



KONTEC GFD

**Very flat, mechanical set-up
system with high pull-down
forces**

Low! Precise! Cost-effective! – The new mechanical set-up system from SCHUNK

The very flat and precise GFD set-up system is the manual addition to the extensive VERO-S modular system. The high pull-down forces of the set-up stations enable low-vibration clamping for general milling applications, especially in combination with clamping devices from the KONTEC family. The GFD set-up stations are made of stainless steel as standard and have anti-rotation protection, which makes them very durable and flexible to use. A self-locking mechanism guarantees that the clamping devices are reliably clamped for the process at all times.



Advantages – Your benefits

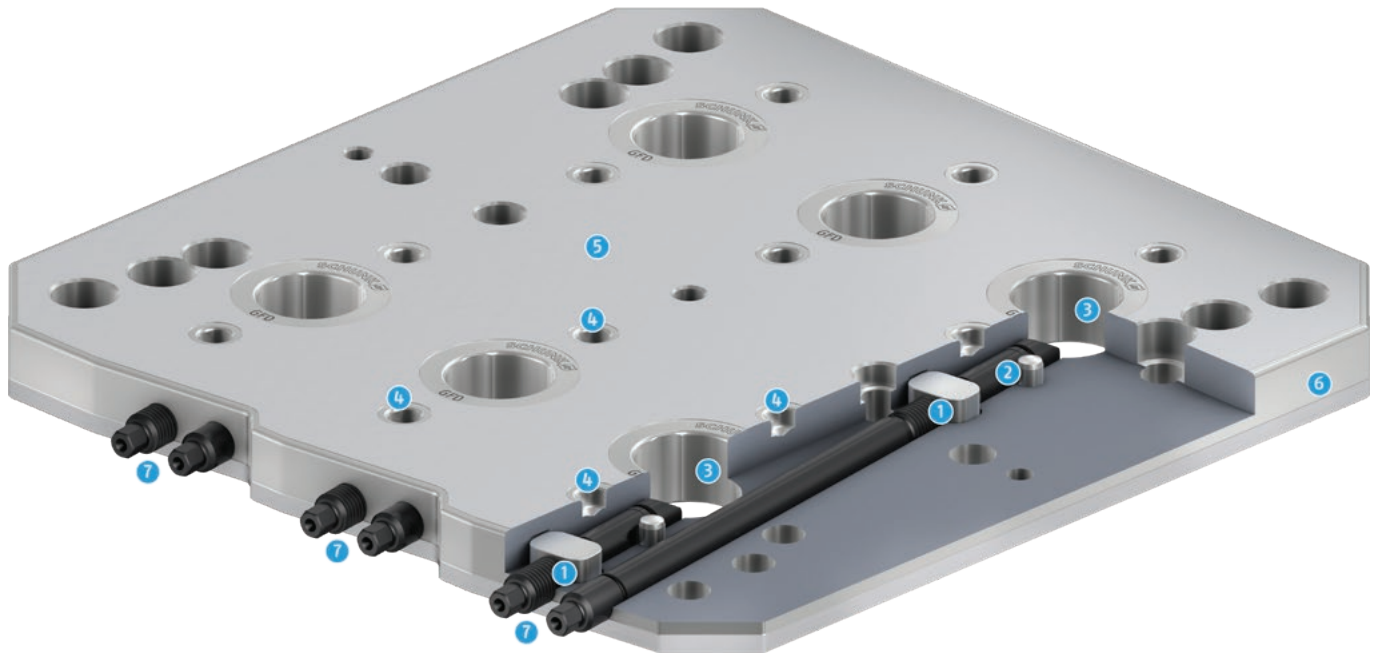
- + SCHUNK modular system**
Innumerable combinations of standard clamping devices to suit all different types of machines
- + Extremely flat design**
For maximum utilization of the machine room
- + High pull-down forces**
Ensure process reliability during machining
- + Positioning via polygonal mounting hole**
Very easy joining behavior with a repeat accuracy of <0.01 mm
- + 100% stainless**
Long life time and maximum process reliability
- + Easy handling**
Fast disassembly and cleaning
- + Form-fit, self-retained locking**
The full pull-down force is maintained throughout
- + Excellent price-performance ratio**
Optimal use of the pallet solution

Technical data

Description	Version	Material	Anti-rotation protection	Pull-down force	Max. torque
				[kN]	[Nm]
GFD-NSL-2 400 x 130	2-way set-up station	Stainless steel	●	40	30
GFD-NSL-3 600 x 130	3-way set-up station	Stainless steel	●	60	30
GFD-NSL-4 400 x 330	4-way set-up station	Stainless steel	●	80	30
GFD-NSL-6 400 x 400	6-way set-up station	Stainless steel	●	120	30
GFD-NSL-6 400 x 530	6-way set-up station	Stainless steel	●	120	30
GFD-NSL-10 497 x 532	10-way set-up station	Stainless steel	●	200	30

Function GFD

The clamping procedure of the clamping point is performed by manual actuation of a hexagon screw. The clamping slide presses the clamping pin into a precisely fitting half-shell (polygon) via a spindle. This process ensures that the clamping pin is positioned accurately in the x and y directions with a repeat accuracy of 0.01 mm. The force build-up is direct, linear and depends on the torque applied. The clamping slide is pulled into the clamping station with up to 20 kN and clamped reliably for the process as a result of the oblique pull-down surface on the clamping slide and clamping pin.



