



## 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.

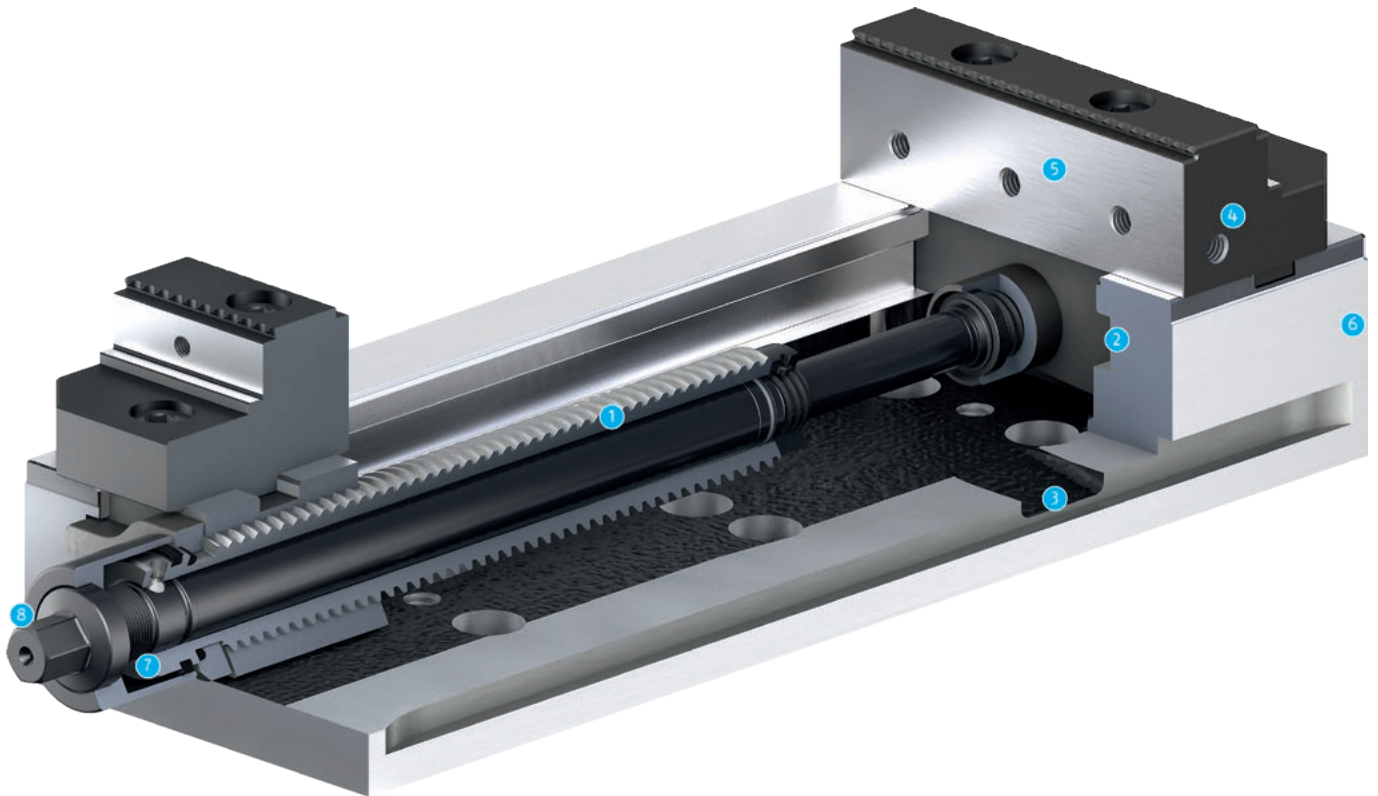


## Advantages – Your benefits

- + 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

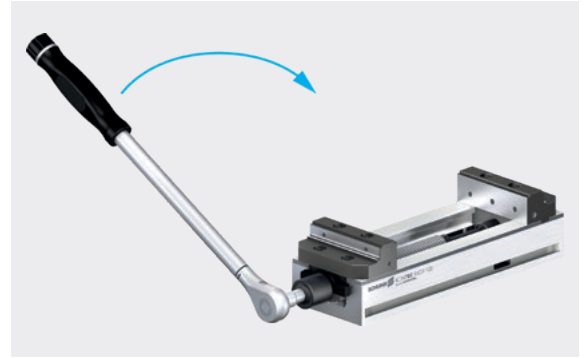
SCHUNK KONTEC KSC-F single-acting clamping vises are manual direct clamping vises. The drive takes place via a spindle. Force generation is carried out with a force transmission (spindle in the spindle) and is linearly. The movable jaw is moved by turning the spindle in direction of the fixed jaw. The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

