



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.

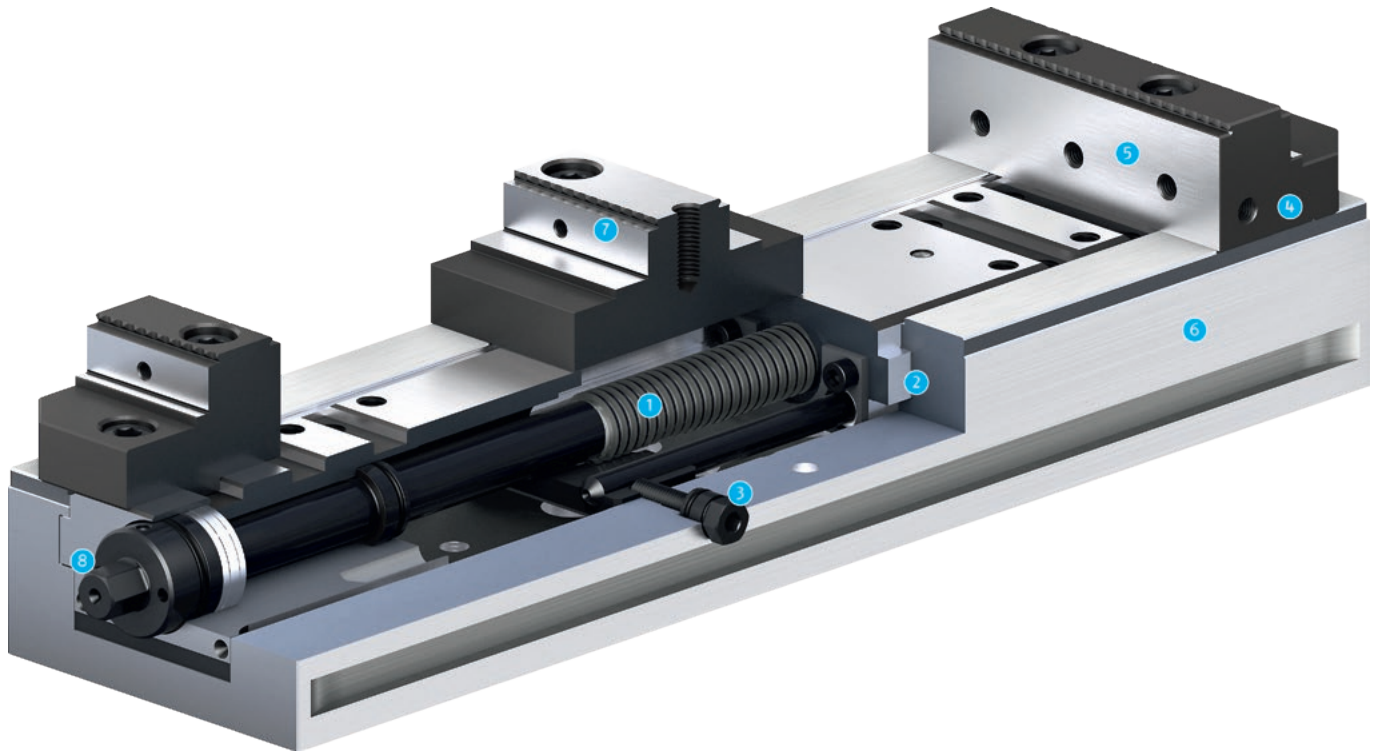


Advantages – Your benefits

- + 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.