- 1 Spindle drive**
For transmitting the torque to the clamping slide
- 2 Clamping slide with large contact surfaces**
For transmitting the pull-down and holding forces
- 3 Polygonal mounting hole**
For precise positioning of the clamping devices
- 4 Indexing holes integrated by default**
Precise and backlash-free clamping of clamping devices with just one clamping pin interface
- 5 Corrosion-free stainless steel design**
For a long service life
- 6 Low height design**
For maximum utilization of the machine room
- 7 Actuation via hexagon connection**
For use of commercially available socket wrenches

Mechanical actuation

All GFD set-up stations are operated manually from the front. Each clamping point is driven individually via a standard hexagonal insert, and the clamping pin is clamped via a clamping slide.

Advantage: No additional pressure intensifier or hydraulic unit is required.



Flat set-up system

Thanks to the mechanical actuation, the GFD set-up stations are mounted very low above the machine table at just 30 mm. This maintains a maximum working range for the clamping device and workpiece in the machine tool.



Positioning via precisely fitting half-shell

A clamping slide presses the clamping pin into a precisely fitting half-shell with a ground short taper. The clamping pin is pulled downwards with 20 kN as a result of the oblique pull-down surface, and simultaneously clamped with repeat accuracy.



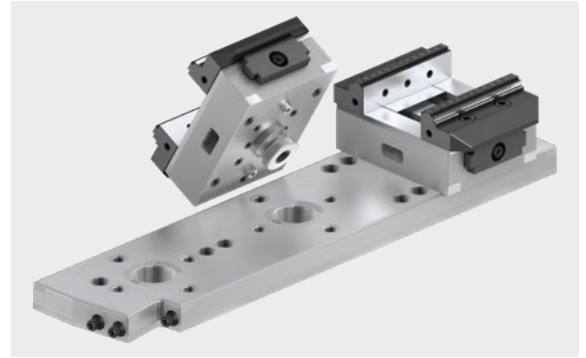
Unit pin

Compared to the pneumatic counterpart VERO-S, the clamping devices or fixtures are clamped via a standardized pin. Overdetermination is prevented by the clamping pins being pushed evenly and axially into the same precisely fitting half-shell position.



Indexing

For manual single palletizing, all GFD set-up stations are equipped with indexing holes at each clamping pin position. With the help of indexing pins, the clamping devices or the clamping pallet can be fixed in two positions with high precision and free from play.



100 mm grid dimension

A particular highlight of the GFD 4-way and 10-way set-up station is the grid dimension of 100 mm. Standard set-up and clamping stations only ever have distances of 200 mm. Thanks to the smaller grid size, several clamping devices can be placed on the one hand, and one clamping device directly in the middle of the set-up station on the other hand.



Made of stainless steel – long service life

All functional components are made of hardened stainless steel.



Set-up station

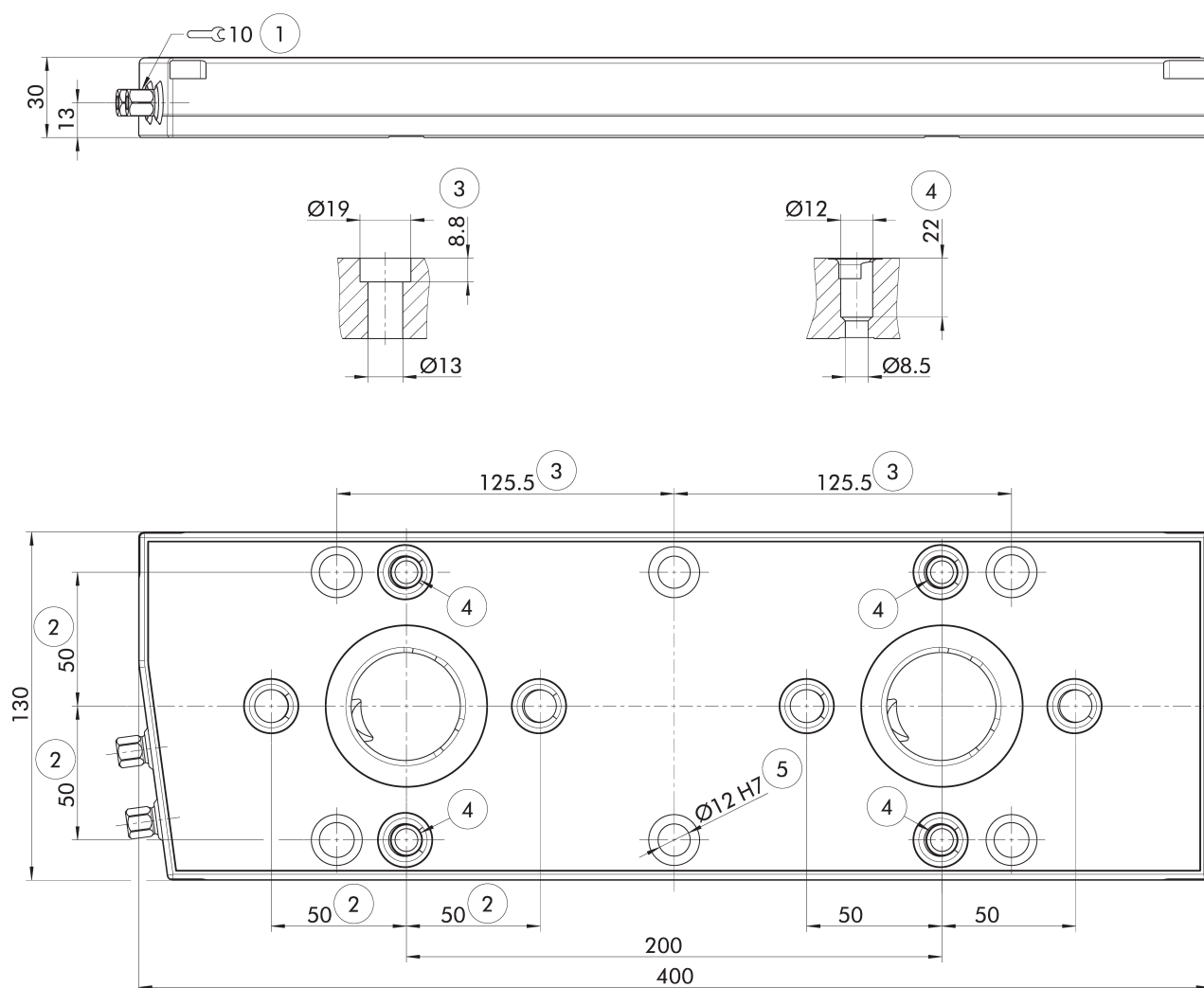
2-way set-up station with 4 x 90° GFD indexing each

