



KONTEC KSC-F

**Highly efficient single-acting
vise especially for pallet
automation**

Highly efficient all-rounder with quick lever clamping for machining raw and finished parts

SCHUNK KONTEC KSC-F single-acting vise with fixed jaw is especially suitable for use in automated machine loading. They score with a quick adjustment of the clamping range, flat design, and low weight. These are the perfect conditions for the use in pallet storage units. The sizes KSC-F 80, KSC-F 125 and KSC-F 160 are particularly designed for the common pallet sizes 320 x 320 mm, 400 x 400 mm, and 500 x 500 mm. It achieves high clamping forces even at a comparably low torque. Thanks to the interface for quick-change pallet systems, the single-acting vise can be optimally combined with the large NSE3 and GFD modular system to greatly reduce set-up times on machine tools.

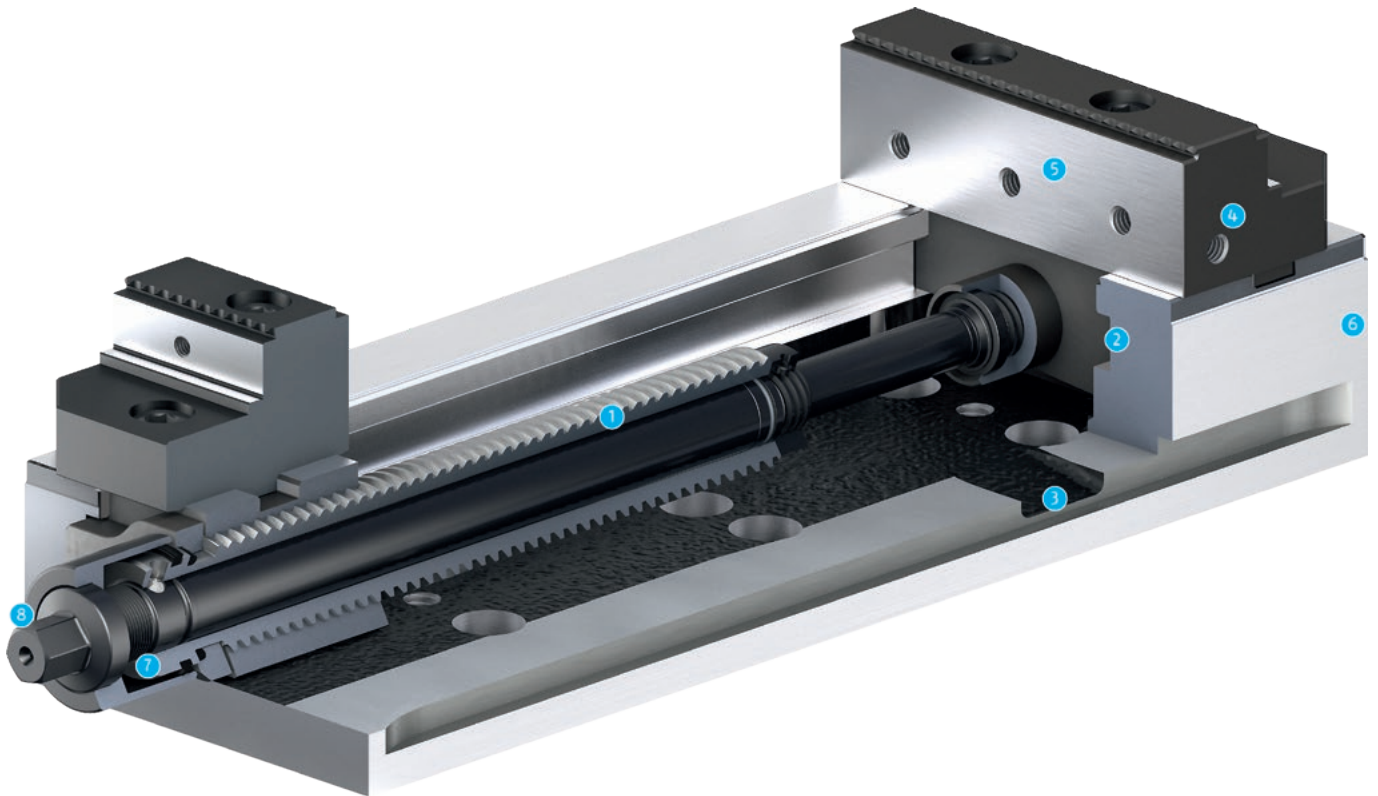


Advantages – Your benefits

- + Extremely flat design**
For maximum utilization of the machine room
- + Quick clamping via torque wrench**
Simple, fast, and reliable workpiece clamping
- + High clamping forces**
Ensure process reliability during machining
- + Large clamping range**
High level of flexibility
- + Lateral drainage slots**
For drainage of coolant and chips
- + Wide range of applications**
Suitable for rough and finished parts machining
- + Wide jaw program**
Optimal adaptation to new clamping tasks
- + Optimum jaw support for O.D. and I.D. clamping due to a very long base jaw guidance**
Allows high clamping forces at a long service life
- + Clamping by tension – prevents the base body from bending**
Maximum machining precision
- + Integrated NSE3 and GFD interface**
