



KONTEC KSC-D

**Double clamping vise with
third-hand function**

User-friendly double clamping vise with third-hand function for consistently high precision and efficiency

The manual KONTEC KSC-D double clamping vises from SCHUNK are specially designed for demanding continuous use in automated machine tools with workpiece storage. Due to the nickel-plated base body, these vises are perfectly protected against corrosion. As part of the large KSC modular system, they can be quickly and easily adapted to new clamping tasks. By means of a convenient third-hand function, two workpieces can be inserted next to each other, fixed, and securely clamped. The vises also have an impressive flat design and low weight. Thanks to the interface for the quick-change pallet system, the double clamping vises can be perfectly combined with the large NSE3 and GFD modular system.

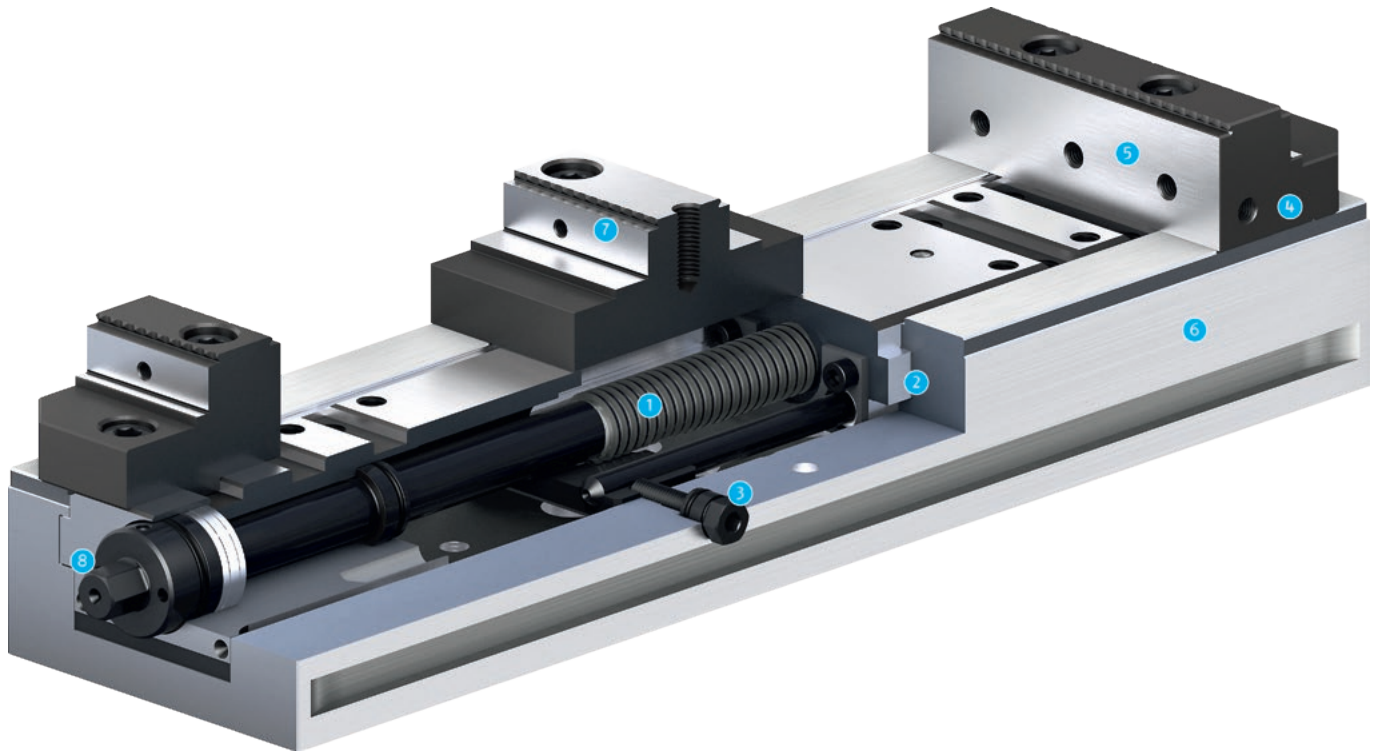


Advantages – Your benefits

- + Extremely flat design**
For maximum utilization of the machine room
- + Third-hand function**
Reliable pre-loading of the first workpiece when clamping the second workpiece
- + Spindle encapsulated**
Dirt-resistant and low-maintenance clamping devices
- + Innovative encapsulation of the base jaws**
Perfectly prepared for tombstone solutions
- + High clamping forces**
Ensure process reliability 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 KSC-D

