

# CENTRERANDE SKRUVSTYCKE

## FRÅN

# SKÄRPVERKTYG AB



## **SKÄRPVERKTYG AB**

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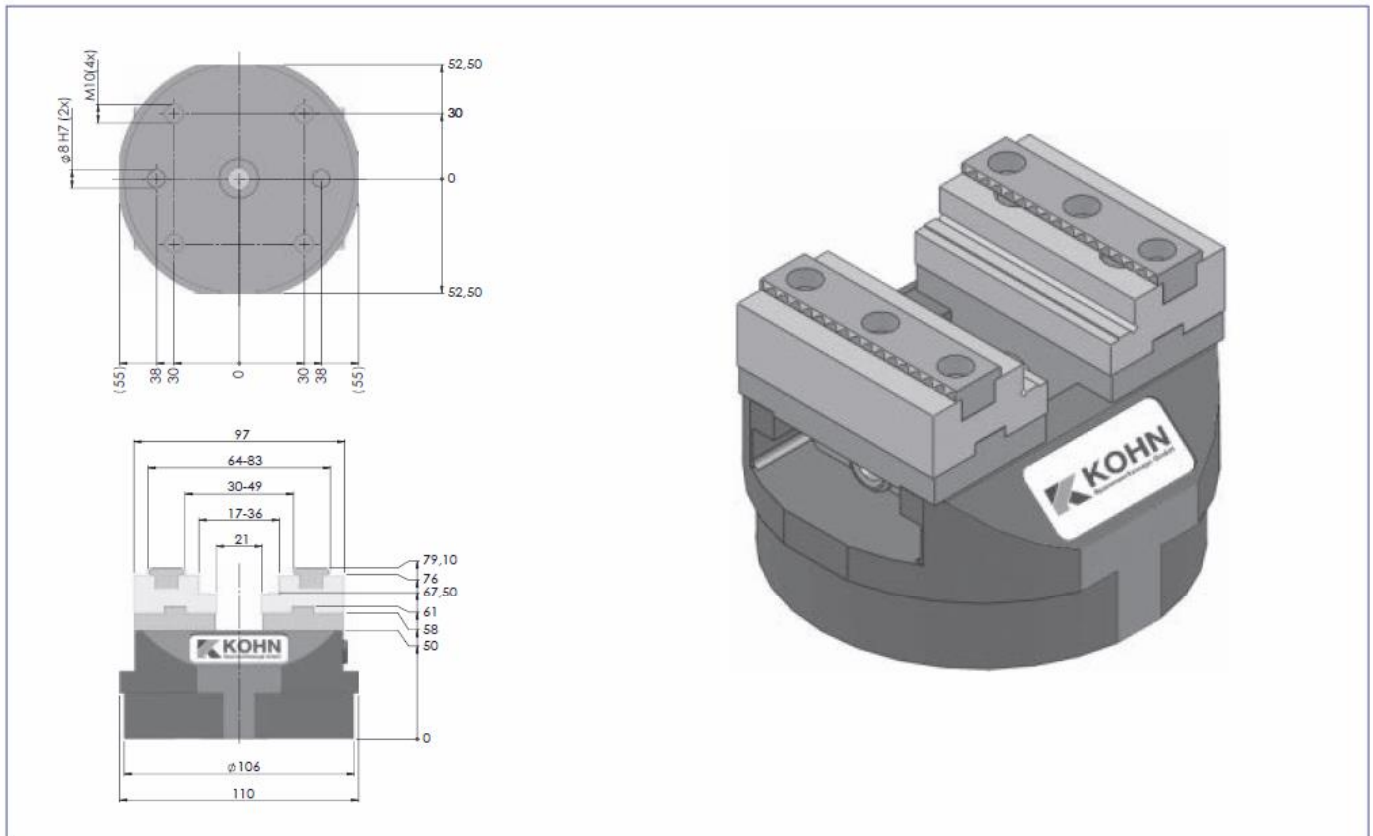
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## MACHINE VICES FOR WORKPIECE AUTOMATION

### ZSS 65 / 100 M (mechanically)



#### DESCRIPTION ZSS 65/100 M

- ▶ Body and hardened steel jaws, hardened and ground on all sides
- ▶ Spindle made of special steel
- ▶ Clamping bolt and the nut in one piece
- ▶ 4 x M10 and 2 x Ø 8 H7 to attach to the adapter plate and fixing
- ▶ Zentrierspannstock integrated range of zero-point clamping system
- ▶ arbitrary zero point clamping systems (eg Hirschmann, Erowa, ...) can be realized
- ▶ Centering accuracy  $\pm 0.1$  mm
- ▶ Weight: 3,3 kg