Scope of delivery

Set-up station, operating manual; without clamping pins, without indexing pin

Technical data

Description	ID	Pull-down force [kN]	Max. torque [Nm]	Weight [kg]
GFD-NSL-2 400 x 130	1394829	40	30	11



Subject to technical changes.

- ① SW 10 locking mechanism
- ② Clearance 50 ±0.01 mm for indexing pin GFD-IXB
- ③ Prepared for 4x cylindrical screws M12, low head
- ④ Prepared for 4x GFD special screw M8
- ⑤ Prepared for set-up and centering set

Set-up station

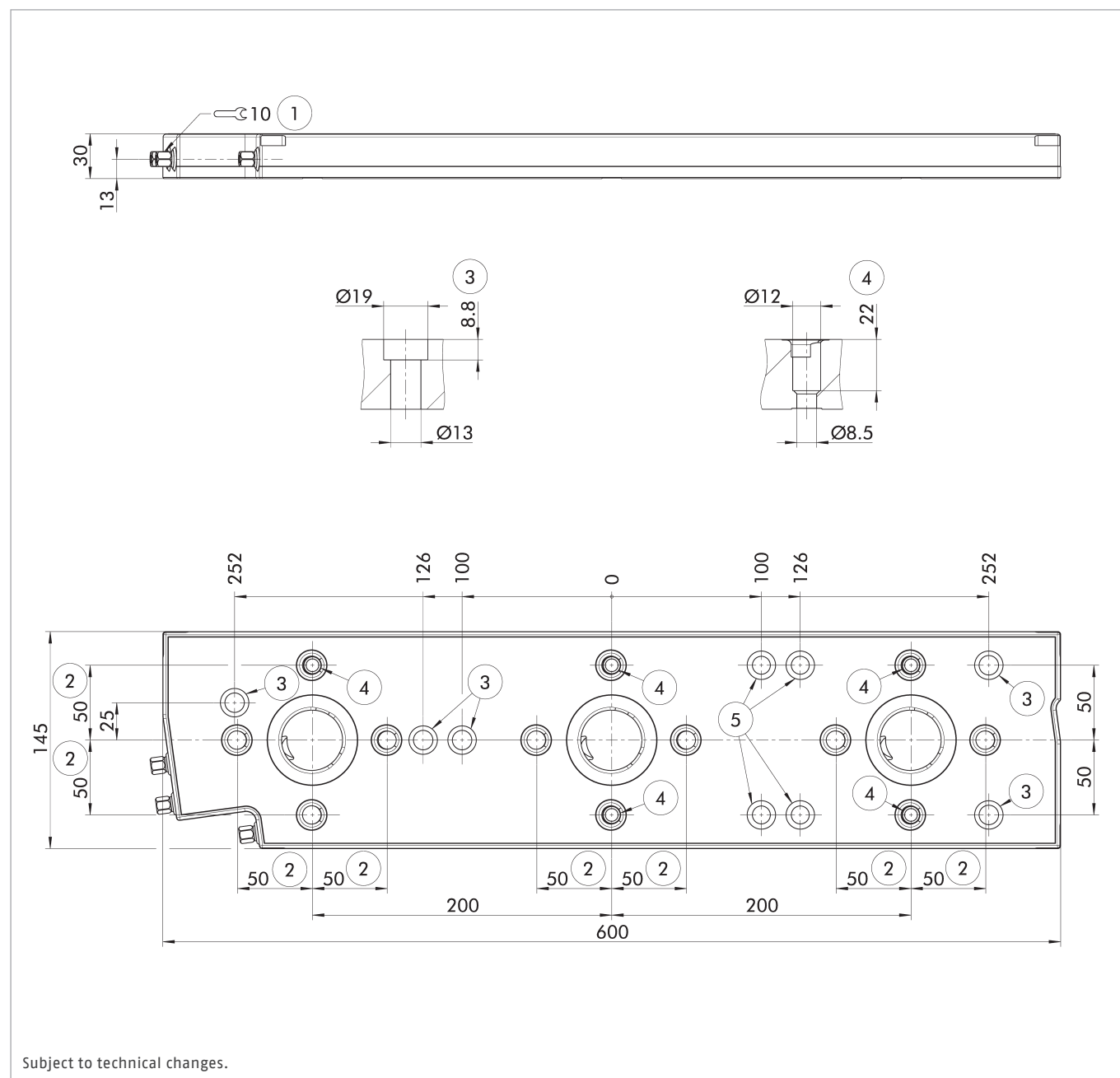
3-way set-up station with 4 x 90° GFD indexing each

