SKÄRPVERKTYG AB

KOHN Spannwerkzeuge

solid. connections.

Clamping and Automation Solutions for High-End Machining

2017

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Design & Implementation
Werbeagentur Rudolph GmbH, Winnenden
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Automation, innovation, investment – we have the right product range to meet your requirements.

Dear Customer,

our new catalogue is representative of the departure to our company. Clearly structured and self-explanatory, you can now get an excellent overview of the large product range of vices.

Our wide product range of accessories is unique in its diversity and dimension. It is easy to understand and clearly arranged in such a way that you can find and order the right clamping accessories for your production process.

solid. connections. Our new slogan communicates our company's and product philosophy, which has been pursued for many years. "solid" is part of our product aspiration to consistently deliver the highest quality, precision and associated longevity, coupled with maximum efficiency. Sound advice and excellent quality as well as fast availability and fair prices are the basic pillars of our customer-oriented thinking.

Our "connections" is a priority for us. We see our products as the key link between machine and workpiece. At the same time, in the age of on-line thinking, we continue to be the contact partner, solution provider and innovation motivator for our customers in the machining industry.
Feel free to contact us, we are the experts with decades of experience and also have the right answer to your clamping task.

Heike Kohn
Managing Director

About us

> 66

Expertise and experience

With experience extending over more than 66 years in the production of vices, KOHN today more than ever stands for the highest quality and precision in the development and production of the vices. We cover the entire process chain. From consulting services, the development, manufacture and installation to customer support services, we always want to support our customers to the best of our abilities.

innovation and structure

Our team-oriented corporate structure integrates development, manufacturing, marketing and sales to the highest degree. Innovations and new products are created in close cooperation with our customers.

!?

Standard and special accessories

Our extensive standard range offers a wide range of clamping solutions to our customers in the areas of mechanical clamping, mechanical-hydraulic clamping and fully hydraulic clamping. We are also known as a specialist in customer-specific solutions in the market. We see ourselves as problem solvers. Our products are characterized by a long service life and precision with a fine price-performance ratio.

Our objective

We always want to remind ourselves of the art to listen to what our customer wants. We see this as the main condition for satisfied customers. We want to inspire our customers with team spirit, motivation and joy. The best advice, top quality, custom solutions and last not least, fast and reliable after-sales service are the focal point of our efforts. Long-term partnership with our customers and suppliers. Satisfied and motivated employees. In this respect, the person should always play a key role.

this is what the KOHN team stands for.

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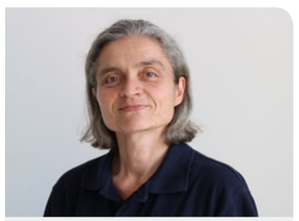

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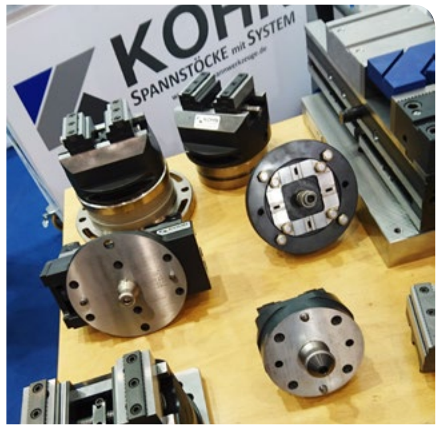
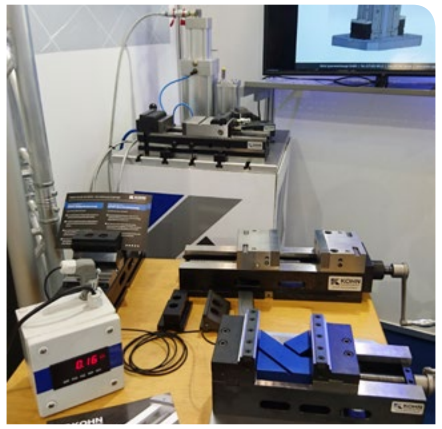
KOHN on the road: Our Trade Fair Goals

You do not need to find the way to Rudersberg: Our entire product range is represented at the most important trade fairs: AMB and Molding Expo in Stuttgart, EMO in Hanover, InTEC in Leipzig - get to know us when when you visit our booth. Our technicians take the time to respond to your enquiries. Our wide range of accessories is particularly interesting. We offer: Products which you can touch and test! The best tips and tricks given by our clamping professionals. Thus, any clamping task can be solved much more easily.





Training provided: By professionals, for professionals

What does the right clamping mean? How do I handle steel, aluminium or plastic? What forces affect the blank during clamping and cutting? What tools and tricks are there for difficult clamping tasks and how do I achieve the best repetition accuracy? Many questions about clamping are discussed and solved in our workshops. Do you want to learn more? Then you should definitely visit us in the beautiful town of Rudersberg. Just call us and make an appointment.

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Customer references

Our customers range from small businesses in trade and industry leading up to Germany's leading large enterprises, as well as machinery manufacturers and dealers in Germany and abroad.

For us, the only manufacturer in the field of centring vices is: the KOHN company! Why? We feel that your product is versatile and particularly stable. Moreover, ZSS 125 is characterised by easy handling and what is especially important, its high repeatability is really impressive.

Hans Hellbeck Maschinenbau – Horst Hellbeck, Company Owner

1.) Clamping means/ tools are of super quality
2.) Delivery times are met
3.) Super service in the repair shop, including fair dealing policy
4.) Price-performance ratio is fine, individual arrangements with regard to terms and conditions is always possible

Mauersberger & Fritzsche GmbH & Co. KG – Pierre Neitsch, Head of Purchasing

In our daily processing of thermosetting fibre-glass reinforced plastics, we use your mechanical centring vice ZSS 80/200 M with internal spindle bearing and this is absolutely reliable and low-maintenance. The open spindle system does not cause any problems and makes chips and dust easy to remove.

HZ GmbH – Matthias Zeder, Managing Director

The documents and website are clearly arranged, the service is fast and uncomplicated, the cooperation is always pleasant. We have no problems with the open spindle. We flush the chips through the side holes by means of cooling water.

Promet AG – Simon Fässler, Productions Manger & Evelyne Kruger, Assistant Manager

We have used the KOHN centring vice ZSS 80/200 as well as several NCS-ZA125 M-HD for many years and are extremely satisfied. The KOHN booth is always a pleasant place to visit and assess novelties with a cup of coffee.

Robolution GmbH – Stefan Seipel, CNC Operations Manager

Above all, we value the possibility of individually adapting machine vices to different working environments. The NCS design allows easy removal of chips and thus also a fast change of the workpiece.

Werkzeugbau LEISS GmbH – Georg Hörning, Production Manager

Our company Metall + Plastic has been a customer of KOHN for over 15 years and utilises 22 vices with the utmost satisfaction.

METALL + PLASTIC GmbH –
Sassa Hlavacek, Documentation

For more than 25 years, we have continually gained positive experience with the versatile products by KOHN and we would like to thank you for your trusting cooperation over many years.

Rogatti Bewegungstechnik GmbH & Co. KG –
Mike Strohmaier, Production Manager

For several years now, we have equipped our machining centres with KOHN hydraulic vices,
as their reliability and durability is a guarantee for trouble-free production. In the service sector, we can rely on a short response time and professional consultation and/or fast turnaround.

Schleicher-Laller GmbH –
Rupert Laller, Managing Director

We have been using the "HWS" centring vices every day since 2001, and to date every vice has operated as if on the first day. The free-running spindle can be easily cleaned and greased, if necessary.

Zeppelin Baumaschinen GmbH –
Mathias Fahrenholz, Technician

I have been using KOHN vices for over 20 years. Single tensioners as well as the popular double tensioners. We had over 30 purchased vices repaired 4 times within 2-3 days. The vices provide for maximum flexibility in the clamping situation, whether mould, step, clawed, or prism jaws. If it has to be fast, you can buy it or adapt it yourself to a workpiece.
As regards the "open spindles" we never had any problems, despite high chip volume in VA and steel chips. To date, no spindle has yet to be replaced! They will last forever if handled reasonably.

Klenk & Stiefele –
Andreas Stiefele, Managing Director

We have used NCS 125 vices by KOHN since 2009. Both vices and accessories have operated properly since then. We opted for these vices, because KOHN was able to implement our special requirements quickly and easily, such as special drilling patterns and special setting-out dimensions. Moreover, all KOHN special clamping jaws were supplied, which provided for easy and fast adaptation. Even after 8 years on a machining centre with pallet changer, both the vices and mounted parts still function flawlessly.

Boerkey GmbH –
Detlef Knupp, Production Manager

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We use KOHN NCS vices daily on all milling machines, both hydraulic and mechanical. They are very reliable and versatile.

Hinkelmann Metall GmbH & Co. KG –
Mark Hinkelmann, Managing Director

We have opted for KOHN vices to achieve our Vision 2030 "We are the fastest plastic chipper in Europe".

Dutec Kunststofftechnik GmbH –
Hendrik Wielens, Tool Procurement

KOHN has adjusted one-metre long vices "ESS-FV 160/1000 HD SV" to our machine precisely in accordance with our requirements, which allows us to make maximum use of the machine area. The precision and reliability is provided throughout the clamping range. Due to the quick adjustment of the Clamping sliderrs we are able to change over to different workpiece sizes in seconds. The solid jaw at the front is a luxury feature for the operator, which allows to bring workpieces to the machine quickly, comfortably and ergonomically. A complete package, including hydraulic accessories, enabled a fast connection to the machine hydraulics without additional specialist personnel.

Walther Flender GmbH –
Christof Hanning, Production & Assembly Manager,
Member of the Executive Board

In our production we use the KOHN VZA cross-clamping system in various sizes. In the field of CNC special machining we specialize in the customised production of tool components. These individual pieces require a flexible clamping system. The VZA cross-clamping system reduces set-up times by up to 30%. Large workpieces can be quickly and securely fastened on the machine table by clamping on four sides. The workpieces are precisely positioned in the machine centre by means of the two centring spindles. In most cases, no probing is needed. The investment made in the VZAs has quickly paid off for us.

Marks GmbH –
Lothar Marks, Managing Director

Regarding the open spindle: Easy-to-clean, trouble-free, no chip accumulation.

Miratec Kunststofftechnik GmbH –
Michael Hamsen, Managing Director

We use KOHN products every day and are thrilled by the longevity at a fair price. A competent partner with whom we can efficiently implement our special solutions. Excellent consulting and fast shipping of spare parts guarantee the utmost satisfaction.

Solidtec GmbH –
Daniel Parr, Project Manager

New product update: Clamping force measurement in vice

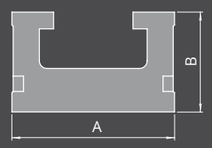
Absolute process safety during clamping. Plastics, aluminium and steel - you can now precisely monitor the pre-configured clamping pressures for each material, similar to your production process. The right step into the future in combination with the proven KOHN quality. Feel free to contact our Technology Department for any queries.

- Force measurement via sensors: before, during and after machining
- Quick recognition of clamping errors and optimum workpiece handling during cutting process – minimises rejects and reduces production costs
- Continuous reading via stand-alone display or control panel
- Suitable for any standard interface

Flatbed versions: more space, less weight:

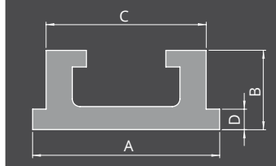
More space in all dimensions! Do you work with multiple clamps on tower or cube? The crucial millilitres for the implementation of your project are missing because the working space is insufficient. Unique solutions provided by KOHN: All vices marked with the "Flat bed version" button come in a body with a reduced height and save up to 20% of weight: Less is more - this is how clever clamping works!

High bed:



Size	A	B
80	84	65
100	104	78
125	127	78

Flat bed:



Size	A	B	C	D
80	98	45	80	12
100	118	52	100	14
125	146	62	125	16

KOHN automation: clamping and loading

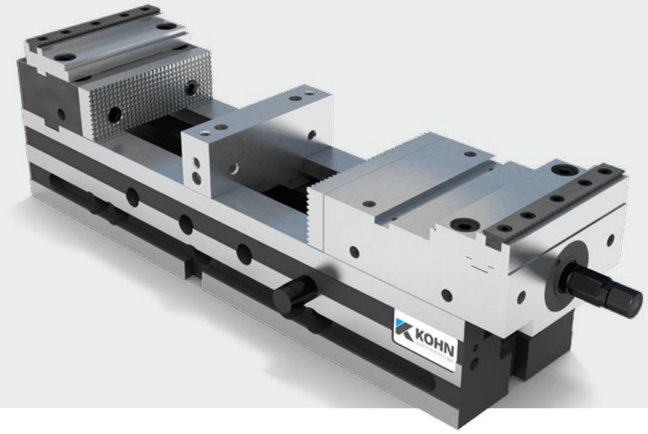
One-stop solution - a complete turn key from the beginning. As an experienced manufacturer of high-quality clamping devices, we provide solutions for complete, automated loading of your machines. Successful automation with the KOHN full service: Upon request, you will receive all the necessary components and services virtually from one source:

- KOHN vices, including adaptation to your existing zero-point clamping system
- System integration of robots by our system partner
- Software, test run and instruction on site
- Upon request, funding by our partner GEFA-Bank

Demonstration vices: First test, then invest!

You would like to use a vice from our product range and do not yet know if it fits your application? No problem: Ask to view or test your KOHN vice free of charge! You couldn't invest better and safer. What else can you expect?

Feel free to contact our Service Department for any enquiries.



KOHN Spannwerkzeuge +++ News+++ *solid. connections.*

The small ABC of the KOHN product range...

DSS
Double vice

Vice with two symmetrical current clamping bolts, a central jaw and a continuous spindle.

ESS
single vice

Vice equipped with one fixed jaw and a movable clamping slider with continuous spindle.

FV
"fixed jaw in front"

Fixed jaw on the operator side of the vice.

HP
Hydraulic

Hydraulic pressure build-up, hydraulic unit required, mechanical span adjustment.

M
Mechanical

Mechanical pressure build-up and span adjustment, the use of a torque wrench is recommended.

MFS
Multi-functional vice

Two individually adjustable clamping sliders, which can be moved both separately and jointly. The central jaw is fixed.

M-HD
Mechanical-hydraulic

Mechanically operated vice with mechanical-hydraulic power transmission, (no hydraulic unit required).

MK
mechanical-disk cam

vice equipped with cam-plate locking for adjusting. One or two clamping sliders can be adjusted.

MOT
motor-driven

Span adjustment and pressure build-up powered by a hydraulic motor.

NCA
NC-vice vertical

Vice with a fixed jaw and a movable clamping slider, which can be mounted vertically on the machine table.

NCS
NC-vice

Vice equipped with one fixed jaw and a movable clamping slider. Build-up of the clamping force optionally with mechanical and hydraulic booster or purely hydraulic.

NCS-ZA
NCS-vice with tie rods

Vice equipped with one fixed jaw and a movable clamping slider and tie rod system to prevent the fixed jaw from tilting away.

UNI
universal/ all-purpose

UNI vices can be used for a wide range of purposes for clamping and workpiece automation. They are suitable for all zero point clamping systems and can be adapted by means of pallets.

VZA
Starting from the center

Workpiece is clamped with two spindles arranged crosswise in the centre of vice.

ZSS
Self-centering vice

Vice with two concentric converging clamping bolts.

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False jaw

Attachable clamping element with different clamp steps on the clamping slider, fixed and central jaw.

Jaw width

Measurment for specifying the vice width and breadth of the screw in jaw.

Bed/bed length

Main body of the vice and its length.

Screw-in jaw

Clamping unit mountable on fixed, middle and clamping jaws, according to the requirements.

Clamping depth

Measures from the top screw-in jaw up to the bed surface.

Fixed jaw

A fixed jaw screwed to the bed at the width of the vice.

Grip bar

Screw-in insert, for clamping with clamping edge, with grip or smooth.

Clamping slide

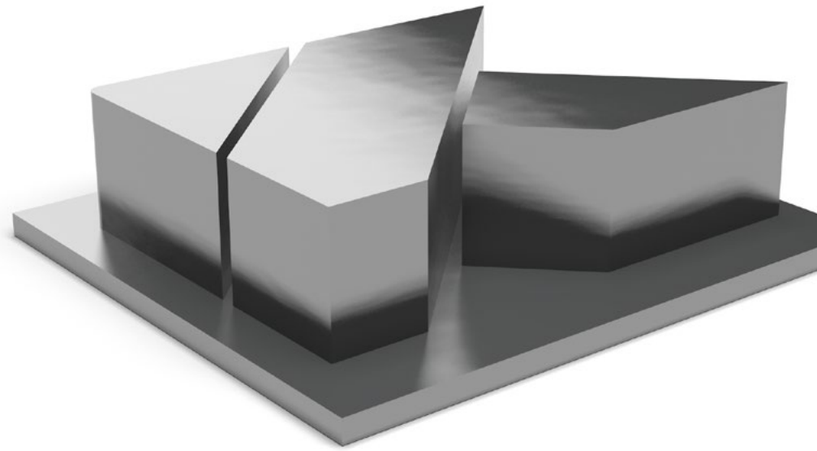
A movable element with a thread for clamping of workpieces, which jaws can be screwed in and onto.

Changeover slider

A mountable sliding jaw (without tools) for multiple clamping, that floats along the vice bed.

Important:

All dimensions in the tables are listed in mm. We reserve the right to undertake technical modifications. Depending on the series product, figures may deviate from the actual equipment. Order numbers are stated in pieces, unless specified otherwise.



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Quality is our product range: What do all KOHN vices have in common?

HRC

Main bodies are milled from a solid block as well as fixed and standard jaws. Hardened to 58 Rc on all sides.

The spindles consist of high-tensile special steel.

Lateral grooves for quick positioning.

Side threads for workpiece stops.

Grooves and installation thread for accommodating stepped jaw attachments and grip bars.

1.200 mm

Bed lengths up to 1,200 mm available, other sizes available on request.

Fixed and central jaws are secured on all levels (X,Y,Z).

Fastening of workpiece materials are possible with changeover sliders. No tools required for assembly. (not possible on ZSS),

Nm

We recommend to use a torque wrench from our accessory product range for mechanical clamping.

+49 (0)7183-8922 info@Kohn-Spannwerkzeuge.de

The quickest way to the right accessories

Our strength - your advantage! We have over 70 different jaws, changeover sliders and grip bars in the product range for your individual clamping solutions. Quickfinder shows the compatibility of the accessories with your KOHN vice.

If suitable accessories are not listed in the catalogue, please contact our Technical Department - our clamping experts will also find the right solution for your production.

Accessories Quickfinder you can find starting from page 94

Type: Machine vice

NCS

View on-line:

System:

Accurate position clamping with a clamping slider against a fixed jaw.

Versions:

NCS 125 M-HD

Mechanical-hydraulic power transmission up to 40 kN.

NCS 125 HD

hydraulic version via external hydraulic power unit up to 35 kN.

NCA 125 M-HD/HD

Version for vertical use, direct mounting on the machine table

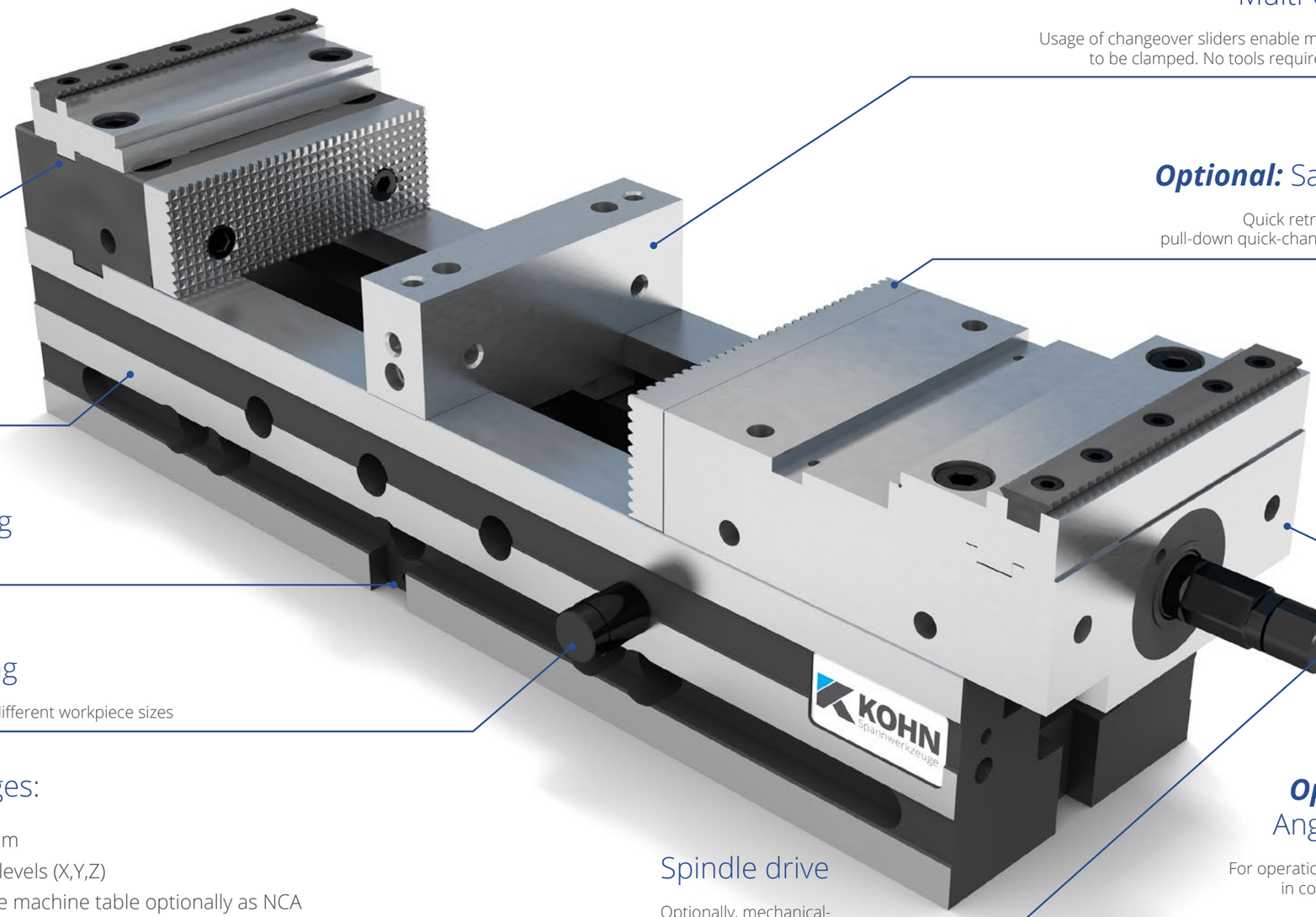
NCS-ZA 125 M-HD

with tie-rod system and mechanical-hydraulic power transmission up to 25 kN.

NCS is our best-seller!
Versatile and cost-efficient

Suitable accessories you can find starting from page 94

ON REQUEST:
Bed length up to 1,200 mm



Customisable

Groove and thread for false jaws and grip bars

Stand-alone

Flexible - suitable for every machine table, with clamping insert and tenon blocks (optional) ready to go

Optimum positioning

Traverse groove for alignment

Quick pre-configuring

Shot pin for fast pre-positioning of different workpiece sizes

Multi-clamping

Usage of changeover sliders enable more workpieces to be clamped. No tools required for assembly

Optional: Saves time

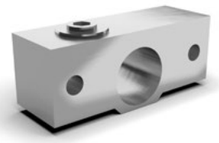
Quick retrofitting through pull-down quick-change jaws (p. 126)

Spindle drive

Optionally, mechanical-hydraulic version up to 40kN or purely mechanical clamping up to 10kN. Pure hydraulic clamping up to 35kN by replacing the clamping slider.

