



## KONTec KSX-C2

**5-axis machining in  
perfection**

Hand in hand for tomorrow

## 5-axis vise with adjustable clamping center and active jaw pull-down function for 6-sided machining

The KONTEC KSX-C2 single-acting vise represents 5-axis machining in perfection. An adjustable clamping center, optimum accessibility to the workpiece and the basic clamping stroke of 130 mm make the KSX-C2 an incredibly versatile clamping device. The absolute highlight is the active pull-down function of the vise integrated as standard. This allows complete and precise machining of the sixth side without additional conversion measures. A jaw quick-change system enables the exchange of a large number of system jaws with each other within a few seconds and completely without tools. 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.

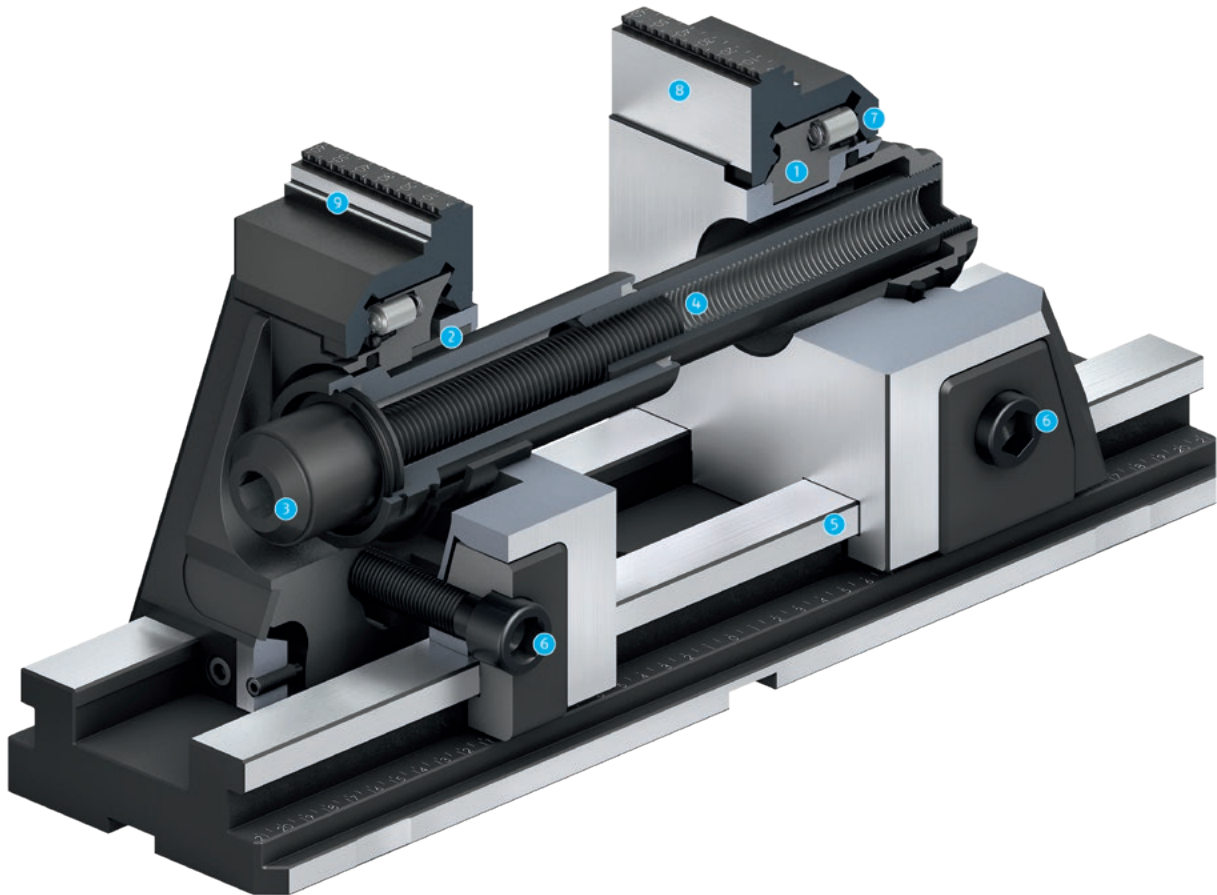


### Advantages – Your benefits

- + Active jaw pull-down**  
Optionally allows complete and precise machining of the sixth side
- + Jaw quick-change without any tools**  
Adjustment to new clamping tasks within seconds
- + Adjustable clamping center**  
Small and large workpieces are always clamped centrically
- + Long basic clamping stroke with 130 mm**  
Wide range of applications without additional extensions
- + Optimal accessibility**  
Allows the workpiece to be machined from five sides
- + Extendable clamping range**  
Enables clamping of various workpiece lengths
- + Integrated elastomer damping**  
To minimize vibrations during machining
- + Wide range of applications**  
Suitable for rough and finished parts machining
- + Wide jaw program**  
Optimal adaptation to new clamping tasks
- + 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 KSX-C2 125