Scope of delivery

Set-up station, operating manual; without clamping pins, without indexing pin

Technical data

Description	ID	Pull-down force [kN]	Max. torque [Nm]	Weight [kg]
GFD-NSL-3 600 x 130	1381161	60	30	18



- ① SW 10 locking mechanism
- ② Clearance 50 ±0.01 mm for indexing pin GFD-IXB
- ③ Prepared for 5x cylindrical screws M12, low head

- ④ Prepared for 5x GFD special screw M8
- ⑤ Prepared for set-up and centering set

Set-up station

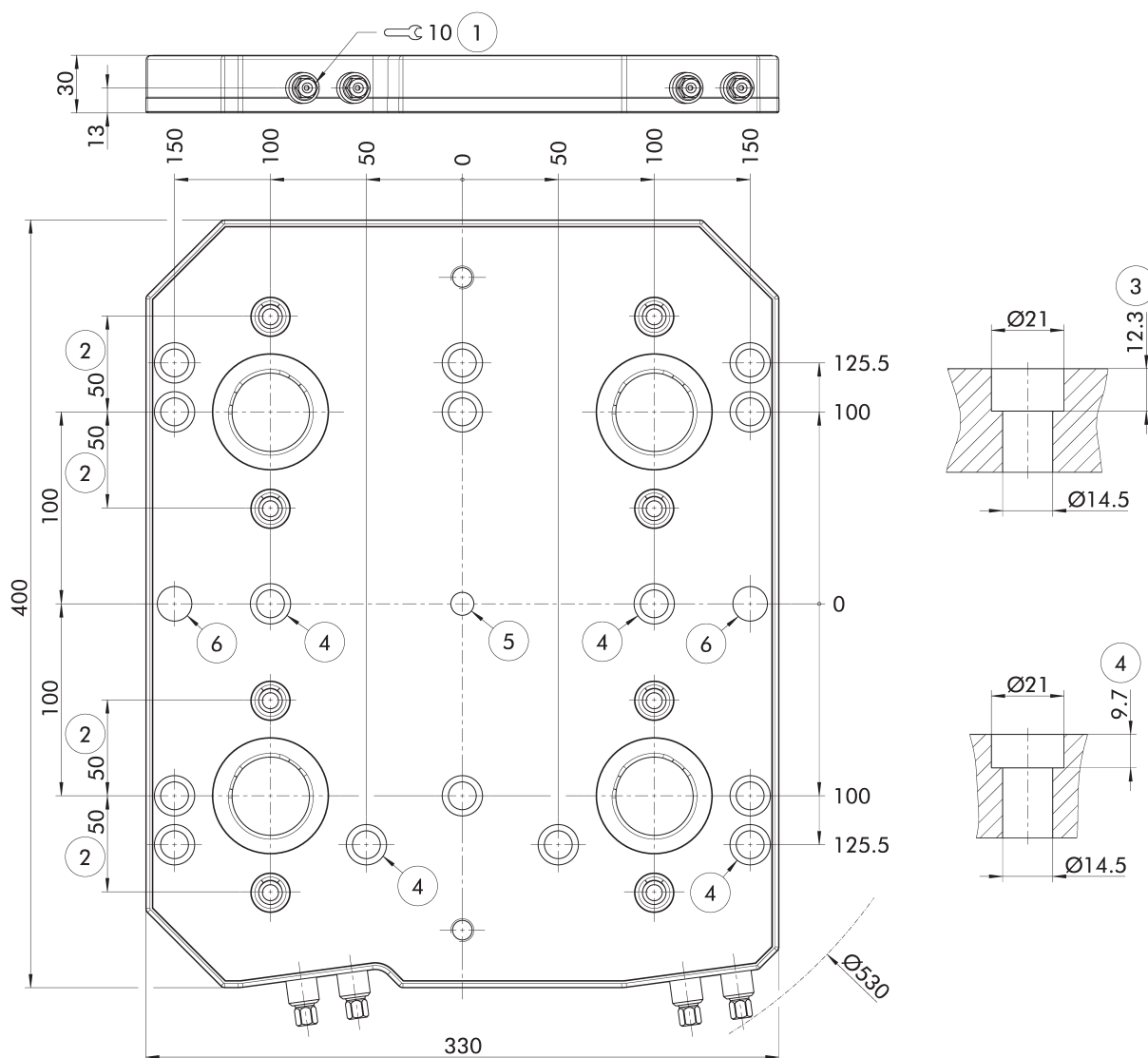
4-way set-up station with 2 x 180° GFD indexing each

Scope of delivery

Set-up station, operating manual; without clamping pins, without indexing pin

Technical data

Description	ID	Pull-down force [kN]	Max. torque [Nm]	Weight [kg]
GFD-NSL-4 400 x 330	1598321	80	30	28



Subject to technical changes.