SCHUNK KONTEC KSC-D double clamping vises are manual multi clamping vises. The preliminary clamping of the third-hand function keeps the workpiece secure in the first clamping position. By further turning of the spindle, the second movable jaw is pushed towards the workpiece and fixed into position. The clamping force actuation is linear and 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 Third-hand function**
Holds the first workpiece while the second is clamped in
- 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 Central jaw**
Used for clamping of two components
- 8 Actuation via hexagon connection**
This ensures easy operation

Double encapsulated spindle

The spindle drive is protected against the penetration of coolant and chips. The spindle is always sealed, regardless of the clamping position. This ensures a continuously reliable functioning and clamping force.

- ① Sealing on the actuation connection
- ② Sealing on the spindle bearing



Actuation via hexagon nut

The vise can be easily actuated via a standard hexagon connection using either conventional socket wrenches, extensions or torque wrenches.



Third-hand function

Third-hand operation is ensured by preliminarily clamping the workpiece with the rear jaw by using pressure springs. If the third-hand function is activated, the springs ensure that the upper jaws are led to the workpiece first during closing operation, and thus preliminary clamps them slightly. Following this operation, the second jaw begins aligning with the second workpiece.



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



Encapsulation of the base jaws

The base jaws are provided with an innovative encapsulation. This makes the multi clamping vise particularly suitable for tombstone clamping solutions. On the upper jaw, the actuating screw is entirely encapsulated to prevent ingress of chips. The lower jaw has recesses that drain coolant and chips.

- ① Upper jaw
- ② Lower jaw



Extremely flat design

Due to the extremely flat design, the KSC-D 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.