Optional: Angle drive

For operation from above in confined spaces



Impressive advantages:

- Repeat accuracy ≤ 0.01 mm
- Fixed jaws secured on all levels (X,Y,Z)
- Vertical use directly on the machine table optionally as NCA
- Large clamping range due to stepped jaw attachments
- Basic equipment: 2 reversible screw-in jaws and 1 hand crank
- Laterally tiltable, with mounting holes for a groove of 63 mm and 100 mm (for a bed length of 470 mm – otherwise optional)

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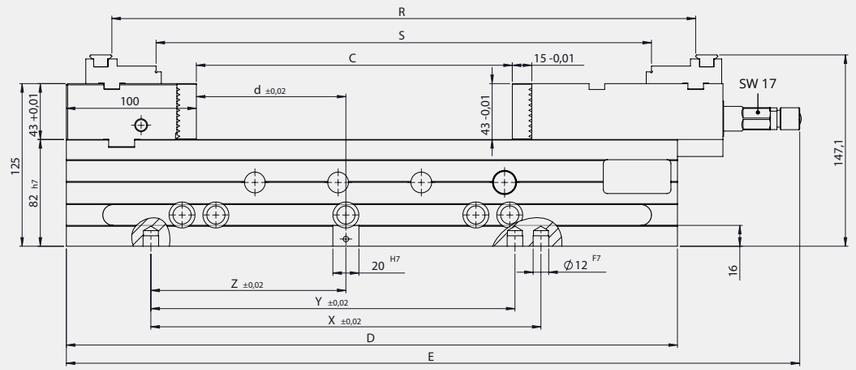
NCS 125 M-HD

Manual or mechanical-hydraulic – clamping up to 1,200 mm of bed length

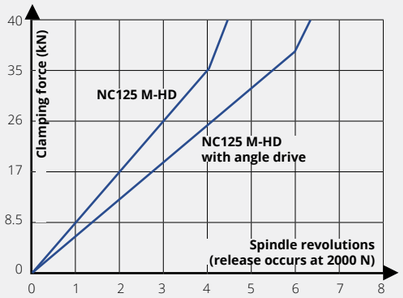
Technical drawing



Technical specifications

Order No.		09522	09523	09524	09525	09526	09527	09528	09529	Optionally
without jaws		09522 000100	09523 000100	09524 000100	09525 000100	09526 000100	09527 000100	09528 000100	09529 000100	
Jaw width/ Total width						125/127				
Bed length	D	470	534	598	662	726	790	854	918	max. 1,200
Overall length	E	564	628	692	756	820	884	948	1012	
	d	115	167	199	231	263	295	327	359	
	X	300	400	500	500	500	500	500	500	
	Y	280	–	480	480	480	480	480	480	
	Z	150	200	250	250	250	250	250	250	
Span	C	0-239	0-303	0-367	0-431	0-495	0-559	0-623	0-687	
Span	R	131-445	131-509	131-573	131-637	131-701	131-765	131-829	131-893	
Span	S	63-377	63-441	63-505	63-569	63-633	63-697	63-761	63-825	
Weight	kg	37.6	41.7	45.1	48.5	51.9	55.3	58.7	62.1	

Clamping force diagram



Suitable accessories you can find starting from page 94

NCS 125/990 M-HD as the double vice of special central jaws and the second clamping jaw slide

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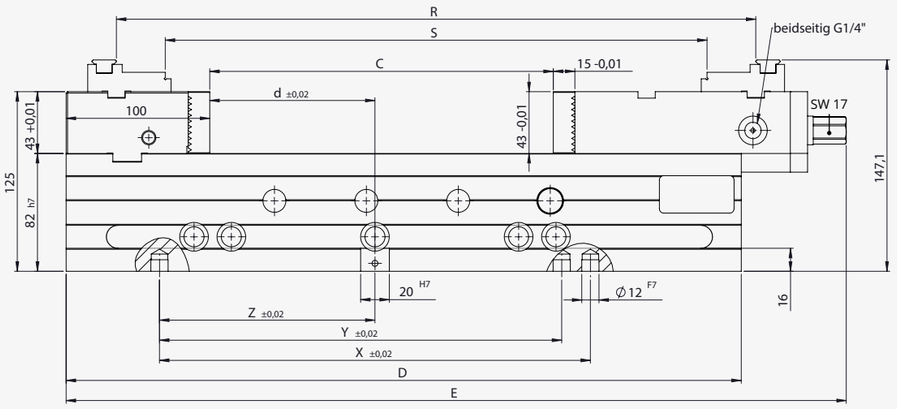
NCS 125 HD

Hydraulic clamping – for your mass production

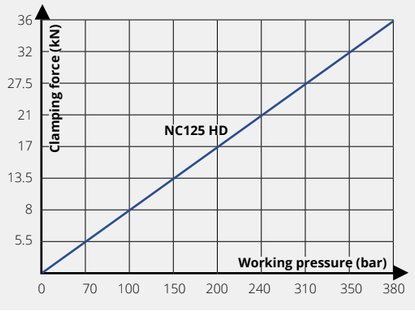
Technical drawing



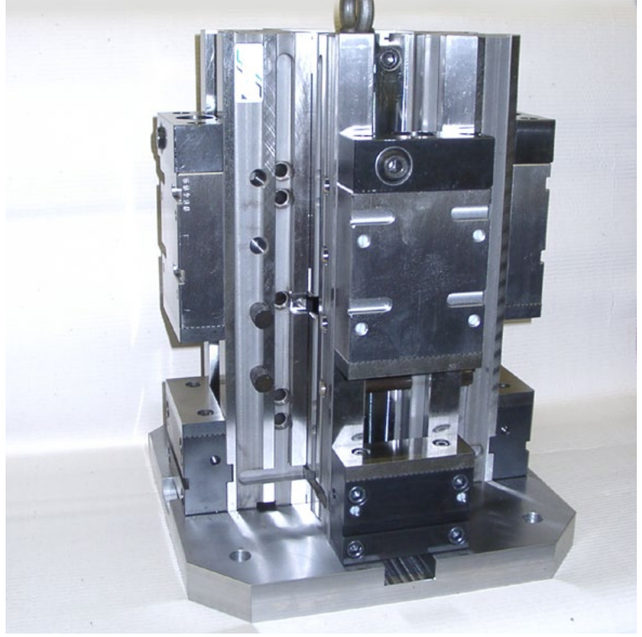
Technical specifications

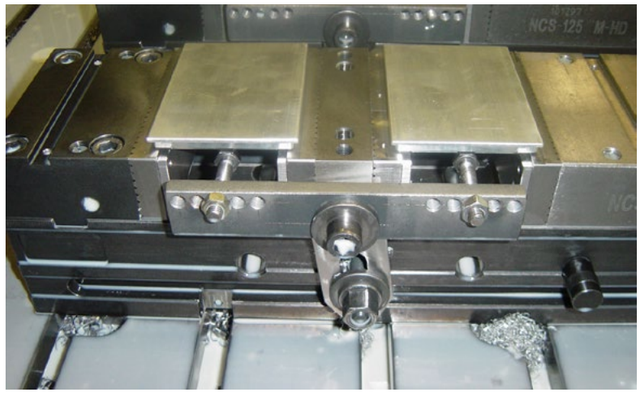
Order No.		09532	09533	09534	09535	09536	09537	09538	09539	Optionally
without jaws		09532 000100	09533 000100	09534 000100	09535 000100	09536 000100	09537 000100	09538 000100	09539 000100	
Jaw width/ Total width		125/127								
Bed length	D	470	534	598	662	726	790	854	918	max. 1,200
Overall length	E	542	606	670	734	798	862	926	990	
	d	115	167	199	231	263	295	327	359	
	X	300	400	500	500	500	500	500	500	
	Y	280	–	480	480	480	480	480	480	
	Z	150	200	250	250	250	250	250	250	
Span	C	0-239	0-303	0-367	0-431	0-495	0-559	0-623	0-687	
Span	R	131-445	131-509	131-573	131-637	131-701	131-765	131-829	131-893	
Span	S	63-377	63-441	63-505	63-569	63-633	63-697	63-761	63-825	
Weight	kg	37.7	41.1	45.2	48.6	52	55.4	58.8	62.2	

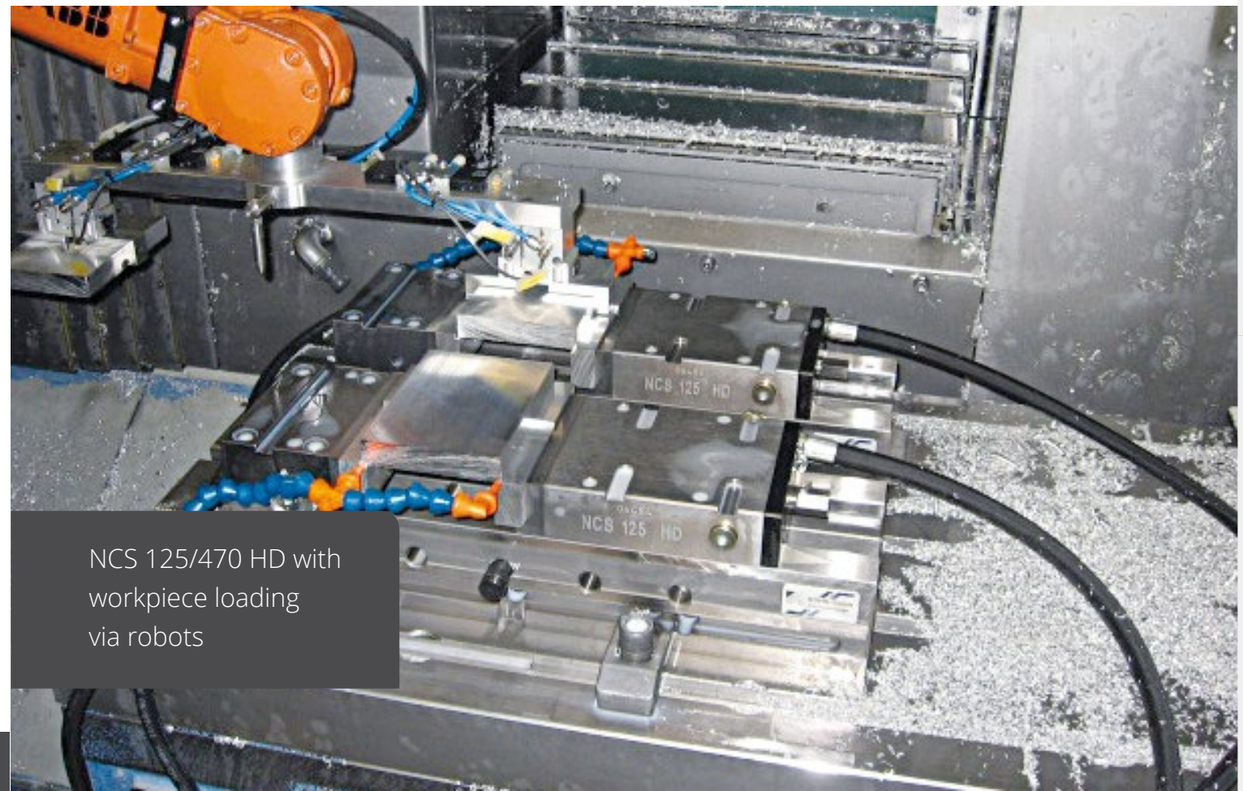
Clamping force diagram



Suitable accessories you can find starting from page 94







NCS 125/470 HD with workpiece loading via robots

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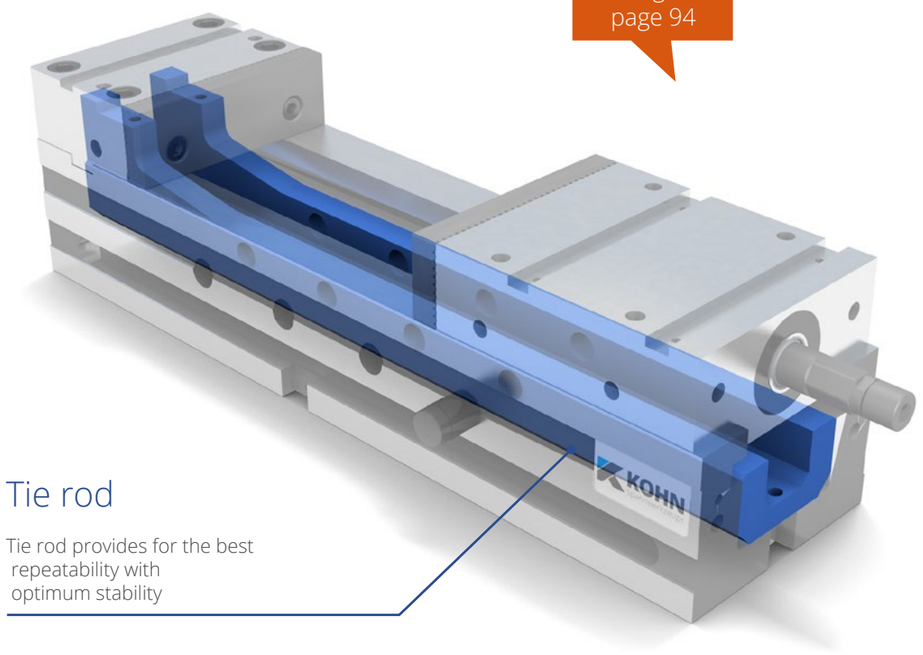
NCS-ZA 125 M-HD

Highest repeating accuracy and precision due to tie rod system

Suitable accessories you can find starting from page 94



Tie rod

Tie rod provides for the best repeatability with optimum stability

Impressive advantages:

- At full tension, the fixed jaw of the clamping slider is only deflected in the µ range. This substantially prevents misalignment of the fixed jaw and thereby the workpiece.
- Tie rod significantly improves perpendicularity. This ensures that precision components can be produced.
- The use of pull-down quick-change jaws extends the range of applications of the vice. It is even possible to compensate for existing angular misalignment of the workpieces.

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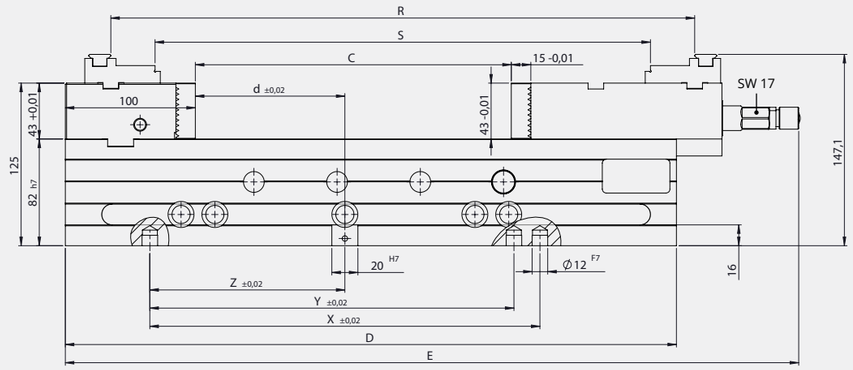
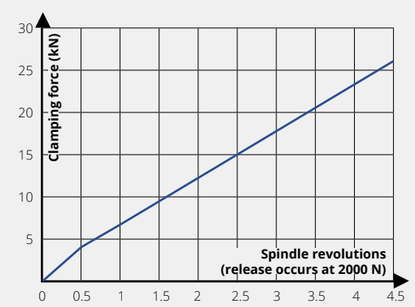
Technical drawing



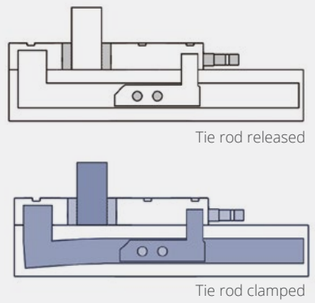
Technical specifications

Order No.		09522ZA	09523ZA	09524ZA	09525ZA	09526ZA
Jaw width/ Total width				125/127		
Bed length	D	470	534	598	662	726
Overall length	E	564	628	692	756	820
	d	115	167	199	231	263
	X	300	400	500	500	500
	Y	280	–	480	480	480
	Z	150	200	250	250	250
Span	C	0-239	0-303	0-367	0-431	0-495
Span	R	131-445	131-509	131-573	131-637	131-701
Span	S	63-377	63-441	63-505	63-569	63-633
Weight	kg	39.7	43.2	46.7	50.2	53.7

Clamping force diagram



Mode of operation



Tie rod released

Tie rod clamped

Type: single vice

ESS

View on-line:

System:

A clamping slider clamps with a continuous spindle against a fixed jaw.

Versions:

ESS-M

Mechanical clamping range adjustment and force build-up

ESS-M-HD

Mechanical clamping range adjustment and mechanical-hydraulic force build-up

ESS-HD

Mechanical clamping range adjustment and hydraulic force build-up

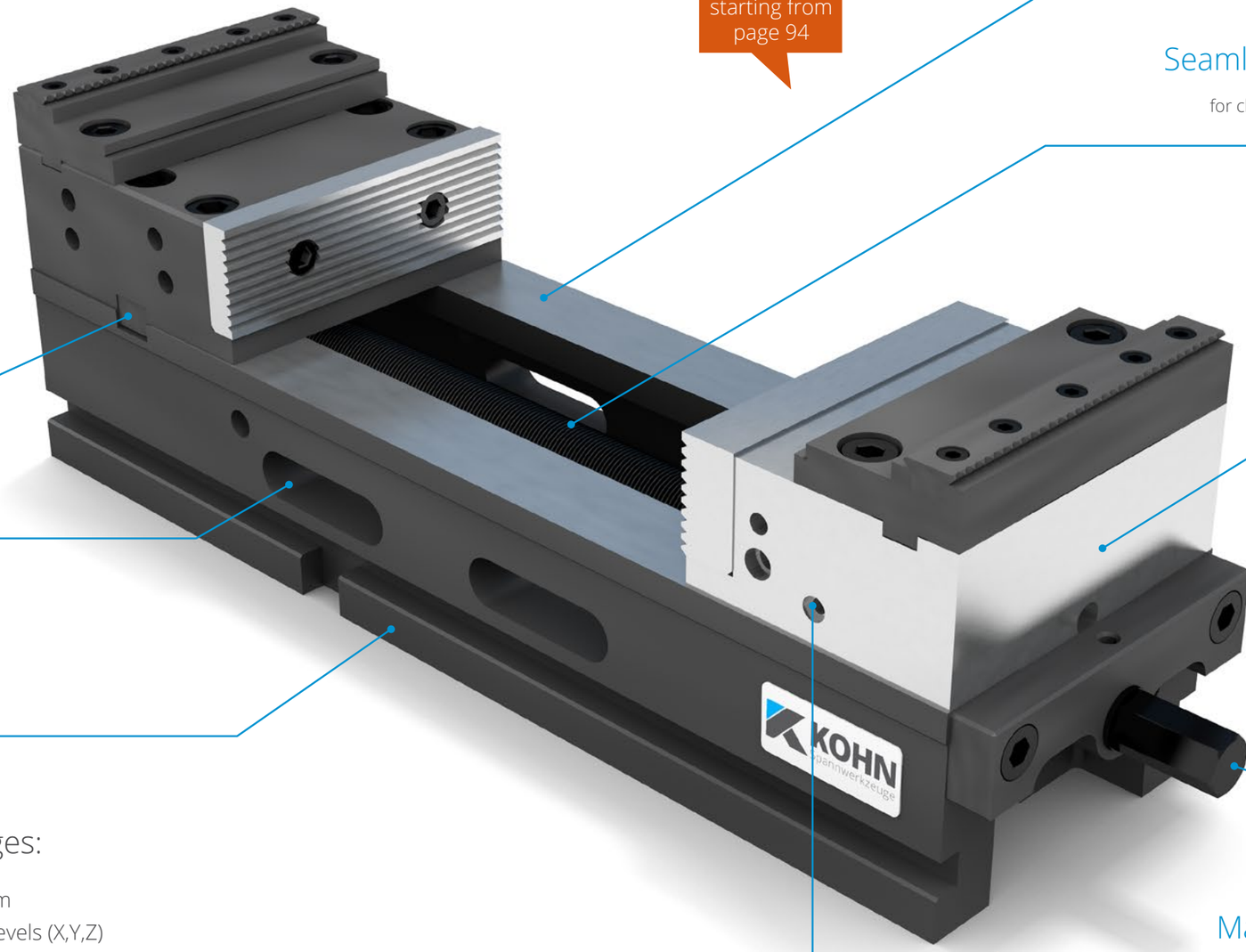
ESS-FV

Fixed jaw forward at operating side for easy mounting of heavy workpieces

Single vice – unrivalled versatility and economy

ON REQUEST:
Bed length up to 1,200 mm

OPTIONAL:
Flat bed version on request (p. 8)



Optionally, front or rear

For optimum loading select front or rear fixed jaw.

Optimised

coolant and chip flow

Optional: tiltable

Tempered and smoothed sides for maximum flexibility

Suitable accessories you can find starting from page 94

Multi-clamping

Usage of changeover sliders enable more workpieces to be clamped.
No tools required for assembly

Seamless clamping range

for clamping width adjustment through a continuous spindle

very best repeating accuracy

Clamping slider and spindle nut made of one piece

Grease nipple

Grease nipple for lubrication of the clamping slider guideway

Manual, hydraulic or mechanical-hydraulic

Depending on requirements: boost your productivity

Impressive advantages:

- Repeat accuracy ≤ 0.01 mm
- Fixed jaws secured on all levels (X,Y,Z)
- Can be used horizontally and vertically (on the tower)
- Large clamping range due to stepped jaw attachments
- Basic equipment: 2 screw-in jaws and 1 hand crank

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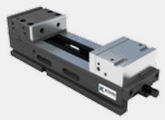
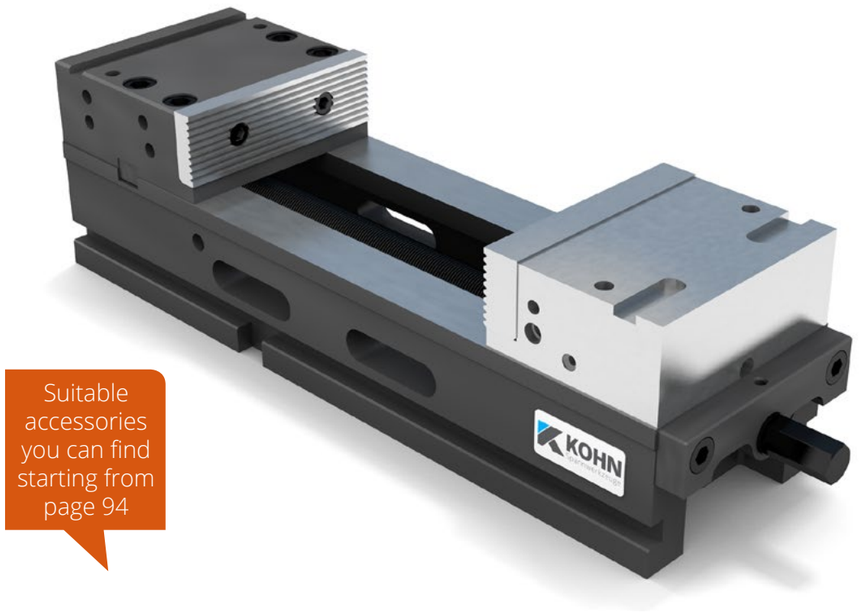


ESS-M & ESS-HD

Single vice, mechanical or hydraulic version, *Fixed jaw on the rear*

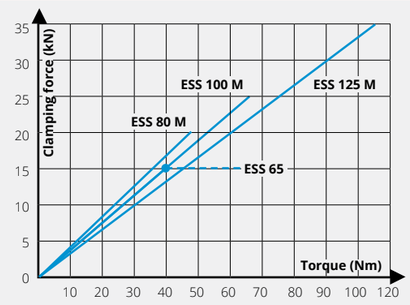


Suitable accessories you can find starting from page 94

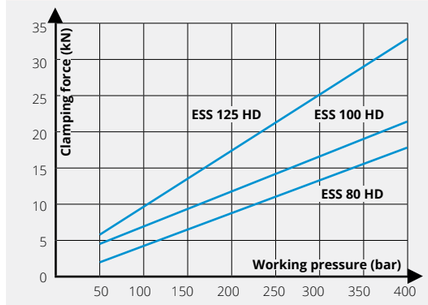
Impressive advantages:

- ESS-HD: Option for quick adjustment spindle for rapid moves of the clamping slider (no vertical clamping possible). Clamping force adjustment via hydraulic pressure
- Option: Mounting holes and holes for your zero-point clamping
- Option for longitudinal groove

Clamping force diagram M



Clamping force diagram HD



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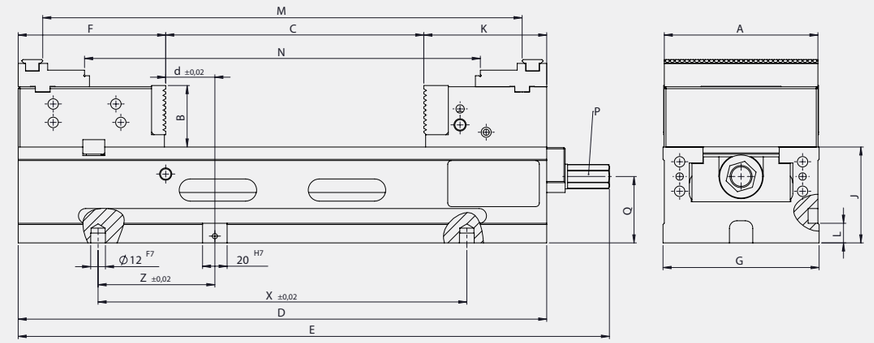
Technical drawing



Technical specifications

Jaw width	A	65	80	100	125
Order No. mechanical		01211	01311	01411	01511
without jaws		01211000100	01311000100	01411000100	01511000100
Order No. hydraulic		–	01331	01431	01531
without jaws		–	01331000100	01431000100	01531000100
Clamping depth	B	25	32	44	50
Span	C	0-99	0-173	0-180	0-210
Bed length	D	220	300	360	430
Overall length	E	260	345 (HD 330)	404 (HD 392)	481 (HD 472)
Fixed jaw	F	65.5	63.5	100	120
Base width	G	78	84	104	127
Overall height	H	63	100	122	128
Bed height	J h7	38	68	78	78
Clamping slide length	K	55.5	63.5	80	100
	L	10	12	14	16
Hexagonal connection SW	P	10	12	14	17
	Q	23	51	58	54
	d	20	20	40	40
	X	150	150	300	300
	Z	50.5	0	120	95
Span with stepped jaw attachments	M	–	95-268	148-328	180-390
	N	–	39-212	92-272	112-322
Clamping stroke	mm	–	4-5	4-5	4-5
Mechanical clamping force	kN/Nm	15/40	20/48	25/64	35/115
Hydraulic clamping force	kN/380 bar	–	15	20	30
Weight	kg	5	11.5	21	36

ESS-FV M-HD

Single vice, mechanical-hydraulic booster, *"fixed jaw on the front"*

Suitable accessories you can find starting from page 94

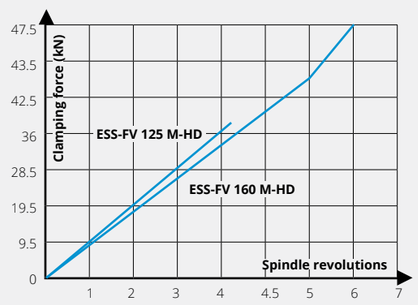
Ergonomic vice

easy to operate with great clamping force

Impressive advantages:

- Fixed jaw on the operator side: Best handling for the machine operator, ideal for great Y-travel distance
- Option: Mounting holes and holes for zero-point clamping
- Clamping force via marking rings readable

Clamping force diagram



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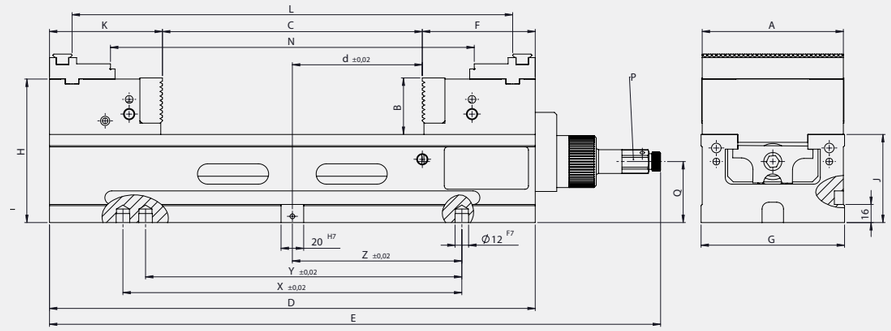
Technical drawing

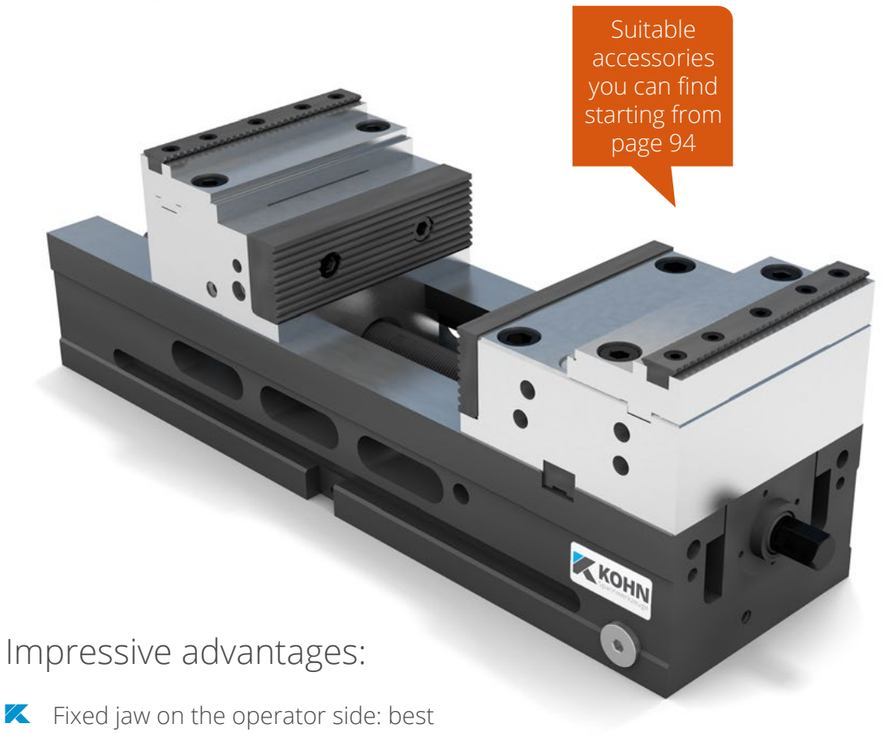


Technical specifications

Jaw width	A	125					160			
Order No.		01520-FV	01521-FV	01522-FV	01523-FV	01524-FV	01620-FV	01621-FV	01622-FV	01623-FV
Clamping depth	B	50					54			
Bed length	D	430	500	560	680	740	600	750	900	1050
Overall length	E	545	615	675	795	855	714	864	1014	1164
Span	C	0-230	0-300	0-360	0-480	0-540	0-342	0-492	0-642	0-792
Fixed jaw	F	100					130			
Base width	G	127					162			
Overall height	H	128					144			
Bed height	J h7	78					90			
Clamping slide	K	100					126			
Top stepped jaws	L	160-390	160-460	160-520	160-640	160-700	204-546	204-696	204-846	204-996
	N	92-322	92-392	92-452	92-572	92-632	134-476	134-626	134-776	134-926
Hexagonal connection SW	P	17					17			
	Q	54					64			
	d	115	150	180	240	270	170	245	320	395
	X	300	400	400	500	500	500	500	500	500
	Y	280	–	–	480	480	-	480	480	480
	Z	150	200	200	250	250	250	250	250	250
Clamping force	kN	38					47.5			
Weight	kg	35	39	42	47	50	68	78	88	98