- ① SW 10 locking mechanism
- ② Clearance 50 ±0.01 mm for indexing pin GFD-IXB
- ③ Prepared for 11x cylindrical screw M12
- ④ Prepared for 4x cylindrical screws M12, low head
- ⑤ Fitting bore Ø 12F7, prepared for centering pin
- ⑥ Fitting bore Ø 18G7, prepared for positioning pin

Set-up station

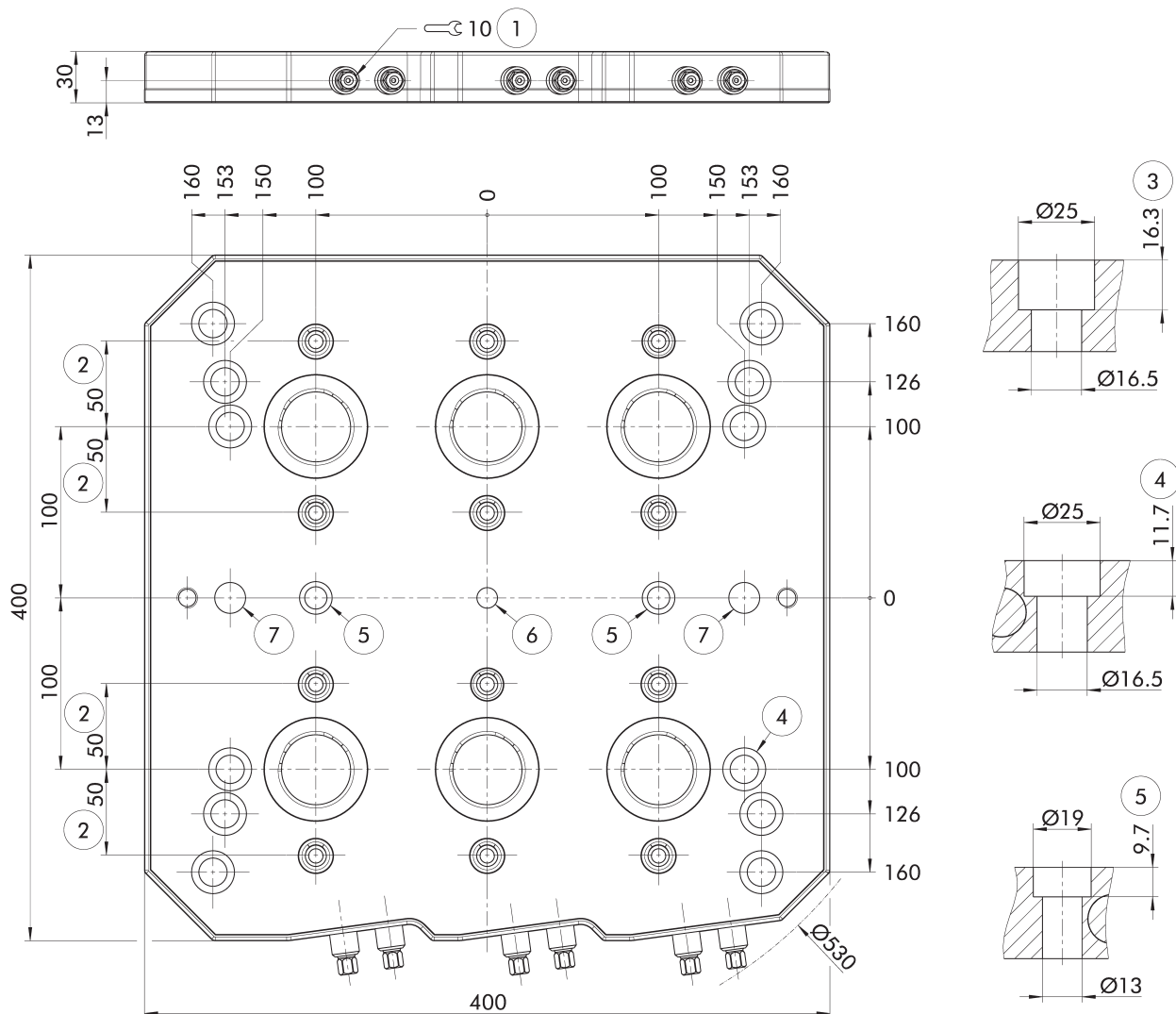
6-way set-up station with 2 x 180° GFD indexing each

Scope of delivery

Set-up station, operating manual; without clamping pins, without indexing pin

Technical data

Description	ID	Pull-down force [kN]	Max. torque [Nm]	Weight [kg]
GFD-NSL-6 400 x 400	1598322	120	30	33



Subject to technical changes.

