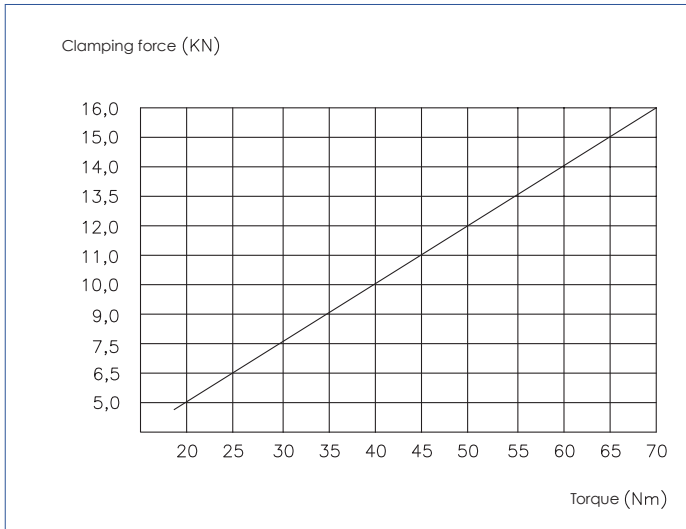


**ZSS 80 M with top-
Stepped jaws and Grappleisen**

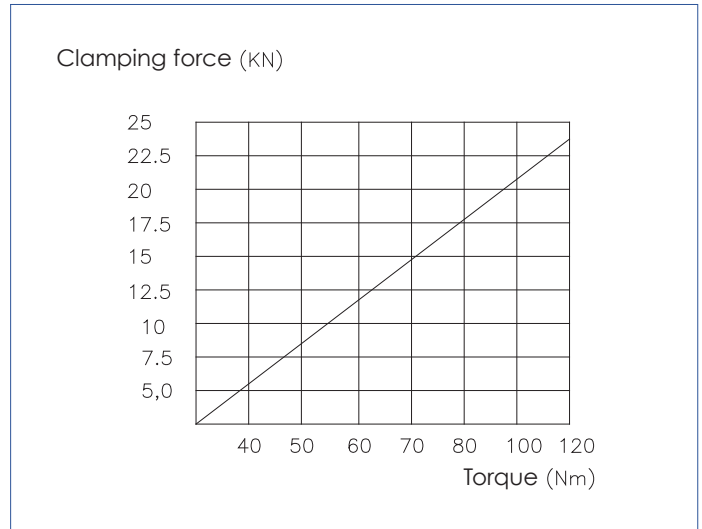
TECHNICAL CHANGES RESERVED

MACHINE VICES FOR WORKPIECE AUTOMATION
SELF-CENTERING VICE ZSS M (MECHANICALLY)

ZSS Clamping force diagrams



ZSS 80 M



ZSS 125 M



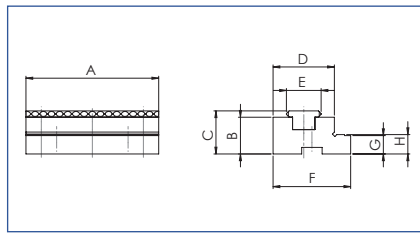
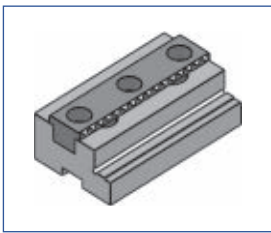
ZSS 80/200 M with prismatic jaws horizontally and vertically on the base plate

Order No. 03311

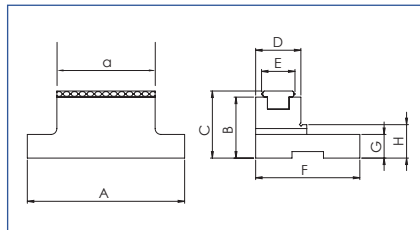
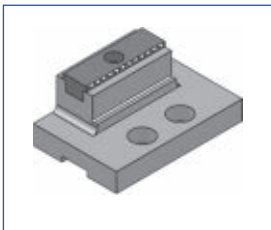