ESS-FV HD

Single vice, hydraulic force regulation, *"fixed jaw on the front"*

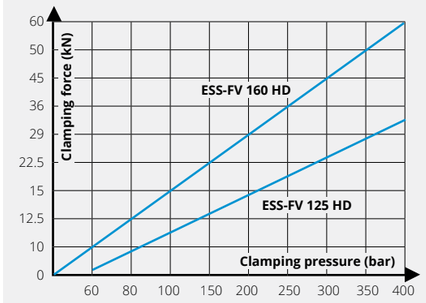


Suitable accessories you can find starting from page 94

Impressive advantages:

- Fixed jaw on the operator side: best handling for the machine operator, ideal for great Y-travel distance
- The clamping force is adjusted via the hydraulic pressure.
- ESS-HD: Option for quick adjustment spindle for rapid moves of the clamping slider (no vertical clamping possible).
- Option: Mounting holes and holes for zero-point clamping

Clamping force diagram



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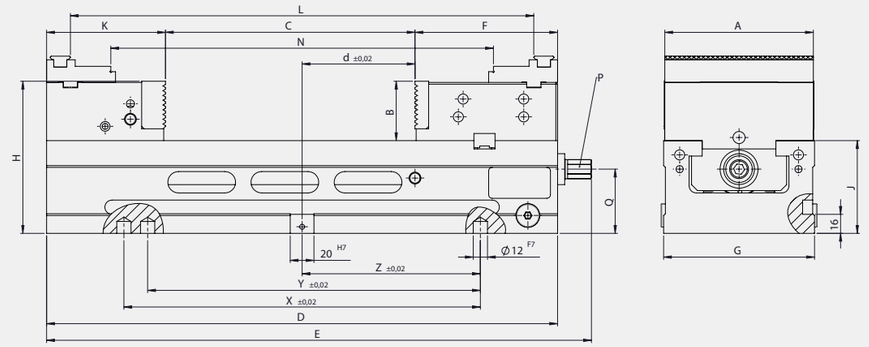
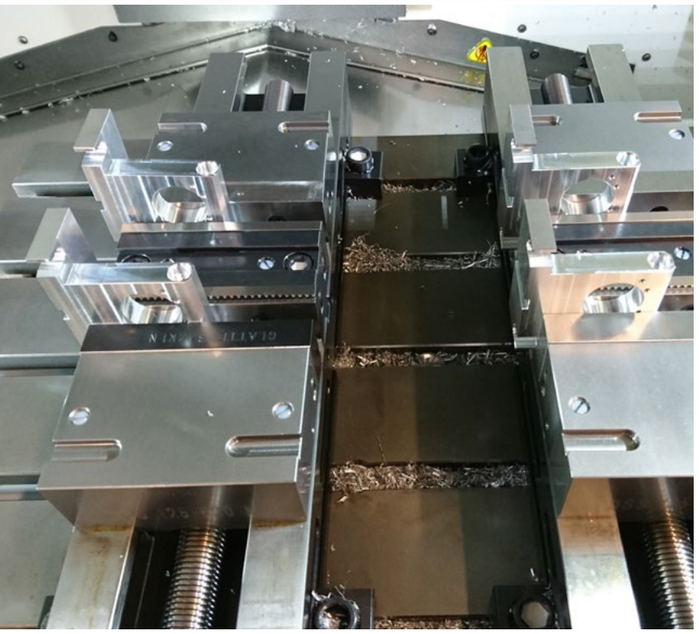
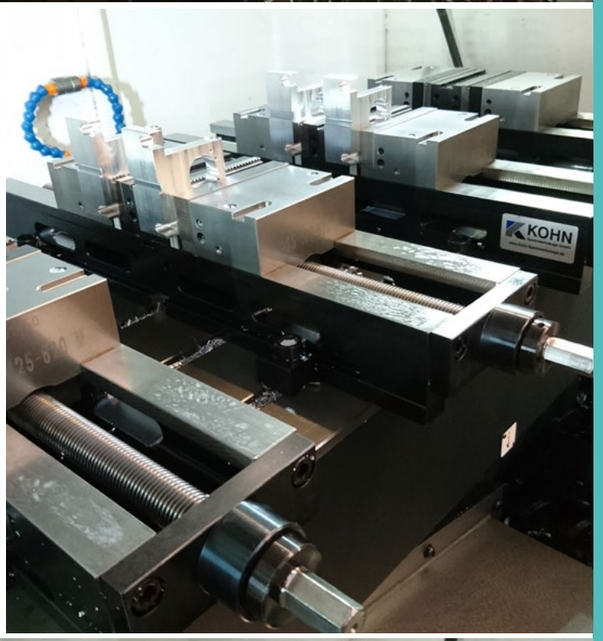
Technical drawing



Technical specifications

Jaw width	A	125					160			
Order No.		01530-FV	01531-FV	01532-FV	01533-FV	01534-FV	01630-FV	01631-FV	01632-FV	01633-FV
Clamping depth	B	50					54			
Bed length	D	430	500	560	680	740	600	750	900	1050
Overall length	E	463	533	593	713	773	647	797	947	1097
Span	C	0-210	0-280	0-340	0-460	0-520	0-325	0-475	0-625	0-775
Fixed jaw	F	120					146.5			
Base width	G	127					162			
Overall height	H	128					144			
Bed height	J h7	78					90			
Clamping slide	K	100					126			
False jaws	L	180-390	180-460	180-520	180-640	180-700	221-529	221-679	221-829	221-979
	N	112-322	112-392	112-452	112-572	112-632	151-478	151-628	151-778	151-928
Hexagonal connection SW	P	14					17			
	Q	54					64			
	d	95	130	160	220	250	153.5	228.5	303.5	378.5
	X	300	400	500	500	500	400	500	500	500
	Y	280	-	480	480	480	–	480	480	480
	Z	150	200	200	250	250	200	250	250	250
Clamping stroke		4					4			
Clamping force hydraulic	kN/ 380 bar	30					55			
Weight	kg	46	51	55	63	67	72	82	93	103





Type: Double vice

DSS

View on-line:

System:

Two clamping sliders, one central jaw, and one continuous spindle simultaneous clamping from both sides against the central jaw.

Versions:

DSS-M

Mechanical span adjustment and pressure build-up. Different work-piece dimensions ± 2 mm can be compensated by spindle bearings.

DSS – multi-clamping in all dimensions to ensure economic small-batch and series production

Suitable accessories you can find starting from page 94

ON REQUEST:
Bed length up to 1,200 mm

OPTIONAL:
Flat bed version on request (p. 8)

Best repeat accuracy

Clamping slider and spindle nut made of one piece

Simple pre-clamping (3-hand operation)

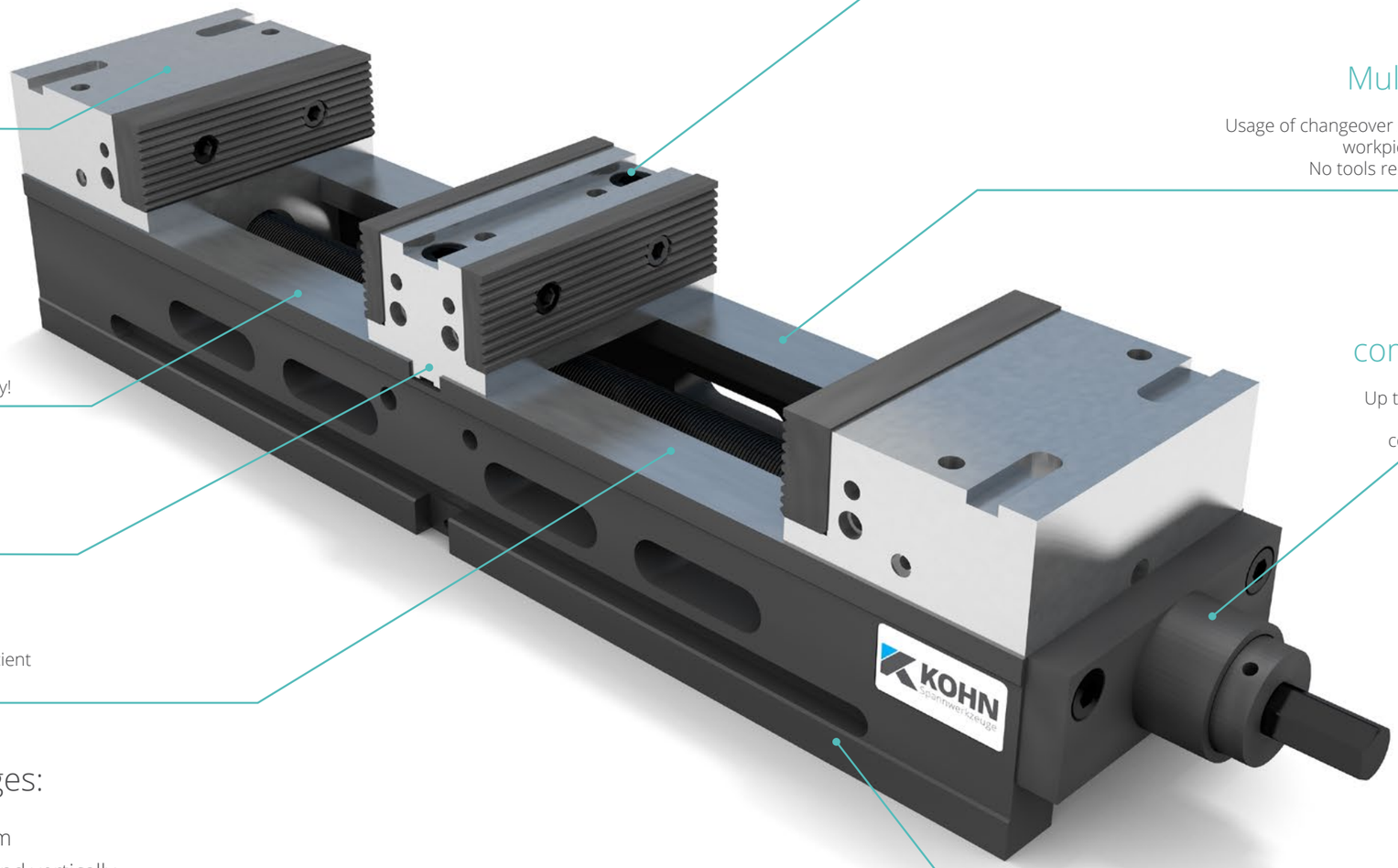
Pre-clamping of workpiece 1, Insert workpiece 2 and clamp both. And that can be easily done vertically!

Safe stop

The free-standing central jaw is secured on all levels (X,Y,Z)

Delayed stroke

2 mm delayed stroke provides sufficient clearance for inserting workpiece 2



Consistent Clamping force

Both workpieces are clamped with identical clamping force

Multi-clamping

Usage of changeover sliders enable more workpieces to be clamped. No tools required for assembly

Tolerance compensation

Up to ± 2mm workpiece tolerances can be compensated by vice

Optional: tiltable

Tempered and smoothed side walls ensure maximum flexibility

Impressive advantages:

- Repeat accuracy ≤ 0.01 mm
- Can be used horizontally and vertically
- Large clamping range due to stepped jaw attachments
- Basic equipment: 4 screw-in jaws and 1 hand crank
- Option: Mounting holes and transverse groove position for your zero-point clamping
- Option for longitudinal groove

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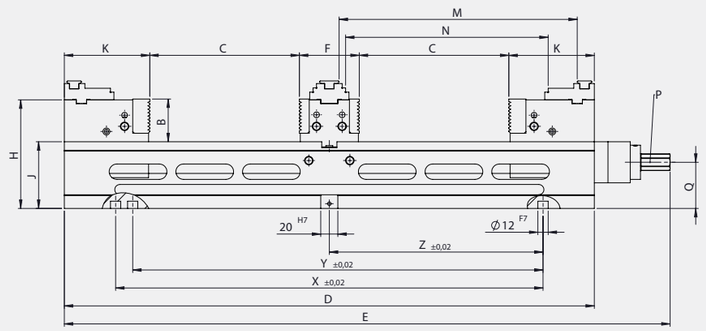
DSS-M

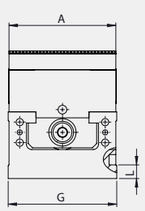
Double vice, mechanical version with delayed stroke

Technical drawing



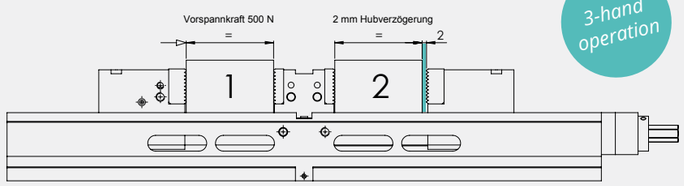
You need more flexibility?

Then our MFS would be the right solution for you.



The delayed stroke favors fixed clamping when it is used on vertical situations

3-hand operation



Workpiece 1: clamped with an initial force of approx. 500 N

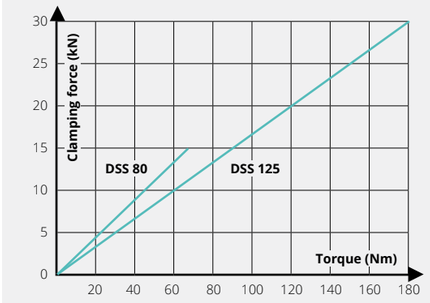
Workpiece 2: has not been clamped by the jaws and can be positioned

Suitable accessories you can find starting from page 94

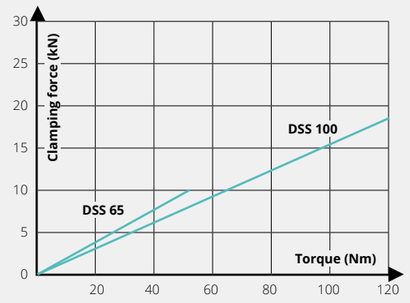
Technical specifications

Jaw width	A	65			80				100				125			
Order No.		02211	02212	02213	02311	02312	02313	02314	02411	02412	02413	02414	02511	02512	02513	02514
Order No. without jaws		02211 000100	02212 000100	02213 000100	02311 000100	02312 000100	02313 000100	02314 000100	02411 000100	02412 000100	02413 000100	02414 000100	02511 000100	02512 000100	02513 000100	02514 000100
Clamping depth	B	25			32				44				50			
Span	C	0-74	0-99	0-124	0-76	0-96	0-116	0-136	0-115	0-140	0-165	0-190	0-145	0-175	0-205	0-235
Bed length	D	300	350	400	340	380	420	460	450	500	550	600	560	620	680	740
Overall length	E	360	410	460	410	450	490	530	530	580	630	680	650	710	770	830
Fixed jaw	F±0,02	40			60				60				70			
Base width	G	78			84				104				127			
Overall height	H	63			100				122				128			
Bed height	J h7	38			68				78				78			
Clamping slide	K	55.5			63.5				80				100			
	L	10			12				14				16			
	M	-	-	-	62-140	62-160	62-180	62-200	82-196	82-221	82-246	82-271	103-248	103-278	103-308	103-338
	N	-	-	-	32-110	32-130	32-150	32-170	50-165	50-190	50-215	50-240	62-207	62-237	32-267	32-297
Hexagonal connection SW	P	10			12				14				17			
	Q	23			51				58				54			
	X	200	200	300	200	300	300	300	300	400	400	400	400	500	500	500
	Y	-	-	-	-	280	280	280	280	-	-	-	-	480	480	480
	Z	100	100	150	100	150	150	150	150	200	200	200	200	250	250	250
Clamping force	kN/Nm	10/50			15/70				20/130				30/180			
Weight	kg	6.3	6.5	6.7	18	19	20	21	31	32	33	34	48	51	53	55

Clamping force diagram DSS 80 M, DSS 125 M



Clamping force diagram DSS 65 M, DSS 100 M



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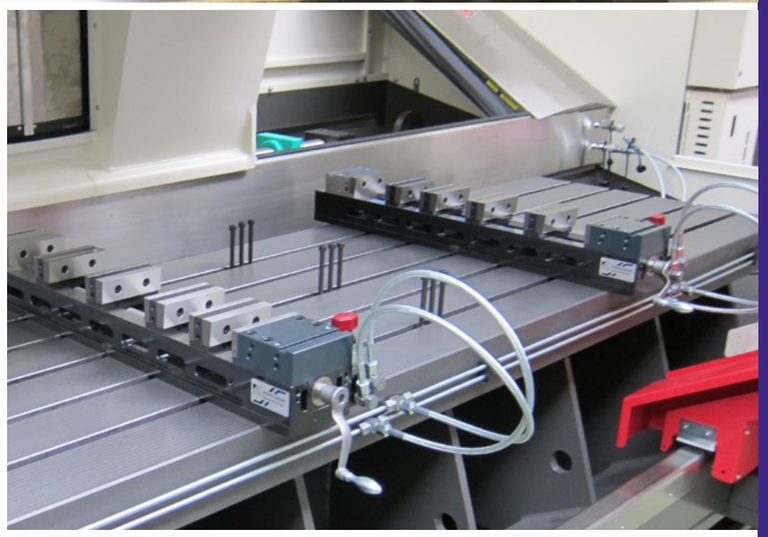

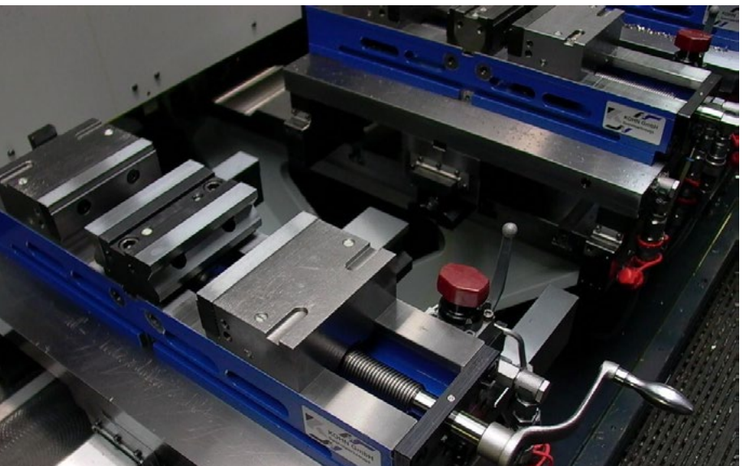

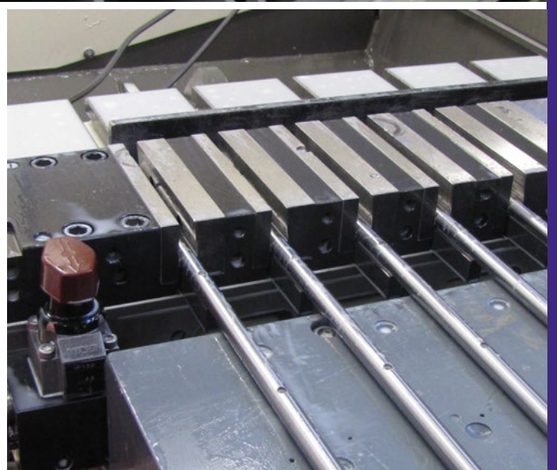

Type: Multi-functional vice

MFS

View on-line:

System:

Two clamping sliders, one central jaw, and two continuous spindles easy to rebuild in a single vice, double vice or multiple clamping vice.

Versions:

MFS-MK

Mechanical operation with lock-in discs for span adjustment, mechanical force build-up.

MFS-HD

Mechanical span adjustment, hydraulic strength build-up, return stroke through air cushions.

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solid. connections.

MFS – can be used for various purposes, ideal for multi-clamping. Our vice with the greatest possible utilisation factor!

OPTIONAL:
Flat bed version on request (p. 8)

ON REQUEST:
Bed length up to 1,200 mm

Suitable accessories you can find starting from page 94

Multi-clamping

Usage of changeover sliders enable more workpieces to be clamped, depending on the bed length.

Maximum span width

Use the maximum potential of your vice through the use of false jaws

Permanently consistent Clamping force

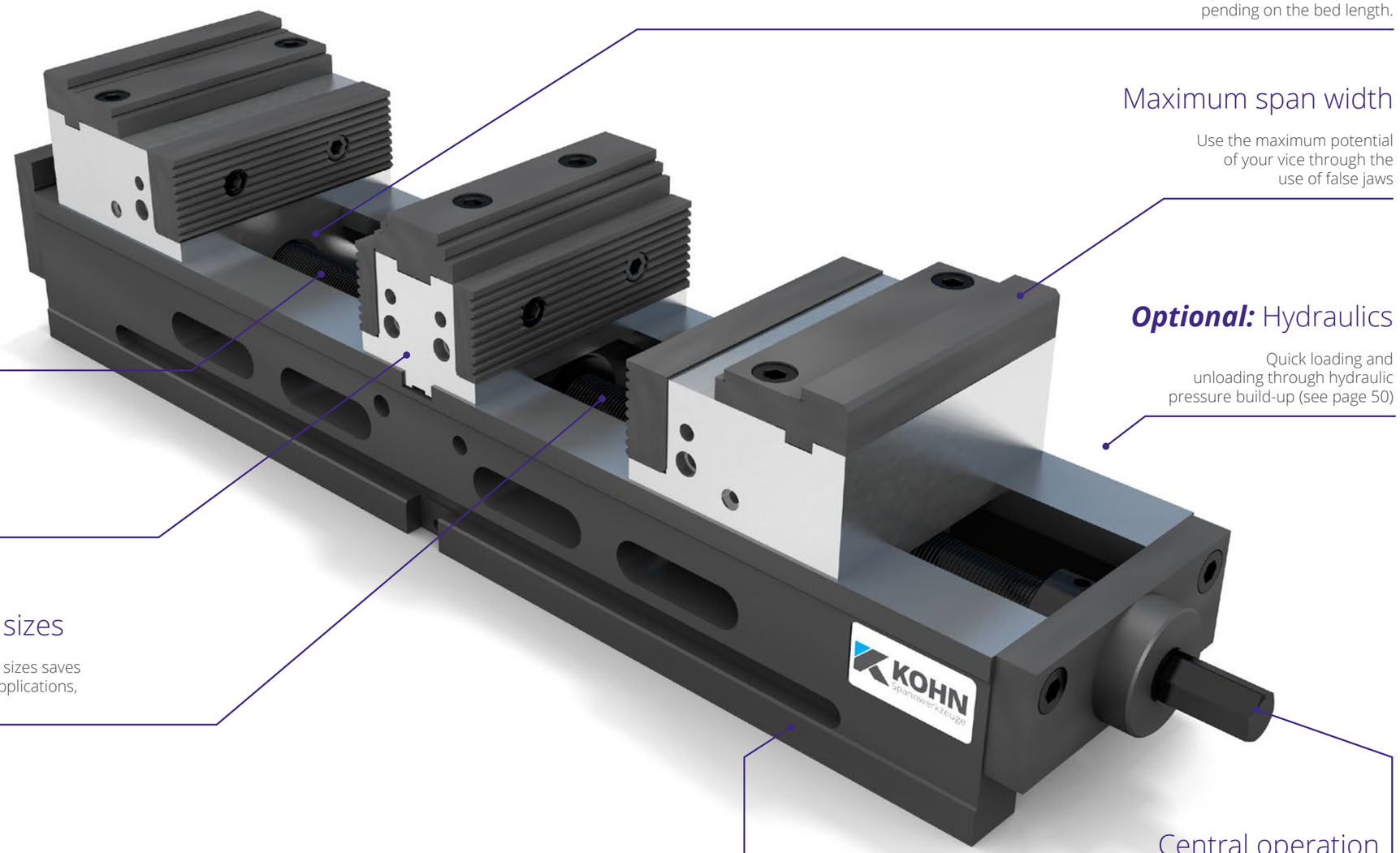
Two independent spindles generate the same clamping force for each individual clamping.

Safe stop

The free-standing central jaw is secured on all levels (X,Y,Z)

Variable workpiece sizes

Clamping with different workpiece sizes saves presetting and set-up times. For applications, see next page



Optional: Hydraulics

Quick loading and unloading through hydraulic pressure build-up (see page 50)

Tiltable

Hardened and smoothed side walls provide for even more flexibility (option)

Central operation for quick clamping

Ideal for the operator: Closing and clamping of only one side allows a workpiece changeover in a few seconds.

Impressive advantages:

- Best repeat accuracy ≤ 0.01 mm
- Extended clamping range due to stepped jaw attachments

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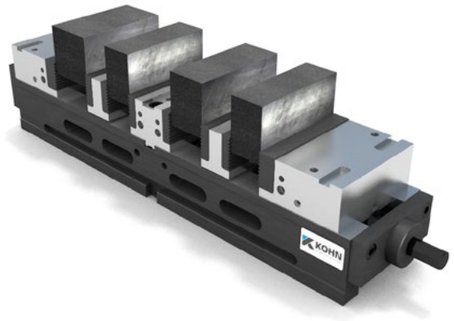
MFS

1 vice – 3 different clamping functions

Clamping of ***2 blanks***:

Simple and extremely rapid movement of the clamping slider allows clamping of the similarly and differently sized workpieces. Clamping sliders may be moved together or individually to adjust the clamping range.



Clamping of ***3 or more blanks***:

Rapid installation of changeover sliders enable more work pieces to be clamped. No tools required for assembly.

Clamping of ***large blanks***:

Divided into three differently sized clamping ranges. after removal of the central jaw, the rear clamping slider serves as a fixed jaw. Large or long workpieces (e.g., plates, strips, etc.) may be clamped by attaching stepped jaw attachments to the fixed jaw and the movable clamping slider.

MFS-MK

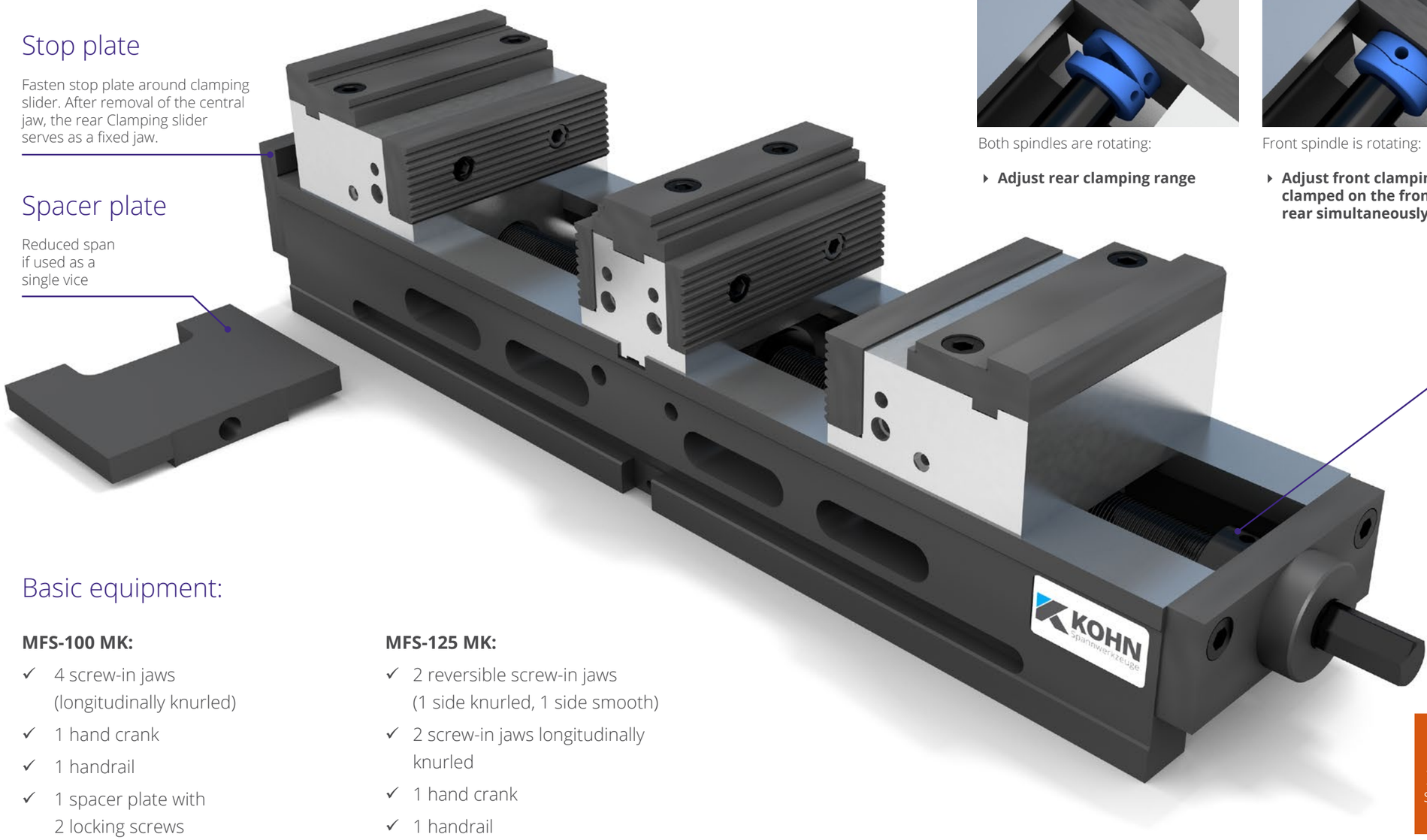
Multi-functional vice – mechanical version with cam-plate locking

Stop plate

Fasten stop plate around clamping slider. After removal of the central jaw, the rear Clamping slider serves as a fixed jaw.