- ① SW 10 locking mechanism
- ② Clearance 50 ±0.01 mm for indexing pin GFD-IXB
- ③ Prepared for 11x cylindrical screw M16
- ④ Prepared for 1x cylindrical screw M16, low head
- ⑤ Prepared for 2x cylindrical screws M12, low head
- ⑥ Fitting bore Ø 12F7, prepared for centering pin
- ⑦ Fitting bore Ø 18G7, prepared for positioning pin

Set-up station

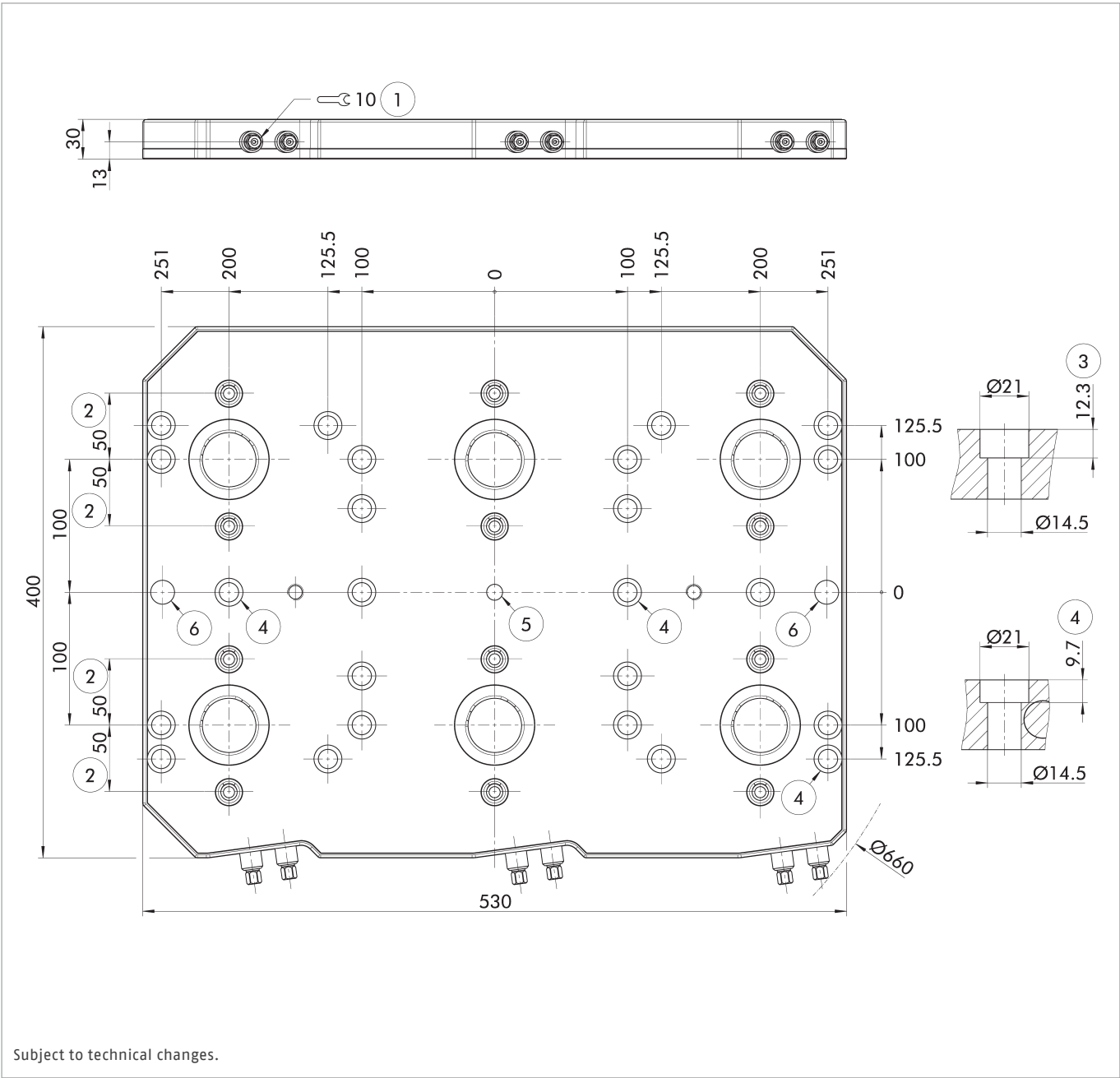
6-way set-up station with 2 x 180° GFD indexing each

Scope of delivery

Set-up station, operating manual; without clamping pins, without indexing pin

Technical data

Description	ID	Pull-down force [kN]	Max. torque [Nm]	Weight [kg]
GFD-NSL-6 400 x 530	1598323	120	30	45



- ① SW 10 locking mechanism
- ② Clearance 50 ±0.01 mm for indexing pin GFD-IXB
- ③ Prepared for 21x cylindrical screw M12
- ④ Prepared for 3x cylindrical screws M12, low head
- ⑤ Fitting bore Ø 12F7, prepared for centering pin
- ⑥ Fitting bore Ø 18G7, prepared for positioning pin