Minimization of set-up times. Can be flexibly combined with the large modular quick-change pallet system

Function KSC-F

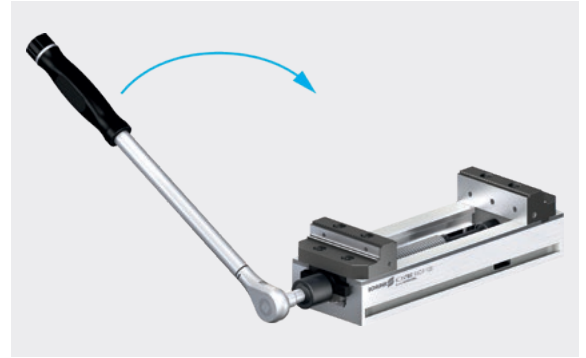
SCHUNK KONTEC KSC-F single-acting clamping vises are manual direct clamping vises. The drive takes place via a spindle. Force generation is carried out with a force transmission (spindle in the spindle) and is linearly. The movable jaw is moved by turning the spindle in direction of the fixed jaw. The clamping force depends on the torque. The clamping range depends on the used jaw range.



- 1 Spindle drive**
For the highest of clamping forces
- 2 Long jaw guidance**
Offers optimal support for O.D.- and I.D. clamping
- 3 Drainage slots**
For coolant and chips
- 4 Mounting thread**
For workpiece stops
- 5 Standard jaw interface**
For the use of standard top jaws from SCHUNK
- 6 Low height design**
Expands your machine's workspace
- 7 Mechanical force transmission**
For self-locking and vibration-resistant clamping
- 8 Actuation via hexagon connection**
This ensures easy operation

Quick clamping

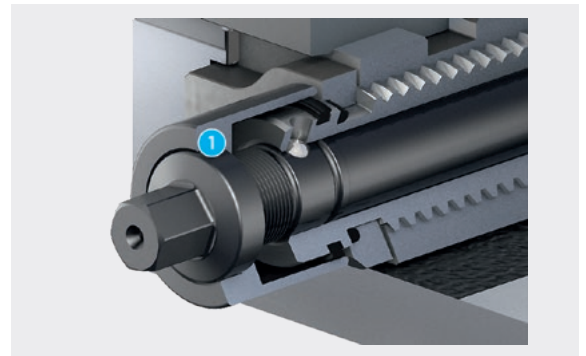
Due to 160° quick clamping, workpieces are clamped in under a second and the vise reliably locked. An additional retightening of the torque wrench or an additional angle drive is no longer required.



Force actuation via fine thread

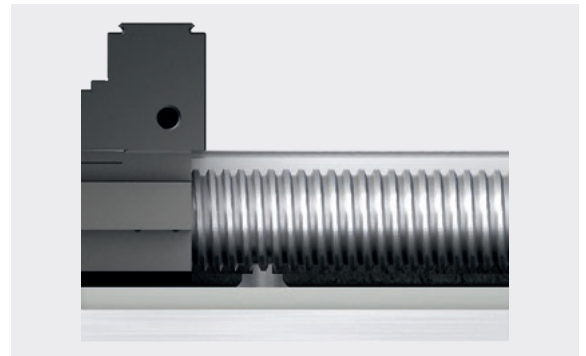
A rough quick adjustment of the clamping range is carried out via the main spindle. In the event of workpiece contact, the main spindle is uncoupled via a ball mechanism and the force transmission is initialized via a fine thread. This is how the KSC-F achieves high clamping forces even at a comparably low torque.