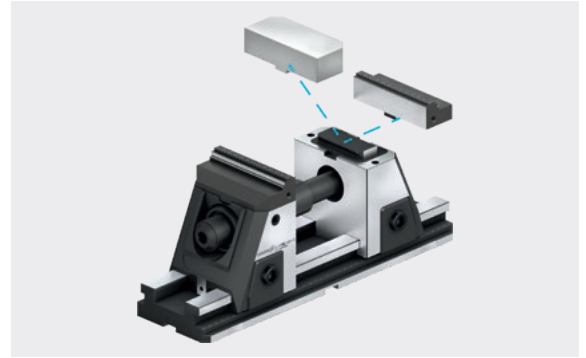
The KSX-C2 is operated via an encapsulated spindle. Turning the spindle advances the moving jaw to the workpiece and it is clamped via torque. The fixed jaw can be released and the clamping center of the vise can be individually adjusted by loosening the fastening screw. By fixing the movable jaw, an active pull-down effect can be generated during the clamping process. This allows very precise machining of the sixth side.



- 1 Jaw quick-change system**  
System jaws can be exchanged in seconds, completely without tools
- 2 Jaw pull-down mechanism**  
For the most accurate clamping of pre-machined workpieces
- 3 Actuation via hexagon connection**  
This ensures easy operation
- 4 Completely encapsulated spindle**  
Offers optimal protection against coolant and chips
- 5 Long jaw guidance**  
Offers optimal support
- 6 Jaw clamping via hexagonal connection**  
For individual adjustment of the clamping center and clamping of the second jaw for the active jaw pull-down
- 7 Spring-loaded pressure piece**  
Secures the jaw against falling out in unclamped condition
- 8 Quick-change jaws**  
Large selection for every type of application
- 9 Diverse applications**  
For first- and second-side machining

### Jaw quick-change system

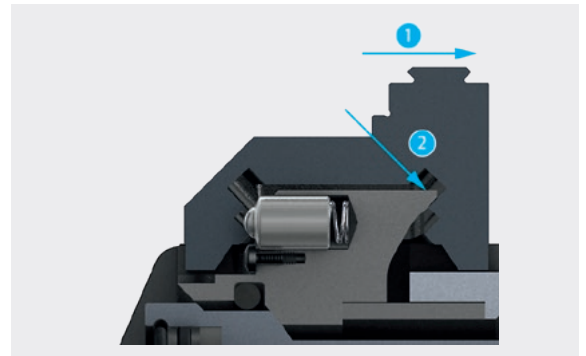
Due to the jaw quick-change system, the system jaws of the KSX-C2 vise can be extremely fast exchanged to new ones. The whole jaw change is achieved without any tools at all. You can choose from a broad range of system jaws.



### Active jaw pull-down for the most accurate clamping of pre-machined workpieces

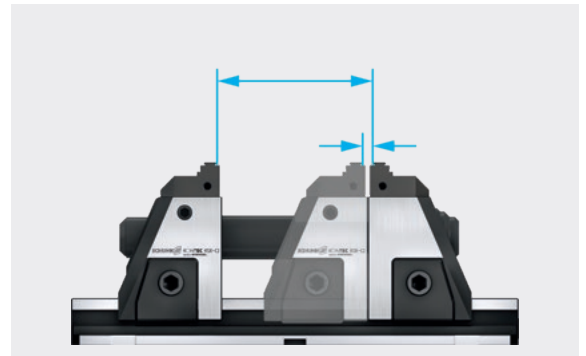
Fixing of both clamping jaws (via the two attachment screws) results in a small jaw movement with an active pull-down function due to the inlying mechanical system. This pull-down mechanism allows the KSX-C2 to realise a complete and precise machining of the sixth side.