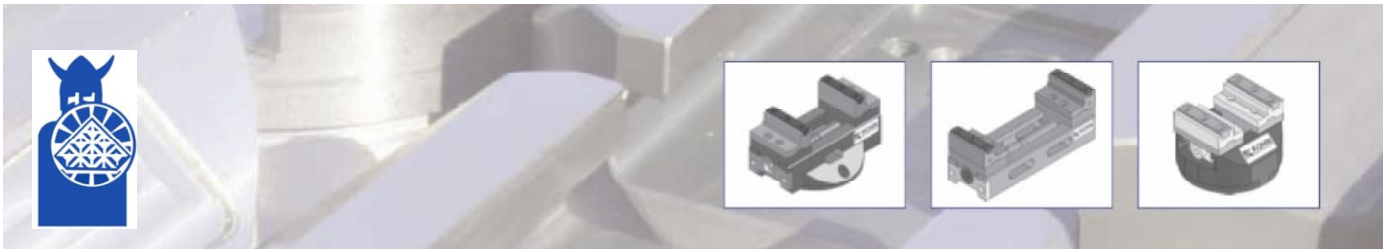
#### DESCRIPTION

**Basic equipment: 2 pcs top step jaws with Grippeleiste**

Order No. 03211

**Option: adjustable to  $\pm 0.03$  mm**

**Other shoes available on request!**



**Figures and elasticity graph**

**ZSS 65 M**



**ZSS 65 M in the standard version**

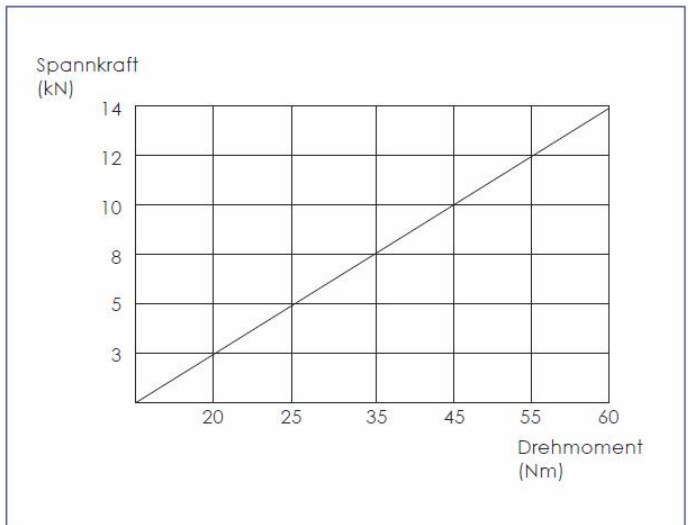


**ZSS 65 M with special jaws**

**ZSS 65 M im Einsatz**

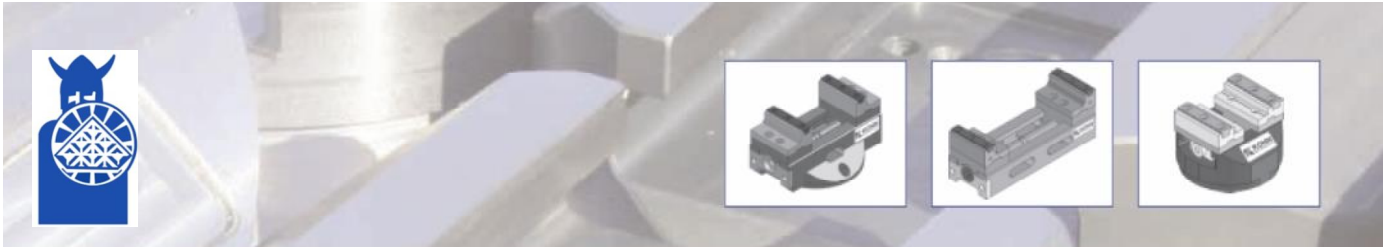


**ZSS 65 M with step jaw and Grippleiste**



**Clamping force diagram ZSS 65 M**

**Dimensions in mm**



## SELF-CENTERING VICE ZSS 80 M UNIVERSAL AND THE WORKPIECE AUTOMATION

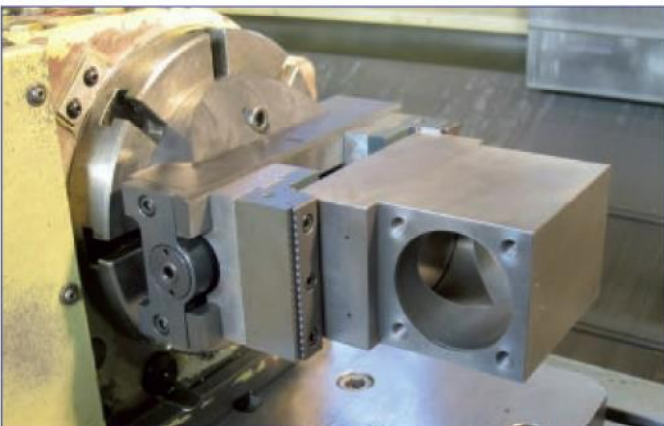
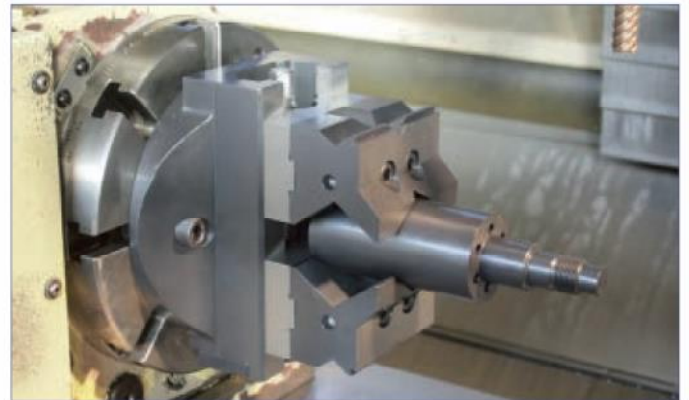
### ZSS 80 M UNI