Set-up station

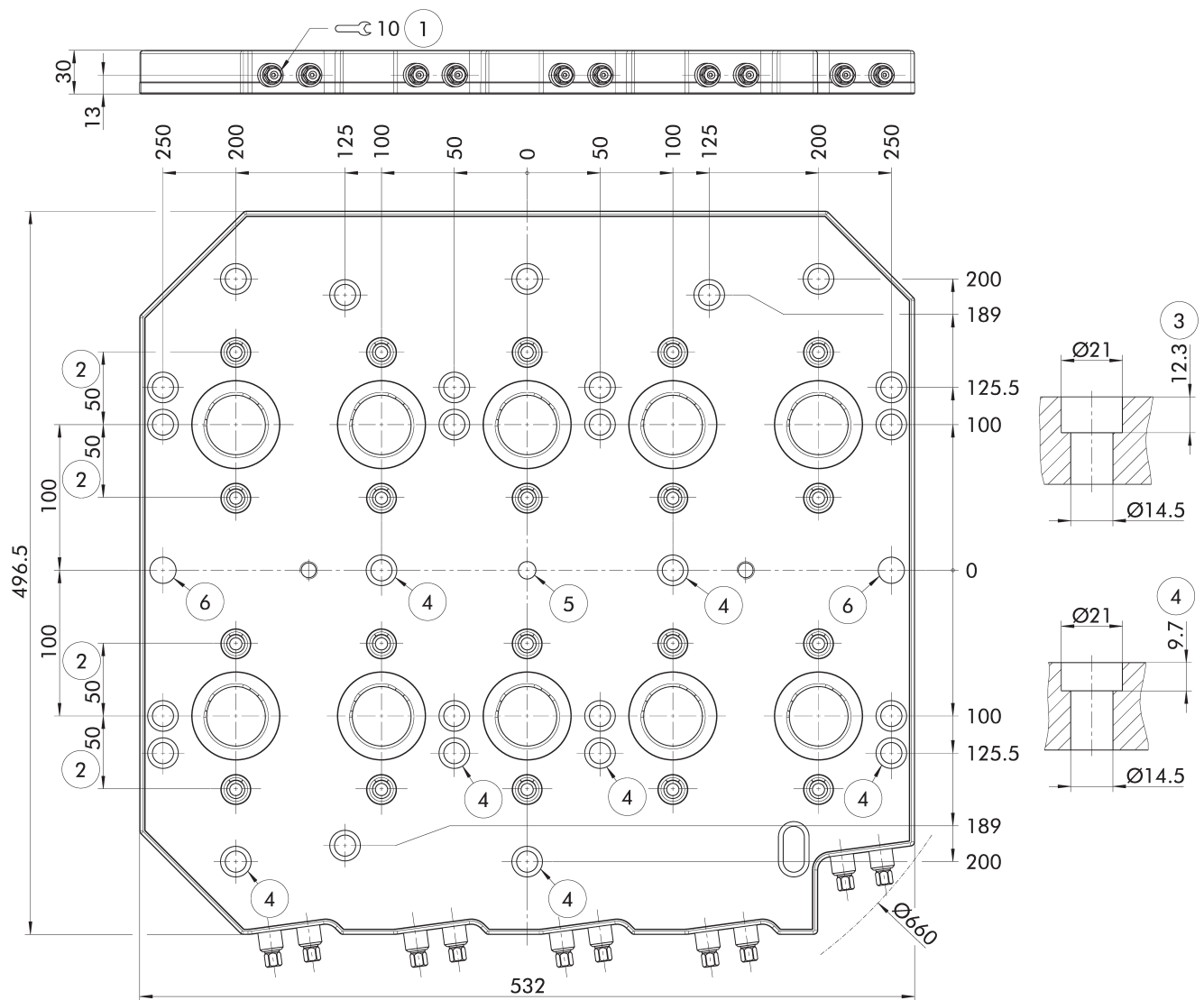
10-way set-up station with 2 x 180° GFD indexing each

Scope of delivery

Set-up station, operating manual; without clamping pins, without indexing pin

Technical data

Description	ID	Pull-down force [kN]	Max. torque [Nm]	Weight [kg]
GFD-NSL-10 497 x 532	1598324	200	30	54



Subject to technical changes.

- | | |
|--|---|
| ① SW 10 locking mechanism | ④ Prepared for 7x cylindrical screws M12, low head |
| ② Clearance 50 ±0.01 mm for indexing pin GFD-IXB | ⑤ Fitting bore Ø 12F7, prepared for centering pin |
| ③ Prepared for 20x cylindrical screw M12 | ⑥ Fitting bore Ø 18G7, prepared for positioning pin |

Accessories

Clamping pin GFD-SP

Clamping pin for positive connection with GFD set-up stations.



Suitable for	Description	ID
GFD-NSL-2 400 x 130	GFD-SP 40	0433600
GFD-NSL-3 600 x 130		
GFD-NSL-4 400 x 330		
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		

Indexing pin GFD

Indexing pins for position orientation of clamping pallets and clamping devices on GFD set-up stations.



Suitable for	Description	ID
GFD-NSL-2 400 x 130	GFD-IXB	1367937
GFD-NSL-3 600 x 130		
GFD-NSL-4 400 x 330		
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		

Torque wrench 5 – 50 Nm

Serves for applying a defined torque. With 3/8" square drive.



Suitable for	Description	ID
GFD-NSL-2 400 x 130	GSH-D 5-50	0432355
GFD-NSL-3 600 x 130		
GFD-NSL-4 400 x 330		
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		

Hexagonal insert AF 10

Suitable for square drive 3/8".