- ❶ Jaw stroke
- ❷ Resulting pull-down function



### Long basic clamping stroke as standard

The KSX-C2 has always the basic stroke of 130 mm for each clamp length. Compared with its competitors, it has by far the longest basic stroke. Depending on the length of the base body, this can be individually extended with different drawbar extensions.



### Freely configurable spindle system

The spindle of the KSX-C2 is completely encapsulated. The basic clamping stroke here is always 130 mm. In order to cover the entire clamping range of 420 mm, the vise can be adapted to the respective workpiece size with drawbar extensions. Installation, removal or conversion is carried out without any tools at all.

- ❶ Drawbar extension



### Quick conversion to a larger clamping range

The KSX-C2 can be converted to an extended clamping range without tools and additional accessories. For the conversion, only the reversal jaws have to be removed and turned via the quick-change system. Absolutely uncomplicated and within a few seconds.



### Two heights are available

The KSX-C2 is available in two different heights. With reversal jaw grip, the workpiece support is carried out at a height of 208 mm or 169 mm. The height and the special design allow for optimum access from all sides without the need for additional support of the vise.

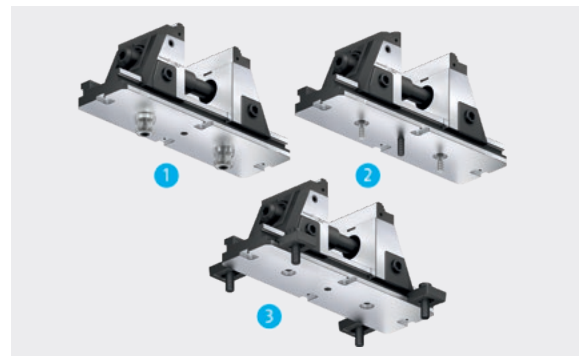
- ❶ **KSX-C2 125**  
Standard version, height 208 mm (including jaws)
- ❷ **KSX-C2 125-L**  
Low version, height 169 mm (including jaws)