#### DESCRIPTION ZSS 80 M UNI (MECHANICALLY)

- ▶ Body and hardened steel jaws, hardened and ground on all sides
- ▶ Spindle made of special steel
- ▶ Clamping bolt and the nut in one piece
- ▶ Zentrierspannstock integrated range offers universal application
- ▶ arbitrary zero point clamping systems (eg Hirschmann, Erowa, ...) can be realized
- ▶ Dividing possible inclusion on
- ▶ can be directly mounted on the machine table
- ▶ suitable for 5-axis machines
- ▶ large range with a small vice
- ▶ Back extensive range offers many different edits
- ▶ Centering accuracy  $\pm 0.02$  mm

#### DESCRIPTION

**Basic equipment: 2 pcs top step jaws with Grippleiste, a crank-handle**



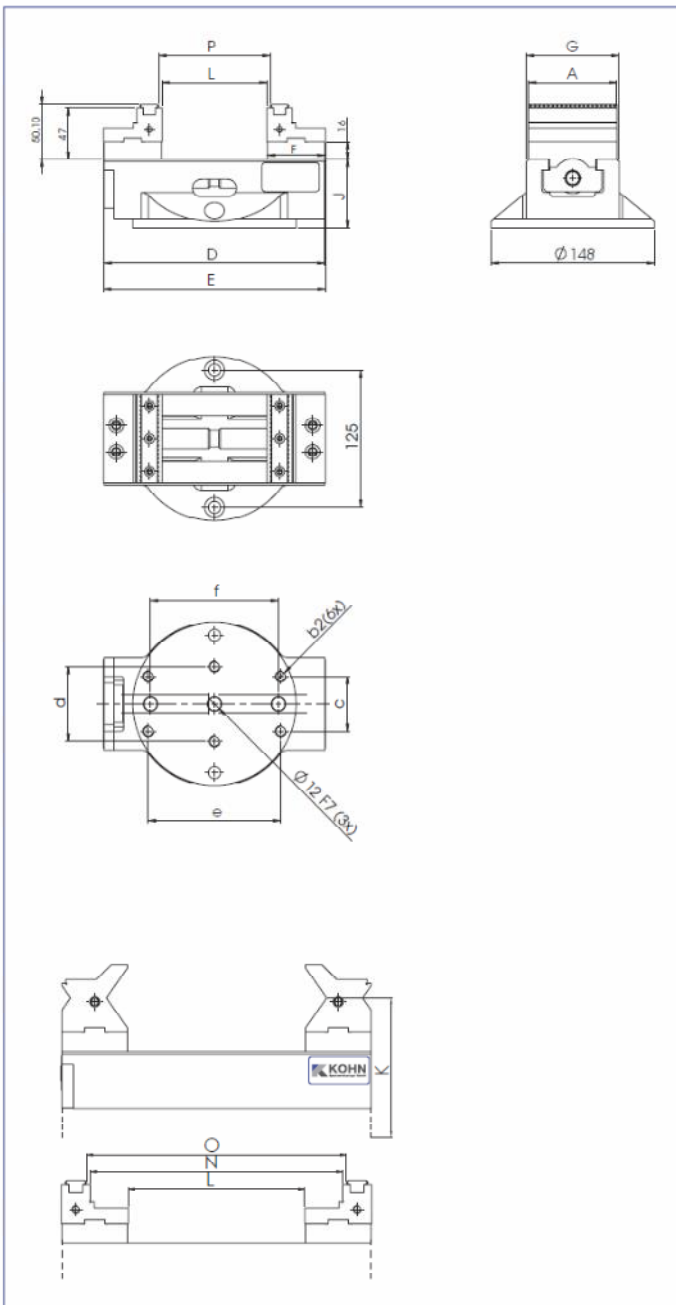