1 Fine thread



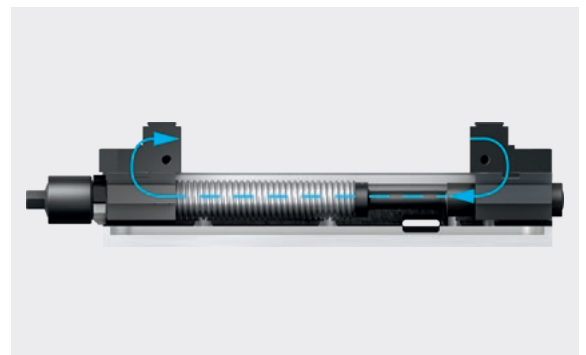
Quick-adjustment of the clamping range

Due to the large spindle pitch, the jaw stroke can be passed through with a minimum of turns. In order to accelerate this process in addition, a crank can be used.



Clamping by tension

The spindle is subjected to tensile force during the clamping process. The closed force system prevents the base body from bending. This makes the KSC-F ideal for the use with quick-change pallet systems.



Threads for stops in the base jaws

The lateral threads in the clamping jaws allow a quick and easy attachment of workpiece-specific stops.

1 Thread for stops



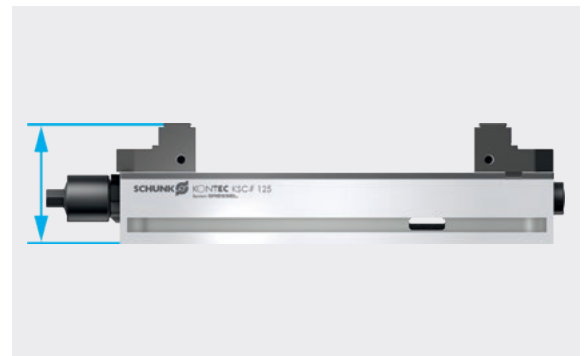
Clamping jaws with a very large clamping range

With the reversible grip jaws, a very large clamping range can be covered thanks to simple turning over. This benefit particularly pays off as it allows smaller and therefore lighter vises to be used.



Extremely flat design

Due to the extremely flat design, the KSC-F takes up only a small amount of space in the machine. The largest part of the machine room is available for the workpiece and for machining.