MACHINE VICES FOR WORKPIECE AUTOMATION ACCESSORIES

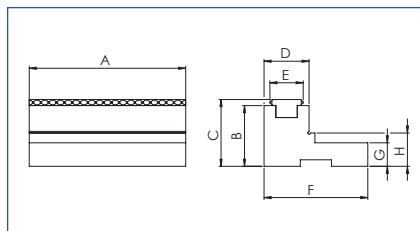
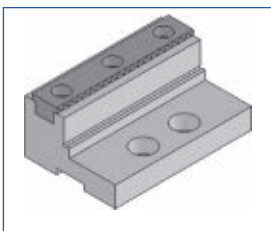
Step jaw with grip-strip



Size	Order No.	A	B	C	D	E	F	G	H
65	03210011	65	18	21	30	17	38	9	9.5



Size	Order No.	A/a	B	C	D	E	F	G	H
80/40	03310024	80/40	31	34	23	17	53	12	17
80/50	03310025	80/50	31	34	23	17	53	12	17

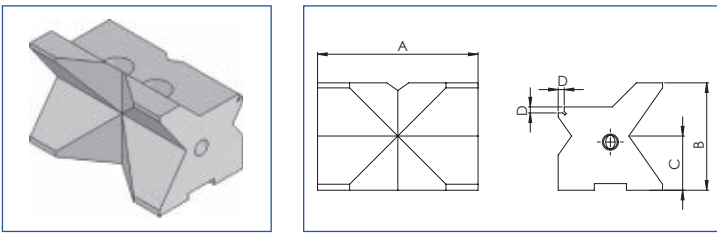


Size	Order No.	A	B	C	D	E	F	G	H
80	03310535P	80	31	34	23	17	53	12	17
80	03310017	125	31	34	23	17	53	12	17
125	03510028	125	31	34	23	17	67	18	23

More shoes in different sizes and voltage ranges on request

MACHINE VICES FOR WORKPIECE AUTOMATION ACCESSORIES

Prismatic jaw (horizontal and vertical)



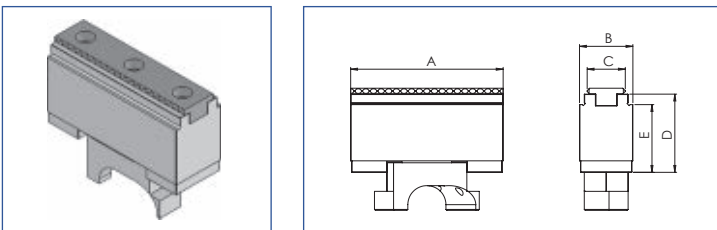
Size	Order No.	A	B	C	D
80	03310501V	80	53.5	27	3

Clamping diameter

	Area 1	Area 2
horizontal and vertical	Ø 11-30	Ø 30-80

Prisms with 110 °

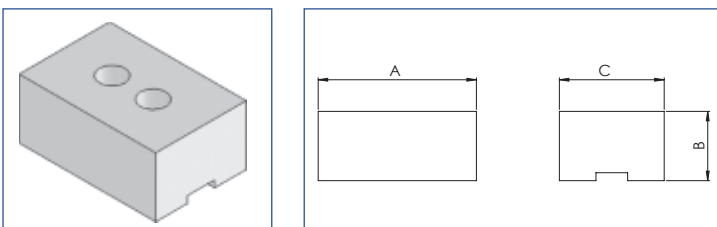
Complete changeover slider



Size	Order No.	A	B	C	D	E
80	03310215	80	28	17	22.5	28
80	03310228	80	28	17	41	35.5
80	03310234	80	28	17	47	33

Window slide facilitate clamping of multiple workpieces

Jaw blank of aluminum



Size	Order No.	A	B	C
80	03310505FL	80	35	45
80	03310505	80	35	53
80	03310507	80	20	53

Back blanks of aluminum

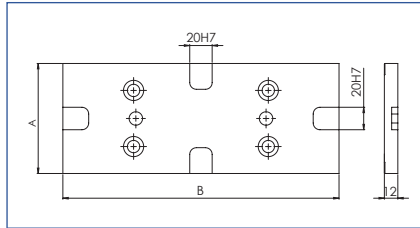
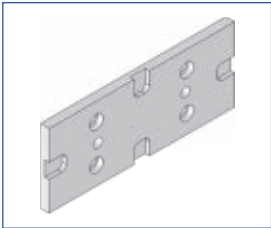
Dimensions in mm