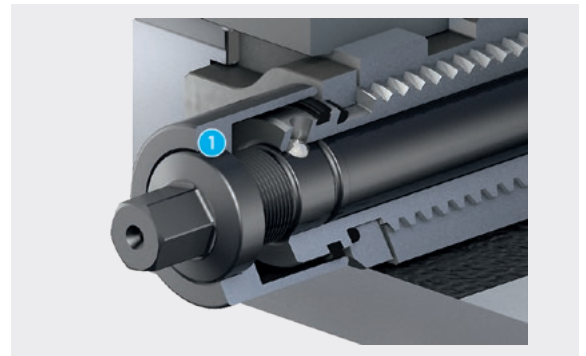
Due to 160° quick clamping, workpieces are clamped in under a second and the vise reliably locked. An additional retightening of the torque wrench or an additional angle drive is no longer required.



## Force actuation via fine thread

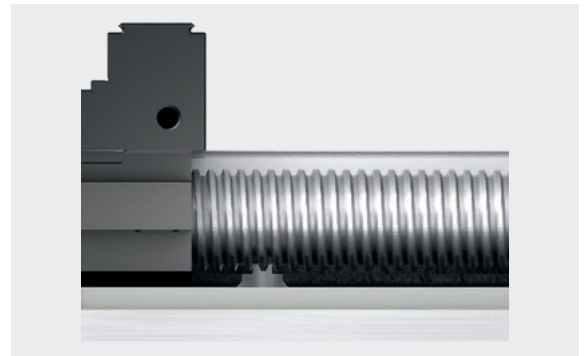
A rough quick adjustment of the clamping range is carried out via the main spindle. In the event of workpiece contact, the main spindle is uncoupled via a ball mechanism and the force transmission is initialized via a fine thread. This is how the KSC-F achieves high clamping forces even at a comparably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

### 1 Fine thread



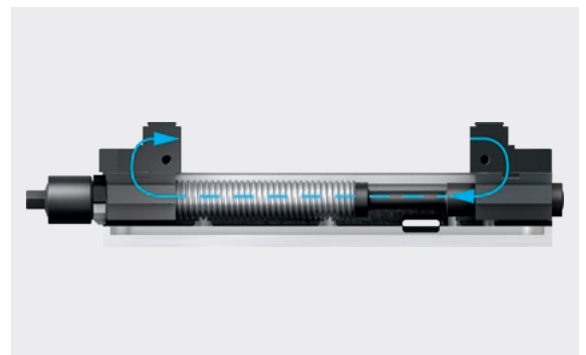
## Quick-adjustment of the clamping range

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



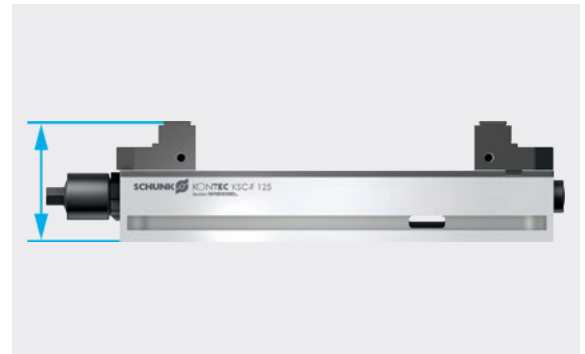
## Clamping jaws with a very large clamping range

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.