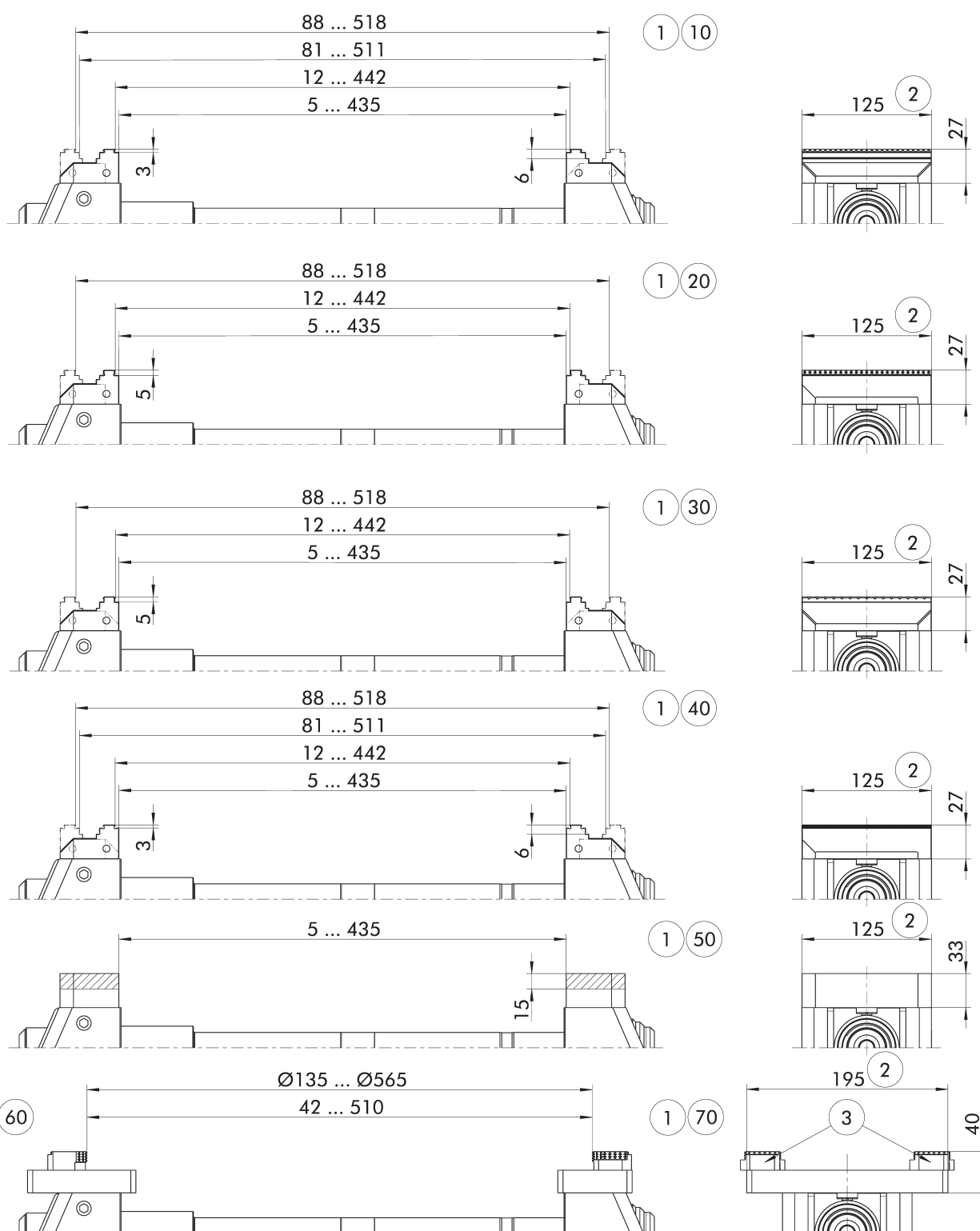


### Mounting options

The KSX-C2 offers several mounting options on the machine table. They are all integrated in the clamping vise. The 5-axis vise can be used for minimizing the set-up time. It can be mounted on the NSE3 or GFD quick-change pallet modules using the previously prepared interface for quick-change pallet systems. Alternatively, the vise can be set up via clamping claws, fitting screws or alignment sets.

- ❶ **Mounting via quick-change pallet system**
- ❷ **Fastening via fitting and clamping screws**
- ❸ **Mounting via precision T-nuts and clamping claws**





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

① Min. clamping range with standard spindle, max. clamping range with illustrated drawbar extension GZV-2 630 (ID 1453118)

② Same clamping ranges for jaw widths 40, 65, 80 and 125 mm

③ 6-way reversal jaw grip or 6-way reversal jaw carbide grip

## Technical data

| Description      | ID      | Width of the clamping vise [mm] | Height (H) [mm] | Max. clamping force Raw part/precision clamping [kN] | Max. torque Raw part/precision clamping [Nm] | Basic clamping stroke [mm] | Weight [kg] |
|------------------|---------|---------------------------------|-----------------|------------------------------------------------------|----------------------------------------------|----------------------------|-------------|
| KSX-C2 125-630   | 1493483 | 125                             | 181             | 50/40                                                | 100/120                                      | 130                        | 40.8        |
| KSX-C2 125-630-L | 1493484 | 125                             | 142             | 50/34                                                | 100/120                                      | 130                        | 34.8        |

## Scope of delivery

Vise, operating manual; without spanner wrench, without clamping claws, without drawbar extension