TECHNICAL CHANGES RESERVED

strong Hold
Gripp without end

MACHINE VICES FOR WORKPIECE AUTOMATION ACCESSORIES

Base

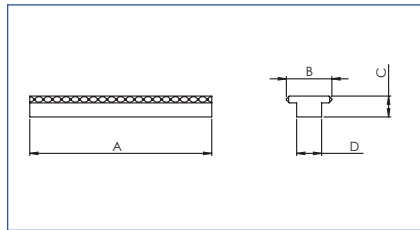
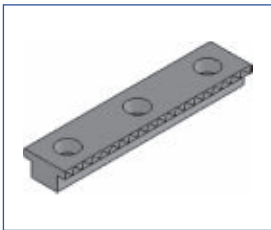


Size	Order No.	A	B
80	033101041	98	200
80	033101042	98	230
80	033101043	98	246

**Base plate as an adapter
between vice and
machine table**

Size 125 on request

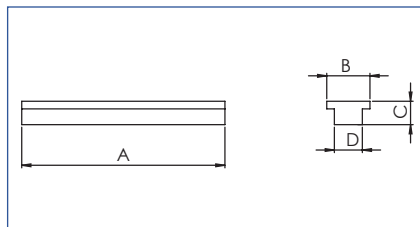
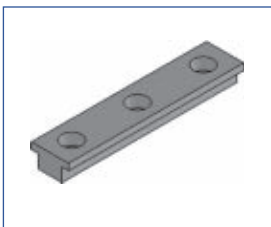
Gripp-use for Step jaw and slide change*



Size	Order No.	A	B	C	D
65	03210002	65	17	9.2	11
80	03310550	80	17	9.2	11
80	03310551*	80	20	9.2	11
80/125	03510550	125	17	9.2	11

**Gripp-use for both sides geriffelt Step
jaw and removable vane ***

Used for Step jaw and removable slide*



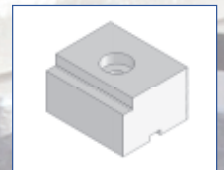
Size	Order No.	A	B	C	D
80	03310553	80	17	9.2	11
80	03310554	80	20	9.2	11

**Clamping bar with a smooth cut-
ting surface Size 125 on request**



SELF-CENTERING AND SHAFT VICE

We create tension



SELF-CENTERING AND SHAFT VICE HWS MECHANICAL MODEL

HWS

PRODUCT DESCRIPTION

- ▶ Main body and jaws made of case-hardened steel, hardened and ground on all sides
- ▶ Base of vice made of GGG 40
- ▶ Guides ground
- ▶ Spindle made of high-strength special steel
- ▶ Reversible jaws can also be used to clamp cubic workpieces (Size 80 + 150)
- ▶ The prismatic jaw on the side of the crank has a centering bush, so that the jaw can be rotated to enable tightening of conical workpieces (Size 80 + 150)
- ▶ side threads for workpiece stops

DESCRIPTION

CENTERING ACCURACY

- ▶ With the same clamping range ± 0.02 mm
- ▶ For the entire clamping range within ± 0.04 mm
- ▶ The use of a torque wrench is recommended to achieve controlled and reproducible clamping forces (ESS-M) to obtain a controllable and reproducible clamping force

CENTERING ACCURACY

STANDARD EQUIPMENT

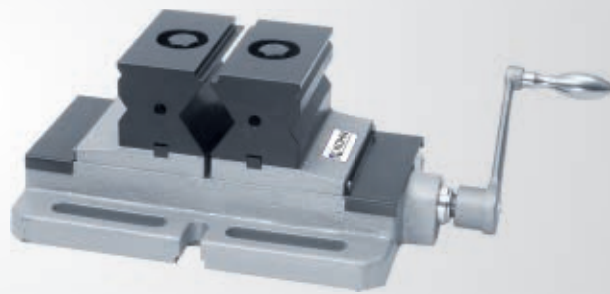
- ▶ 2 pcs. prismatic jaws (HWS 80 + 150)
- ▶ 2 pcs. prismatic jaws incl. 4 pcs. screw-in jaws (HWS 250 + 400)
- ▶ 1 pcs. hand crank, hexagonal

STANDARD EQUIPMENT

OPTIONS

- ▶ Powered by a hydraulic or electric motor (size 250 + 400)
- ▶ Alignment of the center of the workpiece with respect to the positioning groove ± 0.02 mm
- ▶ Alignment of two vices to achieve the same center point ± 0.02 mm
- ▶ additional clamping ranges are possible by using the corresponding screw-in jaws