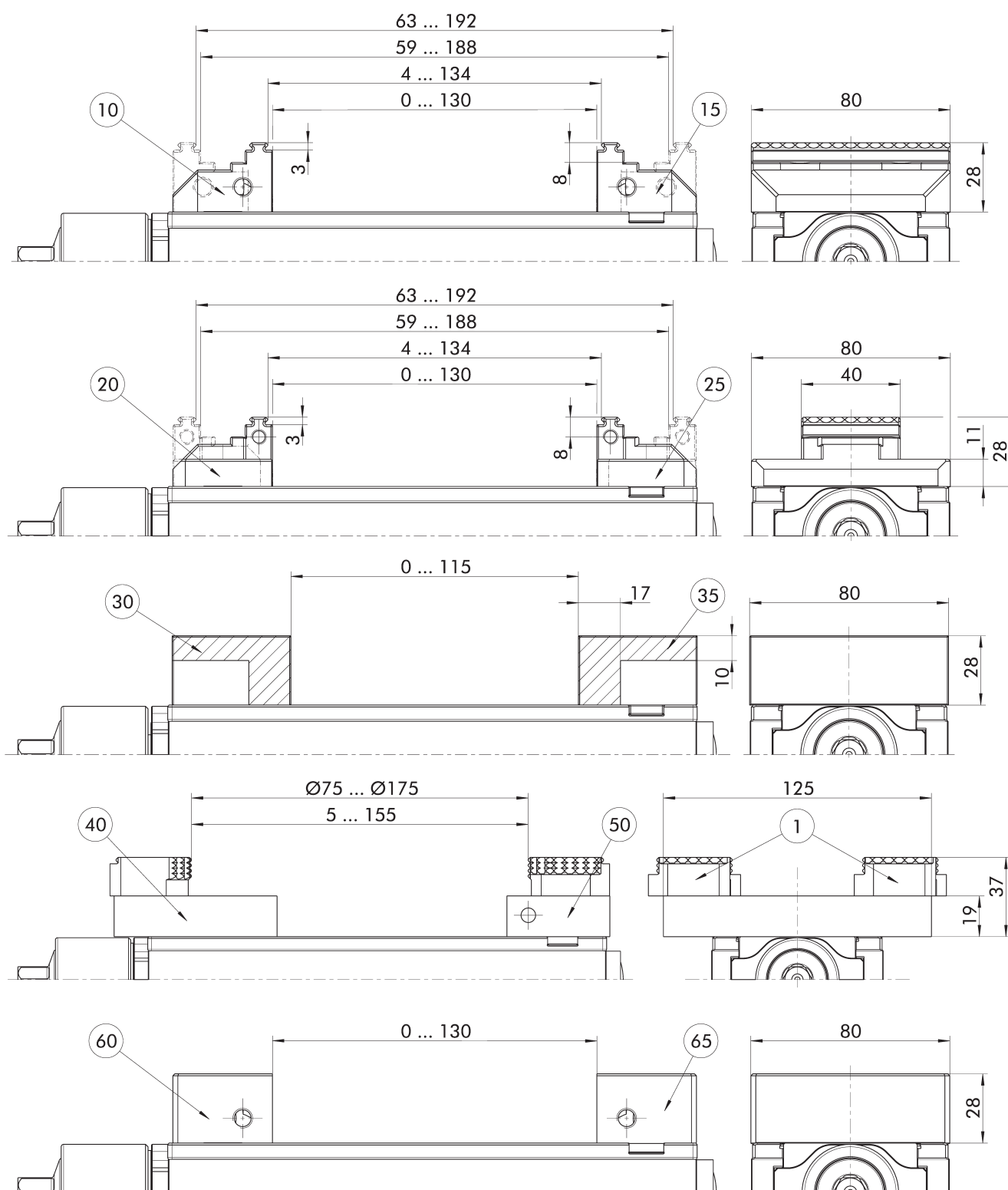


## Mounting options

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<br>[mm] | Max. clamping force<br>[kN] | Max. torque<br>[Nm] | Weight<br>[kg] |
|--------------|---------|------------------------------------|-----------------------------|---------------------|----------------|
| KSC-F 80-214 | 0432729 | 80                                 | 25                          | 50                  | 5              |