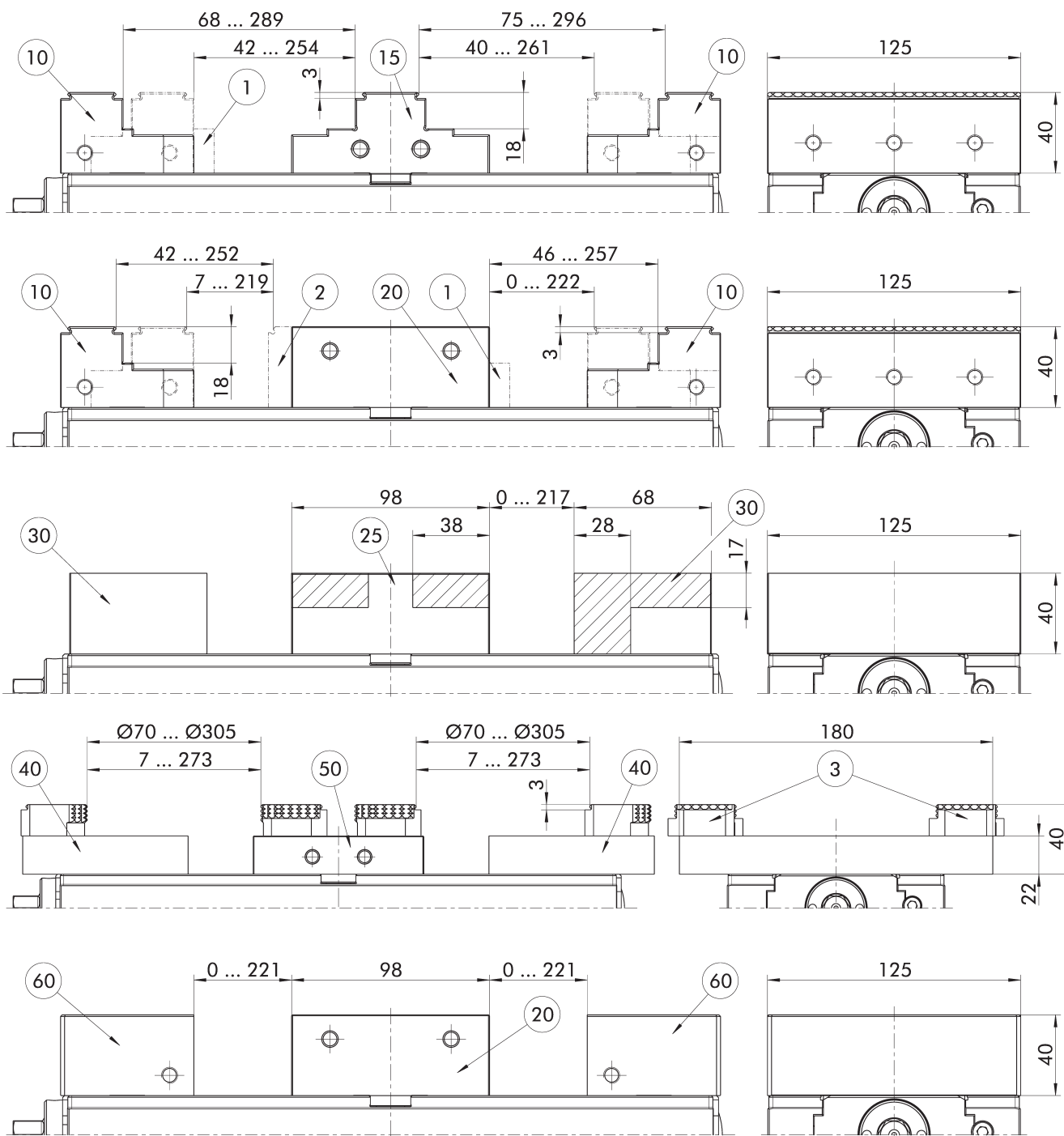


Mounting options

The KSC-D offers multiple integrated options for mounting on the machine table. The double clamping 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 system. Alternatively, the vise can be mounted with screws, fitting screws or clamping claws.

- ① Mounting via quick-change pallet system
- ② Mounting via clamping claws
- ③ Mounting via screws
- ④ Fastening via fitting screws





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

- ① Workpiece support (ID 1326818)
- ② Stepped jaw, grip (ID 1373331)

- ③ 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-D 125-670	1334724	125	40	100	30