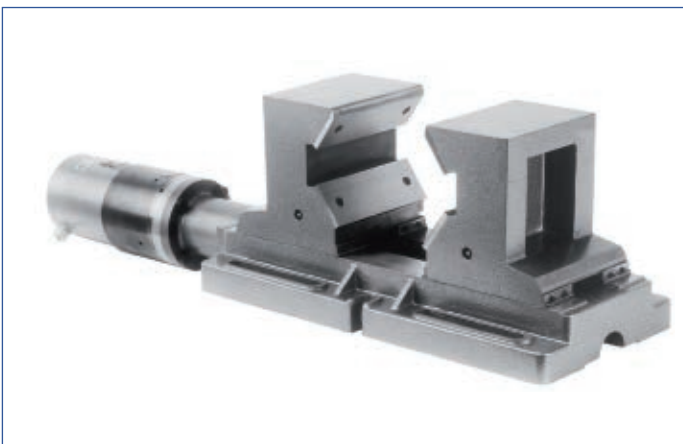
OPTIONS



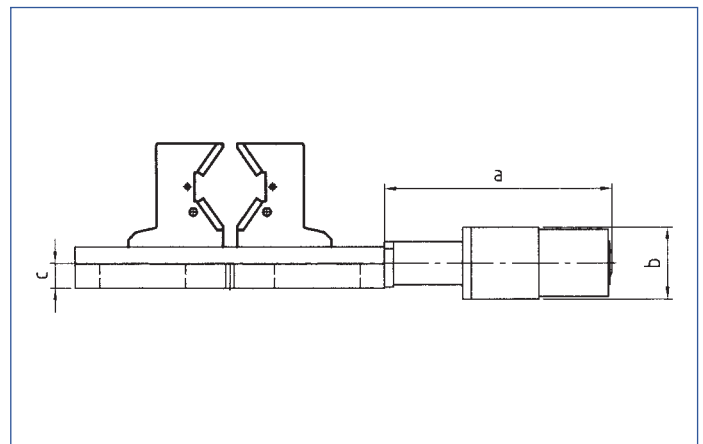
Simply well centered

HWS with electric motor

Images of the HWS electric motor solution



HWS 250 mot. with electric motor



HWS 250 mot. with electric motor

TECHNICAL SPECIFICATIONS

Type	HWS mot. (electric motor)		
		250	400
Weight electric motor	kg	25	25
max. Clamping force	kN	25	18
max. Torque	Nm	200	200
max. RPM	1/min	50	50
	a	460	480
	b	150	150
	c	52	59

Dimensions in mm

TECHNICAL CHANGES RESERVED

SELF-CENTERING AND SHAFT VICE HWS MECHANICAL MODEL

HWS

TECHNICAL SPECIFICATIONS

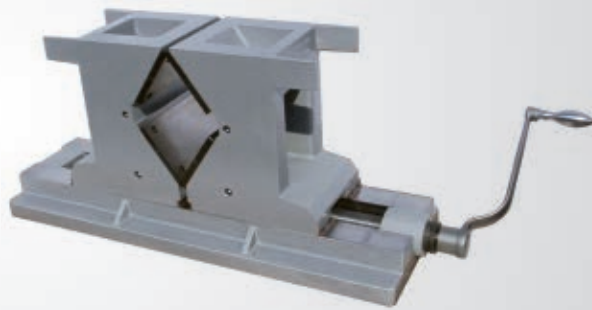
Type	HWS M / HWS mot.				
Size		80	150	250	400
Weight	kg	14	42	145	300
max. Clamping force mechanical	kN/Nm	20/130	35/260	50/380	60/750
max. Jaw opening	mm	90	155	260	410
Clamping range round max.	mm	80 ¹	150 ¹	250 ²	400 ²
Clamping range round min.	mm	6 ¹	30 ¹	100 ²	160 ²
Number of clamping prisms per prismatic jaw		3	2	1	1
Clamping range flat max.	mm	100	178	-	-
Clamping range flat min.	mm	13	28	-	-
Dimensions in mm	A	100	120	200	220
	B	119,5	200	308	430
	C	385	545	850	1150
	D	255	400	655	940
	E	315	465	745	1040
	F	138	176	255	-
	G	175	220	310	335
	H	35	60	62	-
	J	66	105	160	-
	K	14	20	20	-
	SW	14	17	22	27
	M	45	66	86	84
	N	22	27	50	40
	O	42	84	127	200,5
	P	100	160	250	315
	R	60	100	-	-
	S	87	150	213	284,5
	T	110,5	-	-	-
	W	20H7	20H7	-	-