## Scope of delivery

Vise, operating manual; without system jaws

## Notes

### System jaws

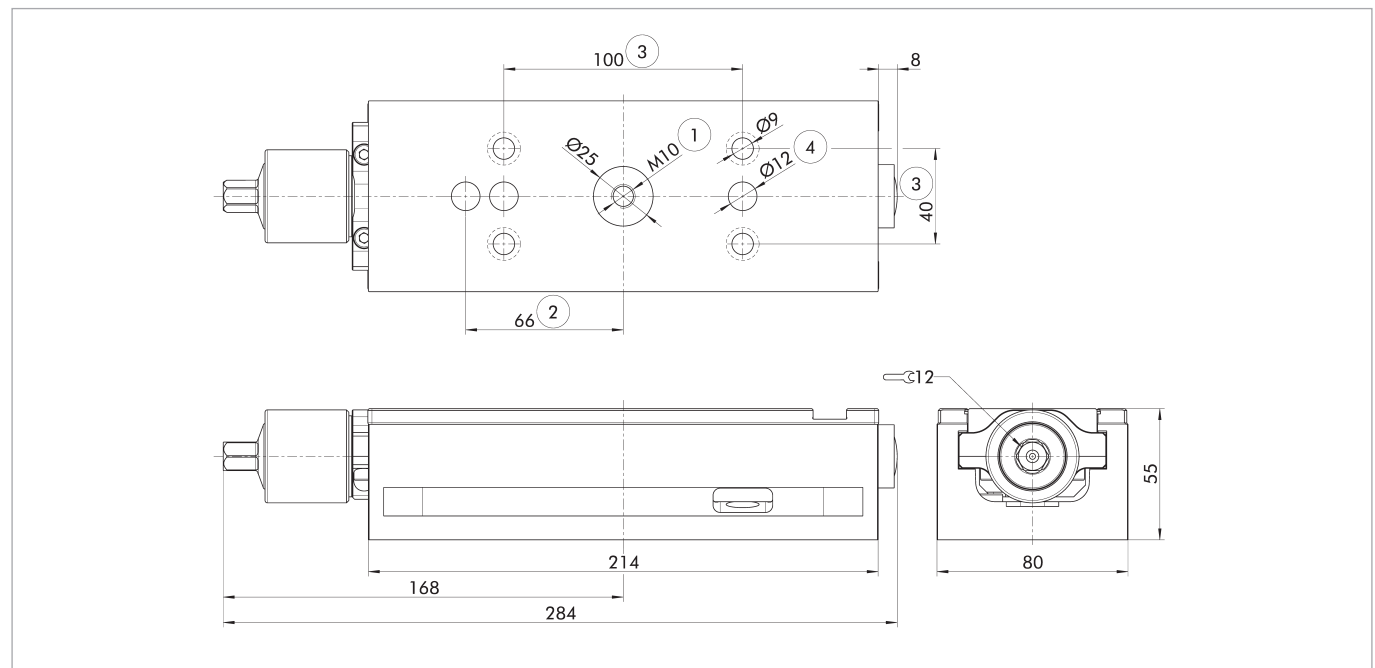
The clamping device and the system jaws have to be put together separately for this version.

### Use of VERO-S

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

## Suitable system jaws

| Description         | Pos. | Description          | ID      | Width<br>[mm] | Depth<br>[mm] | Height<br>[mm] | Weight<br>[kg] |
|---------------------|------|----------------------|---------|---------------|---------------|----------------|----------------|
| Reversible grip jaw | 10   | SGWB-G3-B 80-40.3-28 | 0432715 | 80            | 40.3          | 28             | 0.5            |
| Reversible grip jaw | 15   | SGWB-G3-F 80-40.3-28 | 0432732 | 80            | 40.3          | 28             | 0.5            |
| Reversible grip jaw | 20   | SGWB-G3-B 40-40.3-28 | 1514379 | 40            | 40.3          | 28             | 0.4            |
| Reversible grip jaw | 25   | SGWB-G3-F 40-40.5-28 | 1587365 | 40            | 40.5          | 28             | 0.4            |
| Aluminum jaw        | 30   | SGAL-B 80-48-28      | 0432718 | 80            | 48            | 28             | 0.4            |
| Aluminum jaw        | 35   | SGAL-F 80-48-28      | 0432733 | 80            | 48            | 28             | 0.4            |
| Swivel plate        | 40   | SGP-3 125-76-19      | 0432720 | 125           | 76            | 19             | 1.3            |
| Adapter plate       | 50   | SGA-4 125-48-19      | 0432735 | 125           | 48            | 19             | 0.8            |
| Monoblock jaw       | 60   | SGBB-B 80-40-28      | 1349856 | 80            | 40            | 28             | 0.7            |
| Monoblock jaw       | 65   | SGBB-F 80-40-28      | 1349855 | 80            | 40            | 28             | 0.7            |