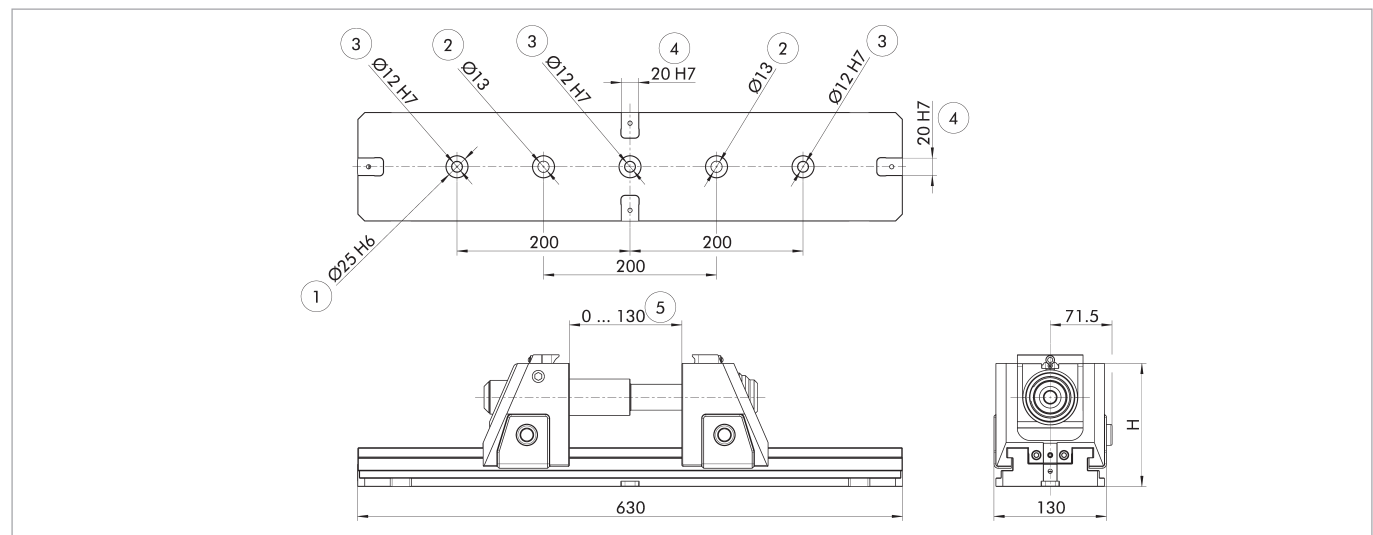
## Note

### Reduced clamping force precision clamping

Fixing both mobile jaws results in a different transmission ratio in the clamping force application. This results in a higher torque application with a lower clamping force at the same time.

## Suitable system jaws

| Description                          | Pos. | Description          | ID      | Width [mm] | Depth [mm] | Height [mm] | Weight [kg] |
|--------------------------------------|------|----------------------|---------|------------|------------|-------------|-------------|
| Reversible grip jaw                  | 10   | SGWB-G3-B 40-57-27   | 1494296 | 40         | 57         | 27          | 0.8         |
| Reversible grip jaw                  | 10   | SGWB-G3-B 65-57-27   | 1494297 | 65         | 57         | 27          | 0.8         |
| Reversible grip jaw                  | 10   | SGWB-G3-B 80-57-27   | 1494298 | 80         | 57         | 27          | 0.8         |
| Reversible grip jaw                  | 10   | SGWB-G3-B 125-57-27  | 1494299 | 125        | 57         | 27          | 0.9         |
| Reversible grip jaw                  | 20   | SGWB-G5-B 40-57-27   | 1494303 | 40         | 57         | 27          | 0.8         |
| Reversible grip jaw                  | 20   | SGWB-G5-B 65-57-27   | 1494304 | 65         | 57         | 27          | 0.8         |
| Reversible grip jaw                  | 20   | SGWB-G5-B 80-57-27   | 1494305 | 80         | 57         | 27          | 0.8         |
| Reversible grip jaw                  | 20   | SGWB-G5-B 125-57-27  | 1494306 | 125        | 57         | 27          | 0.9         |
| Reversible carbide-grip jaw          | 30   | SGWB-CG5-B 40-57-27  | 1494320 | 40         | 57         | 27          | 0.8         |
| Reversible carbide-grip jaw          | 30   | SGWB-CG5-B 65-57-27  | 1494321 | 65         | 57         | 27          | 0.8         |
| Reversible carbide-grip jaw          | 30   | SGWB-CG5-B 80-57-27  | 1494322 | 80         | 57         | 27          | 0.8         |
| Reversible carbide-grip jaw          | 30   | SGWB-CG5-B 125-57-27 | 1494323 | 125        | 57         | 27          | 0.9         |
| Reversible jaw with embossed profile | 40   | SGWB-GL-B 125-57-27  | 1494324 | 125        | 57         | 27          | 0.9         |
| Steel jaw                            | 50   | SGS-B 125-57-33      | 1453106 | 125        | 57         | 33          | 2           |
| Swivel plate                         | 60   | SGP-2 195-105-22     | 1453108 | 195        | 105        | 22          | 4.1         |
| Adapter plate                        | 70   | SGA-2 195-72-22      | 1453107 | 195        | 72         | 22          | 2           |



- ① Prepared for NSE3 and GFD clamping pins
- ② Prepared for M12 screws
- ③ Prepared for M12 screws or M12 fitting screws
- ④ Prepared for precision T-nuts
- ⑤ Basic clamping stroke supplied as standard

## System jaws

### Reversible jaw

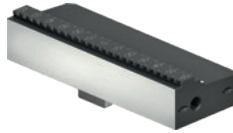
Designed as a quick-change jaw. One side with a smooth 6 mm step for enlarged clamping width, one side with a smooth clamping surface.