¹ = special purpose jaw upon request

² = for other clamping ranges refer to accessories or ask for availability

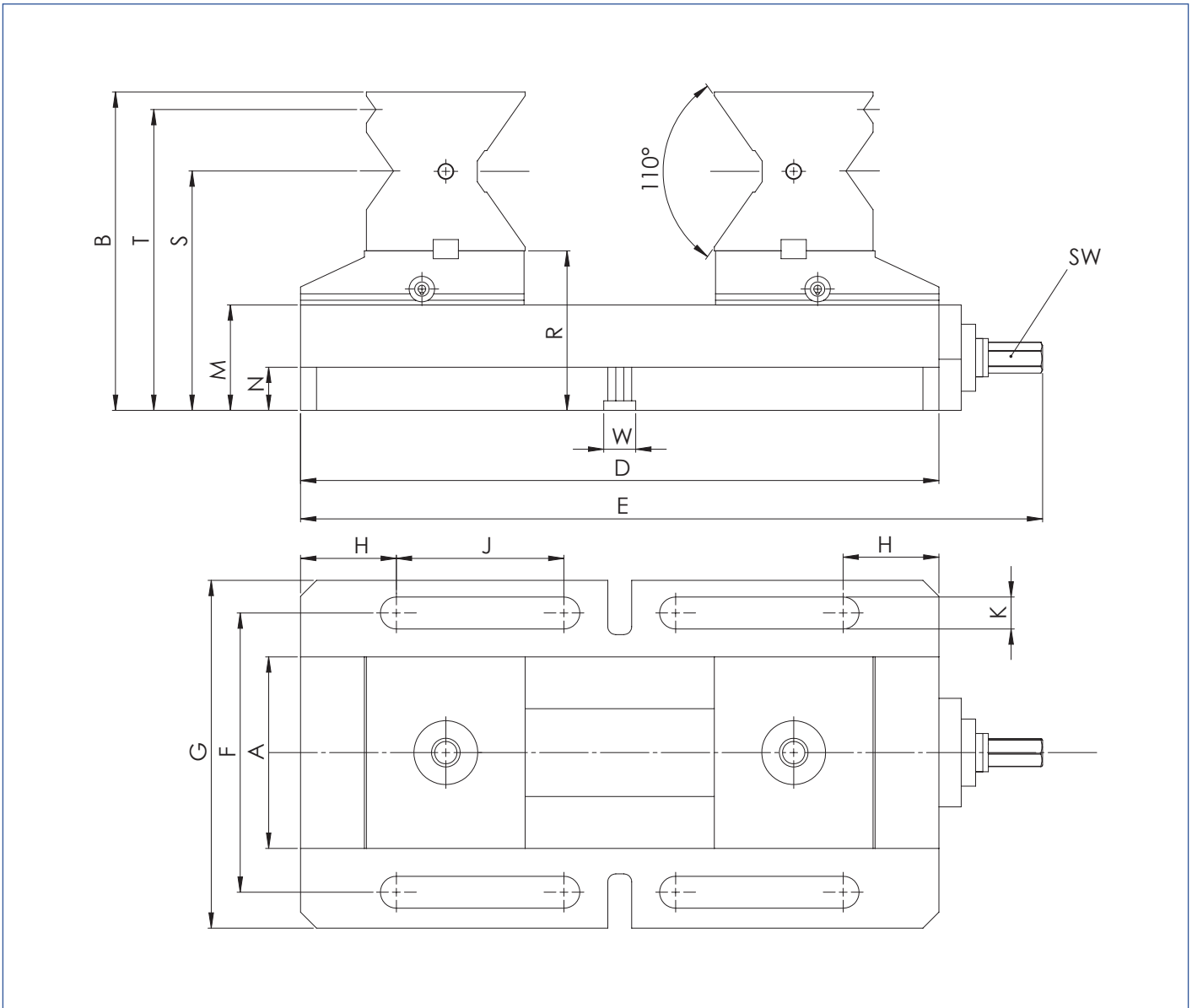
Dimensions in mm

TECHNICAL CHANGES RESERVED



Automatically centered

SELF-CENTERING AND SHAFT VICE HWS MECHANICAL MODEL



NCS

ESS

DSS

KORNA RASANT

MULTI - MFS

ZSS

ZUBEHÖR

AUTOMATION

HWS

TECHNICAL CHANGES RESERVED

SELF-CENTERING AND SHAFT VICE HWS

Accessories HWS

HWS M and HWS mot.	80	150	250	400
HWS M basic version, Order No.	04411	04511	04811	04911
HWS mot. – Basic version prepared for motor-powered operations, Order No.	–	–	04851	04951
Screw-in jaws, smooth, hardened and ground Order No. Step jaws hardened, with knurling for cubic workpieces, order no.	–	–	● 04810500	● 04910500
Two vices aligned at the same height, order no.	○ 04410504	○ 04510504	–	–
Alignment of the workpiece center with the positioning groove 20H7, order no.	○ (± 0,015) 04410700	○ (± 0,015) 04510700	○ (± 0,02) 04810700	○ (± 0,025) 04910700
Two vices aligned at the same height, order no.	○ (± 0,015) 04410701	○ (± 0,015) 04510701	○ (± 0,02) 04810701	○ (± 0,025) 04910701
Alignment of the workpiece center with the positioning groove 20H7, order no.	○ 02410701	○ 02510701	○ 04811701	○ 04911701
Workpiece stop, adjustable Order No.	● Series	● Series	○ 04810705	○ 04910705
Positioning groove 20H7 Order No.	–	–	○ 04811700	○ 04911700