- ① Prepared for NSE3 and GFD clamping pins
- ② Prepared for indexing pin IXB V1-K

- ③ Prepared for M8 screws
- ④ Prepared for GFD-IXB indexing pin



## 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 80-214 | SGWB-G3-B 80-40.3-28 | W-80-1    | <a href="#">0432715</a> |

### 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 80-214 | SGWB-G3-F 80-40.3-28 | W-80-1    | <a href="#">0432732</a> |

### 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 80-214 | SGWB-G3-B 80-40-28 |           | <a href="#">1514368</a> |

### 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 80-214 | SGWB-G3-F 80-40-28 |           | <a href="#">1467016</a> |

### 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 80-214 | SGWB-G3-B 40-40.3-28 |           | <a href="#">1514379</a> |

### 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 80-214 | SGWB-G3-F 40-40.5-28 |           | <a href="#">1587365</a> |

### 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 80-214 | SGAL-B 80-48-28 |           | <a href="#">0432718</a> |

### 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 80-214 | SGAL-F 80-48-28 |           | <a href="#">0432733</a> |

### 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 80-214 | SGS-B 80-48-28 |           | <a href="#">1367467</a> |

### 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 80-214 | SGS-F 80-48-28 |           | <a href="#">1561216</a> |

### Swivel plate

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



| Suitable for | Description     | Interface | ID                      |
|--------------|-----------------|-----------|-------------------------|
| KSC-F 80-214 | SGP-3 125-76-19 | W-38      | <a href="#">0432720</a> |

### Adapter plate

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



| Suitable for | Description     | Interface | ID                      |
|--------------|-----------------|-----------|-------------------------|
| KSC-F 80-214 | SGA-4 125-48-19 | W-38      | <a href="#">0432735</a> |

### Monoblock jaw

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



| Suitable for | Description     | Interface | ID                      |
|--------------|-----------------|-----------|-------------------------|
| KSC-F 80-214 | SGBB-B 80-40-28 | W-80-1    | <a href="#">1349856</a> |

### Monoblock jaw

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



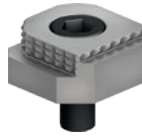
| Suitable for | Description     | Interface | ID                      |
|--------------|-----------------|-----------|-------------------------|
| KSC-F 80-214 | SGBB-F 80-40-28 | W-80-1    | <a href="#">1349855</a> |



## Top jaws

### 6-way reversible jaws grip

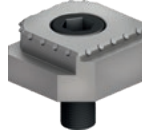
With five grip steps as well as a coated clamping face.



| Description     | Width<br>mm | Height<br>mm | Depth<br>mm | Interface | ID                      |
|-----------------|-------------|--------------|-------------|-----------|-------------------------|
| GBG-6W 38-38-18 | 38.5        | 18           | 38.2        | W-38      | <a href="#">0430803</a> |

### 6-way reversible jaw carbide grip

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



| Description      | Width<br>mm | Height<br>mm | Depth<br>mm | Interface | ID                      |
|------------------|-------------|--------------|-------------|-----------|-------------------------|
| GBCG-6W 38-38-18 | 38.5        | 18           | 38.2        | W-38      | <a href="#">1395550</a> |

### Stepped jaw

With coated step, 5 mm.



| Description      | Width<br>mm | Height<br>mm | Depth<br>mm | Interface | ID                      |
|------------------|-------------|--------------|-------------|-----------|-------------------------|
| GBS-W 80-28-10-5 | 80          | 28           | 10          | W-80-1    | <a href="#">1395509</a> |

### Stepped jaw

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



| Description     | Width<br>mm | Height<br>mm | Depth<br>mm | Interface | ID                      |
|-----------------|-------------|--------------|-------------|-----------|-------------------------|
| GBS-G3 80-28-10 | 80          | 28           | 10          | W-80-1    | <a href="#">1326805</a> |