ZSS 80 M UNI on dividing



ZSS 80 M UNI on the machine table

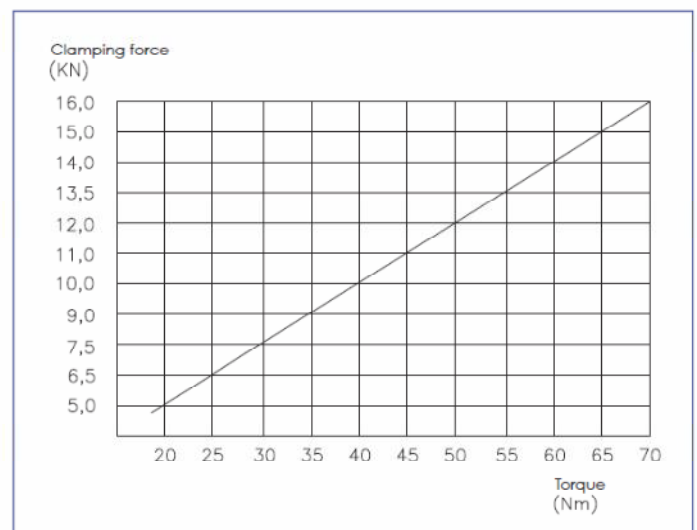


## Technical drawing ZSS 80 M UNI



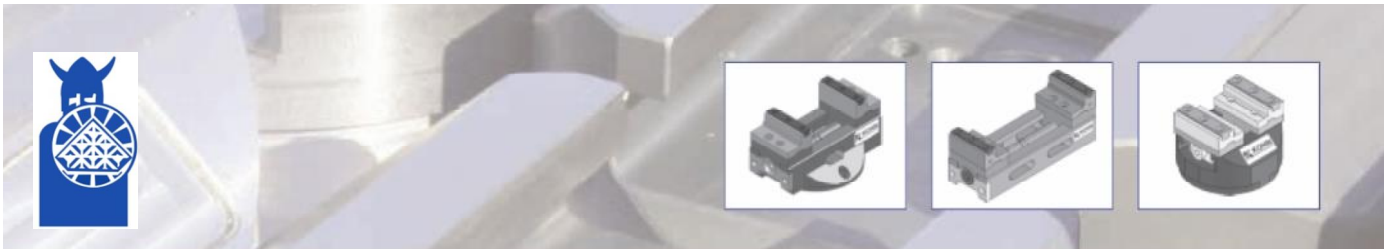
Type		ZSS M universal	
Jaw width	A	80	
Order No.		Z3310	Z3311
bed length	D	170	200
total length	E	171	201
cocking lever	F	52	52
total width	G	84	84
bed height	Jh7	62	62
top center	K	105	105
Hexagon		12	12
	b2	M10	M10
	c	50	50
	d	68	68
	e	120	120
	f	116	116
clamping range	L	1.64	1.94
	N	124	154
	O	130	160
	P	70	100
centering		± 0.02	± 0.02
weight	kg	8.3	8.8

## Clamping force diagram ZSS 80 M UNI



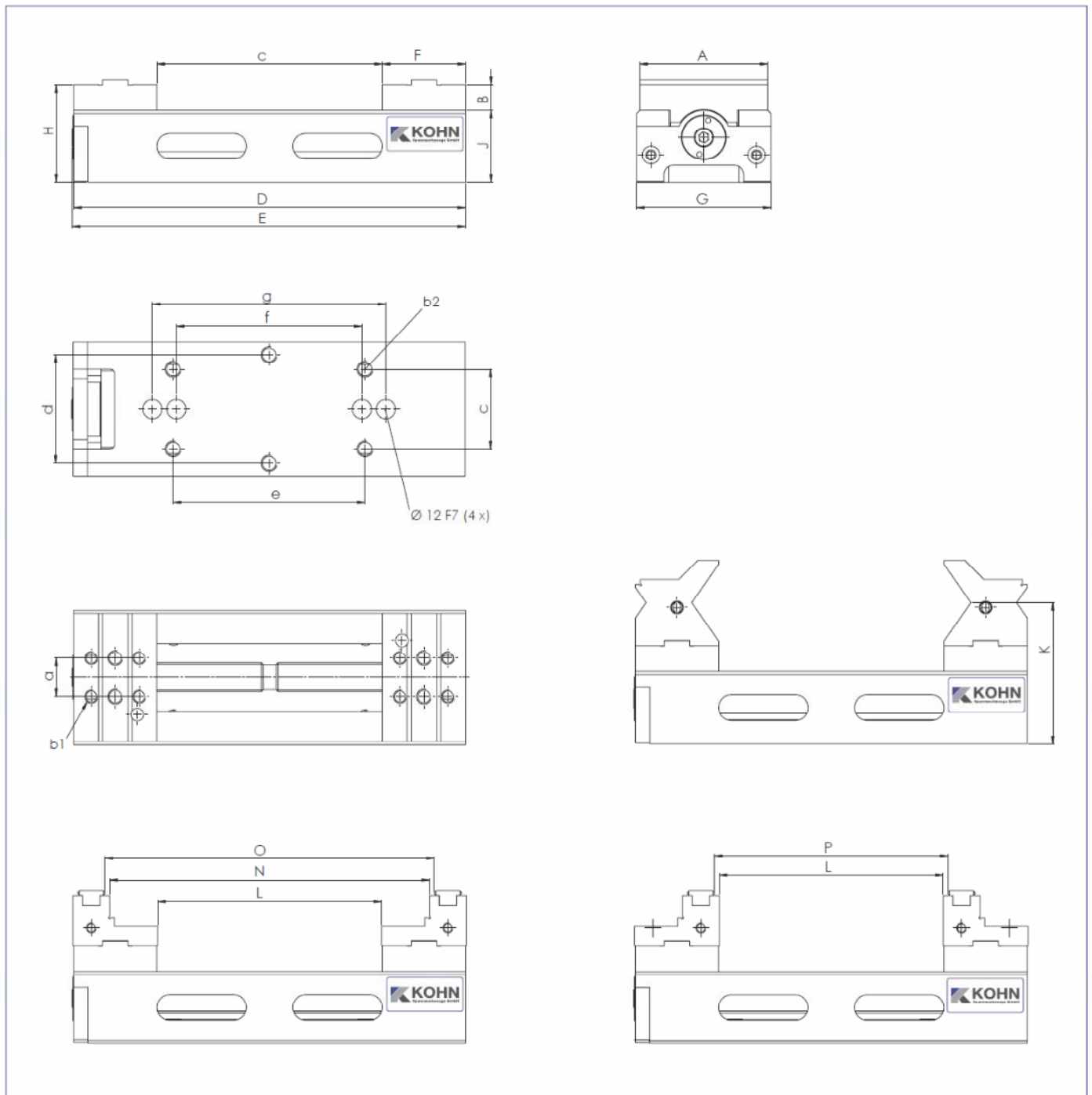
See pages 85-87 range back  
Other bed lengths on request