Spindle hardened and ground Order No.	● 04410704	–	○ 04810704	○ 04910704
Wiper for guideways Order No. –	–	○ 04510703	● 04810703	● 04910703
Lubrication via 4 lubrication nipples for guideways and spindles, order no.	○ 04410702	● 04510702	● 04810702	● 04910702
Groove and control cam limit for limit switch Order No.	–	–	○ 04810706	○ 04910706
Electric motor	–	–	○	○
Hydraulic motor	–	–	○	○
Special purpose screw-in jaws Clamping range in mm Order No.			○ Ø 72-205 04810510	○ Ø 65-182 04910510
Order No.			○ Ø 34-90 04810520	○ Ø 32-90 04910520

● **Included with the delivery**

○ **Optional**

– **not available**



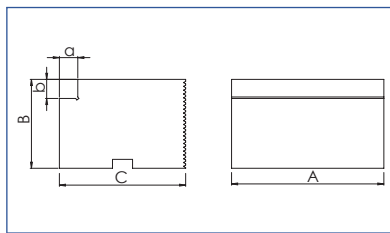
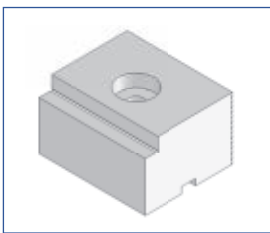
Highest precision

SELF-CENTERING AND SHAFT VICE HWS ACCESSORIES

Jaws, workpiece stop

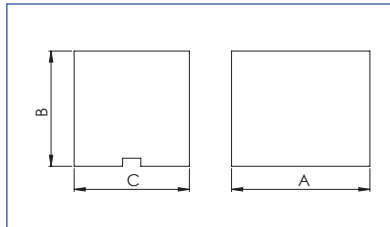
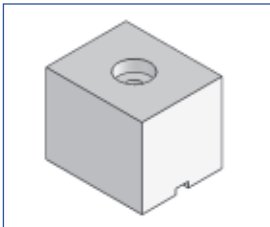
Step jaws hardened, with knurling for cubic workpieces

ACCESSORIES



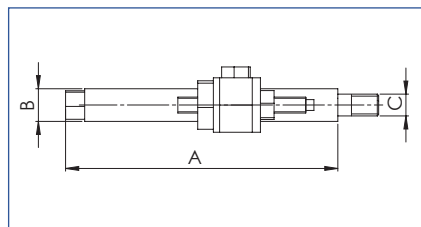
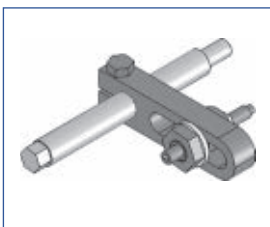
Size	Order No.	A	B	C	a	b
80	04410504	100	45	59.5	11.5	12
150	04510504	120	70	99.5	14.5	15

Jaw blank of steel (soft), with pre-machined groove and grinding allowance



Size	Order No.	A	B	C
80	04410503	100	60	60
150	04510503	120	100	100

The workpiece stop is attached to the vice



Size	Order No.	A	B	C
80	02410701	100	12	M8
150	02510701	125	16	M10
250	04811701	160	20	M12
400	04911701	200	30	M16