### 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<br>mm | Height<br>mm | Depth<br>mm | Interface | ID                      |
|-------------|-------------|--------------|-------------|-----------|-------------------------|
| GFB 80-24-9 | 80          | 24.3         | 9           | W-80-1    | <a href="#">0432736</a> |

### Universal stepped jaw

Versatile stepped jaw with ground step.



| Description    | Width<br>mm | Height<br>mm | Depth<br>mm | Interface | ID                      |
|----------------|-------------|--------------|-------------|-----------|-------------------------|
| GPE 80-28-10-5 | 80          | 28           | 10          | W-80-1    | <a href="#">0432721</a> |

## Accessories

### Clamping force tester

For measuring the jaw clamping force of stationary clamping devices.



| Suitable for | Description | ID                      |
|--------------|-------------|-------------------------|
| KSC-F 80-214 | IFT SST Set | <a href="#">1475766</a> |

### Standard clamping pins

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



| Suitable for | Description | ID                      |
|--------------|-------------|-------------------------|
| KSC-F 80-214 | SPA 40-K    | <a href="#">0432369</a> |

### Indexing pin

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



| Suitable for | Description | ID                      |
|--------------|-------------|-------------------------|
| KSC-F 80-214 | IXB V1-K    | <a href="#">0432371</a> |

### Clamping pin GFD-SP

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



| Suitable for | Description | ID                      |
|--------------|-------------|-------------------------|
| KSC-F 80-214 | GFD-SP 40   | <a href="#">0433600</a> |

### Indexing pin GFD

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



| Suitable for | Description | ID                      |
|--------------|-------------|-------------------------|
| KSC-F 80-214 | GFD-IXB     | <a href="#">1367937</a> |

### Torque wrench 10 – 100 Nm

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



| Suitable for | Description  | ID                      |
|--------------|--------------|-------------------------|
| KSC-F 80-214 | GSH-D 10-100 | <a href="#">0432477</a> |

### Actuating lever, articulated

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



| Suitable for | Description | ID                      |
|--------------|-------------|-------------------------|
| KSC-F 80-214 | GSH-G 1/2"  | <a href="#">0432478</a> |

### Hexagonal insert SW 12

Suitable for square drive 1/2".



| Suitable for | Description     | ID                      |
|--------------|-----------------|-------------------------|
| KSC-F 80-214 | GSK-I SW12-1/2" | <a href="#">0432479</a> |

### 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 80-214 | GWSA M8-23  | <a href="#">1645258</a> |

### Magnetic workpiece stop, small

For quick and easy attachment to system jaws or vises.



| Suitable for | Description    | ID                      |
|--------------|----------------|-------------------------|
| KSC-F 80-214 | GWSA-M 60 x 15 | <a href="#">1391293</a> |

### Magnetic workpiece stop, large

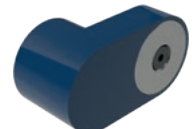
For quick and easy attachment to system jaws or vises.



| Suitable for | Description     | ID                      |
|--------------|-----------------|-------------------------|
| KSC-F 80-214 | GWSA-M 115 x 15 | <a href="#">1391331</a> |

### Extensions

As an accessory for the magnetic workpiece stops.



| Suitable for | Description     | ID                      |
|--------------|-----------------|-------------------------|
| KSC-F 80-214 | GWSA-V Ø68 x 30 | <a href="#">1394477</a> |

### Clamping screws for clamping claws

Used in combination with clamping claws for fastening clamping devices.



| Suitable for | Description   | T-slot    | ID                      |
|--------------|---------------|-----------|-------------------------|
| KSC-F 80-214 | GSC-S M10-T12 | 12 mm/M10 | <a href="#">0432043</a> |
| KSC-F 80-214 | GSC-S M12-T14 | 14 mm/M12 | <a href="#">0432044</a> |
| KSC-F 80-214 | GSC-S M14-T16 | 16 mm/M14 | <a href="#">0432045</a> |
| KSC-F 80-214 | GSC-S M16-T18 | 18 mm/M16 | <a href="#">0432046</a> |
| KSC-F 80-214 | GSC-S M16-T20 | 20 mm/M16 | <a href="#">1550423</a> |
| KSC-F 80-214 | GSC-S M16-T22 | 22 mm/M16 | <a href="#">1550424</a> |