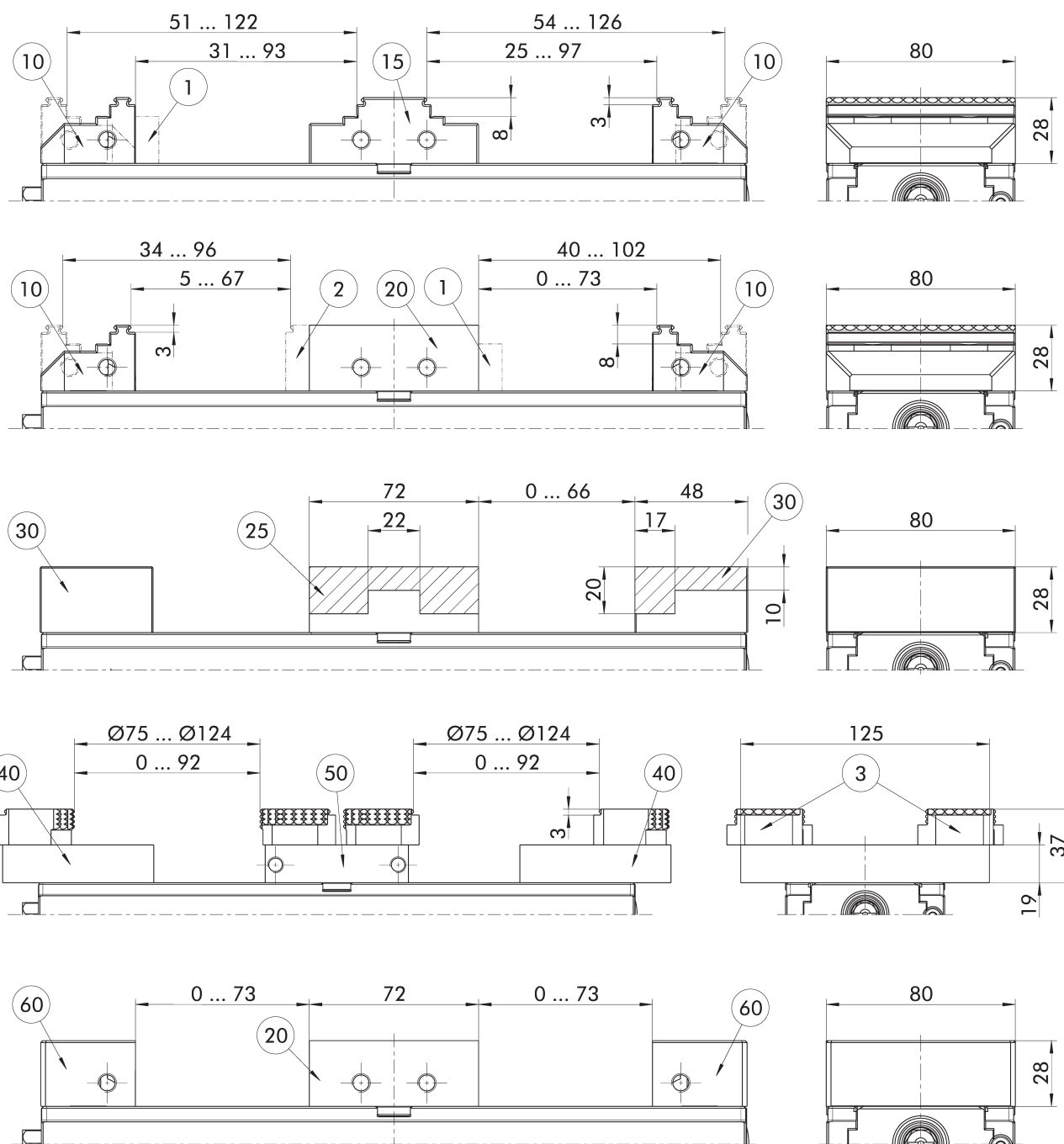


Mounting options

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 1326817)
- ② Stepped jaw, grip (ID 1326805)

- 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 80-300	1322945	80	25	100	8