| Suitable for   | Description      | Interface | ID                      |
|----------------|------------------|-----------|-------------------------|
| KSX-C2 125-630 | SGWB-B 125-57-27 |           | <a href="#">1502843</a> |

### Reversible grip jaw

Designed as a quick-change jaw. With grip step 3 mm (up to 22 HRC) and a smooth clamping surface on both sides.



| Suitable for   | Description         | Interface | ID                      |
|----------------|---------------------|-----------|-------------------------|
| KSX-C2 125-630 | SGWB-G3-B 40-57-27  |           | <a href="#">1494296</a> |
| KSX-C2 125-630 | SGWB-G3-B 65-57-27  |           | <a href="#">1494297</a> |
| KSX-C2 125-630 | SGWB-G3-B 80-57-27  |           | <a href="#">1494298</a> |
| KSX-C2 125-630 | SGWB-G3-B 125-57-27 |           | <a href="#">1494299</a> |

### Reversible grip jaw

Designed as a quick-change jaw. With grip step 5 mm (up to 22 HRC) and a smooth clamping surface on both sides.



| Suitable for   | Description         | Interface | ID                      |
|----------------|---------------------|-----------|-------------------------|
| KSX-C2 125-630 | SGWB-G5-B 40-57-27  |           | <a href="#">1494303</a> |
| KSX-C2 125-630 | SGWB-G5-B 65-57-27  |           | <a href="#">1494304</a> |
| KSX-C2 125-630 | SGWB-G5-B 80-57-27  |           | <a href="#">1494305</a> |
| KSX-C2 125-630 | SGWB-G5-B 125-57-27 |           | <a href="#">1494306</a> |

### Reversible carbide-grip jaw

Designed as a quick-change jaw. With carbide-grip step 5 mm (up to 58 HRC) and smooth clamping surface on both sides.



| Suitable for   | Description          | Interface | ID                      |
|----------------|----------------------|-----------|-------------------------|
| KSX-C2 125-630 | SGWB-CG5-B 40-57-27  |           | <a href="#">1494320</a> |
| KSX-C2 125-630 | SGWB-CG5-B 65-57-27  |           | <a href="#">1494321</a> |
| KSX-C2 125-630 | SGWB-CG5-B 80-57-27  |           | <a href="#">1494322</a> |
| KSX-C2 125-630 | SGWB-CG5-B 125-57-27 |           | <a href="#">1494323</a> |

### Reversible jaw with embossed profile

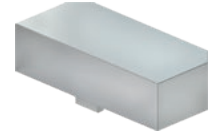
Designed as a quick-change jaw. Both sides with embossed profile LANG, step 3 mm and smooth clamping face.



| Suitable for   | Description         | Interface | ID                      |
|----------------|---------------------|-----------|-------------------------|
| KSX-C2 125-630 | SGWB-GL-B 125-57-27 |           | <a href="#">1494324</a> |

### Steel jaw

Designed as a quick-change jaw. Hardenable jaws for rework at the customer site, e.g. for incorporating contours or special shapes.



| Suitable for   | Description     | Interface | ID                      |
|----------------|-----------------|-----------|-------------------------|
| KSX-C2 125-630 | SGS-B 125-57-33 |           | <a href="#">1453106</a> |

### Swivel plate

Designed as a quick-change jaw. Used – in combination with adapter plates and 6-way reversal jaws – to clamp bulky workpieces.



| Suitable for   | Description      | Interface | ID                      |
|----------------|------------------|-----------|-------------------------|
| KSX-C2 125-630 | SGP-2 195-105-22 | W-38      | <a href="#">1453108</a> |

### Adapter plate

Designed as a quick-change jaw. Used – in combination with swivel plates and 6-way reversal jaws – to clamp bulky workpieces.



| Suitable for   | Description     | Interface | ID                      |
|----------------|-----------------|-----------|-------------------------|
| KSX-C2 125-630 | SGA-2 195-72-22 | W-38      | <a href="#">1453107</a> |

### Precision jaw set

Designed as a quick-change jaw. Precision jaws that can be finish milled under preliminary clamping, for even greater angularity on the workpiece.