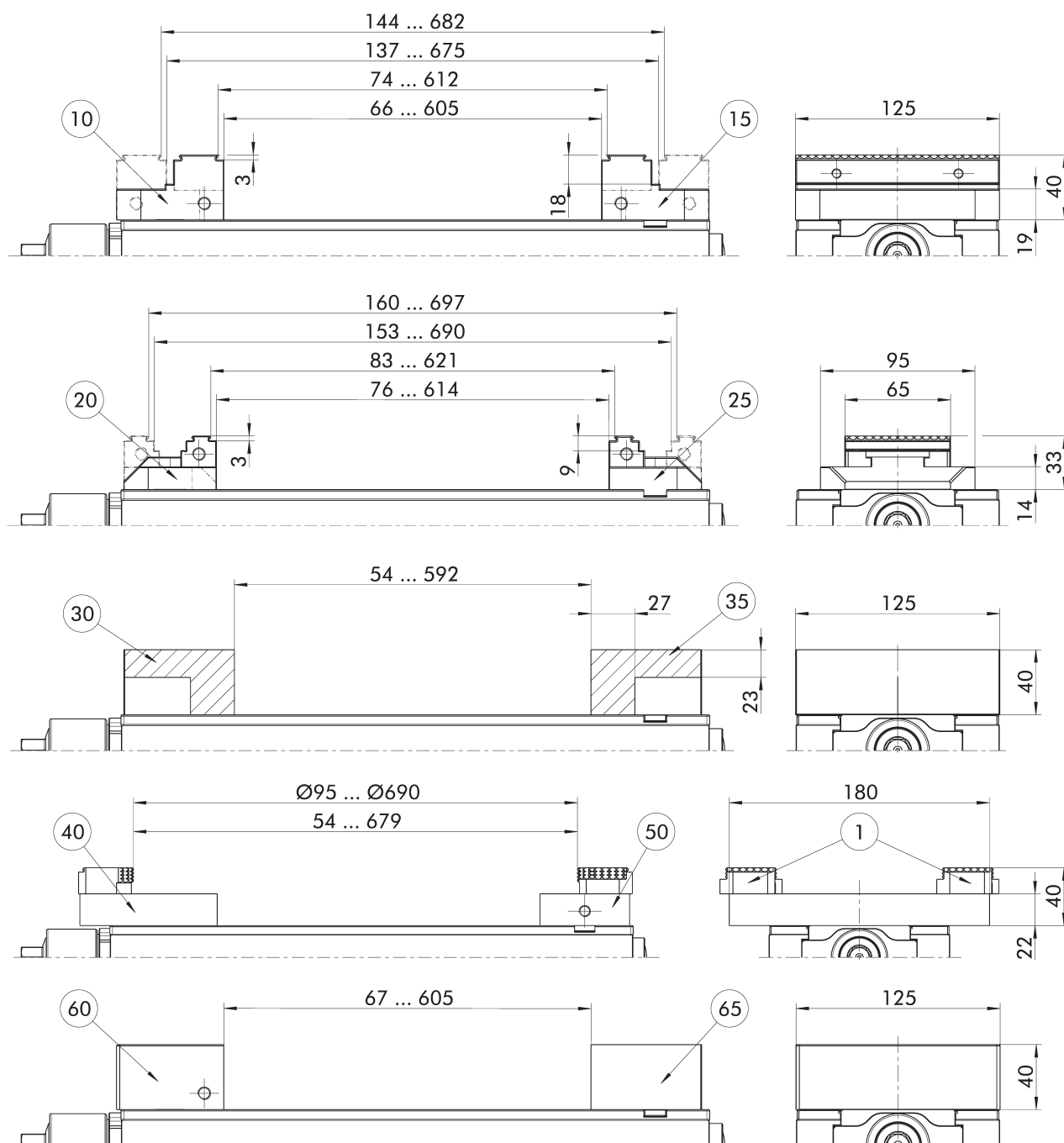


Mounting options

The KSC-F offers multiple integrated options for mounting on the machine table. The fixed-jaw vise can be mounted on the NSE3 or GFD quick-change pallet modules via the preconfigured interface for quick-change pallet systems to minimize set-up times. Alternatively, the vise can be mounted with screws or clamping claws.

- 1 Mounting via quick-change pallet system
- 2 Mounting via clamping claws
- 3 Mounting via screws





Suitable system jaws with position number on the next page.
Subject to technical changes.

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

Technical data

Description	ID	Width of the clamping vise [mm]	Max. clamping force [kN]	Max. torque [Nm]	Weight [kg]
KSC-F 125-740	1440492	125	40	90	30

Scope of delivery

Vise, operating manual; without system jaws

Notes

System jaws

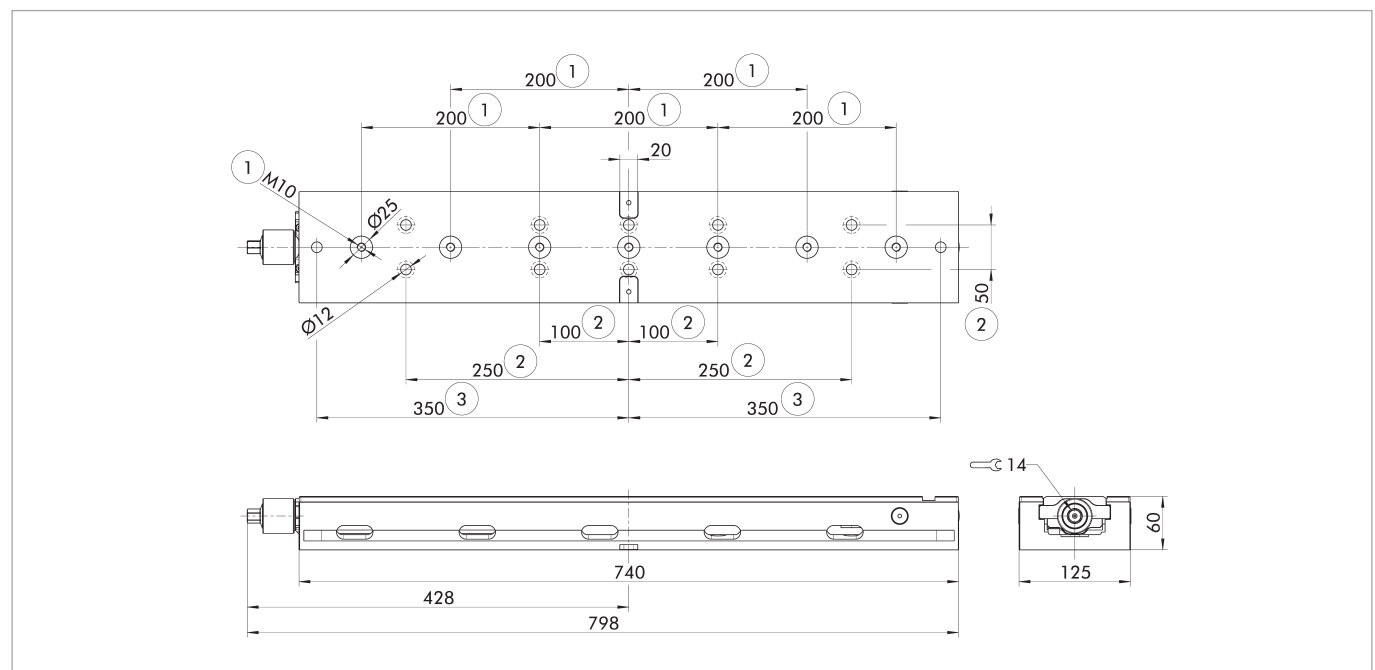
The clamping device and the system jaws have to be put together separately for this version.