Dimensions in mm

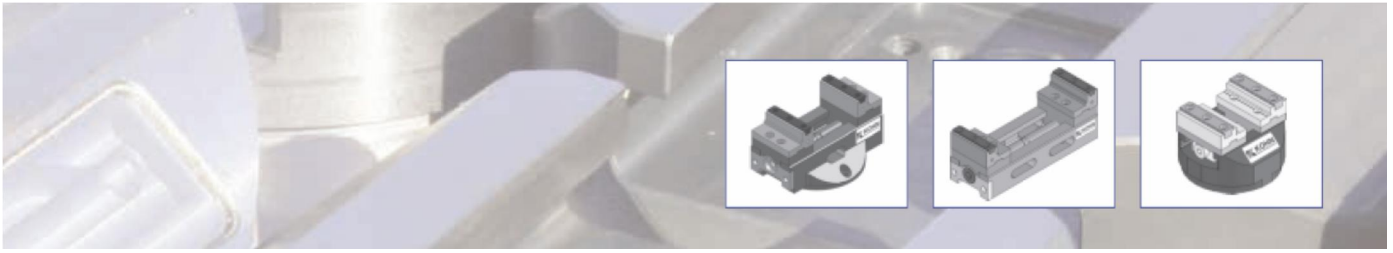


## MACHINE VICES FOR WORKPIECE AUTOMATION SELF-CENTERING VICE ZSS M (MECHANICALLY)

### Technical drawing



Dimensions in mm



## MACHINE VICES FOR WORKPIECE AUTOMATION SELF-CENTERING VICE ZSS M (MECHANICALLY)

### ZSS

Type	ZSS					
	A	80			125	
Order No.		03311000200	0331S2450001	0331S3150001	0351S2450001	0351S3150001
Chucking	B	16	16	16	17	17
Span	C	96	141	211	113	183
Bed length	D	200	245	315	245	315
Total length	E	217	246	316	246	316
Cocking lever	F	52	52	52	66	66
Foot width	G	84	84	84	127	127
Total height	H	61	61	61	79	79
Bed height	Jh7	45	45	45	62	62
Top center	K	88	88	88	-	-
Prism jaw clamping range						
Hexagon		12	12	12	17	17
	a	24	24	24	32	32
	b1	M8	M8	M8	M8	M8
	b2	M10	M10	M10	M10	M10
	c	50	50	50	50	50
	d	68	68	68	68	68
	e	120	120	120	120	120
	f ± 0.02	116	116	116	116	116
	g ± 0.02	-	146	146	146	146
	L	95	140	210	112	182
	N	155	200	270	200	270
	O	161	206	276	206	276
	P	101	146	216	118	188
Centering		± 0.02	± 0.02	± 0.02	± 0.02	± 0.02
Weight	kg	5.4	5.5	6.7	12.7	15.5

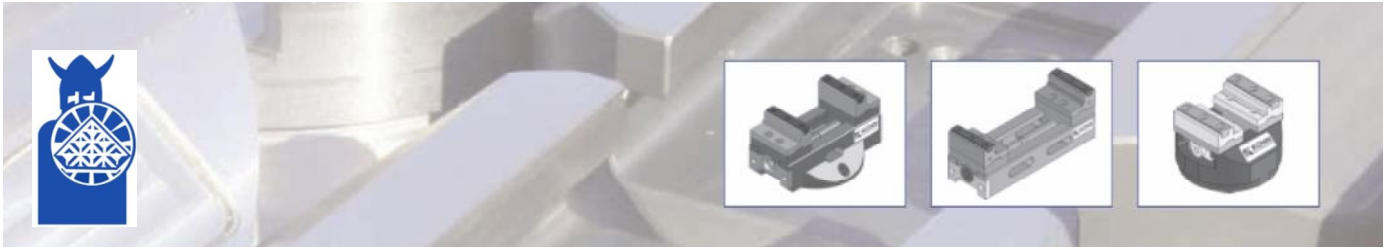
Other bed lengths are available upon request