Spacer plate

Reduced span if used as a single vice



Basic equipment:

MFS-100 MK:

- ✓ 4 screw-in jaws (longitudinally knurled)
- ✓ 1 hand crank
- ✓ 1 handrail
- ✓ 1 spacer plate with 2 locking screws

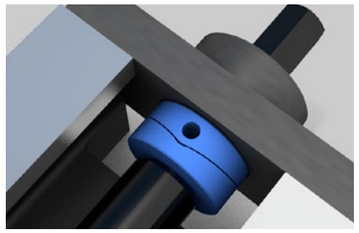
MFS-125 MK:

- ✓ 2 reversible screw-in jaws (1 side knurled, 1 side smooth)
- ✓ 2 screw-in jaws longitudinally knurled
- ✓ 1 hand crank
- ✓ 1 handrail
- ✓ 1 spacer plate with 2 locking screws

Cam-plate locking

Both spindles are rotating:

- **Adjust rear clamping range**



Front spindle is rotating:

- **Adjust front clamping range clamped on the front and rear simultaneously**

Suitable accessories you can find starting from page 94

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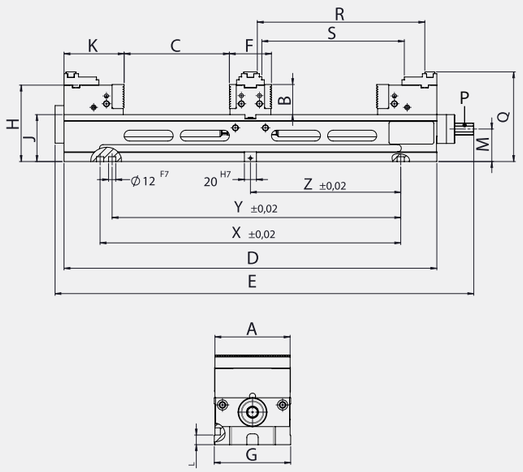
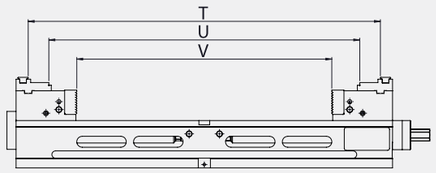
MFS-MK

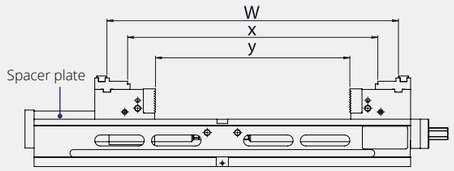
Mechanical design with cam-plate locking

Technical drawing

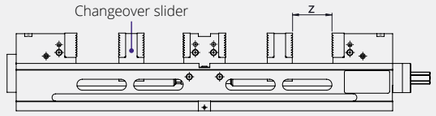




Single vice with the large clamping range.
Rear clamping slider blocked in this 0 position.



Single vice with a medium clamping range.
Central jaw removed, clamping slider is attached to the rear spacer plate.

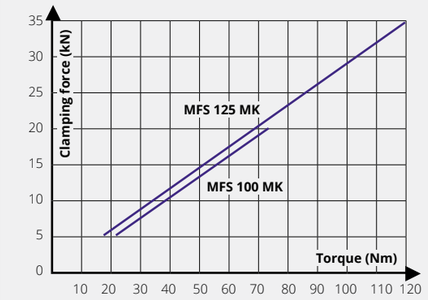


with changeover sliders as multi-duty vice.
No tools required for installation of changeover sliders.

Technical specifications

Jaw width	A	100				125				
Order No.		08481	08482	08483	08484	08580	08581	08582	08583	08584
Order No. without jaws		08481 000100	08482 000100	08483 000100	08484 000100	08580 000100	08581 000100	08582 000100	08583 000100	08584 000100
Clamping depth	B	44				50				
Bed length	D	450	500	550	600	500	560	620	680	740
Overall length	E	535	585	635	685	564	645	705	765	825
Fixed jaw	F±0.02	60				70				
Total width	G	104				127				
Overall height	H	122				128				
Bed height	Jh7	78				78				
Clamping slide	K	80				100				
Metal clamping flange	L	14				16				
Spindle centre point	M	58				54				
Hexagonal connection SW	P	14				17				
	Q	137.5				149.1				
	X	300	300	400	400	400	400	500	500	500
	Y	280	280	–	–	–	–	480	480	480
	Z	150	150	200	200	200	200	250	250	250
Span	C	0-113	0-138	0-163	0-188	0-113	0-143	0-173	0-203	0-233
Span	R	84-195	84-220	84-245	84-270	102-213	102-243	102-273	102-303	102-333
Span	S	52-163	52-188	52-213	52-238	64-175	64-205	64-235	64-265	64-295
Span	T	416	466	516	566	458	518	578	638	698
Span	U	249-360	274-410	299-460	324-510	279-390	309-450	339-510	369-570	399-630
Span	V	177-288	202-338	227-388	252-438	187-298	217-358	247-418	277-478	307-538
	W	316	366	416	466	358	418	478	538	598
	x	149-260	174-310	199-360	224-410	179-290	209-350	239-410	269-470	299-530
	y	77-188	102-238	127-288	152-338	87-198	117-258	147-318	177-378	207-438
	z	0-39	0-51	0-64	0-76	0-36	0-51	0-66	0-81	0-96
Weight	kg	31	32	33	34	46	48	51	53	55
Clamping force	kN/Nm	20/72				35/120				

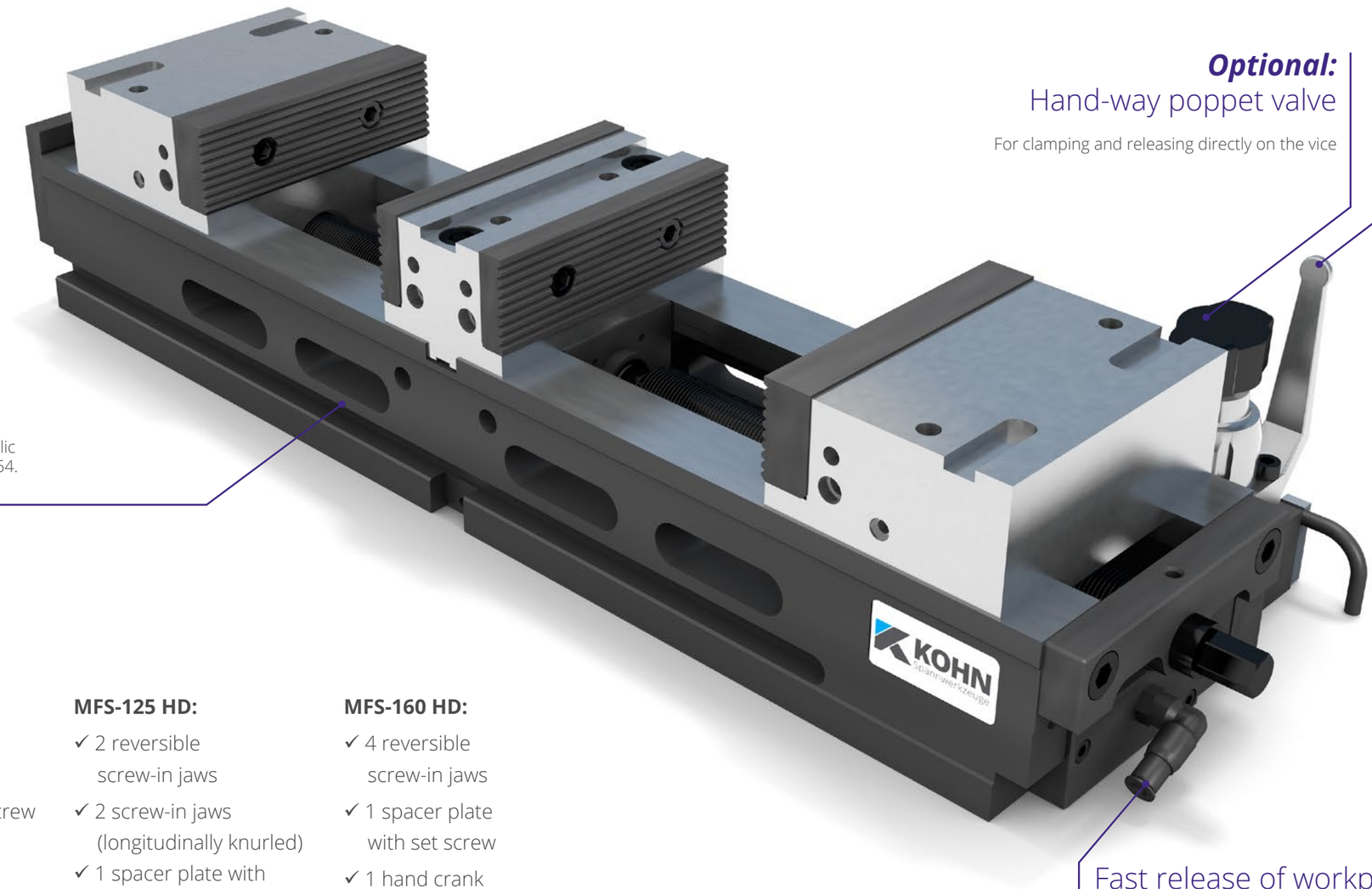
Clamping force diagram



MFS-HD

Multi-functional vice – hydraulic version

Suitable accessories you can find starting from page 94



Flexible applications

such as customer-specific hydraulic solutions are described on page 54.

Ball valve three-way plates

For separate adjustment of the two clamping ranges. Hydraulic operation instead of cam-plate locking (p. 47).

Optional: Hand-way poppet valve

For clamping and releasing directly on the vice

Fast release of workpieces

The return stroke is produced by an air cushion that can be filled by way of a valve.

Basic equipment:

MFS-80 HD/MFS-100 HD:

- ✓ 4 screw-in jaws (longitudinally knurled)
- ✓ 1 spacer plate with set screw
- ✓ 1 hand crank
- ✓ 1 ball valve

MFS-125 HD:

- ✓ 2 reversible screw-in jaws
- ✓ 2 screw-in jaws (longitudinally knurled)
- ✓ 1 spacer plate with set screw
- ✓ 1 hand crank
- ✓ 1 ball valve

MFS-160 HD:

- ✓ 4 reversible screw-in jaws
- ✓ 1 spacer plate with set screw
- ✓ 1 hand crank
- ✓ 1 ball valve

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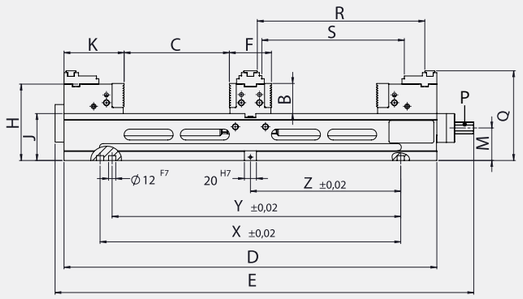
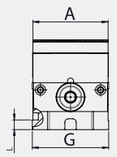
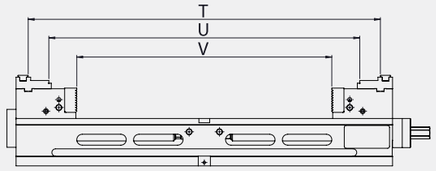
MFS-HD

Multi-functional vice – hydraulic version

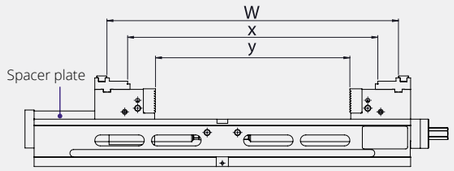
Technical drawing



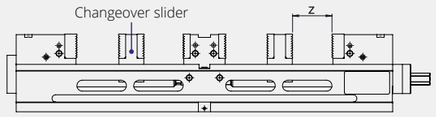




Single vice with the large clamping range.
Rear clamping slider blocked in this 0 position.



Single vice with a medium clamping range.
central jaw removed, clamping slider is attached to the rear spacer plate.



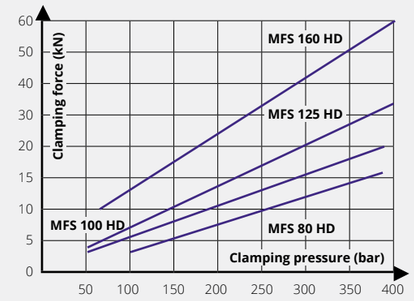
with changeover sliders as multi-duty vice.
No tools required for installation of changeover sliders.

Technical specifications

Jaw width	A	80		100				125				160
Order No.		08333	08334	08431	08432	08433	08434	08531	08532	08533	08534	08631
Order No. without jaws		08333 000100	08334 000100	08431 000100	08432 000100	08433 000100	08434 000100	08531 000100	08532 000100	08533 000100	08534 000100	08631 000100
Clamping depth	B	32		44				50				54
Bed length	D	420	460	450	500	550	600	560	620	680	740	750
Overall length	E	504	544	535	585	635	685	645	705	765	825	797
Fixed jaw	F ±0.02	60		60				70				90
Total width	G	84		104				127				161
Overall height	H	100		122				128				144
Bed height	J h7	68		78				78				90
Clamping slide	K	63.5		80				100				126
Metal clamping flange	L	12		14				16				16
Spindle centre point	M	51		58				54				64
Hexagonal connection SW	P	12		14				14				19
	Q	115.5		137.5				146				167
	X	300	300	300	300	400	400	300	400	500	500	500
	Y	280	280	280	280	–	–	280	–	480	480	480
	Z	150	150	150	150	200	200	150	200	250	250	250
Span	C	0-116	0-136	0-113	0-138	0-163	0-188	0-143	0-173	0-203	0-233	0-204
Span	R	69-185	69-205	84-195	84-220	84-245	84-270	102-243	102-273	102-303	102-333	125-329
Span	S	37-153	37-173	52-163	52-188	52-213	52-238	64-205	64-235	64-265	64-295	85-289
Span	T	388	428	416	466	516	566	518	578	638	698	698
Span	U	175-332	215-372	249-360	274-410	299-460	324-510	309-450	339-510	369-570	399-630	220-628
Span	V	136-293	197-333	177-288	202-338	277-388	252-438	217-358	247-418	277-478	307-538	294-498
Span	W	211-328	232-368	316	366	416	466	418	478	538	598	394-598
Span	x	155-272	176-312	149-260	174-310	199-360	224-410	209-350	239-410	269-470	299-530	324-528
Span	y	116-233	137-273	77-188	102-238	127-288	152-338	117-258	147-318	177-378	207-438	194-398
Span	z	0-43	0-53	0-39	0-51	0-64	0-76	0-51	0-66	0-81	0-96	–
Weight	kg	20	21	31	32	33	34	48	51	53	55	83
Clamping force	kN bar	15 380		20 380				30 380				60 400

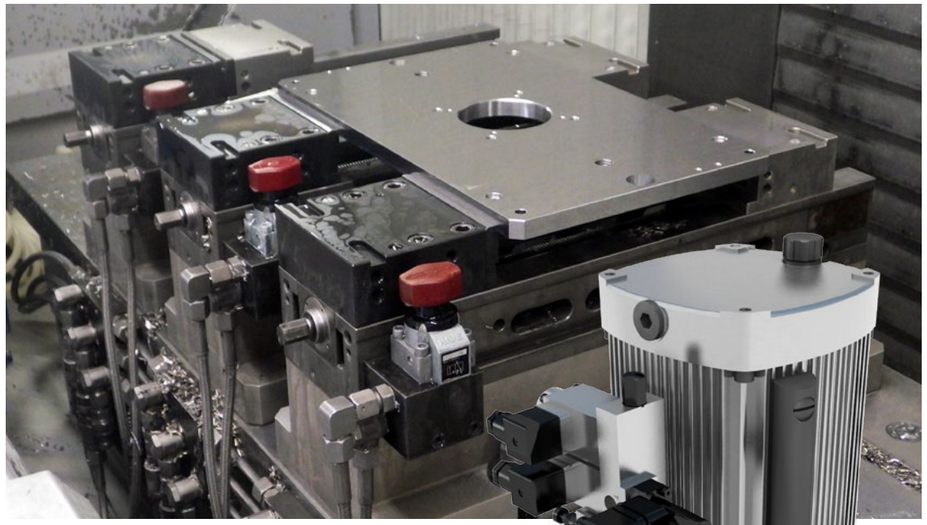
Additional bed lengths (D) upon request

Clamping force diagram



MFS-HD

Ready to start: Our customised hydraulic solutions allow for immediate production:



Feel free to contact our Technology Department specialists for various options.

- Operation of the vice requires a hydraulic pump or a pressure booster delivering a pressure of up to 400 bar. The maximum operating pressure of the vice is 380 bar. The clamping force is adjusted via hydraulic pressure. The return stroke is produced by an air cushion that can be filled through a valve. No permanent connection necessary, but this is possible (through check valve).
- Control and monitoring of the vices (operation on electric push button, foot switch, hand-way poppet valve or connection to the machine control unit via control box pp. 140-141).
- Design of the hydraulic unit with control cabinet according to their assigned tasks (unit in a simple, 1-pass or multi-circuit version)
- Clamping and release of one or several vices individually and / or jointly, etc.

Type: Self-centring vice

ZSS

View on-line:

System:

Two clamping sliders with continuous spindle and simultaneous centric clamping of two sides

Versions:

ZSS-M

mechanical span adjustment and pressure build-up

ZSS-MOT

Span adjustment and pressure build-up powered by a hydraulic motor

ZSS – outstanding accessibility, ideal for complex and heavy-duty machining

Suitable accessories you can find starting from page 94

OPTIONAL:
Flat bed version on request (p. 8)

ON REQUEST:
Bed length up to 1,200 mm

Perfect grip

The wide support for the clamping slider ensures maximum grip.

Impressive centring

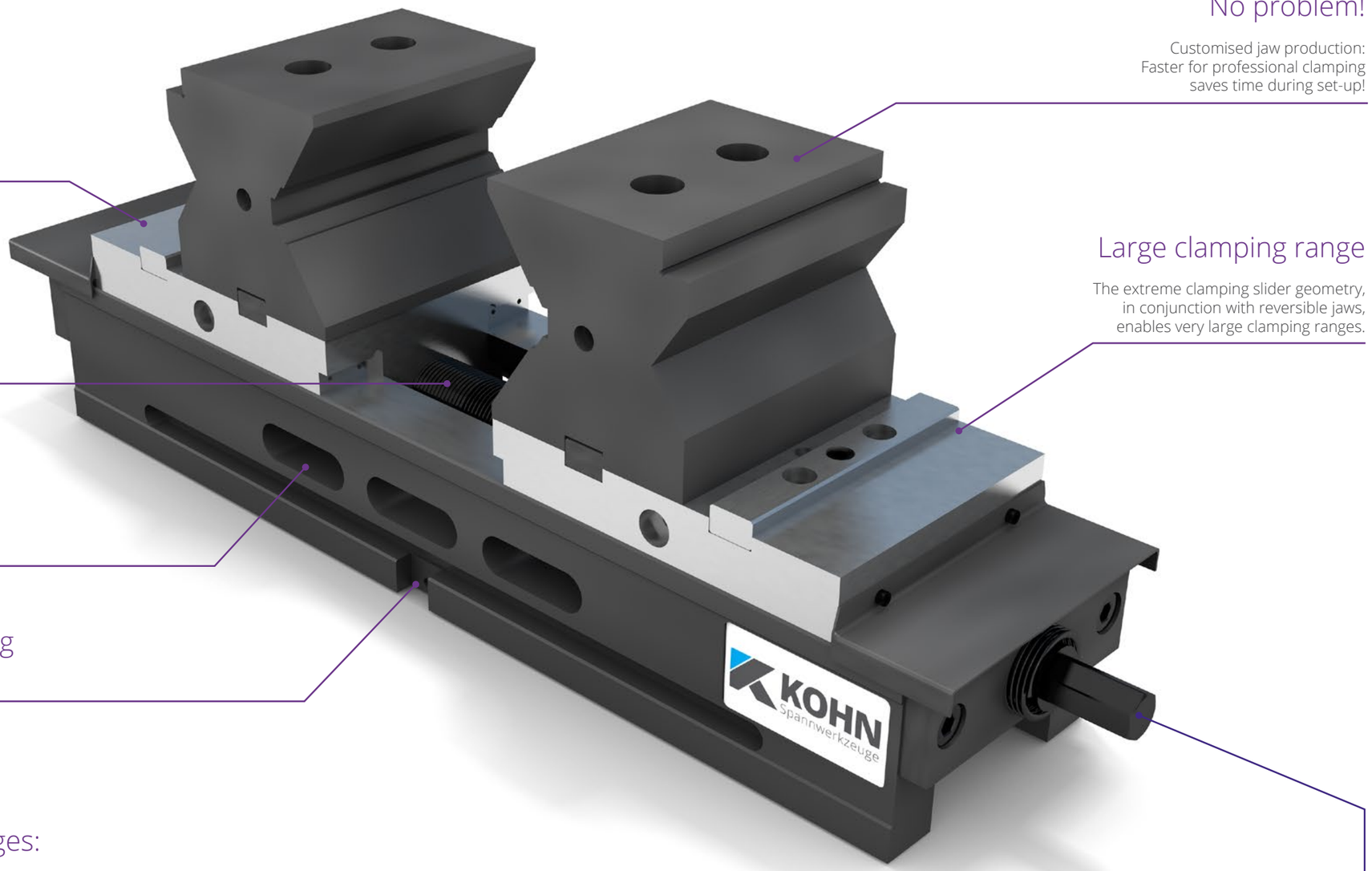
Hardened and smoothed trapezoidal thread spindle (for ZSS 100 and ZSS 125)

Trouble-free for large chip volumes

Outstanding chip and coolant discharge

Optimum positioning

Traverse groove for alignment



Special jaws? No problem!

Customised jaw production: Faster for professional clamping saves time during set-up!

Large clamping range

The extreme clamping slider geometry, in conjunction with reversible jaws, enables very large clamping ranges.

Spindle drive

Optionally, mechanic or motorised version

Impressive advantages:

- Repeat accuracy ≤ 0.015 mm
- Heavy-duty design prevents vibrations
- Large clamping range due to reversible jaws
- Basic equipment: 2 standard prismatic jaws and 1 hand crank

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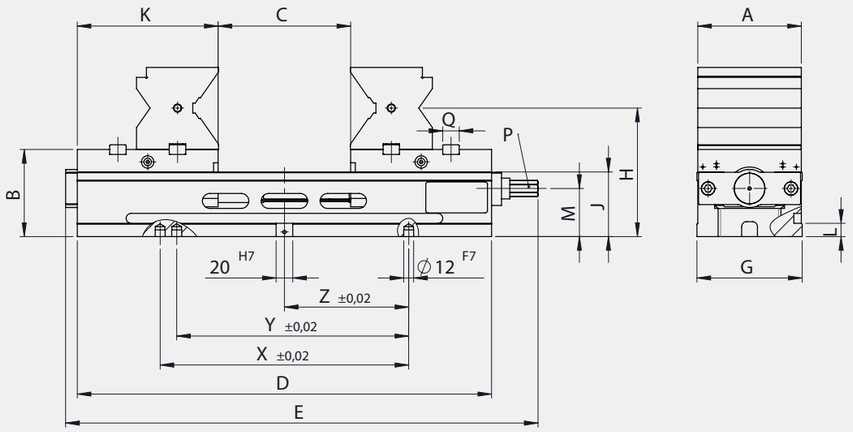
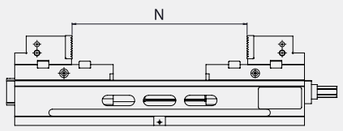
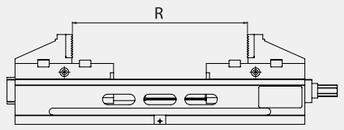
ZSS-M & ZSS-MOT

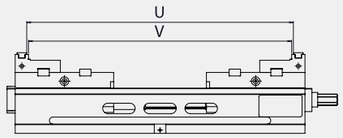
Self-centring vice ZSS-M (mech.) and ZSS-MOT (hydraulic)

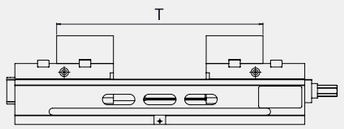
Technical drawing

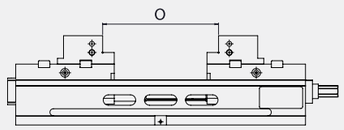


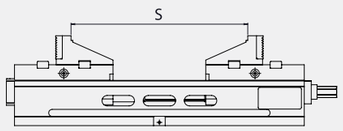








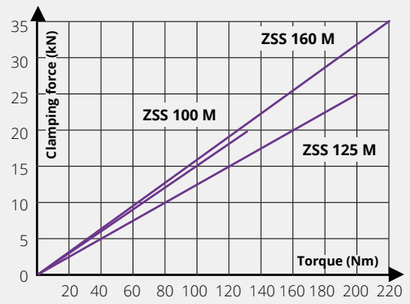




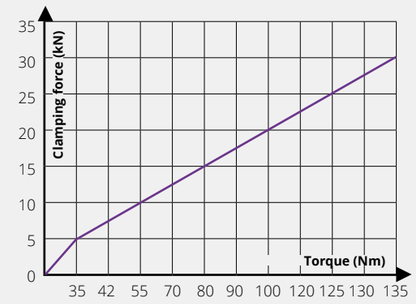
Technical specifications

Jaw width	A	100	125	160
Order No. ZSS-M		03411A	03511A	03611
without jaws		03411A000100	03511A000100	03611000100
	B-0,03	96	105	125
Bed length	D	350	500	650
Overall length	E	408	567	733
Total width	G	104	127	162
Center point	H	130	155	211
Bed height	J h7	78	78	90
Clamping slide	K	118	170	200
	L	14	16	16
	M	63	58	64
Hexagonal connection SW	P	17	17	19
	Q	20h7	19.8h7	19.8h7
	X	300	300	400
	Y	-	280	-
	Z	150	150	200
Clamping range with prismatic jaws		Ø 20-100	Ø 30-150	Ø 30-240
Span	C	114	160	250
Span	N	0-219	0-300	0-398
Span	O	32-252	42-340	30-430
Span	R	0-219	0-300	-
Span	S	86-308	147-447	-
Span	T	118-336	198-500	-
	U	10-310	10-455	-
	V	90-300	155-450	-
Weight	kg	26.4	53.5	98
Clamping force	kN/Nm	20/130	25/200	35/220

ZSS-M – span force diagram



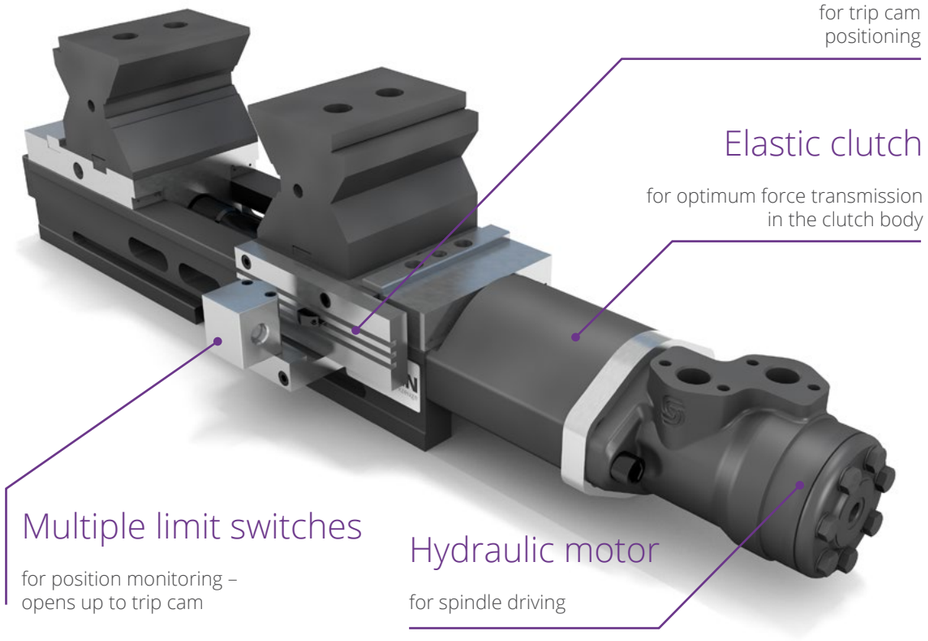
ZSS 125 mot. with OMP 125 motor



NOTE: A hydraulic unit is necessary to operate motorised centring vice.