Use of VERO-S

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

Suitable system jaws

Description	Pos.	Description	ID	Width [mm]	Depth [mm]	Height [mm]	Weight [kg]
Reversible grip jaw	10	SGWB-G3-B 125-66-40	0432490	125	66	40	1.8
Reversible grip jaw	15	SGWB-G3-F 125-66-40	0432489	125	66	40	1.8
Reversible grip jaw	20	SGWB-G3-B 65-57-33	1514380	65	57	33	0.9
Reversible grip jaw	25	SGWB-G3-F 65-57-30	1587366	65	57	30	0.9
Aluminum jaw	30	SGAL-B 125-68-40	0432469	125	68	40	1
Aluminum jaw	35	SGAL-F 125-68-40	0432492	125	68	40	1.1
Swivel plate	40	SGP-3 180-95-22	0432470	180	95	22	2.8
Adapter plate	50	SGA-4 180-62-22	0432493	180	62	22	1.9
Monoblock jaw	60	SGBB-B 125-66-40	1349858	125	66	40	2.6
Monoblock jaw	65	SGBB-F 125-66-40	1349857	125	66	40	2.6



① Prepared for NSE3 and GFD clamping pins

③ Prepared for dowel pin set Ø 12m6

② Grid dimension prepared for screws M12 and fitting screws M12

System jaws

Reversible grip jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-G3-B 125-57-33		0432474
KSC-F 125-740	SGWB-G3-B 125-66-40	W-125-1	0432490

Reversible grip jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-G3-F 125-57-33		1359848
KSC-F 125-740	SGWB-G3-F 125-66-40	W-125-1	0432489

Reversible carbide-grip jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-CG3-B 125-57-33		1514374

Reversible carbide-grip jaw

Design as fixed jaw.
With carbide-grip step 3 mm (up to 58 HRC) and smooth clamping face on both sides.



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-CG3-F 125-57-33		1590610

Reversible jaw with embossed profile

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-GL-B 125-57-33		1514378

Reversible jaw with embossed profile

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-GL-F 125-57-33		1627092

Reversible jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-G3-B 125-59-40	W-125-1	0430387

Reversible jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-G3-F 125-59-40	W-125-1	1586742

Reversible grip jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-G3-B 65-57-33		1514380

Reversible grip jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-G3-F 65-57-30		1587366

Aluminum jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGAL-B 125-68-40		0432469

Aluminum jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGAL-F 125-68-40		0432492

Steel jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGS-B 125-68-40		1452569

Steel jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGS-F 125-68-40		1559434

Swivel plate

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGP-3 180-95-22	W-38	0432470

Adapter plate

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGA-4 180-62-22	W-38	0432493

Monoblock jaw

Design as movable jaw.
Jaw with a smooth clamping face for mounting top jaws.