Basic features: Without shoes, a crank-handle

Dimensions in mm

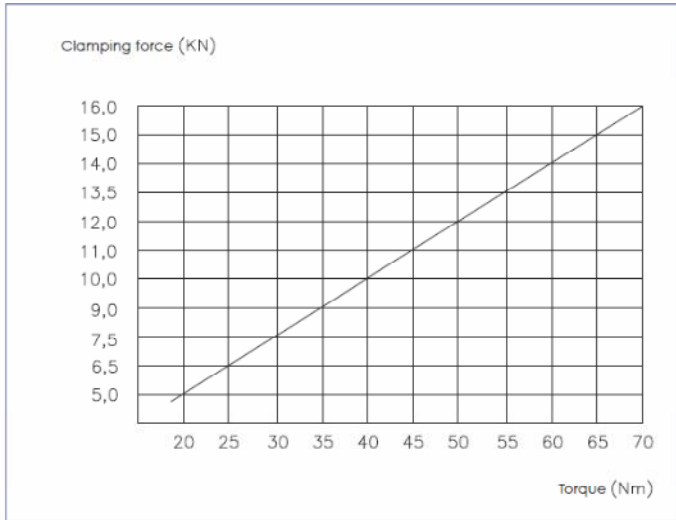


**ZSS 80 M with top-  
Stepped jaws and Grippleisten**

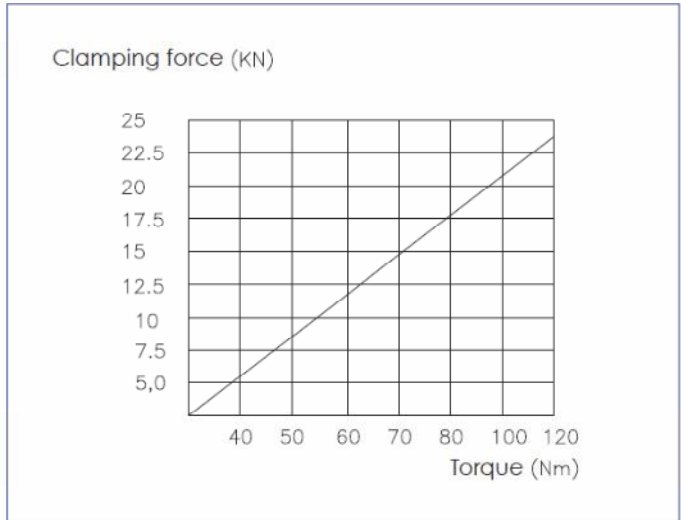


**MACHINE VICES FOR WORKPIECE AUTOMATION**  
**SELF-CENTERING VICE ZSS M (MECHANICALLY)**

**ZSS Clamping force diagrams**



**ZSS 80 M**

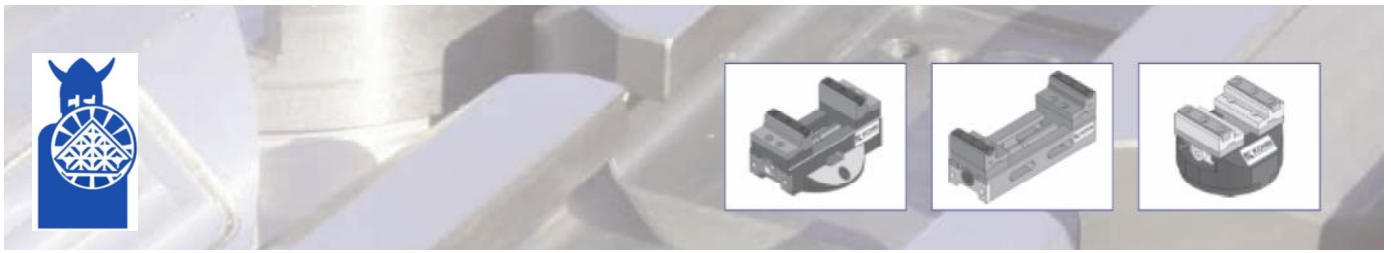


**ZSS 125 M**



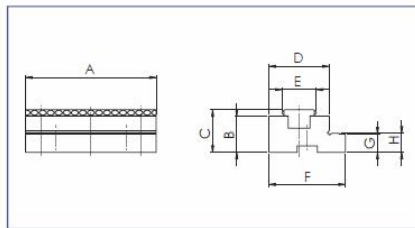
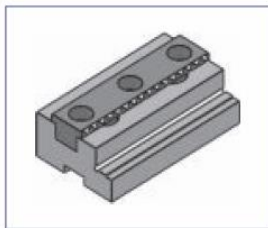
**ZSS 80/200 M with prismatic jaws horizontally and vertically on the base plate**

**Order No.** 03311

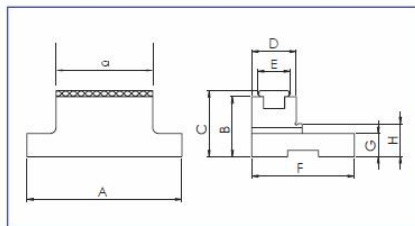
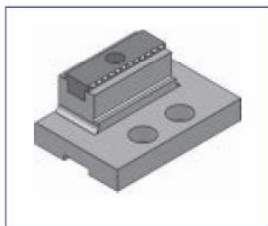


## MACHINE VICES FOR WORKPIECE AUTOMATION ACCESSORIES

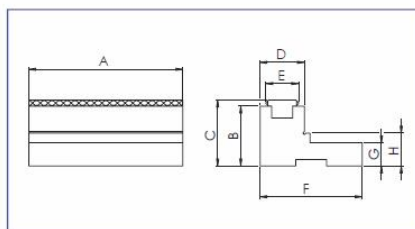
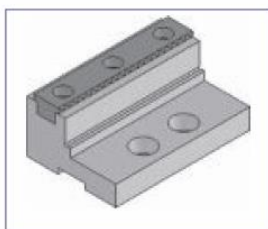
### Step jaw with grip-strip