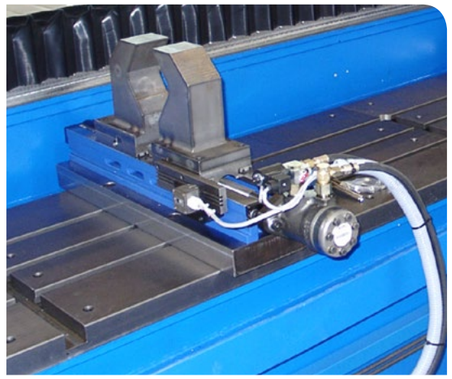
ZSS-MOT

Heavy-duty machining made easy: ZSS-MOT (hydraulic)



Technical specifications				
Jaw width	A	100	125	160
Order No.		03451A	03551A	03651
without jaws		03451A000100	03551A000100	03651000100
Total length without clutch	E	547	610	-
Total length with clutch	E	-	792	972

For other dimensions see previous page



Type: All-purpose vices

UNI

View on-line:

System:

All-purpose vices for clamping device and workpiece automation, direct clamping on zero-point clamping systems, prepared for robot handling, adapter pallets for mounting on grid plates or automation systems.

Versions:

You can find an overview of our complete UNI vice family on the following spread.

Overview of our all-purpose vice family

Centring vices

ZSS 65 AUT from p. 66

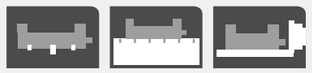
Jaw width:	65 mm
Spans up to:	75 mm

ZSS 80 AUT from p. 68

Jaw width:	80 mm
Spans up to:	161 mm

ZSS 125 UNI from p. 74

Jaw width:	125 mm
Spans up to:	276 mm



ZSS 80 M from p. 76

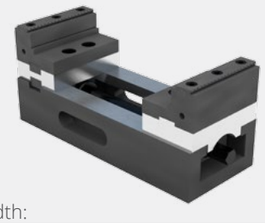
Jaw width:	80 mm
Spans up to:	276 mm

Single vices

ESS 80 M UNI & HD UNI from p. 80

Jaw width:	80 mm
Spans up to:	161 mm

ESS 80 M from p. 82



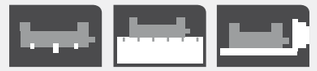
Jaw width:	80 mm
Spans up to:	207 mm

ZSS 65 NPSS from p. 70

Jaw width:	65 mm
Spans up to:	110 mm

ZSS 80 UNI from p. 72

Jaw width:	80 mm
Spans up to:	161 mm



ZSS 125 M from p. 78

Jaw width:	125 mm
Spans up to:	276 mm

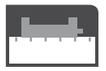
ESS 125 M from p. 84

Jaw width:	125 mm
Spans up to:	276 mm

Direct adaptation to all zero-point clamping systems (NPSS) through integrated vice foot

zero-point clamping system (NPSS) in integrated directly in the vice foot

Gripper groove for robot handling

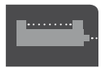


Direct mounting on the machine table

Mounting via base on the machine table

Direct mounting on automation pallets

Optional:
"fixed jaw on the front"



Optional:
Integrated clamping force measurement

+49 (0)7183-8922 info@Kohn-Spannwerkzeuge.de

KOHN Spannwerkzeuge
solid. connections.

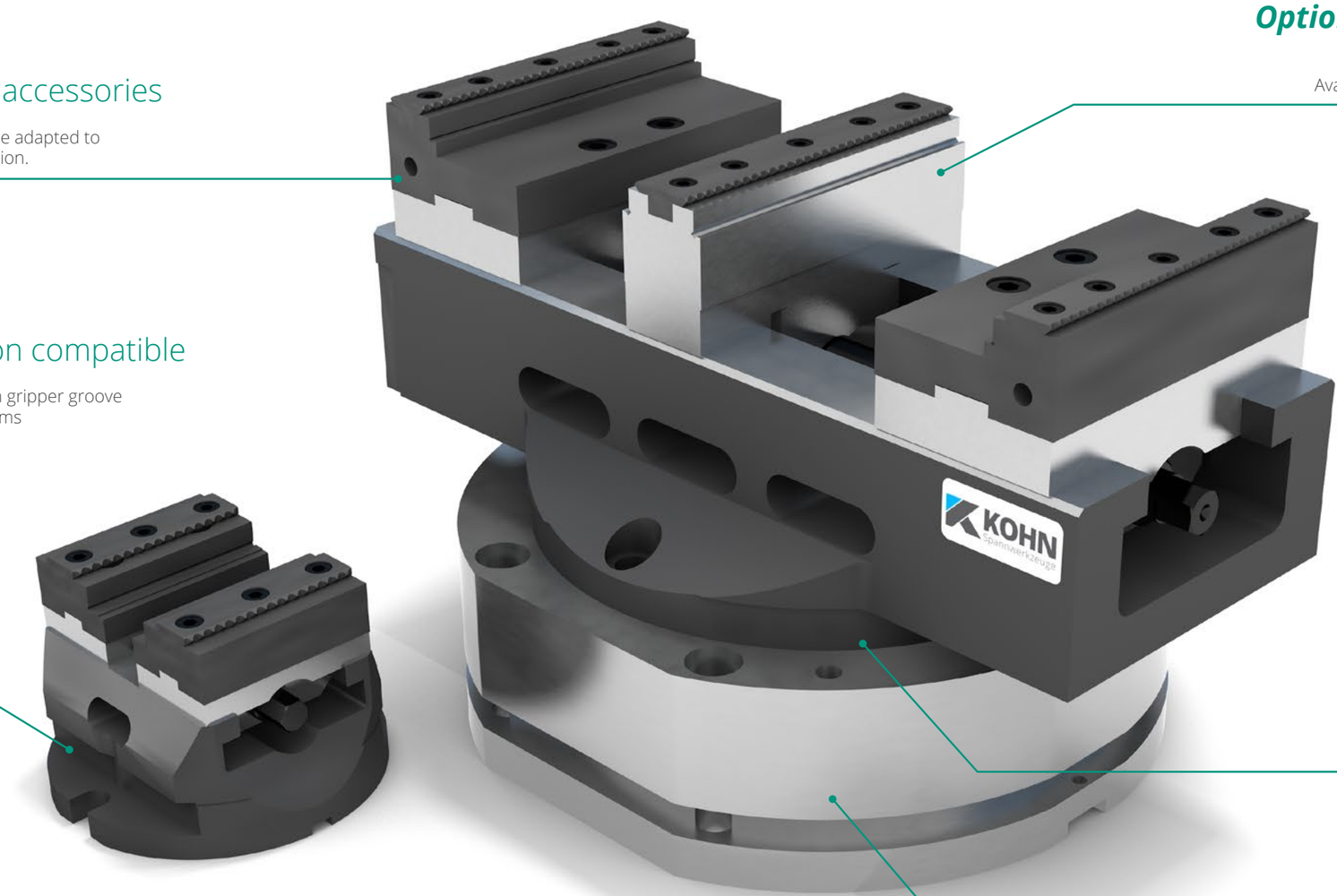
Experience the automation solutions: all-purpose vices for zero-point clamping systems

Numerous accessories

Different jaws can be adapted to a particular application.

Automation compatible

Prefabricated with gripper groove for handling systems



Optional: Changeover slider

Changeover slider for multi-clamping.
Available in the following sizes: 80 and 125.

Suitable for each clamping system

For your zero-point clamping system or mounting on the machine table or with base on your own system.

Optional: Console

To ensure the best accessibility, especially for large tool holders or small workpieces.
With groove for mounting on each machine table.

The new generation of our UNI vices combines traditional precision and durability with innovative zero-point clamping and automation. On request, we also manufacture your vice for manufacturers of other zero-point clamping systems. Our Technology Department specialists will be happy to help you find a suitable solution.

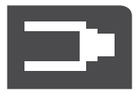
+49 (0)7183-8922 info@Kohn-Spannwerkzeuge.de 65

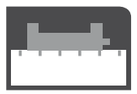
ZSS 65 AUT

Centring vice with mechanical design, for all zero-point clamping systems

Suitable accessories you can find starting from page 94


Support for NPSS

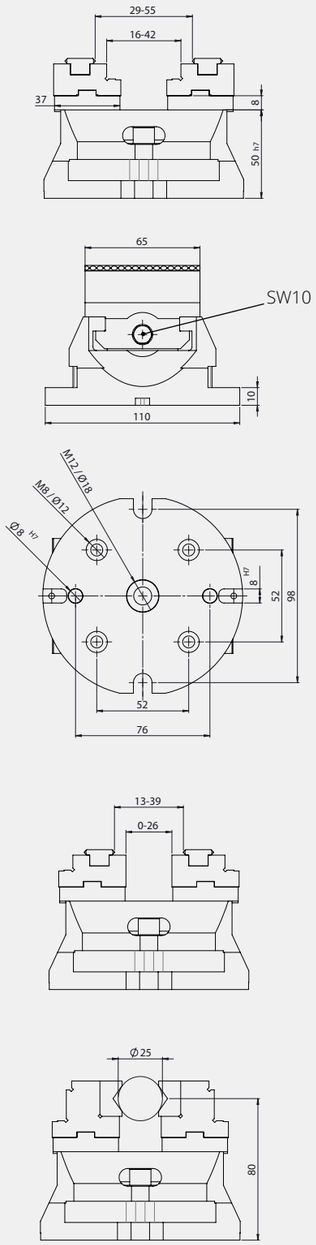

Suitable for: handling systems


Machine table assembly

Impressive advantages:

- Compact design with reduced protruding edges: ideal for 5-axes machines and confined workspaces
- Lightweight model: particularly suitable for smaller handling systems
- Centring accuracy ± 0.1 mm (optional: ±0.03 mm)
- Basic equipment: 2 stepped jaw attachments with grip bar

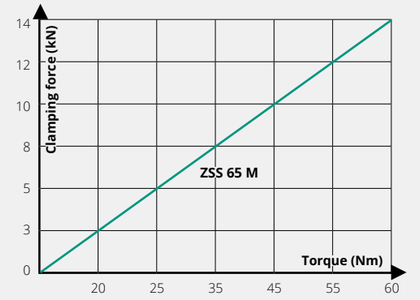
Technical drawing



Technical specifications

Jaw width	65
Order No.	0321A100
Order No. without jaws	0321A1000100
... for Hirschmann 9000 including clamping spigots and two nuts	0321A100H9
... for AMF clamping station incl. four clamping nipples	0321A100AMF

Clamping force diagram



ZSS 80 AUT

Centring vice with mechanical design, for all zero-point clamping systems

Suitable accessories you can find starting from page 94


Support for NPSS

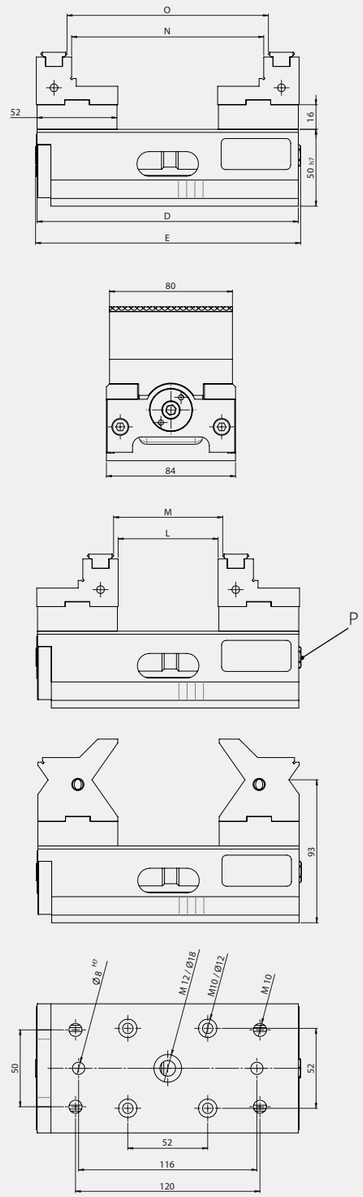

Suitable for: Handling systems


Mounting with Base

Impressive advantages:

- 2 different bed lengths to choose from
- Ideal for medium and large workpieces
- Lightweight model for medium handling systems
- Centring accuracy ± 0.02 mm
- Basic equipment: 2 stepped jaw attachments with grip bar

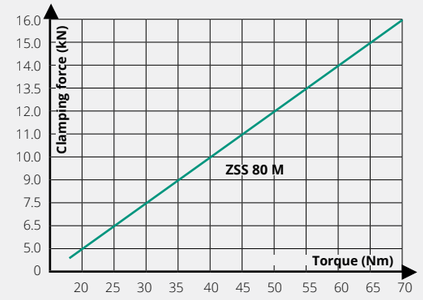
Technical drawing

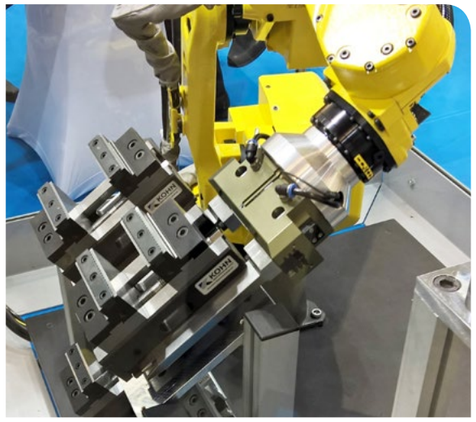


Technical specifications

Jaw width	A	80	80
Order No.		0331A170	0331A200
without jaws		0331A1700100	0331A2000100
for Hirschmann 9000 including clamping spigots and two nuts		0331A170H9	0331A200H9
for AMF clamping station incl. four clamping nipples		0331A170AMF	0331A200AMF
Bed length	D	170	200
Overall length	E	172	202
Span	L	0-65	0-95
	M	6-71	6-101
	N	60-125	60-155
	O	66-131	66-161
Hexagonal connection SW	P	12	12
Centring accuracy		± 0.02	± 0.02
Weight	kg	6.2	6.7

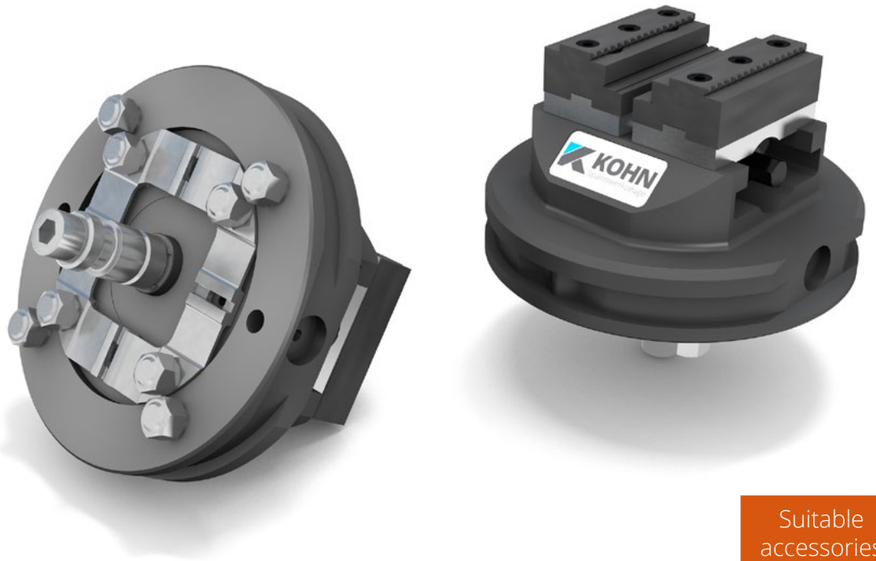
Clamping force diagram





ZSS 65 NPSS

All-inclusive:
centring vice with integrated zero-point clamping system



Integrated NPSS

Suitable for: Handling systems

Suitable accessories you can find starting from page 94

Impressive advantages:

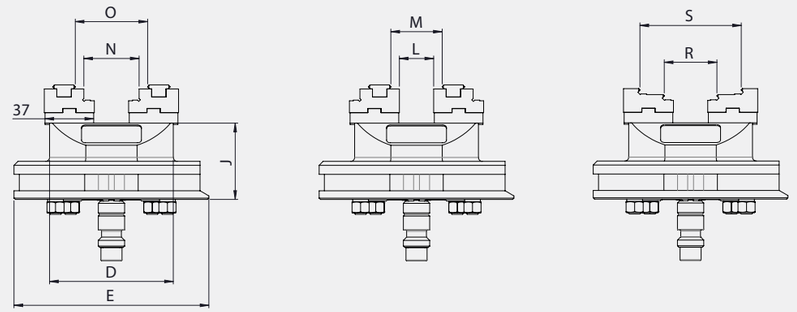
- Centring vice with integrated range for zero-point clamping system
- available for the following zero-point systems: AMF K20, Erowa ITS, Hirschmann 5000 and Hirschmann 9000, other models upon request
- Basic equipment: 2 stepped jaw attachments with grip bar

KOHN Spannwerkzeuge
solid. connections.

Technical specifications

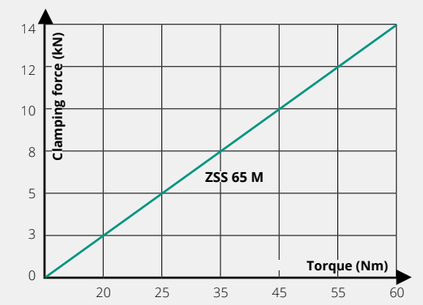
Jaw width		65	65	65	65
					
		for EROWA	**for AMF**	**for HIRSCHMANN PrisFix**	**for HIRSCHMANN 9000**
Order No.		0321ER000010	03211A2	0321S130H510	0321S130H910
Bed length	D	94	94	132	132
Overall length	E	148	106	148	148
	J h7	57.9	50	70	70
Hexagonal connection SW				10	
Clamping range	L	0-26	0-26	0-61	0-61
	M	13-39	13-39	13-74	13-74
	N	17-42	17-42	17-77	17-77
	O	30-52	30-52	30-90	30-90
	R	15-38	15-38	15-74	15-74
	S	52-75	52-75	52-110	52-110
Centring accuracy	mm	±0.1	±0.1	±0.1	±0.1
Weight	kg	5.9	3.9	7.9	7.9

Technical drawing



Other zero-point clamping systems upon request

Clamping force diagram

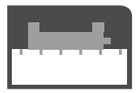


ZSS 80 UNI

Self-centring vice used for a variety of purposes

Suitable accessories you can find starting from page 94


Support for NPSS

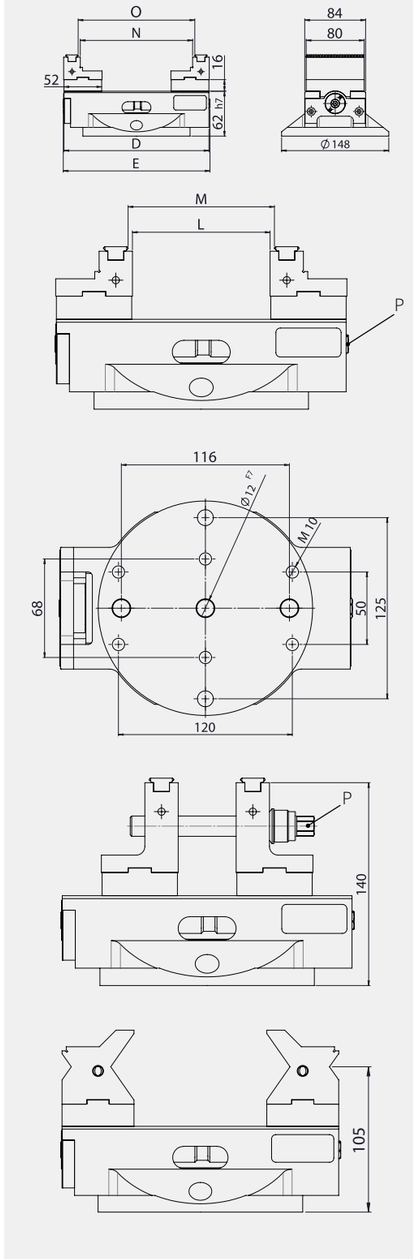

Machine table assembly


Mounting on automation pallet

Impressive advantages:

- Vice foot and bottom part in one piece milled from solid material, maximum stability and accuracy
- 2 different bed lengths to choose from
- A variety of different attachment and screw-in jaws as accessories
- Centring accuracy ± 0.02 mm
- Basic equipment: 2 stepped jaw attachments with grip bar and hand crank

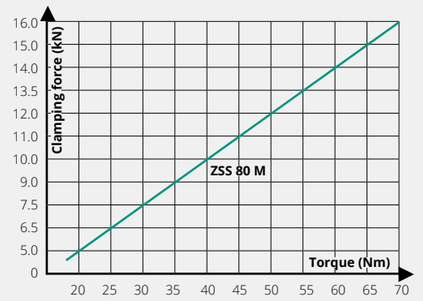
Technical drawing



Technical specifications

Jaw width	A	80	80
Order No.		Z3310	Z3311
without jaws		Z3310000100	Z3311000100
Bed length	D	170	200
Overall length	E	172	202
Span	L	0-65	0-95
Span	M	6-71	6-101
Span	N	60-125	60-155
Span	O	66-131	66-161
Hexagonal connection SW	P	12	12
Centring accuracy		± 0.02	± 0.02
Weight	kg	8.3	8.8

Clamping force diagram



ZSS 125 UNI

Stable centring vice for large dimensions

Suitable accessories you can find starting from page 94


Support for NPSS

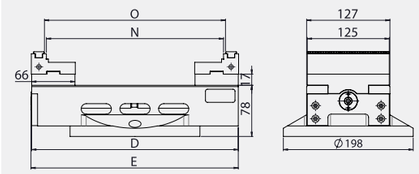

Machine table assembly

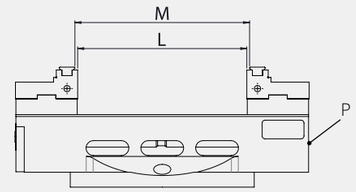

Mounting on automation pallet

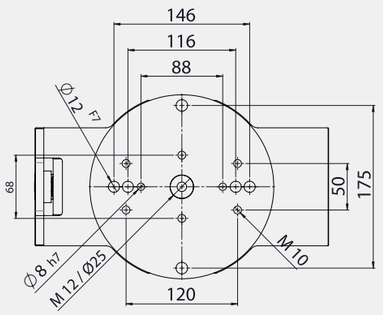
Impressive advantages:

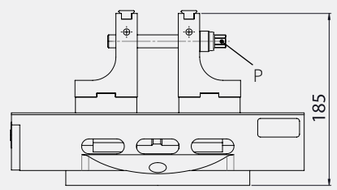
- Vice foot and bottom part in one piece milled from solid material, maximum stability and accuracy
- 2 different bed lengths to choose from
- A variety of different attachment and screw-in jaws as accessories
- Centring accuracy ± 0.02 mm
- Basic equipment: 2 stepped jaw attachments with grip bar and hand crank

Technical drawing





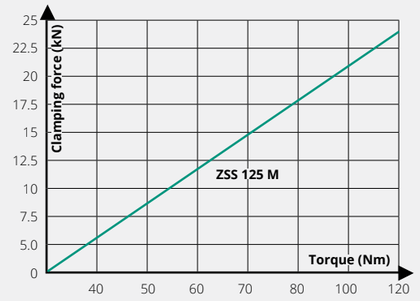




Technical specifications

Jaw width	A	125	125
Order No.		Z3510	Z3511
without jaws		Z3510000100	Z3511000100
Bed length	D	245	315
Overall length	E	246	316
Span	L	0-112	0-182
Span	M	6-118	6-188
Span	N	88-200	88-270
Span	O	94-206	94-276
Hexagonal connection SW	P	14	14
Centring accuracy		± 0.02	± 0.02
Weight	kg	19.9	21.7

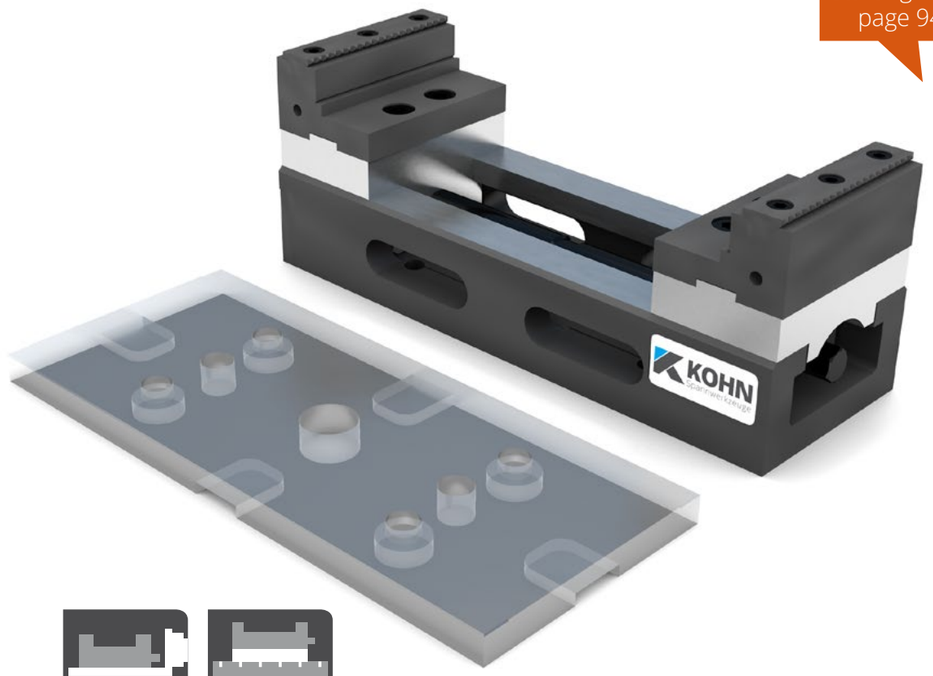
Clamping force diagram



ZSS 80 M

Single centring vice used for a variety of purposes

Suitable accessories you can find starting from page 94



Mounting on automation pallet

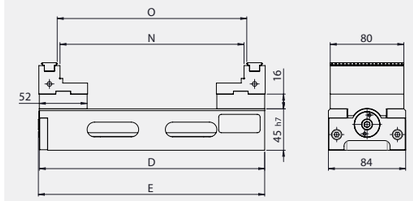
Mounting with Base

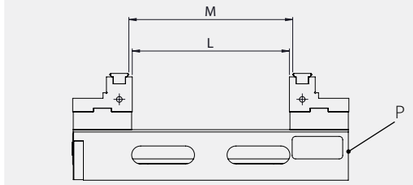
Impressive advantages:

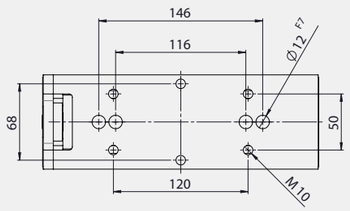
- 3 different bed lengths to choose from
- A variety of different attachment and screw-in jaws as accessories
- Centring accuracy ± 0.02 mm
- Quick mounting with base, which is used as an adapter between vice and machine table.
- Basic equipment: 2 stepped jaw attachments with grip bar and hand crank

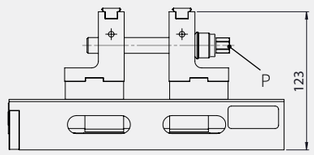
KOHN Spannwerkzeuge
solid. connections.