Special jaws on request

Dimensions in mm

TECHNICAL CHANGES RESERVED

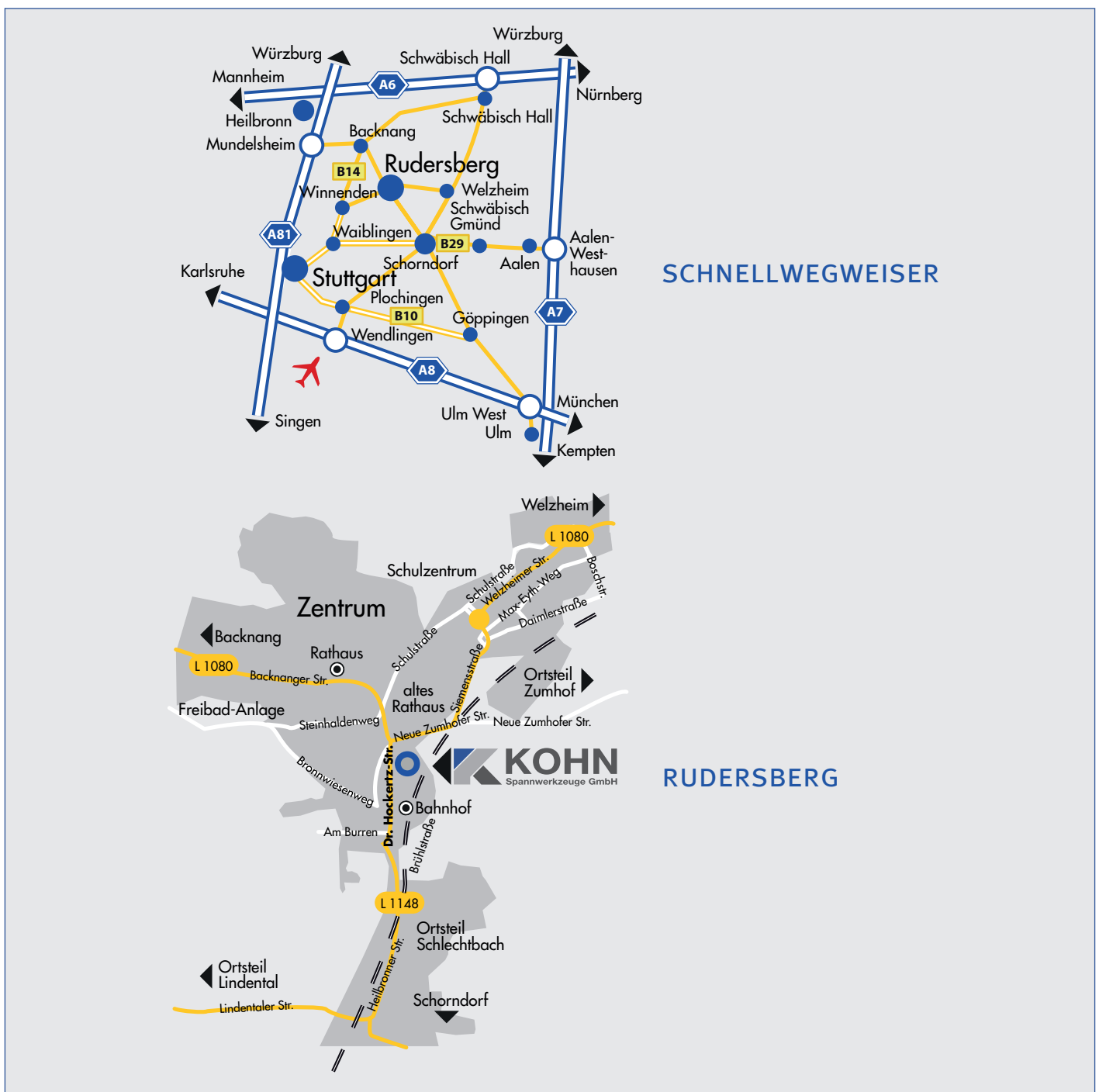
EXTRACTS OF OUR CUSTOMER

Our customers range from small businesses in trade and industry leading up to Germany's leading large enterprises, as well as machinery manufacturers and dealers in Germany and abroad.



DIRECTIONS

How to find us



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