Suitable for	Description	Interface	ID
KSC-F 125-740	SGBB-B 125-66-40	W-125-1	1349858

Monoblock jaw

Design as fixed jaw.
Jaw with a smooth clamping face for mounting top jaws.



Suitable for	Description	Interface	ID
KSC-F 125-740	SGBB-F 125-66-40	W-125-1	1349857

Reversible smooth jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-S8-B 125-57-33		1518691

Reversible smooth jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SGWB-S8-F 125-57-33		1518692

5-axis jaw

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



Suitable for	Description	Interface	ID
KSC-F 125-740	SG5A-B 125-44.5-33		1374778
KSC-F 125-740	SG5A-B 125-45.5-40	W-125-1	0432472

5-axis jaw

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

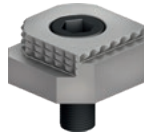


Suitable for	Description	Interface	ID
KSC-F 125-740	SG5A-F 125-44.5-33		1374779
KSC-F 125-740	SG5A-F 125-45.5-40	W-125-1	1551488

Top jaws

6-way reversible jaws grip

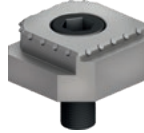
With five grip steps as well as a coated clamping face.



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

6-way reversible jaw carbide grip

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



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

Jaw profiled

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



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

Serrated jaw

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



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

Ground jaw

With a completely ground clamping face.



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

Soft jaw

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



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

Stepped jaw

With ground step, 8 mm.



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

Stepped jaw

With ground step, 17 mm.



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

Stepped jaw

With coated step, 5 mm.



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

Stepped jaw

With grip step 3 mm and ground step 18 mm.



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

Stepped jaw

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



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

Stepped jaw

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



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

Stepped jaw

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



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

Stepped jaw

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



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

Stepped jaw

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



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

Stepped jaw

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



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

Stepped jaw

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



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

Stepped jaw with T-slot

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



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

Stepped jaw with T-slot

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



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

Stepped jaw with T-slot

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



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

Positioning bar

To suit all stepped jaws with T-slot.



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

Grip jaw

For embossed clamping of unhardened materials up to 22 HRC.



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

Chuck jaw with locating pins

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



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

Prism jaw, ground

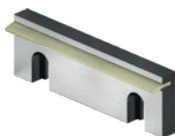
For precise clamping of round workpieces.
100 = Ø11 - Ø41 mm.
125 = Ø14 - Ø48 mm.
160 = Ø16 - Ø60 mm.



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

Spring leaf pull-down jaw

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



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

Spring plate pull-down jaw

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



Description	Width mm	Height mm	Depth mm	Interface	ID
GFB 125-35-10	125	35	10	W-125-1	0432498
GFB 125-39-10	125	39	10	W-125-1	0430192

Precision pull-down jaw

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



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

Accessories

Clamping force tester

For measuring the jaw clamping force of stationary clamping devices.



Suitable for	Description	ID
KSC-F 125-740	IFT SST Set	1475766

Standard clamping pins

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



Suitable for	Description	ID
KSC-F 125-740	SPA 40-K	0432369
KSC-F 125-740	SPB 40-K	0432370

Clamping pin GFD-SP

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



Suitable for	Description	ID
KSC-F 125-740	GFD-SP 40	0433600

Torque wrench 10 – 100 Nm

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



Suitable for	Description	ID
KSC-F 125-740	GSH-D 10-100	0432477

Actuating lever, articulated

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



Suitable for	Description	ID
KSC-F 125-740	GSH-G 1/2"	0432478

Hexagonal insert SW 14

Suitable for square drive 1/2".



Suitable for	Description	ID
KSC-F 125-740	GSK-I SW14-1/2"	0432619

Workpiece stop

Workpiece stop with minimum space requirements and continuously adjustable stop slide.
Including stop slider 40 and 80 mm.



Suitable for	Description	ID
KSC-F 125-740	GWSA M8-23	1645258

Magnetic workpiece stop, small

For quick and easy attachment to system jaws or vises.



Suitable for	Description	ID
KSC-F 125-740	GWSA-M 60 x 15	1391293

Magnetic workpiece stop, large

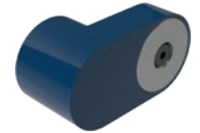
For quick and easy attachment to system jaws or vises.



Suitable for	Description	ID
KSC-F 125-740	GWSA-M 115 x 15	1391331

Extensions

As an accessory for the magnetic workpiece stops.