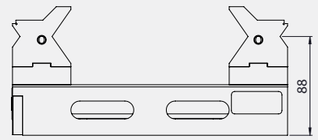
Technical drawing







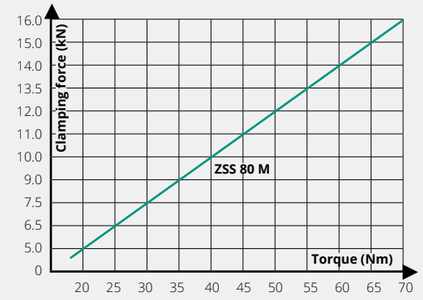




Technical specifications

Jaw width	A	80	80	80
Order No.		0331S200	0331S245	0331S315
without jaws		0331S200 0001	0331S245 0001	0331S315 0001
Bed length	D	200	245	315
Overall length	E	201	246	316
Span	L	0-95	0-140	0-210
Span	M	6-101	6-146	6-216
Span	N	60-155	60-200	60-270
Span	O	66-161	66-206	66-276
Hexagonal connection SW	P	12	12	12
Centring accuracy		± 0.02	± 0.02	± 0.02
Weight	kg	5.4	5.5	6.7

Clamping force diagram



ZSS 125 M

Single centring vice used for a variety of purposes for heavy-duty machining

Suitable accessories you can find starting from page 94

Mounting on automation pallet

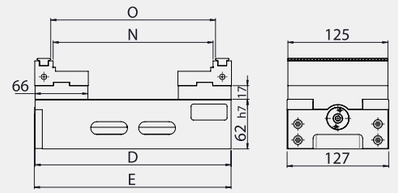
Mounting with Base

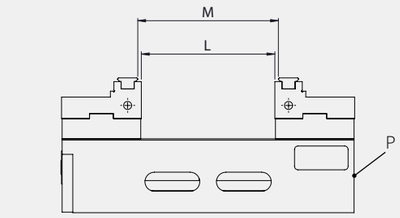
Impressive advantages:

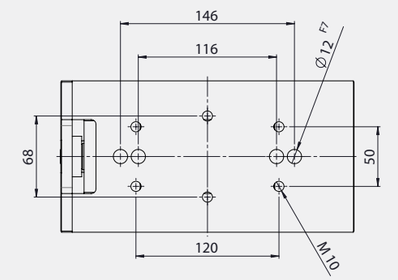
- 2 different bed lengths to choose from
- A variety of different attachment and screw-in jaws as accessories
- Centring accuracy ± 0.02 mm
- Quick mounting with base, which is used as an adapter between vice and machine table.
- Basic equipment: 2 stepped jaw attachments with grip bar and hand crank

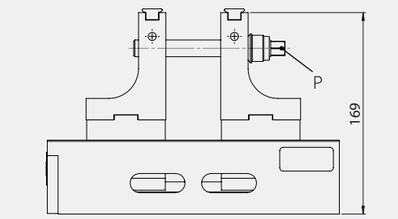
KOHN Spannwerkzeuge
solid. connections.

Technical drawing





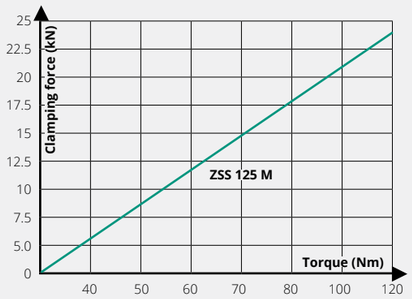


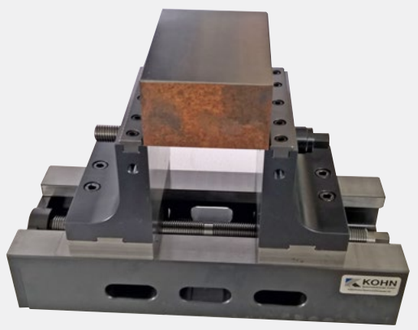


Technical specifications

Jaw width	A	125	125
Order No.		0351S245	0351S315
without jaws		0351S245 0001	0351S315 0001
Bed length	D	245	315
Overall length	E	246	316
Span	L	0-112	0-182
Span	M	6-118	6-188
Span	N	88-200	88-270
Span	O	94-206	94-276
Hexagonal connection SW	P	14	14
Centring accuracy		± 0.02	± 0.02
Weight	kg	12.7	15.5

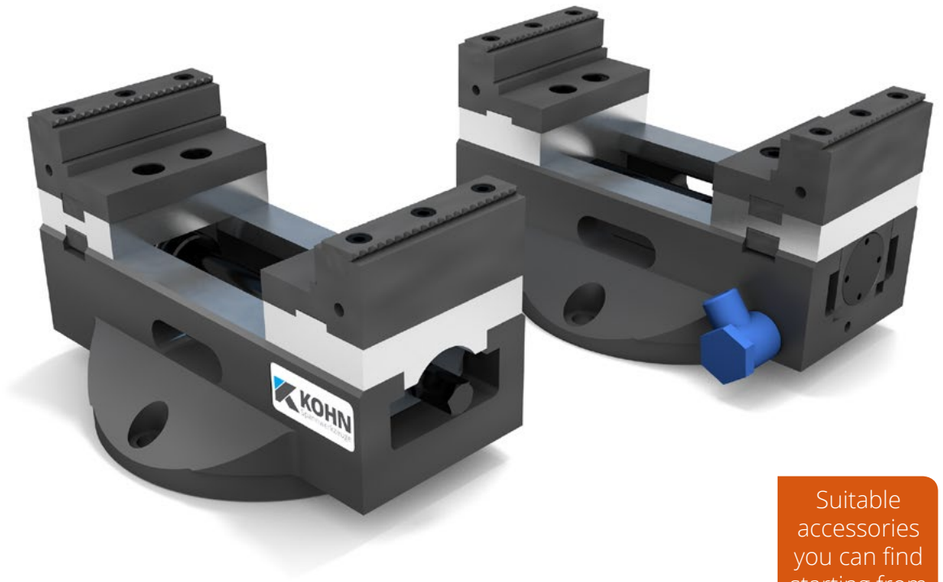
Clamping force diagram





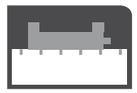
ESS 80 M UNI & HD UNI

Multi-purpose, compact and stable: Single clamp for manual or hydraulic operation



Suitable accessories you can find starting from page 94


Support for NPSS


Machine table assembly


Mounting on automation pallet

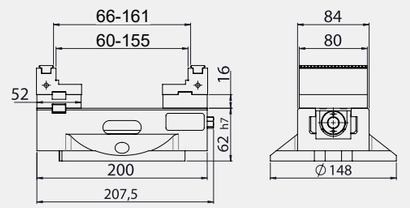

Optional: "fixed jaw on the front"

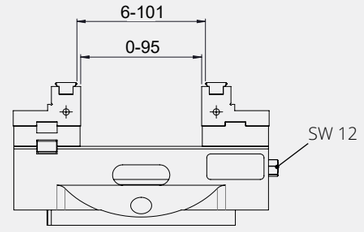
Impressive advantages:

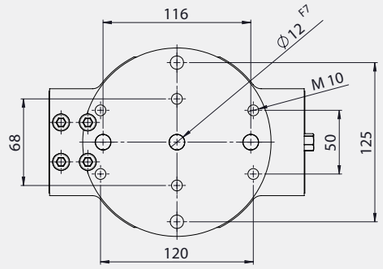
- Multi-purpose, compact design with reduced protruding edges
- Wide range of jaws allows versatile machining.
- Repeat accuracy ≤ 0.01 mm
- Fixed jaws secured on all levels (X,Y,Z)
- Centring accuracy ± 0.1 mm
- Basic equipment: 2 stepped jaw attachments with grip bar and hand crank

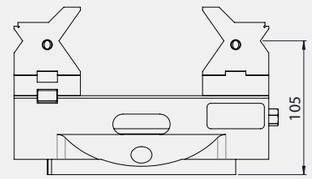
KOHN Spannwerkzeuge
solid. connections.

Technical drawing

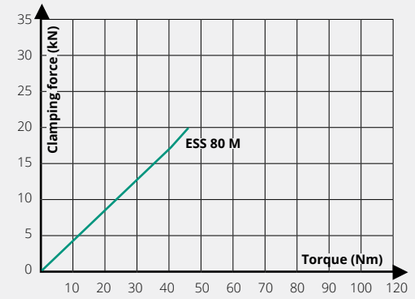


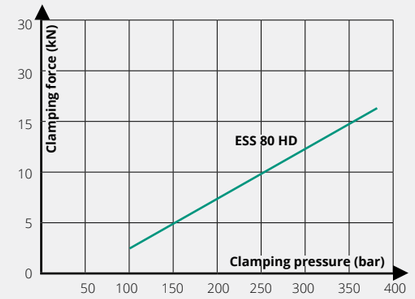






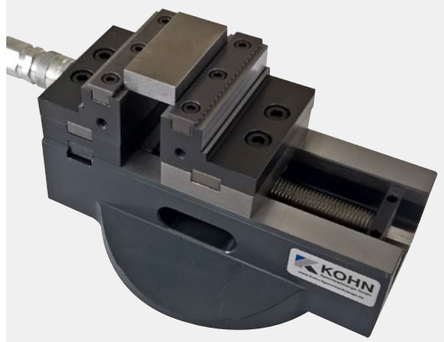
Clamping force diagrams





Order No.

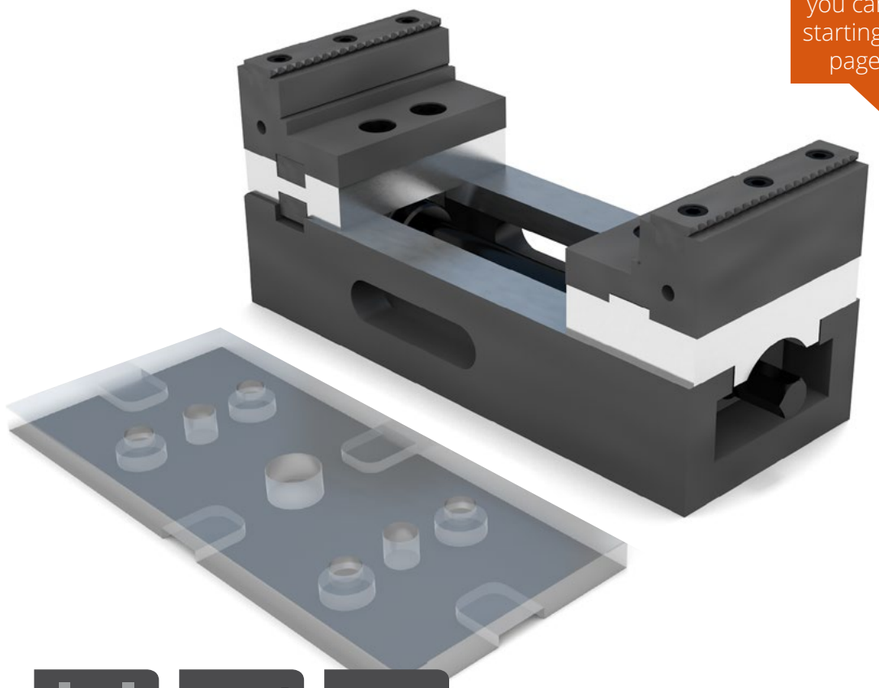
Type	ESS 80 M UNI	ESS 80 HD UNI
Order No.	E1311	E1331
without jaws	E1311000100	E1331000100



ESS 80 M

Single vice used for a variety of purposes

Suitable accessories you can find starting from page 94



Mounting with Base

Mounting on automation pallet

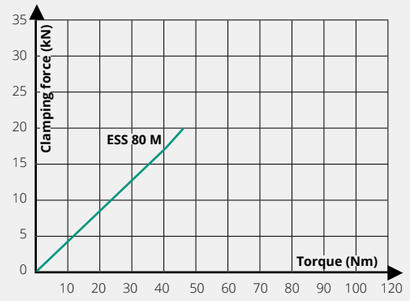
Optional: "fixed jaw in front"

Impressive advantages:

- 2 different bed lengths to choose from
- A variety of different attachment and screw-in jaws as accessories
- Repeat accuracy ≤ 0.01 mm
- Fixed jaws secured on all levels (X,Y,Z)
- Quick mounting with base, which is used as an adapter between vice and machine table.
- Basic equipment: 2 stepped jaw attachments with grip bar and hand crank

KOHN Spannwerkzeuge
solid. connections.

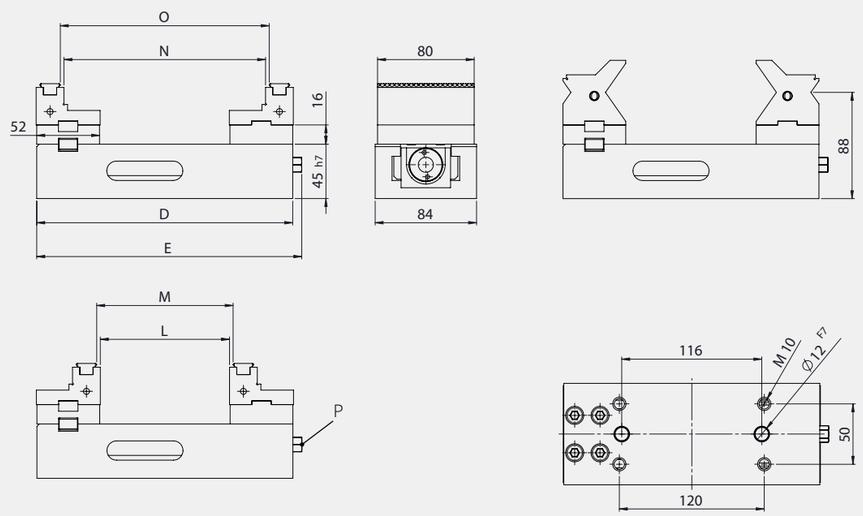
Clamping force diagram



Technical specifications

Jaw width	A	80	80
Order No.		01310IND	01311IND
without jaws		01310INDOB	01311INDOB
Bed length	D	212	246
Overall length	E	246	316
Span	L	0-107	0-141
Span	M	6-113	6-147
Span	N	60-167	60-201
Span	O	66-173	66-207
Hexagonal connection SW	P	12	12
Clamping force at 50 Nm	kN	22	22
Weight	kg	6.1	6.5

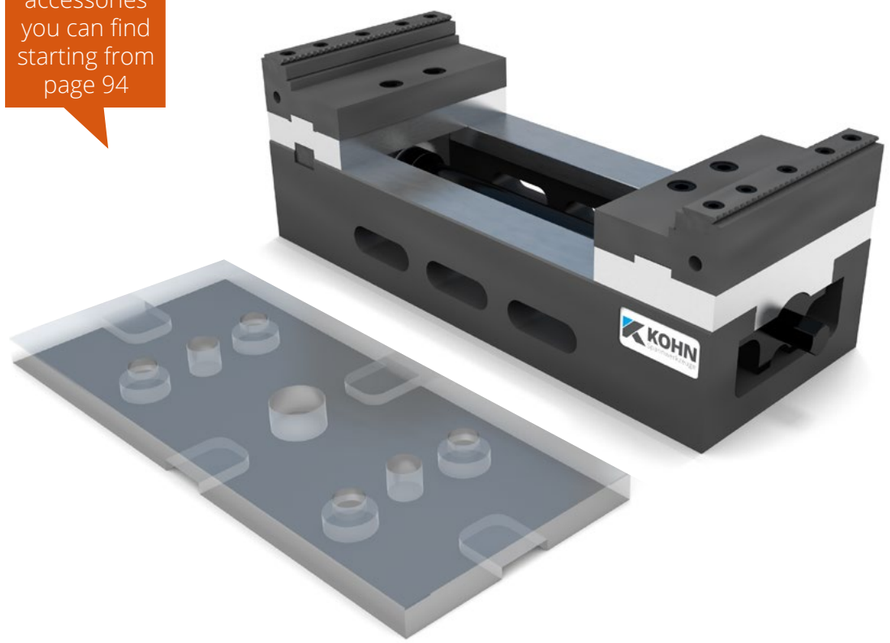
Technical drawing



ESS 125 M

Single vice
for heavy-duty machining

Suitable accessories you can find starting from page 94




Mounting with Base


Mounting on automation pallet


Optional: "fixed jaw on the front"

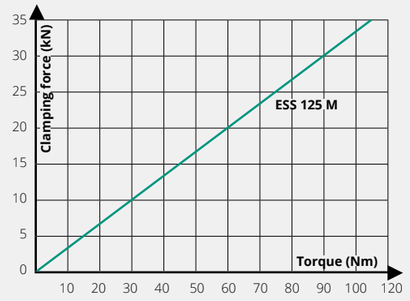

Optional: Clamping force measurement

Impressive advantages:

- 2 different bed lengths to choose from
- A variety of different attachment and screw-in jaws as accessories
- Repeat accuracy ≤ 0.01 mm
- Fixed jaws secured on all levels (X,Y,Z)
- Quick mounting with base, which is used as an adapter between vice and machine table.
- Basic equipment: 2 stepped jaw attachments with grip bar and hand crank

KOHN Spannwerkzeuge
solid. connections.

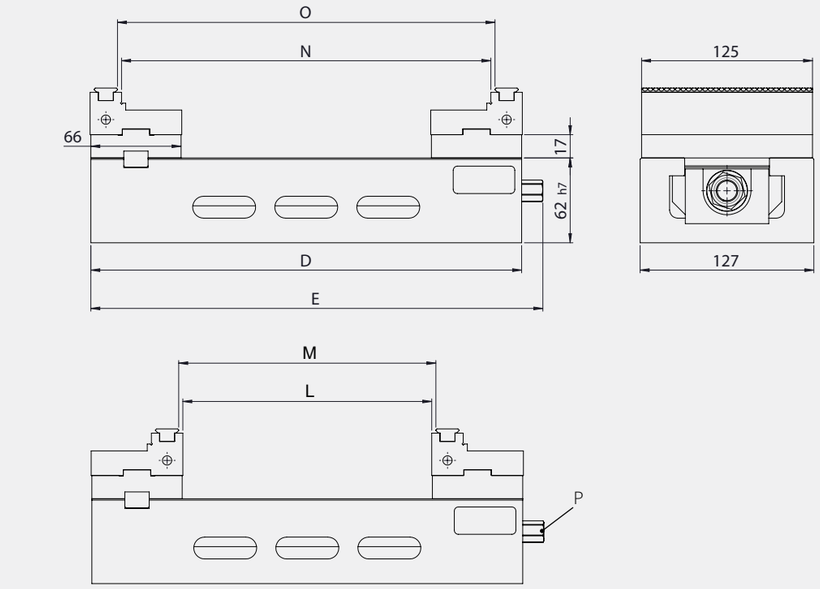
Clamping force diagram



Technical specifications

Jaw width	A	125	125
Order No.		0151S245	0151S315
without jaws		0151S245 0001	0151S315 0001
Bed length	D	245	315
Overall length	E	261	331
Span	L	0-112	0-182
Span	M	6-118	6-188
Span	N	88-200	88-270
Span	O	94-206	94-276
Hexagonal connection SW	P	14	14
Clamping force at 115 Nm	kN	35	35
Weight	kg	12.7	15.5

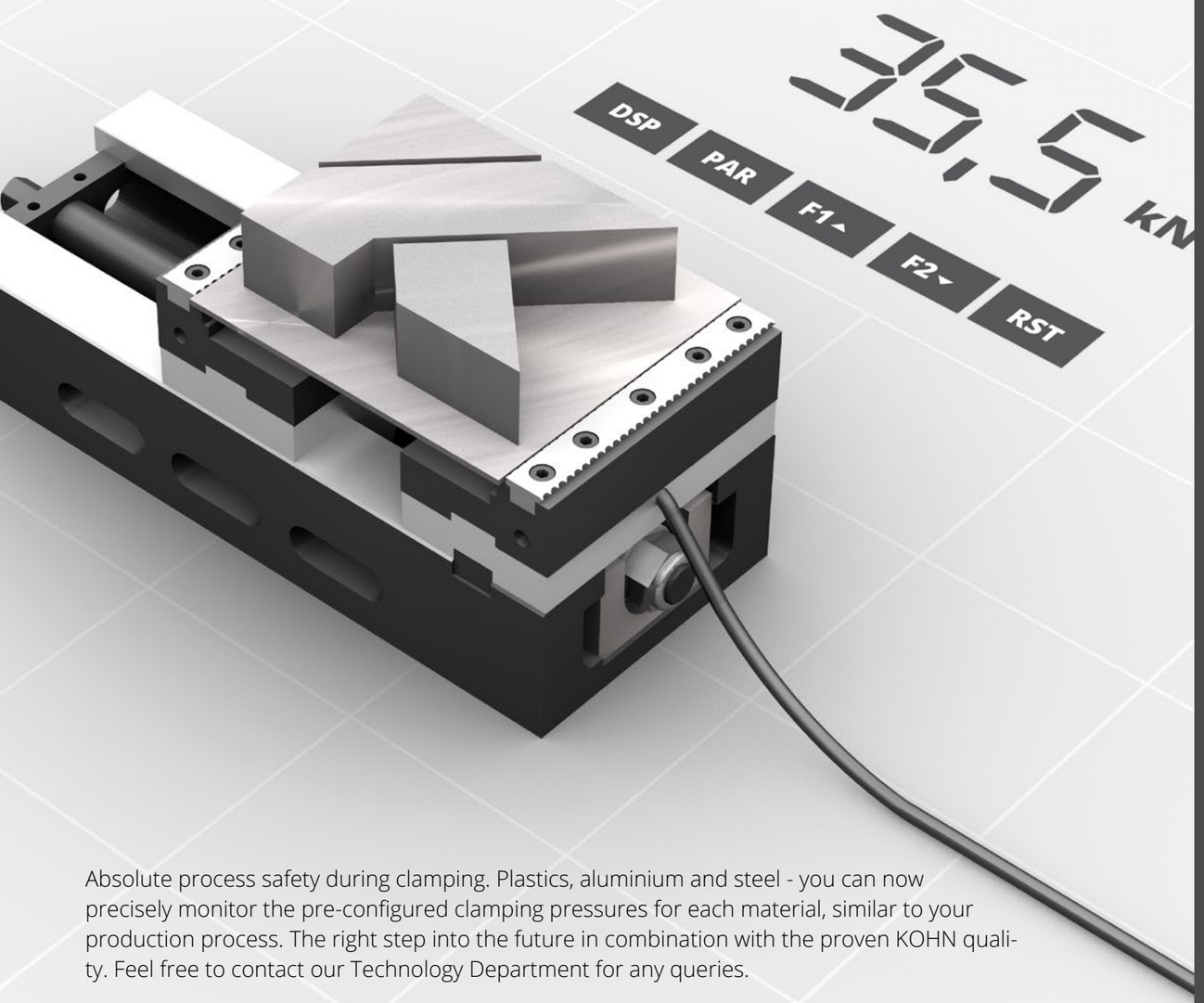
Technical drawing



KOHN Spannwerkzeuge

solid. connections.

Clamping force measurement in the ESS vice



Absolute process safety during clamping. Plastics, aluminium and steel - you can now precisely monitor the pre-configured clamping pressures for each material, similar to your production process. The right step into the future in combination with the proven KOHN quality. Feel free to contact our Technology Department for any queries.

- Force measurement via sensors: before, during and after machining
- Quick recognition of clamping errors and optimum workpiece handling during cutting process – minimises rejects and reduces production costs
- Continuous reading via stand-alone display or control panel
- Suitable for any standard interface

Type: 2-axes centring clamp

VZA

View on-line:

System:

Complex parts reliably brought to the centre

Versions:

Customised...

... bed lengths upon request.

+49 (0)7183-8922 info@Kohn-Spannwerkzeuge.de

VZA

VZA – clamping right in the centre: Highest retention forces and precision for maximum clamping performance!

Suitable accessories you can find starting from page 94

Clamping range up to 560 mm

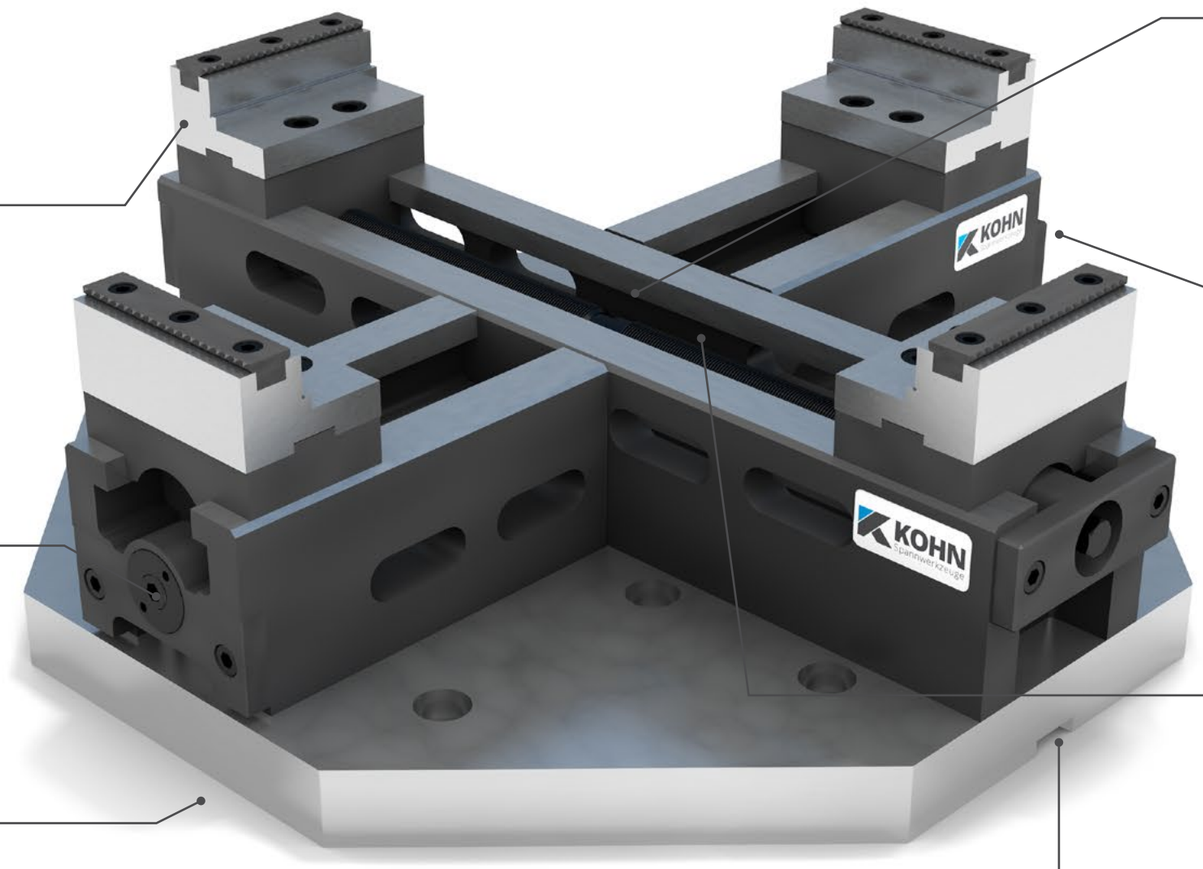
Workpieces up to Ø 560 mm can be clamped with a bed length of 600 mm by means of jaws.