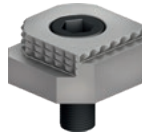


| Suitable for   | Description      | Interface | ID                      |
|----------------|------------------|-----------|-------------------------|
| KSX-C2 125-630 | SGWP-B 125-57-27 |           | <a href="#">1494333</a> |

## Top jaws

### 6-way reversible jaws grip

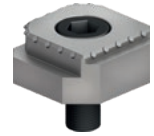
With five grip steps as well as a coated clamping face.



| 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> |

## Accessories

### Clamping force tester

For measuring the jaw clamping force of stationary clamping devices.



| Suitable for   | Description | ID                      |
|----------------|-------------|-------------------------|
| KSX-C2 125-630 | IFT SST Set | <a href="#">1475766</a> |

### Clamping pins SPx

Clamping pin for positive connection with NSE3 clamping modules.



| Suitable for   | Description | ID                      |
|----------------|-------------|-------------------------|
| KSX-C2 125-630 | SPA 40      | <a href="#">0471151</a> |
| KSX-C2 125-630 | SPB 40      | <a href="#">0471152</a> |
| KSX-C2 125-630 | SPC 40      | <a href="#">0471153</a> |

### Clamping pin GFD-SP

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



| Suitable for   | Description | ID                      |
|----------------|-------------|-------------------------|
| KSX-C2 125-630 | GFD-SP 40   | <a href="#">0433600</a> |

### Torque wrench 20 – 200 Nm

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



| Suitable for   | Description  | ID                      |
|----------------|--------------|-------------------------|
| KSX-C2 125-630 | GSH-D 20-200 | <a href="#">0432487</a> |

### Actuating lever, articulated

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



| Suitable for   | Description | ID                      |
|----------------|-------------|-------------------------|
| KSX-C2 125-630 | GSH-G 1/2"  | <a href="#">0432478</a> |

### Hexagonal pin insert SW 14

Suitable for square drive 1/2".



| Suitable for   | Description     | ID                      |
|----------------|-----------------|-------------------------|
| KSX-C2 125-630 | GSK-A SW14-1/2" | <a href="#">0490784</a> |

### Crank handle AF 14

For fast and convenient adjustment of the clamping range.



| Suitable for   | Description  | ID                      |
|----------------|--------------|-------------------------|
| KSX-C2 125-630 | GHK-K-A SW14 | <a href="#">1322990</a> |

### Spindle, mechanical

As a conversion kit with a basic clamping stroke of 130 mm.



| Suitable for   | Description | ID                      |
|----------------|-------------|-------------------------|
| KSX-C2 125-630 | GSD-M 125   | <a href="#">1453120</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                      |
|----------------|-------------|-------------------------|
| KSX-C2 125-630 | 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                      |
|----------------|----------------|-------------------------|
| KSX-C2 125-630 | GWSA-M 60 x 15 | <a href="#">1391293</a> |

### Magnetic workpiece stop, large

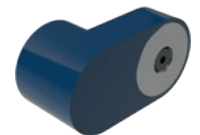
For quick and easy attachment to system jaws or vises.



| Suitable for   | Description     | ID                      |
|----------------|-----------------|-------------------------|
| KSX-C2 125-630 | GWSA-M 115 x 15 | <a href="#">1391331</a> |

### Extensions

As an accessory for the magnetic workpiece stops.



| Suitable for   | Description     | ID                      |
|----------------|-----------------|-------------------------|
| KSX-C2 125-630 | 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                      |
|----------------|---------------|-----------|-------------------------|
| KSX-C2 125-630 | GSC-S M10-T12 | 12 mm/M10 | <a href="#">0432043</a> |
| KSX-C2 125-630 | GSC-S M12-T14 | 14 mm/M12 | <a href="#">0432044</a> |
| KSX-C2 125-630 | GSC-S M14-T16 | 16 mm/M14 | <a href="#">0432045</a> |
| KSX-C2 125-630 | GSC-S M16-T18 | 18 mm/M16 | <a href="#">0432046</a> |
| KSX-C2 125-630 | GSC-S M16-T20 | 20 mm/M16 | <a href="#">1550423</a> |
| KSX-C2 125-630 | GSC-S M16-T22 | 22 mm/M16 | <a href="#">1550424</a> |

### Fitting screws

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



| Suitable for   | Description      | ID                      |
|----------------|------------------|-------------------------|
| KSX-C2 125-630 | GPSC-2 Ø12f7-M12 | <a href="#">0490546</a> |