Scope of delivery

Vise, operating manual; without system jaws

Notes

System jaws

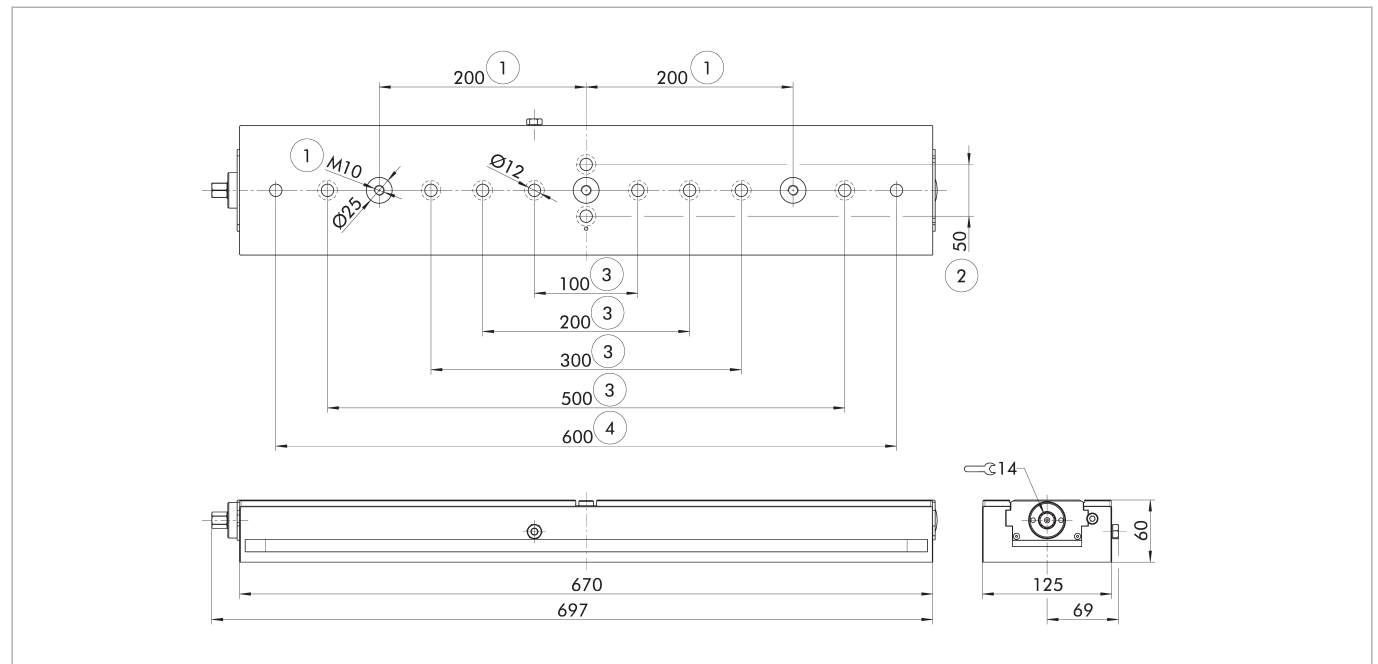
The clamping device and the system jaws have to be put together separately for this version.

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
Central grip jaw	15	SGM-G3 125-98-40	1322973	125	98	40	2.5
Central smooth jaw	20	SGM-E 125-98-40	1322974	125	98	40	3.7
Central aluminum jaw	25	SGM-AL 125-98-40	1322975	125	98	40	1.5
Aluminum jaw	30	SGAL-B 125-68-40	0432469	125	68	40	1
Swivel plate	40	SGP-3 180-95-22	0432470	180	95	22	2.8
Adapter plate	50	SGA-5 180-98-22	1322976	180	98	22	2.8
Monoblock jaw	60	SGBB-B 125-66-40	1349858	125	66	40	2.6



① Prepared for NSE3 and GFD clamping pins

② Prepared for fitting screws M12

③ Grid dimension prepared for screws M12 and fitting screws M12

④ Prepared for dowel pin set Ø 12m6

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-D 125-670	SGWB-G3-B 125-66-40	W-125-1	0432490

Central grip jaw

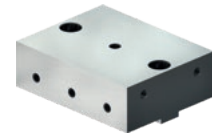
With grip step 3 mm (up to 22 HRC) and a smooth clamping surface on both sides.



Suitable for	Description	Interface	ID
KSC-D 125-670	SGM-G3 125-98-40		1322973

Central smooth jaw

With a smooth clamping surface on both sides for mounting top jaws.



Suitable for	Description	Interface	ID
KSC-D 125-670	SGM-E 125-98-40	W-125-1	1322974

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-D 125-670	SGAL-B 125-68-40		0432469

Central aluminum jaw

Used for rework at the customer site e.g. for incorporating contours or special shapes.



Suitable for	Description	Interface	ID
KSC-D 125-670	SGM-AL 125-98-40		1322975

Adapter plate

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



Suitable for	Description	Interface	ID
KSC-D 125-670	SGA-5 180-98-22	W-38	1322976

Swivel plate

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



Suitable for	Description	Interface	ID
KSC-D 125-670	SGP-3 180-95-22	W-38	0432470

Monoblock jaw

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



Suitable for	Description	Interface	ID
KSC-D 125-670	SGBB-B 125-66-40	W-125-1	1349858

Top jaws

6-way reversible jaws grip

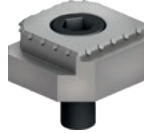
With five grip steps as well as a coated clamping face.