Size	Order No.	A	B	C	D	E	F	G	H
65	03210011	65	18	21	30	17	38	9	9.5

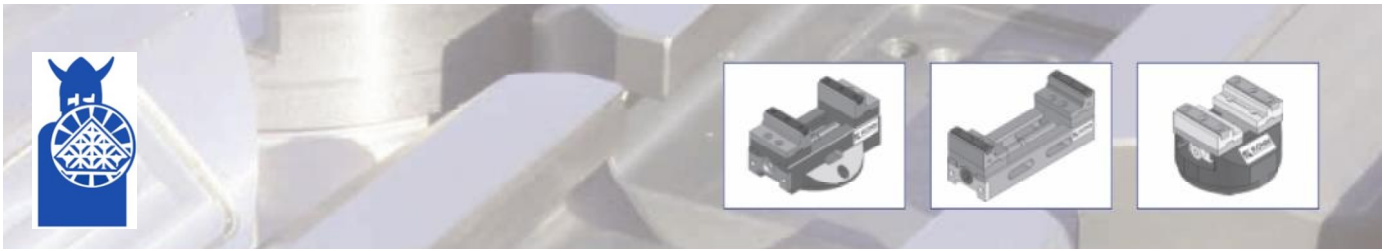


Size	Order No.	A/a	B	C	D	E	F	G	H
80/40	03310024	80/40	31	34	23	17	53	12	17
80/50	03310025	80/50	31	34	23	17	53	12	17



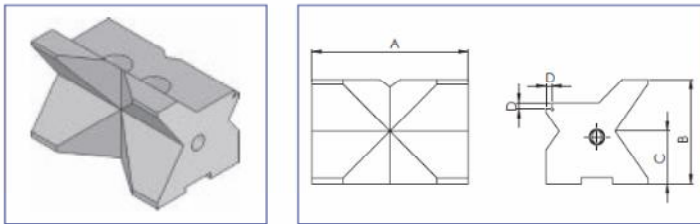
Size	Order No.	A	B	C	D	E	F	G	H
80	03310535P	80	31	34	23	17	53	12	17
80	03310017	125	31	34	23	17	53	12	17
125	03510028	125	31	34	23	17	67	18	23

More shoes in different sizes and voltage ranges on request



## MACHINE VICES FOR WORKPIECE AUTOMATION ACCESSORIES

### Prismatic jaw (horizontal and vertical)



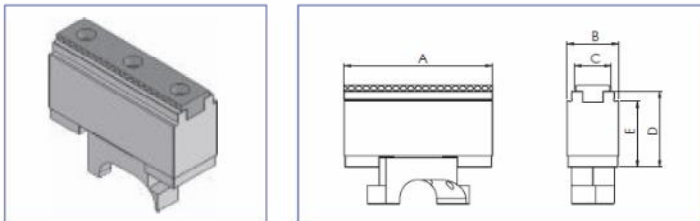
Size	Order No.	A	B	C	D
80	03310501V	80	53.5	27	3

#### Clamping diameter

	Area 1	Area 2
horizontal and vertical	Ø 11-30	Ø 30-80

Prisms with 110 °

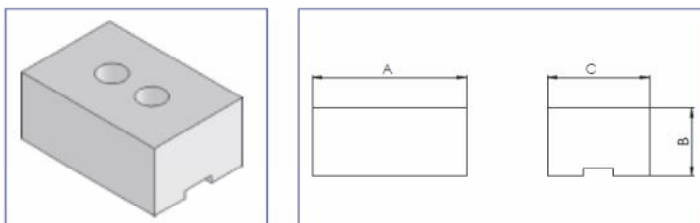
### Complete changeover slider



Size	Order No.	A	B	C	D	E
80	03310215	80	28	17	22.5	28
80	03310228	80	28	17	41	35.5
80	03310234	80	28	17	47	33

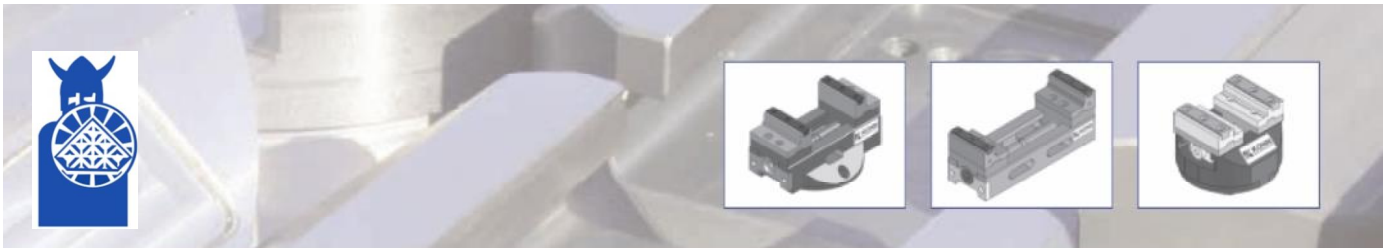
Window slide facilitate clamping of multiple workpieces