### Clamping screws for base body

Used for directly attaching clamping devices via the base body.



| Suitable for | Description     | T-slot    | ID                      |
|--------------|-----------------|-----------|-------------------------|
| KSC-F 80-214 | GSC-G-1 M10-T12 | 12 mm/M10 | <a href="#">0430422</a> |
| KSC-F 80-214 | GSC-G-1 M12-T14 | 14 mm/M12 | <a href="#">0430423</a> |
| KSC-F 80-214 | GSC-G-1 M12-T16 | 16 mm/M12 | <a href="#">0430424</a> |
| KSC-F 80-214 | GSC-G-1 M12-T18 | 18 mm/M12 | <a href="#">0430425</a> |

### Precision T-nuts

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



| Suitable for | Description | T-slot   | ID                      |
|--------------|-------------|----------|-------------------------|
| KSC-F 80-214 | GPN M6-T12  | 12 mm/M6 | <a href="#">0490590</a> |
| KSC-F 80-214 | GPN M6-T14  | 14 mm/M6 | <a href="#">0490547</a> |
| KSC-F 80-214 | GPN M6-T16  | 16 mm/M6 | <a href="#">0490548</a> |
| KSC-F 80-214 | GPN M6-T18  | 18 mm/M6 | <a href="#">0490587</a> |
| KSC-F 80-214 | GPN M6-T20  | 20 mm/M6 | <a href="#">1359734</a> |
| KSC-F 80-214 | GPN M6-T22  | 22 mm/M6 | <a href="#">0490621</a> |

## Workpiece Supports Set

### Set of workpiece supports – width 80 mm

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



| Suitable for | Description      | ID                      |
|--------------|------------------|-------------------------|
| KSC-F 80-214 | GWU-S grip 80-28 | <a href="#">1394225</a> |

### Alignment and centering set

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



| Suitable for | Description | T-slot | ID                      |
|--------------|-------------|--------|-------------------------|
| KSC-F 80-214 | GAZ-1 T12   | 12 mm  | <a href="#">1326851</a> |
| KSC-F 80-214 | GAZ-1 T14   | 14 mm  | <a href="#">1326852</a> |
| KSC-F 80-214 | GAZ-1 T16   | 16 mm  | <a href="#">1326853</a> |
| KSC-F 80-214 | GAZ-1 T18   | 18 mm  | <a href="#">1326854</a> |

### Cylinder pin set

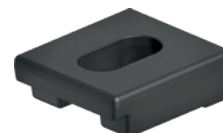
For easier assembly of the clamping device on the machine table.



| Suitable for | Description | ID                      |
|--------------|-------------|-------------------------|
| KSC-F 80-214 | GZS Ø12m6   | <a href="#">1373755</a> |

### Clamping claws

For quick and easy mounting of SCHUNK clamping devices.



| Suitable for | Description  | ID                      |
|--------------|--------------|-------------------------|
| KSC-F 80-214 | GSPR-A 50-57 | <a href="#">0490604</a> |

### Cover screw

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



| Suitable for | Description | ID                      |
|--------------|-------------|-------------------------|
| KSC-F 80-214 | GCS Ø22-M12 | <a href="#">1307880</a> |

## Workpiece supports

### Workpiece supports – width 80 mm

In different heights.

1 Set = 2 pieces



| Suitable for | Description | Height mm | ID                      |
|--------------|-------------|-----------|-------------------------|
| KSC-F 80-214 | GWU-M 80-5  | 5         | <a href="#">1465960</a> |
| KSC-F 80-214 | GWU-M 80-10 | 10        | <a href="#">1465956</a> |
| KSC-F 80-214 | GWU-M 80-15 | 15        | <a href="#">1460327</a> |
| KSC-F 80-214 | GWU-M 80-20 | 20        | <a href="#">1411113</a> |
| KSC-F 80-214 | GWU-M 80-22 | 22        | <a href="#">1411114</a> |





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