Scope of delivery

Vise, operating manual; without system jaws

Notes

System jaws

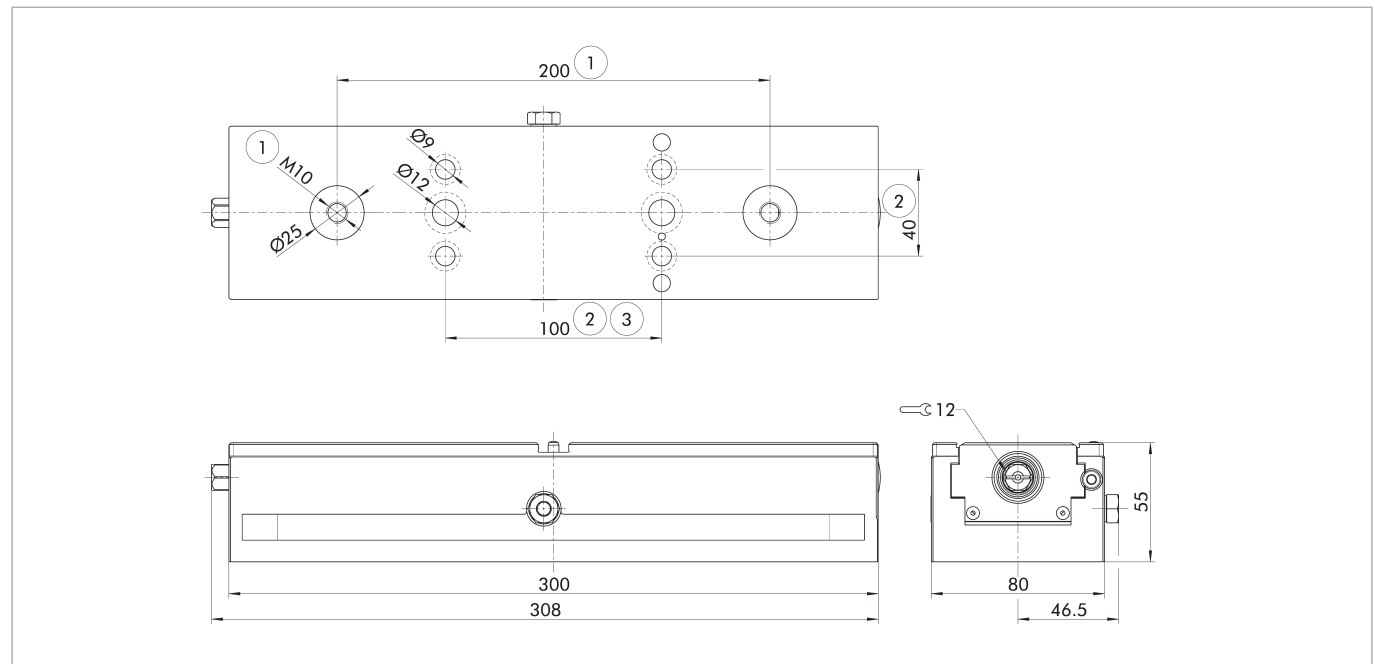
The clamping device and the system jaws have to be put together separately for this version.

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 80-40.3-28	0432715	80	40.3	28	0.5
Central grip jaw	15	SGM-G3 80-72-28	1322972	80	72	28	1
Central smooth jaw	20	SGM-E 80-72-28	1323071	80	72	28	1.3
Central aluminum jaw	25	SGM-AL 80-72-28	1323072	80.4	72	28	0.5
Aluminum jaw	30	SGAL-B 80-48-28	0432718	80	48	28	0.4
Swivel plate	40	SGP-3 125-76-19	0432720	125	76	19	1.3
Adapter plate	50	SGA-5 125-72-19	1323073	125	72	19	1.3
Monoblock jaw	60	SGBB-B 80-40-28	1349856	80	40	28	0.7



① Prepared for NSE3 and GFD clamping pins

② Prepared for M8 screws

③ Grid dimension prepared for M12 fitting screws

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 80-300	SGWB-G3-B 80-40.3-28	W-80-1	0432715

Central grip jaw

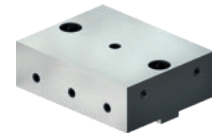
With grip step 3 mm (up to 22 HRC) and a smooth clamping surface on both sides.



Suitable for	Description	Interface	ID
KSC-D 80-300	SGM-G3 80-72-28		1322972

Central smooth jaw

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



Suitable for	Description	Interface	ID
KSC-D 80-300	SGM-E 80-72-28	W-80-1	1323071

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 80-300	SGAL-B 80-48-28		0432718

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 80-300	SGM-AL 80-72-28		1323072

Adapter plate

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



Suitable for	Description	Interface	ID
KSC-D 80-300	SGA-5 125-72-19	W-38	1323073

Swivel plate

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



Suitable for	Description	Interface	ID
KSC-D 80-300	SGP-3 125-76-19	W-38	0432720

Monoblock jaw

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

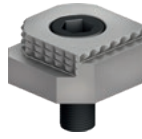


Suitable for	Description	Interface	ID
KSC-D 80-300	SGBB-B 80-40-28	W-80-1	1349856

Top jaws

6-way reversible jaws grip

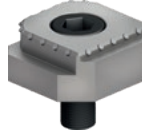
With five grip steps as well as a coated clamping face.



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

Stepped jaw

With coated step, 5 mm.