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

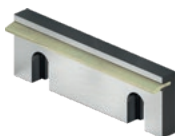
For precise clamping of round workpieces.
100 = Ø11 - Ø41 mm.
125 = Ø14 - Ø48 mm.
160 = Ø16 - Ø60 mm.



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

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-D 125-670	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-D 125-670	SPA 40-K	0432369
KSC-D 125-670	SPB 40-K	0432370
KSC-D 125-670	SPC 40-K	1327450

Clamping pin GFD-SP

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



Suitable for	Description	ID
KSC-D 125-670	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-D 125-670	GSH-D 10-100	0432477

Actuating lever, articulated

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



Suitable for	Description	ID
KSC-D 125-670	GSH-G 1/2"	0432478

Hexagonal insert SW 14

Suitable for square drive 1/2".



Suitable for	Description	ID
KSC-D 125-670	GSK-I SW14-1/2"	0432619

Sealing plug

For thread in the base body.



Suitable for	Description	ID
KSC-D 125-670	GVSS M10x12	1323002

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-D 125-670	GWSA M8-23	1645258

Magnetic workpiece stop, small

For quick and easy attachment to system jaws or vises.



Suitable for	Description	ID
KSC-D 125-670	GWSA-M 60 x 15	1391293

Magnetic workpiece stop, large

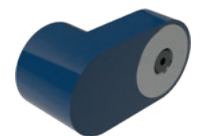
For quick and easy attachment to system jaws or vises.



Suitable for	Description	ID
KSC-D 125-670	GWSA-M 115 x 15	1391331

Extensions

As an accessory for the magnetic workpiece stops.



Suitable for	Description	ID
KSC-D 125-670	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-D 125-670	GSC-S M10-T12	12 mm/M10	0432043
KSC-D 125-670	GSC-S M12-T14	14 mm/M12	0432044
KSC-D 125-670	GSC-S M14-T16	16 mm/M14	0432045
KSC-D 125-670	GSC-S M16-T18	18 mm/M16	0432046
KSC-D 125-670	GSC-S M16-T20	20 mm/M16	1550423
KSC-D 125-670	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-D 125-670	GSC-G-1 M10-T12	12 mm/M10	0430422
KSC-D 125-670	GSC-G-1 M12-T14	14 mm/M12	0430423
KSC-D 125-670	GSC-G-1 M12-T16	16 mm/M12	0430424
KSC-D 125-670	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-D 125-670	GPSC-2 Ø12f7-M12	0490546

Precision T-nuts

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



Suitable for	Description	T-slot	ID
KSC-D 125-670	GPN M6-T12	12 mm/M6	0490590
KSC-D 125-670	GPN M6-T14	14 mm/M6	0490547
KSC-D 125-670	GPN M6-T16	16 mm/M6	0490548
KSC-D 125-670	GPN M6-T18	18 mm/M6	0490587
KSC-D 125-670	GPN M6-T20	20 mm/M6	1359734
KSC-D 125-670	GPN M6-T22	22 mm/M6	0490621

Alignment and centering set

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



Suitable for	Description	T-slot	ID
KSC-D 125-670	GAZ-2 T14	14 mm	0432209
KSC-D 125-670	GAZ-2 T16	16 mm	0432210
KSC-D 125-670	GAZ-2 T18	18 mm	0432211

Cylinder pin set

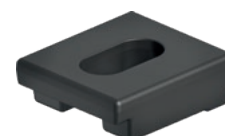
For easier assembly of the clamping device on the machine table.



Suitable for	Description	ID
KSC-D 125-670	GZS Ø12m6	1373755

Clamping claws

For quick and easy mounting of SCHUNK clamping devices.



Suitable for	Description	ID
KSC-D 125-670	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-D 125-670	GCS Ø22-M12	1307880

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-D 125-670	GWU-S grip 125-40	1394229

Workpiece supports

Workpiece supports – width 125 mm

In different heights.

1 Set = 2 pieces



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



**H.-D. SCHUNK GmbH & Co.
Spanntechnik KG**

Lothringer Str. 23
D-88512 Mengen
Tel. +49-7572-7614-1300
Fax +49-7572-7614-1039
CMM@de.schunk.com
schunk.com