Suitable for	Description	ID
KSC-F 125-740	GWSA-V Ø68 x 30	1394477

Clamping screws for clamping claws

Used in combination with clamping claws for fastening clamping devices.



Suitable for	Description	T-slot	ID
KSC-F 125-740	GSC-S M10-T12	12 mm/M10	0432043
KSC-F 125-740	GSC-S M12-T14	14 mm/M12	0432044
KSC-F 125-740	GSC-S M14-T16	16 mm/M14	0432045
KSC-F 125-740	GSC-S M16-T18	18 mm/M16	0432046
KSC-F 125-740	GSC-S M16-T20	20 mm/M16	1550423
KSC-F 125-740	GSC-S M16-T22	22 mm/M16	1550424

Clamping screws for base body

Used for directly attaching clamping devices via the base body.



Suitable for	Description	T-slot	ID
KSC-F 125-740	GSC-G-1 M10-T12	12 mm/M10	0430422
KSC-F 125-740	GSC-G-1 M12-T14	14 mm/M12	0430423
KSC-F 125-740	GSC-G-1 M12-T16	16 mm/M12	0430424
KSC-F 125-740	GSC-G-1 M12-T18	18 mm/M12	0430425

Fitting screws

For precise position orientation and mounting of manual clamping vises on the machine table.



Suitable for	Description	ID
KSC-F 125-740	GPSC-1 Ø12f7-M12	0432047

Precision T-nuts

Suitable for all conventional T-groove widths of machine tables.



Suitable for	Description	T-slot	ID
KSC-F 125-740	GPN M6-T12	12 mm/M6	0490590
KSC-F 125-740	GPN M6-T14	14 mm/M6	0490547
KSC-F 125-740	GPN M6-T16	16 mm/M6	0490548
KSC-F 125-740	GPN M6-T18	18 mm/M6	0490587
KSC-F 125-740	GPN M6-T20	20 mm/M6	1359734
KSC-F 125-740	GPN M6-T22	22 mm/M6	0490621

Workpiece Supports Set**Set of workpiece supports – width 125 mm**

Suitable for system jaws H = 40 mm with grip level 3 mm.
Heights = 9, 22, 27, 32, and 34 mm.



Suitable for	Description	ID
KSC-F 125-740	GWU-S grip 125-40	1394229

Cylinder pin set

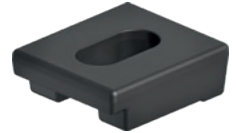
For easier assembly of the clamping device on the machine table.



Suitable for	Description	ID
KSC-F 125-740	GZS Ø12m6	1373755

Clamping claws

For quick and easy mounting of SCHUNK clamping devices.



Suitable for	Description	ID
KSC-F 125-740	GSPR-A 50-57	0490604

Cover screw

Used to cover unused clamping insert mounting holes on pendulum and adapter plates.



Suitable for	Description	ID
KSC-F 125-740	GCS Ø22-M12	1307880

Workpiece supports

Workpiece supports – width 125 mm

In different heights.

1 Set = 2 pieces



Suitable for	Description	Height mm	ID
KSC-F 125-740	GWU-M 125-8	8	1450266
KSC-F 125-740	GWU-M 125-9	9	1462567
KSC-F 125-740	GWU-M 125-10	10	1411328
KSC-F 125-740	GWU-M 125-12	12	1447369
KSC-F 125-740	GWU-M 125-15	15	1411350
KSC-F 125-740	GWU-M 125-20	20	1452308
KSC-F 125-740	GWU-M 125-22	22	1457551
KSC-F 125-740	GWU-M 125-23	23	1411380
KSC-F 125-740	GWU-M 125-25	25	1484475
KSC-F 125-740	GWU-M 125-27	27	1461008
KSC-F 125-740	GWU-M 125-30	30	1411387
KSC-F 125-740	GWU-M 125-31	31	1484477
KSC-F 125-740	GWU-M 125-32	32	1411398
KSC-F 125-740	GWU-M 125-33	33	1484478
KSC-F 125-740	GWU-M 125-34	34	1484480
KSC-F 125-740	GWU-M 125-35	35	1411391
KSC-F 125-740	GWU-M 125-36	36	1429618
KSC-F 125-740	GWU-M 125-37	37	1411395
KSC-F 125-740	GWU-M 125-38	38	1429615



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