Description	Width mm	Height mm	Depth mm	Interface	ID
GBS-W 80-28-10-5	80	28	10	W-80-1	1395509

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 80-28-10	80	28	10	W-80-1	1326805

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 80-24-9	80	24.3	9	W-80-1	0432736

Universal stepped jaw

Versatile stepped jaw with ground step.



Description	Width mm	Height mm	Depth mm	Interface	ID
GPE 80-28-10-5	80	28	10	W-80-1	0432721

Accessories

Clamping force tester

For measuring the jaw clamping force of stationary clamping devices.



Suitable for	Description	ID
KSC-D 80-300	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 80-300	SPA 40-K	0432369
KSC-D 80-300	SPB 40-K	0432370

Clamping pin GFD-SP

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



Suitable for	Description	ID
KSC-D 80-300	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 80-300	GSH-D 10-100	0432477

Actuating lever, articulated

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



Suitable for	Description	ID
KSC-D 80-300	GSH-G 1/2"	0432478

Hexagonal insert SW 12

Suitable for square drive 1/2".



Suitable for	Description	ID
KSC-D 80-300	GSK-I SW12-1/2"	0432479

Sealing plug

For thread in the base body.



Suitable for	Description	ID
KSC-D 80-300	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 80-300	GWSA M8-23	1645258

Magnetic workpiece stop, small

For quick and easy attachment to system jaws or vises.



Suitable for	Description	ID
KSC-D 80-300	GWSA-M 60 x 15	1391293

Magnetic workpiece stop, large

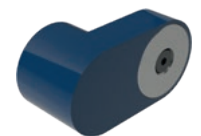
For quick and easy attachment to system jaws or vises.



Suitable for	Description	ID
KSC-D 80-300	GWSA-M 115 x 15	1391331

Extensions

As an accessory for the magnetic workpiece stops.



Suitable for	Description	ID
KSC-D 80-300	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 80-300	GSC-S M10-T12	12 mm/M10	0432043
KSC-D 80-300	GSC-S M12-T14	14 mm/M12	0432044
KSC-D 80-300	GSC-S M14-T16	16 mm/M14	0432045
KSC-D 80-300	GSC-S M16-T18	18 mm/M16	0432046
KSC-D 80-300	GSC-S M16-T20	20 mm/M16	1550423
KSC-D 80-300	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 80-300	GSC-G-1 M10-T12	12 mm/M10	0430422
KSC-D 80-300	GSC-G-1 M12-T14	14 mm/M12	0430423
KSC-D 80-300	GSC-G-1 M12-T16	16 mm/M12	0430424
KSC-D 80-300	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 80-300	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 80-300	GPN M6-T12	12 mm/M6	0490590
KSC-D 80-300	GPN M6-T14	14 mm/M6	0490547
KSC-D 80-300	GPN M6-T16	16 mm/M6	0490548
KSC-D 80-300	GPN M6-T18	18 mm/M6	0490587
KSC-D 80-300	GPN M6-T20	20 mm/M6	1359734
KSC-D 80-300	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 80-300	GAZ-1 T12	12 mm	1326851
KSC-D 80-300	GAZ-1 T14	14 mm	1326852
KSC-D 80-300	GAZ-1 T16	16 mm	1326853
KSC-D 80-300	GAZ-1 T18	18 mm	1326854

Cylinder pin set

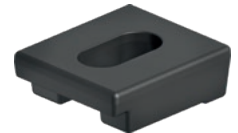
For easier assembly of the clamping device on the machine table.



Suitable for	Description	ID
KSC-D 80-300	GZS Ø12m6	1373755

Clamping claws

For quick and easy mounting of SCHUNK clamping devices.



Suitable for	Description	ID
KSC-D 80-300	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 80-300	GCS Ø22-M12	1307880

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-D 80-300	GWU-S grip 80-28	1394225

Workpiece supports

Workpiece supports – width 80 mm

In different heights.

1 Set = 2 pieces



Suitable for	Description	Height mm	ID
KSC-D 80-300	GWU-M 80-5	5	1465960
KSC-D 80-300	GWU-M 80-10	10	1465956
KSC-D 80-300	GWU-M 80-15	15	1460327
KSC-D 80-300	GWU-M 80-20	20	1411113
KSC-D 80-300	GWU-M 80-22	22	1411114



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