### Jaw blank of aluminum



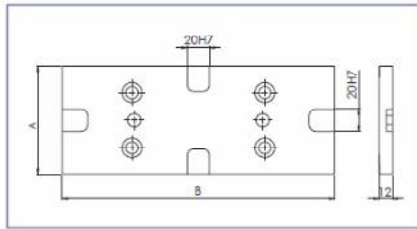
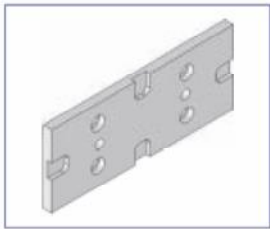
Size	Order No.	A	B	C
80	03310505FL	80	35	45
80	03310505	80	35	53
80	03310507	80	20	53

Back blanks of aluminum



## MACHINE VICES FOR WORKPIECE AUTOMATION ACCESSORIES

### Base

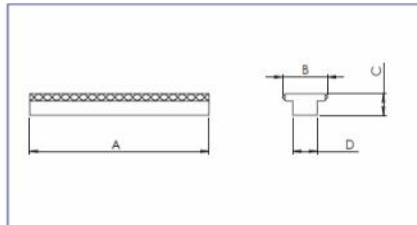
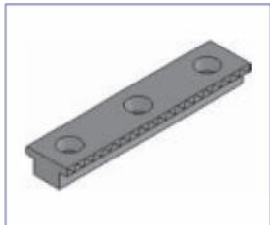


Size	Order No.	A	B
80	033101041	98	200
80	033101042	98	230
80	033101043	98	246

**Base plate as an adapter  
between vice and  
machine table**

**Size 125 on request**

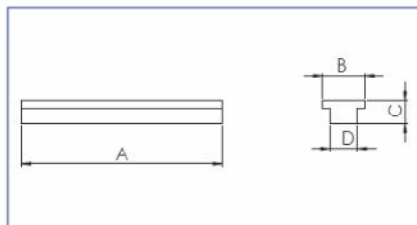
### Gripp-use for Step jaw and slide change\*



Size	Order No.	A	B	C	D
65	03210002	65	17	9.2	11
80	03310550	80	17	9.2	11
80	03310551*	80	20	9.2	11
80/125	03510550	125	17	9.2	11

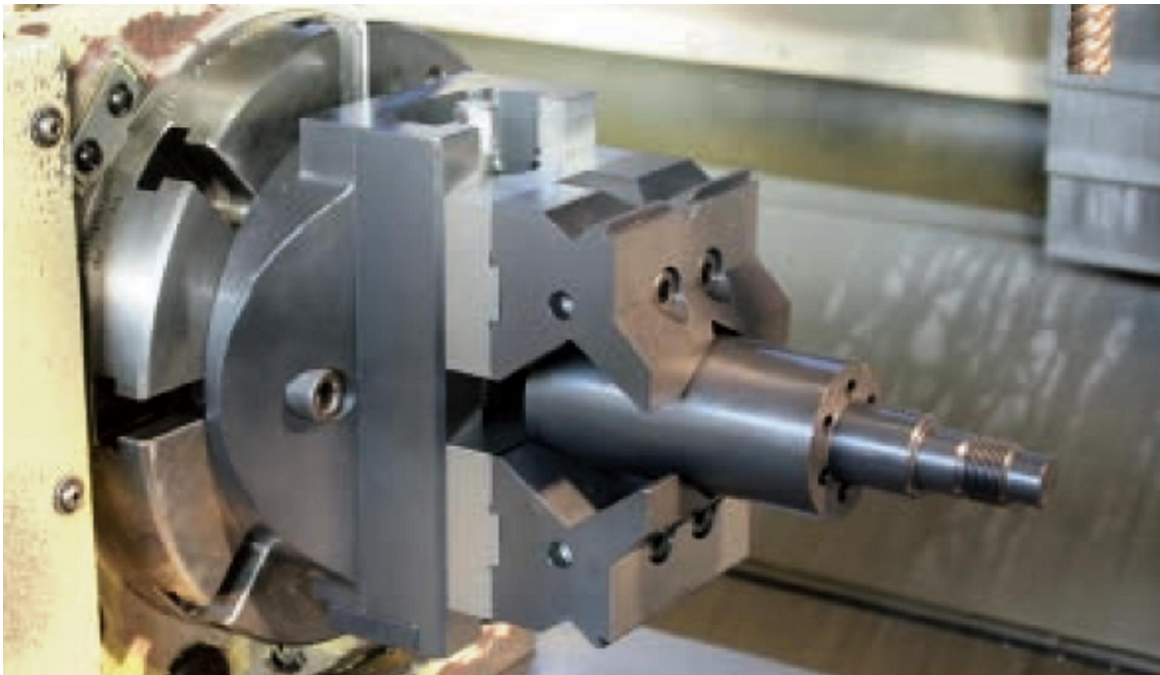
**Gripp-use for both sides geriffelt Step  
jaw and removable vane \***

### Used for Step jaw and removable slide\*



Size	Order No.	A	B	C	D
80	03310553	80	17	9.2	11
80	03310554	80	20	9.2	11

**Clamping bar with a smooth cut-  
ting surface Size 125 on request**



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