Suitable for	Description	ID
GFD-NSL-2 400 x 130	GSK-I SW10-3/8"	1537874
GFD-NSL-3 600 x 130		
GFD-NSL-4 400 x 330		
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		

Clamping set with GFD special screw

For direct fastening of clamping devices including T-nut.



Suitable for	Description	T-slot	ID
GFD-NSL-2 400 x 130	GSC-G-5 M8-T12	12 mm/M8	1542851
GFD-NSL-3 600 x 130			
GFD-NSL-2 400 x 130	GSC-G-5 M8-T14	14 mm/M8	1451024
GFD-NSL-3 600 x 130			
GFD-NSL-2 400 x 130	GSC-G-5 M8-T16	16 mm/M8	1587071
GFD-NSL-3 600 x 130			
GFD-NSL-2 400 x 130	GSC-G-5 M8-T18	18 mm/M8	1449313
GFD-NSL-3 600 x 130			

Clamping set with cylindrical screw, low head

For direct fastening of clamping devices including T-nut.



Suitable for	Description	T-slot	ID
GFD-NSL-2 400 x 130	GSC-GN-1 M10-T12	12 mm/M10	1383603
GFD-NSL-3 600 x 130			
GFD-NSL-2 400 x 130			
GFD-NSL-3 600 x 130			
GFD-NSL-4 400 x 330			
GFD-NSL-6 400 x 400			
GFD-NSL-6 400 x 530	GSC-GN-1 M12-T14	14 mm/M12	1426244
GFD-NSL-10 497 x 532			
GFD-NSL-2 400 x 130	GSC-GN-1 M12-T16	16 mm/M12	1394831
GFD-NSL-3 600 x 130			
GFD-NSL-4 400 x 330			
GFD-NSL-6 400 x 400			
GFD-NSL-6 400 x 530			
GFD-NSL-10 497 x 532			
GFD-NSL-2 400 x 130	GSC-GN-1 M12-T18	18 mm/M12	1399453
GFD-NSL-3 600 x 130			
GFD-NSL-4 400 x 330			
GFD-NSL-6 400 x 400			
GFD-NSL-6 400 x 530			
GFD-NSL-10 497 x 532			

Cylindrical screw

For fastening GFD set-up stations in combination with T-nuts.



Suitable for	Description	ID
GFD-NSL-4 400 x 330	GZSC M12x40	1308121
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532	GZSC M12x45	40107481
GFD-NSL-4 400 x 330		
GFD-NSL-6 400 x 530	GZSC M16x50	1376608
GFD-NSL-10 497 x 532		

Cylinder screw, low head

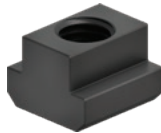
For fastening GFD set-up stations in combination with T-nuts.



Suitable for	Description	ID
GFD-NSL-6 400 x 400	GZSC-N M16x30	1581501
GFD-NSL-6 400 x 400	GZSC-N M16x45	1494132

T-nuts

For fastening GFD set-up stations in combination with cylindrical screws.



Suitable for	Description	T-slot	ID
GFD-NSL-4 400 x 330	GTN M12-T14	14 mm/M12	1303127
GFD-NSL-6 400 x 530			
GFD-NSL-10 497 x 532			
GFD-NSL-4 400 x 330	GTN M12-T18	18 mm/M12	1356662
GFD-NSL-6 400 x 530			
GFD-NSL-10 497 x 532			
GFD-NSL-6 400 x 400	GTN M16-T22	22 mm/M16	1515876

Centering pin

For high-precision centering of KONTEC clamping devices on the machine table.



Suitable for	Description	ID
GFD-NSL-4 400 x 330	GCP Ø12n6-Ø30h6	1430741
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		
GFD-NSL-4 400 x 330	GCP Ø12n6-Ø32h6	1426237
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		
GFD-NSL-4 400 x 330	GCP Ø12n6-Ø50h6	1417596
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		

Positioning pin

For position orientation of KONTEC clamping devices on T-slot tables.



Suitable for	Description	ID
GFD-NSL-4 400 x 330	GPP Ø18n6-Ø14h6	1303129
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		
GFD-NSL-4 400 x 330	GPP Ø18n6-Ø16h6	1464316
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		
GFD-NSL-4 400 x 330	GPP Ø18n6-Ø18h6	1343539
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		
GFD-NSL-4 400 x 330	GPP Ø18n6-Ø20h6	1405843
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		
GFD-NSL-4 400 x 330	GPP Ø18n6-Ø22h6	1579400
GFD-NSL-6 400 x 400		
GFD-NSL-6 400 x 530		
GFD-NSL-10 497 x 532		

Alignment and centering set

For quick and easy alignment and fastening on T-slot tables.



Suitable for	Description	T-slot	ID
GFD-NSL-2 400 x 130	GAZ-7 T12	12 mm/M10	1383597
GFD-NSL-3 600 x 130			
GFD-NSL-2 400 x 130	GAZ-7 T14	14 mm/M10	1421522
GFD-NSL-3 600 x 130			
GFD-NSL-2 400 x 130	GAZ-7 T16	16 mm/M10	1375817
GFD-NSL-3 600 x 130			
GFD-NSL-2 400 x 130	GAZ-7 T18	18 mm/M10	1399440
GFD-NSL-3 600 x 130			



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