High level of centring accuracy ± 0.02 mm

Two continuous spindles allow maximum precision.

Any zero-point clamping systems

Can be adapted to any zero-point clamping system



Central workpiece clamping

Form-locked clamping via 4 sides internally and externally.

Optimal use of space

Best accessibility and optimal machine room utilisation open up countless possibilities.

Easy programming

When programming, just start from the centre. It couldn't be easier:

Easy machine table mounting

To be reproducibly mounted on each machine table via centre hole and transverse groove

Clamping right in the centre: the flexible solution, for example, for the mould maker. You can always clamp your material right in the centre by means of two axes. It couldn't be faster or easier. Any clamping size and base drilling pattern is feasible. Due to their excellent reproducibility, workpieces can be easily removed and reused. In addition, our wide range of jaws offers a number of customised clamping solutions.

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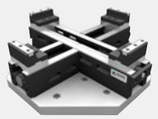
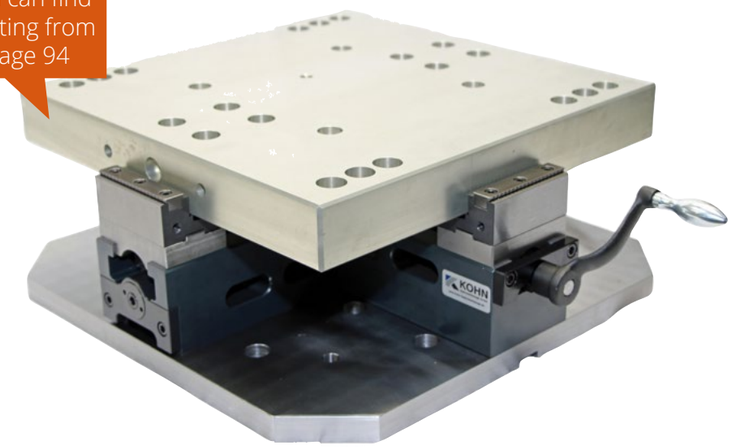
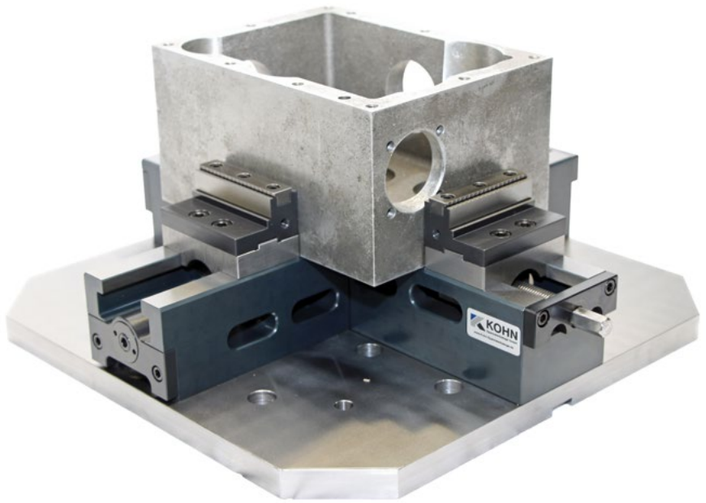


VZA

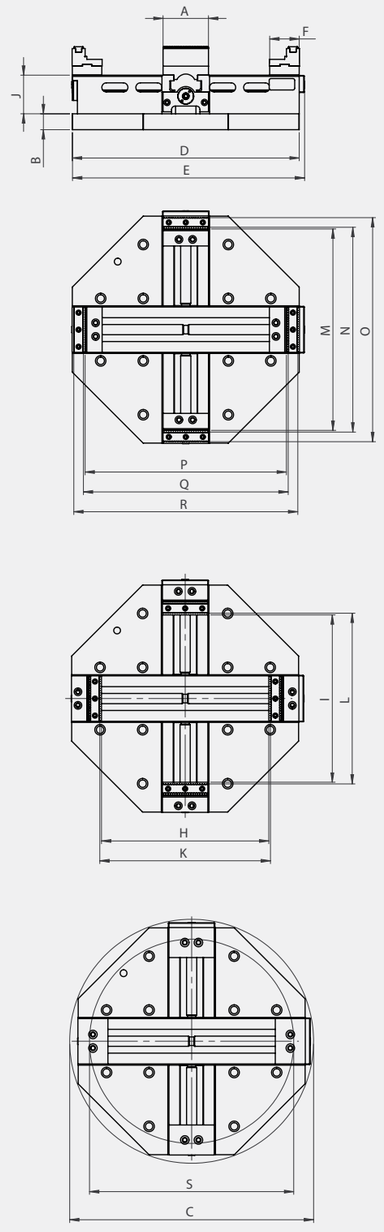
VZA – from the centre: for the right base to ensure the highest-quality workpieces!

Suitable accessories you can find starting from page 94





Technical drawing

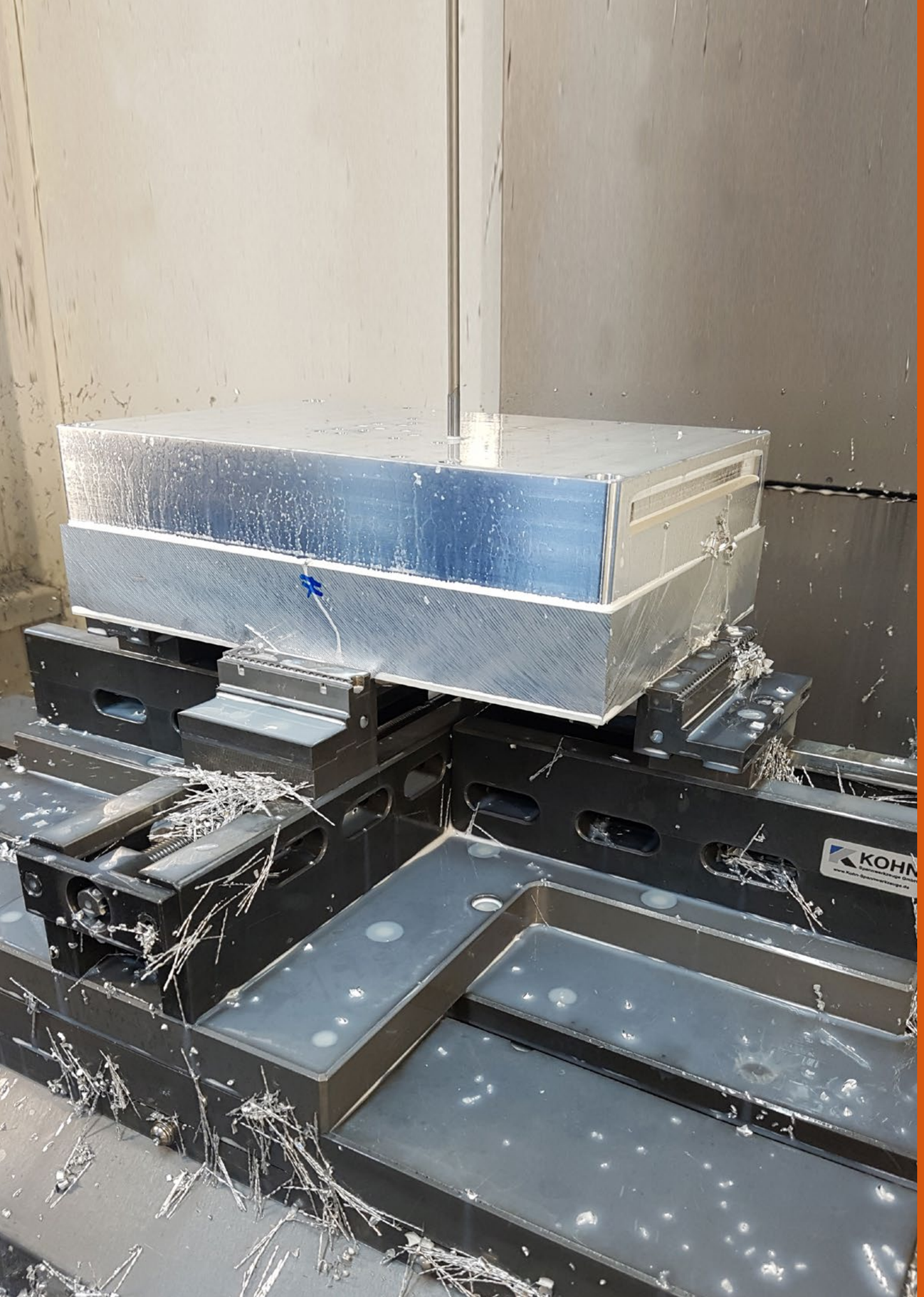


Technical specifications

Jaw width	A		80	
Order No.		V3311	V3313	V3315
Bed length	D	400	500	600
Overall length	E	410x410	510x510	610x610
Interference range	C	Ø430	Ø525	Ø625
Bed height	J h7		68	
Clamping slide	F		52	
Panel height	B		28	
Hexagonal connection SW			12	
Clamping range	H	0-290	0-390	0-490
	I	85-290	85-390	85-490
	K	10-300	10-400	10-500
	L	90-300	90-400	90-500
	M	145-350	145-450	145-550
	N	150-360	150-460	150-560
	O	185-390	185-490	185-590
	P	65-350	65-450	65-550
	Q	70-360	70-460	70-560
	R	100-390	100-490	100-590
	S	Ø100-360	Ø100-460	Ø100-560
Weight	kg	55	70	85
Clamping force at 70 Nm	kN		16	
Centring accuracy	mm		± 0.02	

Basic version: 4 stepped jaw attachments and grip bar, hand crank bent SW 12.

Other bed lengths upon request.



Accessories

Versions:

Accessories Quickfinder

Screw-in jaws

Screw-in jaw
longitudinally knurled

dimensions, etc. on page102

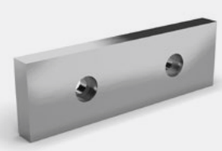
ESS DSS MFS
ZSS UNI VZA

Screw-in jaw
knurled longitudinally and crosswise

dimensions, etc. on 102

ESS DSS MFS
ZSS UNI VZA

Screw-in jaw
smooth



dimensions, etc. on 103

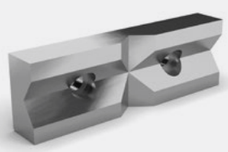
ESS DSS MFS
ZSS UNI VZA

Prismatic jaw

dimensions, etc. on page 105

NCS ESS DSS MFS
ZSS UNI VZA

Prismatic jaw
horizontal and vertical



dimensions, etc. on 105

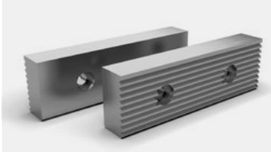
NCS ESS DSS MFS
ZSS UNI VZA

Reversible screw-in jaw
1 side grip step,
1 side smooth

dimensions, etc. on 106

ESS DSS MFS
ZSS UNI

Reversible screw-in jaw
1 side longitudinally knurled, 1 side smooth



dimensions, etc. on 106

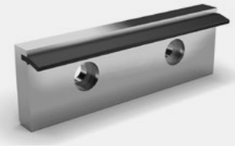
ESS DSS MFS
ZSS UNI

Reversible screw-in jaw
1 side with longitudinal and cross knurls, 1 side smooth

dimensions, etc. on page 108

NCS ESS DSS MFS
ZSS UNI

Spring-down jaw
with spring leaf



dimensions, etc. on page 108

NCS ESS DSS MFS
ZSS UNI VZA

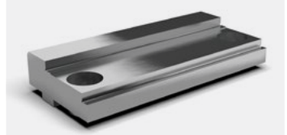
Swing jaw

dimensions, etc. on page 109

NCS

False jaws

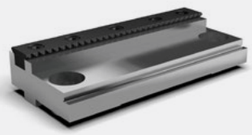
Stepped jaw attachment



dimensions, etc. on page 109

NCS ESS DSS MFS

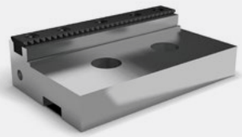
Stepped jaw attachment
with grip bar



dimensions, etc. on page 110

NCS ESS DSS MFS

Stepped jaw attachment
with grip bar



dimensions, etc. on page 110

ZSS

KOHN Spannwerkzeuge
solid. connections.

Soft clamping jaw
with grinding allowance

dimensions, etc. on 103

NCS ESS DSS MFS
ZSS UNI VZA

Step jaw

dimensions, etc. on 104

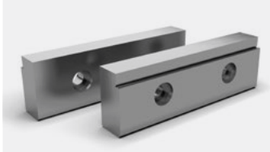
NCS ESS DSS MFS
ZSS UNI VZA

Grip stepped jaw

dimensions, etc. on 104

NCS ESS DSS MFS
ZSS UNI VZA

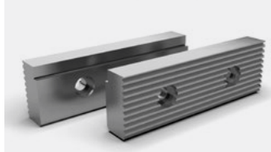
Reversible screw-in jaw
1 side with step,
1 side smooth



dimensions, etc. on page 107

ESS DSS MFS
ZSS UNI

Reversible screw-in jaw
1 side with step,
1 side knurled longitudinally



dimensions, etc. on page 107

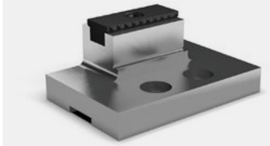
ESS DSS MFS
ZSS UNI

Stepped jaw attachment
with grip bar ZSS 65 (5-axis)

dimensions, etc. on page 111

UNI

Stepped jaw attachment
with grip bar ZSS 80 (5-Axis)
narrow step



dimensions, etc. on page 111

UNI VZA

Stepped jaw attachment
with grip bar ZSS 80 and 125 (5-axis)

dimensions, etc. on page 112

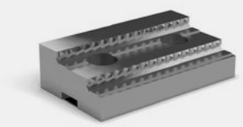
UNI VZA

>>>

Accessories Quickfinder

False jaws

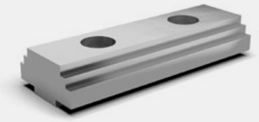
Stepped jaw attachment
with grip



dimensions, etc. on page 112

UNI

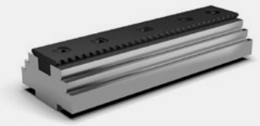
Stepped jaw attachment
for central jaw



dimensions, etc. on page 113

DSS MFS

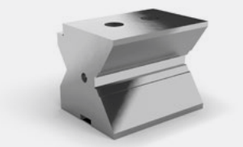
Stepped jaw attachment
for central jaw
with grip bar



dimensions, etc. on page 113

DSS MFS

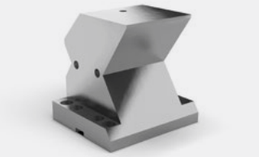
Prismatic jaws as standard



dimensions, etc. on page 115

ZSS

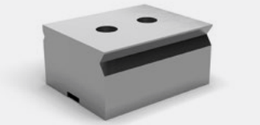
Prismatic jaw



dimensions, etc. on page 116

ZSS

Prismatic jaw
Ø 6 – Ø 32



dimensions, etc. on page 116

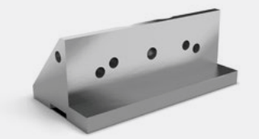
ZSS

False main jaw

dimensions, etc. on page 118

UNI VZA

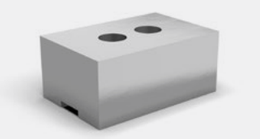
False main jaw
for 5-axis



dimensions, etc. on page 119

UNI

Jaw blank
made from aluminium

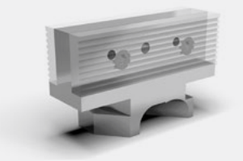


dimensions, etc. on page 119

ZSS UNI VZA

Changeover slider

Changeover slider
without screw-in jaws



dimensions, etc. on page 122

ESS DSS MFS

Changeover slider
set (5-axis)

dimensions, etc. on page 122

UNI VZA

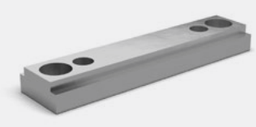
Changeover slider
NCS

dimensions, etc. on page 123

NCS

KOHN Spannwerkzeuge
solid. connections.

Stepped jaw attachment
for changeover slider



dimensions, etc. on page 114

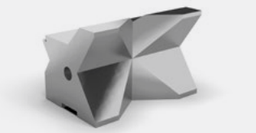
NCS

Screw-in jaw
with groove for grip bar

dimensions, etc. on page 114

NCS ESS DSS MFS

Prismatic jaw
(horizontal and vertical)
for 5-axis



dimensions, etc. on page 115

UNI VZA

Step jaw
with longitudinally knurled screw-in jaw

dimensions, etc. on page 117

ZSS

Stepped jaw attachment
with longitudinally knurled screw-in jaw

dimensions, etc. on page 117

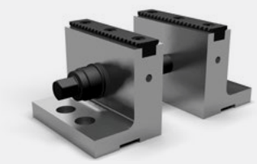
ZSS

Stepped jaw/Main jaw
for ZSS 65

dimensions, etc. on page 118

UNI

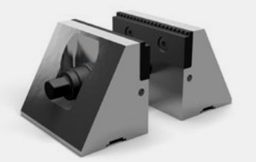
High stepped jaw attachment



dimensions, etc. on page 120

UNI

High main jaw attachment



dimensions, etc. on page 120

UNI

Shim strip
for changeover slider (NCS)
nitrified

dimensions, etc. on page 123

NCS

Accessories Quickfinder

Grip bars

Grip bar
grip on both sides

dimensions, etc. on page 124

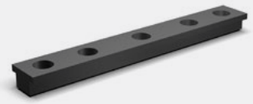
NCS ESS DSS MFS ZSS UNI VZA

Grip bar
a side grip,
a side smooth

dimensions, etc. on page 124

NCS ESS DSS MFS ZSS UNI VZA

Insert
smooth on both sides

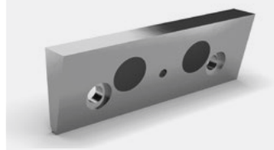


dimensions, etc. on page 125

NCS ESS DSS MFS ZSS UNI VZA

Pull-down-quick-change jaws

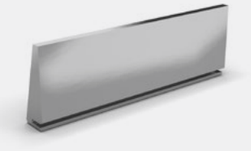
Main jaw with two permanent magnets
hardened and ground



dimensions, etc. on page 126

NCS ESS DSS MFS

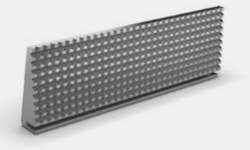
Smooth exchangeable jaw
hardened and ground



dimensions, etc. on page 126

NCS ESS DSS MFS

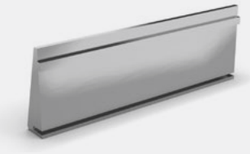
Ribbed exchangeable jaw
hardened and ground



dimensions, etc. on page 127

NCS ESS DSS MFS

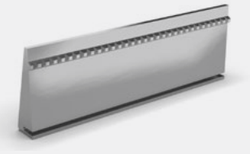
Line exchangeable jaw
hardened and ground



dimensions, etc. on page 127

NCS ESS DSS MFS

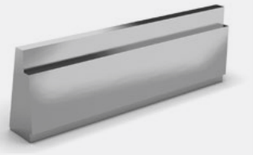
Ribbed line exchangeable jaw
hardened and ground



dimensions, etc. on page 128

NCS ESS DSS MFS

Exchangeable stepped jaw
hardened and ground

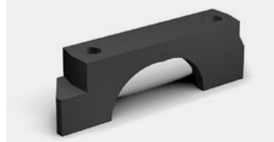


dimensions, etc. on page 128

NCS ESS DSS MFS

Other accessories

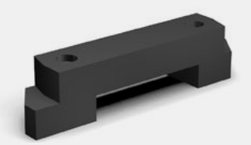
Rhombic T-shaped tenon block
for secure fastening of workpiece material



dimensions, etc. on page 129

ESS DSS MFS UNI VZA

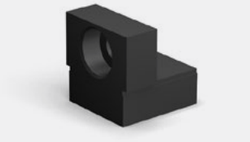
Rhombic T-shaped tenon blocks
for secure fastening of workpiece material



dimensions, etc. on page 129

NCS

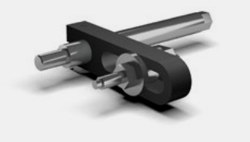
Tenon block



dimensions, etc. on page 130

NCS ESS DSS MFS ZSS

Workpiece stop
is mounted on the vice, clamping slider or in the central jaw



dimensions, etc. on page 131

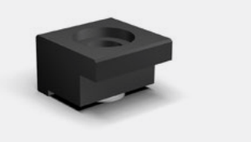
NCS ESS DSS MFS ZSS UNI VZA

Joint stop
is attached to the central jaw or the clamping slider

dimensions, etc. on page 131

NCS ESS DSS MFS ZSS UNI VZA

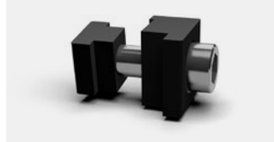
Metal clamp
for attaching the vice to the machine table



dimensions, etc. on page 132

NCS ESS DSS MFS ZSS UNI

Metal clamp set
suitable for clamping vices with a jaw width of 125 mm



dimensions, etc. on page 132

NCS ESS DSS MFS ZSS UNI

Hand crank
straight

dimensions, etc. on page 133

NCS ESS DSS MFS ZSS UNI VZA

Hand crank
bent

dimensions, etc. on page 133

NCS ESS DSS MFS ZSS UNI VZA

Double ended nut driver

dimensions, etc. on page 134

ESS DSS UNI VZA

Special combination wrench (ratchet)

dimensions, etc. on page 134

ESS DSS MFS

Torque wrench ½“

dimensions, etc. on page 135

NCS ESS DSS MFS ZSS UNI VZA

>>>

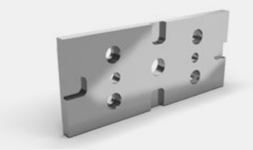
KOHN Spannwerkzeuge solid. connections.

KOHN Spannwerkzeuge
solid. connections.

Accessories Quickfinder

Other accessories

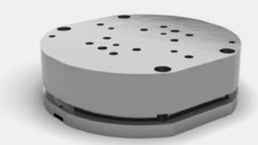
Base



dimensions, etc. on page 135

UNI

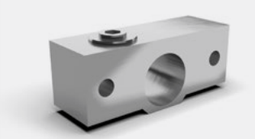
Console



dimensions, etc. on page 130

UNI

Angle drive



dimensions, etc. on page 136

NCS

Angle drive
for MFS-HD

dimensions, etc. on page 136

MFS

Hand-seat valve

dimensions, etc. on page 137

NCS ESS MFS

OMP Hydraulic motor

dimensions, etc. on page 137

ESS ZSS

Elastic clutch

dimensions, etc. on page 138

ESS ZSS

Clutch body
with flange

dimensions, etc. on page 138

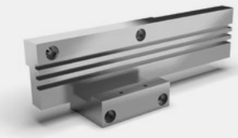
ESS ZSS

Multiple limit switches

dimensions, etc. on page 139

ESS ZSS

Mounting kit
for position monitoring, complete set



dimensions, etc. on page 139

ESS ZSS

Hydraulic accessories

Hydraulic unit single

dimensions, etc. on 140

NCS ESS MFS UNI

Hydraulic unit 1-circuit

dimensions, etc. on 140

NCS ESS MFS UNI

Hydraulic unit 2-circuit

dimensions, etc. on 140

NCS ESS MFS UNI

Pressure gauge

dimensions, etc. on 140

NCS ESS MFS UNI

Control box

dimensions, etc. on 141

NCS ESS MFS UNI

Hydraulic hose with quick-release coupling

dimensions, etc. on 141

NCS ESS MFS UNI

Pressure booster

dimensions, etc. on 141

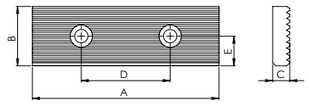
NCS ESS UNI

Pressure booster with medium converter

dimensions, etc. on 141

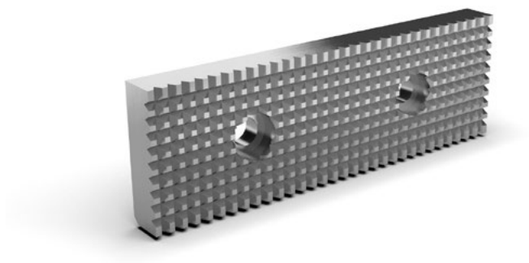
NCS ESS MFS UNI

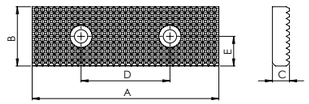
Screw-in jaw
longitudinally knurled



Size	Order No.	A	B*	C*	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210500	66	20	7.5	34	10		✓	✓			✓	
80	02310500	81	25	7.5	38	12.5		✓	✓	✓		✓	✓
100	02410500	101	30	9.5	43	15		✓	✓	✓	✓		
125	02510500	126	40	11.5	60	20		✓	✓	✓	✓	✓	
160	02610500	160	44	14.5	80	22		✓		✓			

Screw-in jaw
knurled longitudinally and crosswise

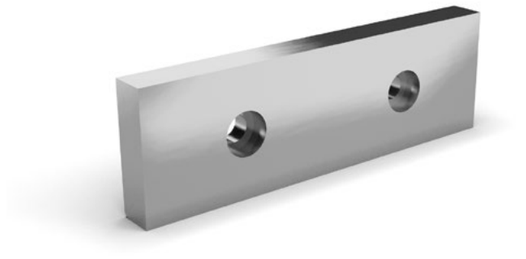


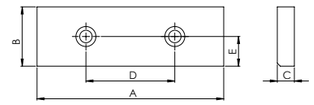


Size	Order No.	A	B*	C*	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210501	66	20	7.5	34	10		✓	✓			✓	
80	02310501	81	25	7.5	38	12.5		✓	✓	✓		✓	✓
100	02410501	101	30	9.5	43	15		✓	✓	✓	✓		
125	02510501	126	40	11.5	60	20		✓	✓	✓	✓	✓	
160	02610501	160	44	14.5	80	22		✓		✓			

KOHN Spannwerkzeuge
solid. connections.