### Precision T-nuts

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



| Suitable for   | Description | T-slot   | ID                      |
|----------------|-------------|----------|-------------------------|
| KSX-C2 125-630 | GPN M6-T12  | 12 mm/M6 | <a href="#">0490590</a> |
| KSX-C2 125-630 | GPN M6-T14  | 14 mm/M6 | <a href="#">0490547</a> |
| KSX-C2 125-630 | GPN M6-T16  | 16 mm/M6 | <a href="#">0490548</a> |
| KSX-C2 125-630 | GPN M6-T18  | 18 mm/M6 | <a href="#">0490587</a> |
| KSX-C2 125-630 | GPN M6-T20  | 20 mm/M6 | <a href="#">1359734</a> |
| KSX-C2 125-630 | GPN M6-T22  | 22 mm/M6 | <a href="#">0490621</a> |

## Drawbar extensions

### Drawbar extension

For extension of the clamping range starting from base body length 430 mm.



| Suitable for   | Description | Length mm | ID                      |
|----------------|-------------|-----------|-------------------------|
| KSX-C2 125-630 | GZV-2 430   | 100       | <a href="#">1453116</a> |

### Drawbar extension

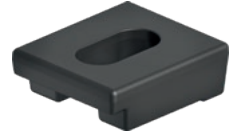
For extension of the clamping range starting from base body length 500 mm.



| Suitable for   | Description | Length mm | ID                      |
|----------------|-------------|-----------|-------------------------|
| KSX-C2 125-630 | GZV-2 500   | 130       | <a href="#">1453117</a> |

### Clamping claws

For quick and easy mounting of SCHUNK clamping devices.



| Suitable for   | Description  | ID                      |
|----------------|--------------|-------------------------|
| KSX-C2 125-630 | GSPR-A 50-57 | <a href="#">0490604</a> |

### Centering pin

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



| Suitable for   | Description     | ID                      |
|----------------|-----------------|-------------------------|
| KSX-C2 125-630 | GCP Ø12n6-Ø30h6 | <a href="#">1430741</a> |
| KSX-C2 125-630 | GCP Ø12n6-Ø32h6 | <a href="#">1426237</a> |
| KSX-C2 125-630 | GCP Ø12n6-Ø50h6 | <a href="#">1417596</a> |

### Cover screw

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



| Suitable for   | Description | ID                      |
|----------------|-------------|-------------------------|
| KSX-C2 125-630 | GCS Ø22-M12 | <a href="#">1307880</a> |

### Drawbar extension

For extension of the clamping range starting from base body length 630 mm.



| Suitable for   | Description | Length mm | ID                      |
|----------------|-------------|-----------|-------------------------|
| KSX-C2 125-630 | GZV-2 630   | 300       | <a href="#">1453118</a> |

## Workpiece Supports Set

### Set of workpiece supports – width 125 mm

Suitable for system jaws H = 27 mm with grip level 3 mm.

Heights = 8, 12, 15, 20, and 22 mm.



| Suitable for   | Description       | ID                      |
|----------------|-------------------|-------------------------|
| KSX-C2 125-630 | GWU-S grip 125-27 | <a href="#">1494332</a> |

## Workpiece supports

### Workpiece supports – width 125 mm

In different heights.

1 Set = 2 pieces



| Suitable for   | Description  | Height mm | ID                      |
|----------------|--------------|-----------|-------------------------|
| KSX-C2 125-630 | GWU-M 125-8  | 8         | <a href="#">1450266</a> |
| KSX-C2 125-630 | GWU-M 125-9  | 9         | <a href="#">1462567</a> |
| KSX-C2 125-630 | GWU-M 125-10 | 10        | <a href="#">1411328</a> |
| KSX-C2 125-630 | GWU-M 125-12 | 12        | <a href="#">1447369</a> |
| KSX-C2 125-630 | GWU-M 125-15 | 15        | <a href="#">1411350</a> |
| KSX-C2 125-630 | GWU-M 125-20 | 20        | <a href="#">1452308</a> |
| KSX-C2 125-630 | GWU-M 125-22 | 22        | <a href="#">1457551</a> |
| KSX-C2 125-630 | GWU-M 125-23 | 23        | <a href="#">1411380</a> |
| KSX-C2 125-630 | GWU-M 125-25 | 25        | <a href="#">1484475</a> |
| KSX-C2 125-630 | GWU-M 125-27 | 27        | <a href="#">1461008</a> |





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