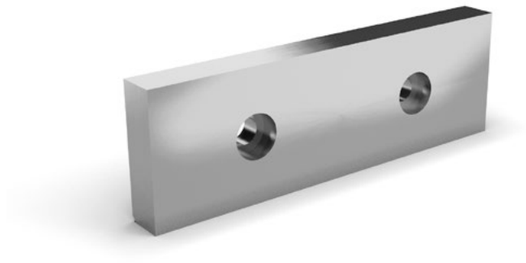
Screw-in jaw
smooth

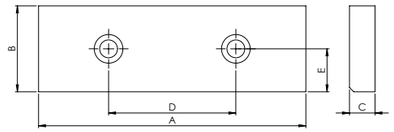




Size	Order No.	A	B*	C*	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210502	66	20	7.5	34	10		✓	✓			✓	
80	02310502	81	25	7.5	38	12.5		✓	✓	✓		✓	✓
100	02410502	101	30	9.5	43	15		✓	✓	✓	✓		
125	02510502	126	40	11.5	60	20		✓	✓	✓	✓	✓	
160	02610502	160	44	14.5	80	22		✓		✓			

Soft clamping jaw
with grinding allowance



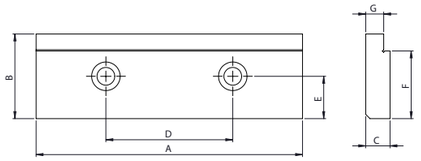


Size	Order No.	A	B	C	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210503	66	20.5	8	34	10.2		✓	✓			✓	
80	02310503	81	25.5	8	38	12.7		✓	✓	✓		✓	✓
100	02410503	101	30.5	10	43	15.2		✓	✓	✓	✓		
125	02510503	126	40.5	12	60	20.2		✓	✓	✓	✓	✓	
125	09520504	125	43.4	15.4	80	16	✓						
160	02610503	160	44.5	15	80	22.2		✓		✓			

*Dimensions ± 0.01 mm

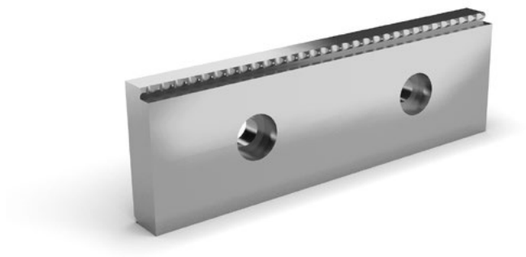
Stepped jaw

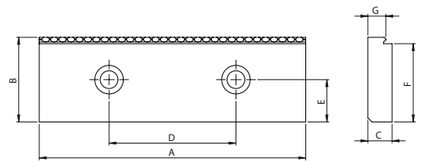
Other steps available upon request.



Size	Order No.	A	B*	C*	D	E	F*	G*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210504	66	20	7.5	34	10	16	4.5		✓	✓			✓	
80	02310510	81	25	7.5	38	12.5	21	4.5		✓	✓	✓		✓	✓
100	02410504	101	30	9.5	43	15	25	6.5		✓	✓	✓	✓		
125	02510504	126	40	11.5	60	20	32	8.5		✓	✓	✓	✓	✓	
125	09510504	125	43	11.5	80	16	35	8.5	✓						
160	02610504	160	44	14.5	80	22	34	11.5		✓		✓			

Grip stepped jaw

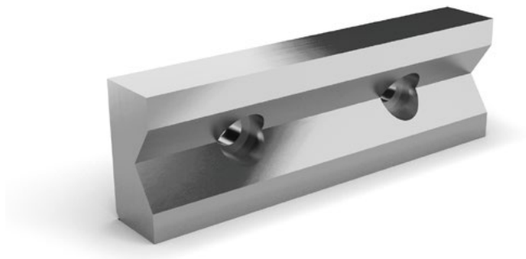




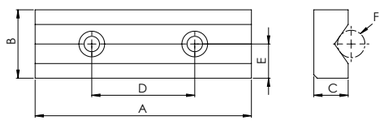
Size	Order No.	A	B*	C*	D	E	F	G	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	02310511	81	25	7.5	38	12.5	22	4.5		✓	✓	✓		✓	✓
100	02410511	101	30	9.5	43	15	27	6.5		✓	✓	✓	✓		
125	02510511	126	40	11.5	60	20	37	8.5		✓	✓	✓	✓	✓	
125	09510511	125	43	11.5	80	16	40	8.5	✓						
160	02610511	160	44	14.5	80	22	41	11.5		✓		✓			

Prismatic jaw

Prisms with 110 °



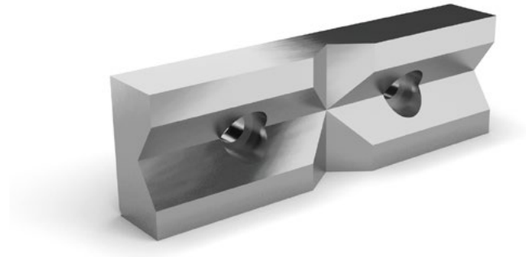
For using a prismatic jaw and a smooth jaw.



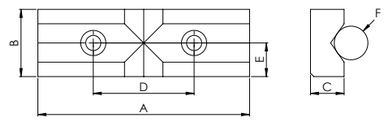
Size	Order No.	A	B*	C*	D	E*	F	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210509	66	20	12.5	34	10	5-25		✓	✓			✓	
80	02310509	81	25	12.5	38	12.5	5-25		✓	✓	✓		✓	✓
100	02410509	101	30	14.5	43	15	7-34		✓	✓	✓	✓		
125	08530509	126	40	20	60	20	8-38		✓	✓	✓	✓	✓	
125	09510509	125	43	20	80	16	8-38	✓						

Prismatic jaw

horizontal and vertical, prisms with 110°



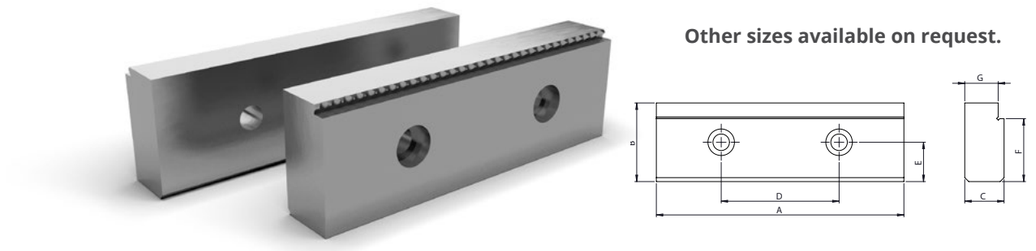
For using a prismatic jaw and a smooth jaw.



Size	Order No.	A	B*	C*	D	E*	F	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210509V	66	20	12.5	34	10	5-25		✓	✓			✓	
80	02310509V	81	25	12.5	38	12.5	5-25		✓	✓	✓		✓	✓
100	02410509V	101	30	14.5	43	15	7-34		✓	✓	✓	✓		
125	08530509V	126	40	20	60	20	8-38		✓	✓	✓	✓	✓	
125	09510509S	125	43	20	80	16	8-38	✓						

*Dimensions ± 0.01 mm

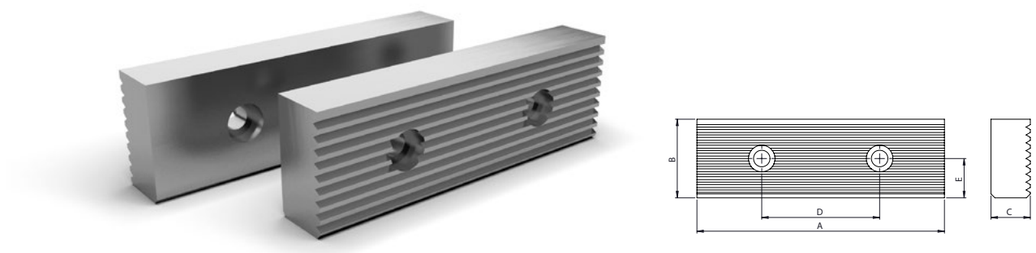
Reversible screw-in jaw
1 side with grip step, 1 side smooth



Other sizes available on request.

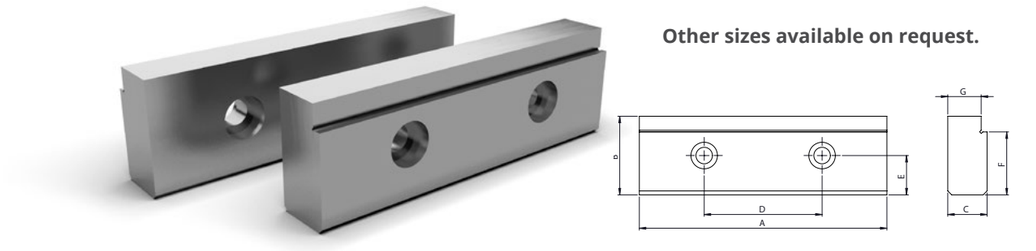
Size	Order No.	A	B*	C*	D	E	F	G	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08510511	126	40	20	60	20	37	17		✓	✓	✓		✓	

Reversible screw-in jaw
1 side knurled longitudinally, 1 side smooth



Size	Order No.	A	B*	C*	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08530500	126	40	20	60	20		✓	✓	✓		✓	

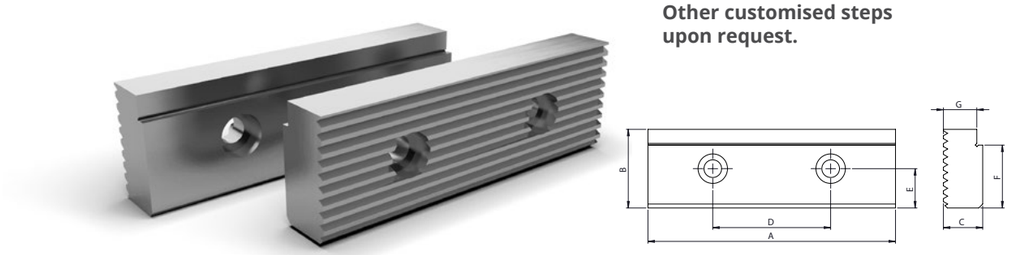
Reversible screw-in jaw
1 side with step, 1 side smooth



Other sizes available on request.

Size	Order No.	A	B*	C*	D	E	F*	G*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08530504	126	40	20	60	20	32	17		✓	✓	✓		✓	

Reversible screw-in jaw
1 side with step, 1 side knurled longitudinally

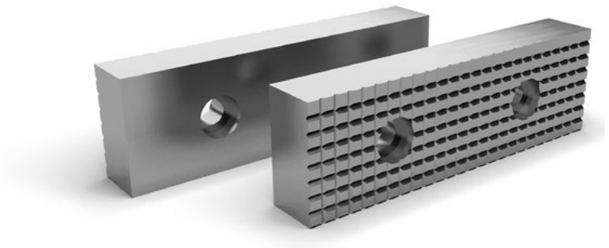


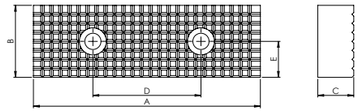
Other customised steps upon request.

Size	Order No.	A	B*	C*	D	E	F*	G*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08530506	126	40	20	60	20	32	17		✓	✓	✓		✓	

*Dimensions ± 0.01 mm

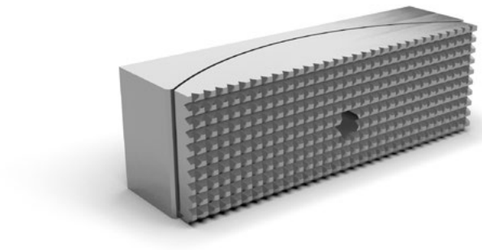
Reversible screw-in jaw
1 side with longitudinal and cross knurls, 1 side smooth

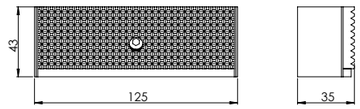




Size	Order No.	A	B*	C*	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08530507	126	40	20	60	20		✓	✓	✓		✓	
125	09520500	125	43	15	80	16	✓						

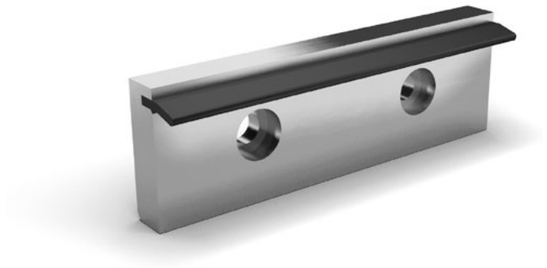
Swing jaw

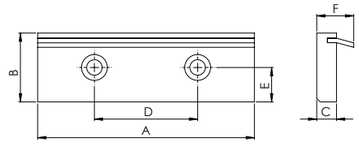




Size	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	09510001	✓						

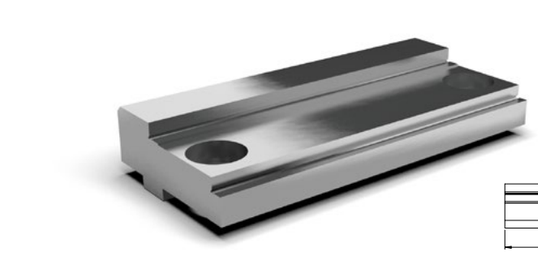
Pull-down jaw
with spring leaf

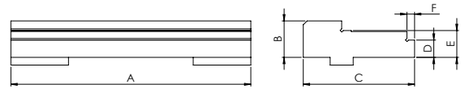




Size	Order No.	A	B*	C	D	E	F	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210505	66	20	7.5	34	10	17.5		✓	✓			✓	
80	02310505	81	25	7.5	38	12.5	17.5		✓	✓	✓		✓	
100	02410505	101	30	9.5	43	15	19.5		✓	✓	✓	✓		
125	02510505	126	40	11.5	60	20	21.5		✓	✓	✓	✓	✓	
125	09520505	125	43	11.5	80	16	21.5	✓						
160	02610505	161	44	14.5	80	22	24.5		✓					

Stepped jaw attachment



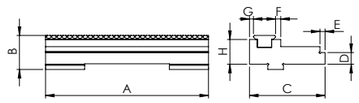


Size	Order No.	A	B	C	D*	E*	F	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	08330510	80	16.5	48	6.5	11.5	4		✓	✓	✓			
100	08430510	100	16.5	48	6.5	11.5	4		✓	✓	✓			
125	08530510	125	19	58	9	14	4	✓	✓	✓	✓			
160	08630510	160	22	64	12	17	4		✓		✓			

*Dimensions ± 0.01 mm

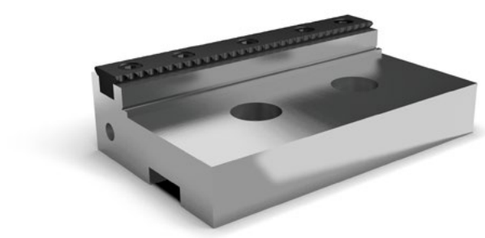
Stepped jaw attachment
with grip bar

Various grip bars can be mounted.

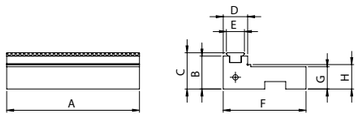


Size	Order No.	A	B	C	D*	E	F	G	H*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	02310026	80	23.6	48	6.5	4	3	3	16.5		✓	✓	✓			
100	02410026	100	23.6	48	6.5	4	3	3	16.5		✓	✓	✓			
125	02510026	125	26.1	58	9	4	4	3	19	✓	✓	✓	✓			
160	02610026	160	29.1	64	12	4	4	3	22		✓		✓			

Stepped jaw attachment
with grip bar



Various grip bars can be mounted.

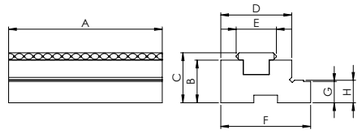


Size	Order No.	A	B*	C	D	E	F	G	H*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
100	03410029	100	31	34.1	23	17	65	20	22					✓		
125	03510029	125	31	34.1	23	17	78	21	23					✓		

KOHN Spannwerkzeuge
solid. connections.

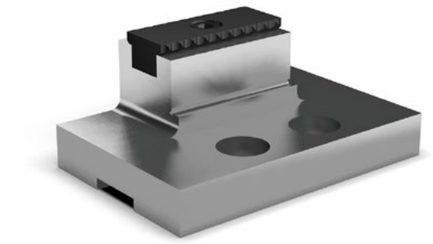
Stepped jaw attachment
with grip bar

Various grip bars can be mounted.

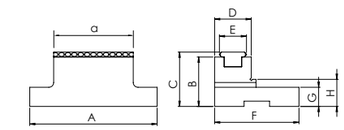


Size	Order No.	A	B*	C	D	E	F	G	H*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	03210011	65	18	21	30	17	38	9	9.5						✓	
65/80	03210013	80	18	21	30	17	38	9	9.5						✓	

Stepped jaw attachment
with grip bar



Various grip bars can be mounted.

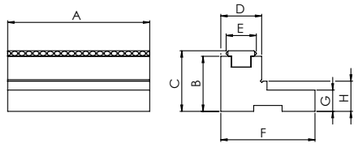


Size	Order No.	A/a	B*	C	D	E	F	G	H*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80/40	03310024	80/40	31	34	23	17	53	12	17						✓	✓
80/50	03310025	80/50	31	34	23	17	53	12	17						✓	✓

*Dimensions ± 0.01 mm

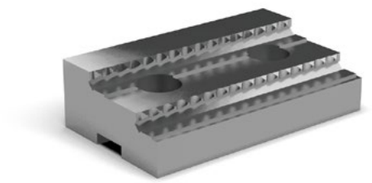
Stepped jaw attachment
with grip bar

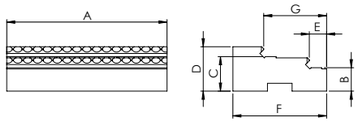
Various grip bars can be mounted.



Size	Order No.	A	B*	C	D	E	F	G	H*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	03310535P	80	31	34	23	17	53	12	17						✓	✓
80	03310026	100	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						✓	

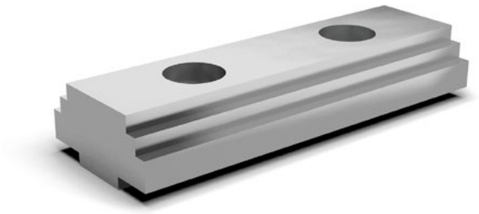
Stepped jaw attachment
with grip





Size	Order No.	A	B	C	D	E	F	G	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	03210015	65	9.5	14	18	7	38	25.5						✓	

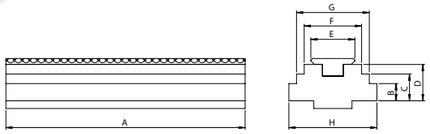
Stepped jaw attachment
for central jaw



Size	Order No.	A	B*	C*	D	E*	F*	G	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	08330520	80	6.5	11.5	16.5	24	32	40			✓	✓			
100	08430520	100	6.5	11.5	16.5	24	32	40			✓	✓			
125	08530520	125	9	14	19	30	38	46			✓	✓			
160	08630520	160	12	17	22	44	52	60				✓			

Stepped jaw attachment
for central jaw with grip bar

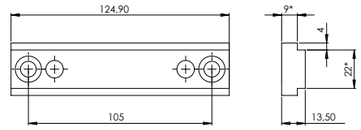
Various grip bars can be mounted.



Size	Order No.	A	B*	C*	D	E	F*	G*	H	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	08330522	80	6.5	11.5	16.5	20	24	32	40			✓	✓			
100	08430522	100	6.5	11.5	16.5	20	24	32	40			✓	✓			
125	08530522	125	9	14	19	23	30	38	46			✓	✓			
160	08630522	125	12	17	22	17	23	52	60				✓			

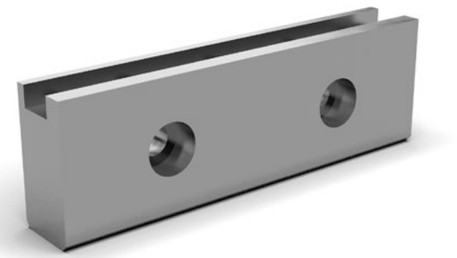
*Dimensions ± 0.01 mm

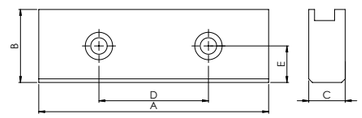
Stepped jaw attachment
for changeover slider



Size	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	09520033	✓						

Screw-in jaw
with groove for grip bar



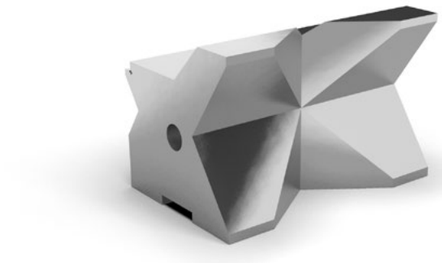


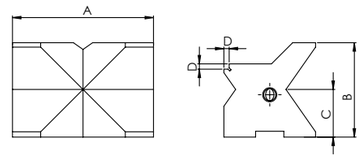
Size	Order No.	A	B*	C*	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08530511	125	40	20	60	20		✓	✓	✓			
125	09520036	125	43	20	80	16	✓						
160	02610512	160	44	20	80	22		✓		✓			

KOHN Spannwerkzeuge
solid. connections.

Prismatic jaw
(horizontal and vertical) for
5-axes, prisms with 110°

ClampØ	vertical	horizontal
Size 80	Ø 11-30	Ø 30-80

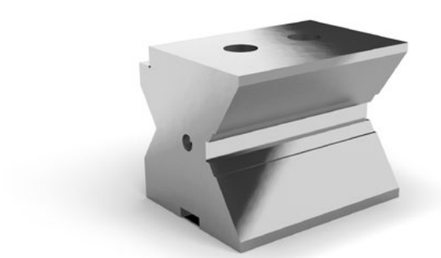


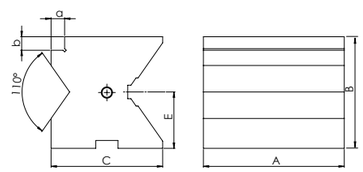


Size	Order No.	A	B	C	D	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	03310501V	80	53.5	27	3						✓	✓

Prismatic jaw
Standard

ClampØ	front	rear
Size 100	Ø 35-100	Ø 20-56
Size 125	Ø 52-150	Ø 30-80



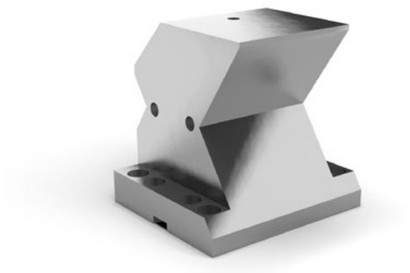


Size	A	B	C	E	a	b	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
100	100	68	58	34	10	10	03410500					✓		
125	125	99	99	50	12	12	03510500					✓		

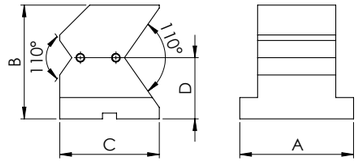
Set consisting of two prismatic jaws.

*Dimensions ± 0.01 mm

Prismatic jaw

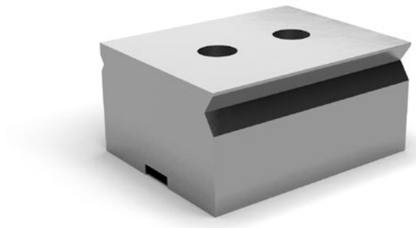


ClampØ	front	rear
Size 160	Ø 80-240	Ø 30-80

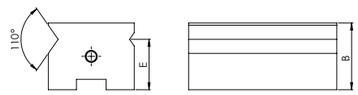


Size	Order No.	A	B	C	D	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
160	03610001S	160	160	140	86					✓		

Prismatic jaw
Ø 6 – 32



ClampØ	front	rear
Size 100	Ø 12-32	Ø 6-14
Size 125	Ø 12-32	Ø 6-13

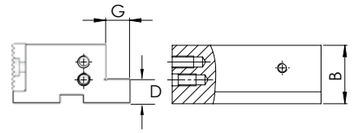


Size	B	E	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
100	45	34	03410501					✓		
125	61	50	03510501					✓		

Set consisting of two prismatic jaws.

Stepped jaw
with screw-in jaw knurled longitudinally

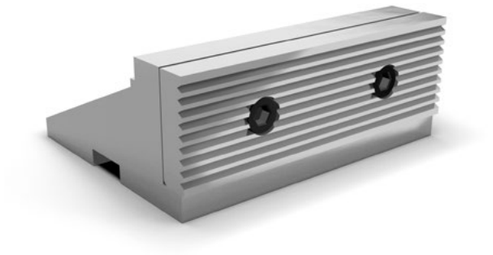
You can find other suitable screw-in jaws starting from 102.



Size	B	D	G	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
100	44	14	15	03410502					✓		
125	50	20	20	03510502					✓		

Set consisting of two stepped jaws with screw-in jaws.

Stepped jaw attachment
with screw-in jaw knurled longitudinally



You can find other suitable screw-in jaws starting from 102.

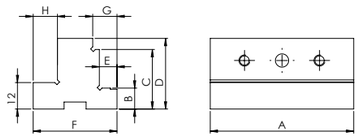
Size	B	a	b	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
100	44	3	5	03410510					✓		
125	50	3	8	03510510					✓		

Set consisting of two stepped jaws with screw-in jaws.

*Dimensions ± 0.01 mm

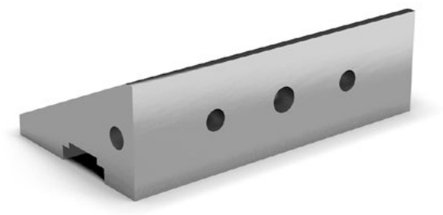
Stepped jaw - Main jaw

All screw-in jaws size 65 can be mounted. Starting from 102.

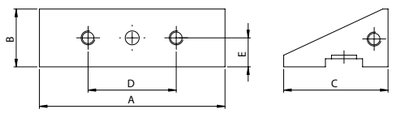


Size	Order No.	A	B*	C*	D	E	F	G	H*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	03210503	65	9.5	27	32	8	38	11	11						✓	

False main jaw



All screw-in jaws size 80 can be mounted. Starting from 102.

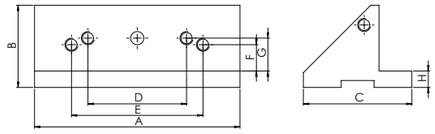


Size	Order No.	A	B	C	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	03310S511	80	25	45	38	12.5						✓	✓

KOHN Spannwerkzeuge
solid. connections.

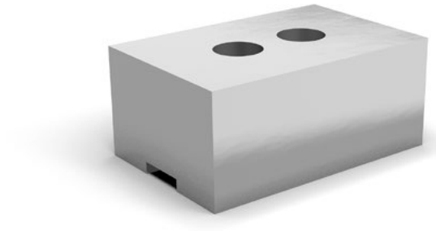
False main jaw
for 5-axis

All screw-in jaws size 125 can be mounted. Starting from 102.

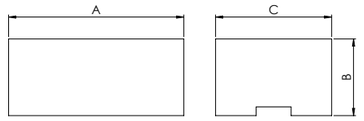


Size	Order No.	A	B	C	D	E	F	G	H	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	03510511S002	125	50	66	60	80	16	20	10						✓	

Jaw blank
made from aluminium



Other materials on request.



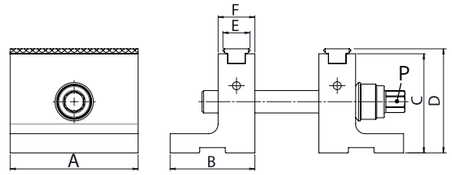
Size	Order No.	A	B	C	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	03310505	80	35	53						✓	✓
80	03310507	80	20	53						✓	✓
100	03410505	100	44	58					✓		
125	03510505	125	48	98					✓		

*Dimensions ± 0.01 mm

High stepped jaw attachment
complete set

First, workpiece is clamped with the centring spindle, then with the clamping spindle.

incl. 3 clamping spindles

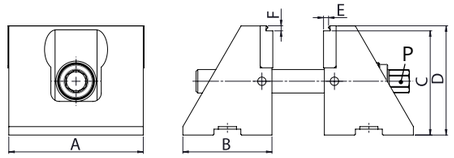


Size	Order No.	A	B	C*	D	E	F	P	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	03310027	80	53	62	65.1	17	23	12						✓	
125	03510030	125	53	90	93.1	17	23	14						✓	

High main jaw attachment
complete set

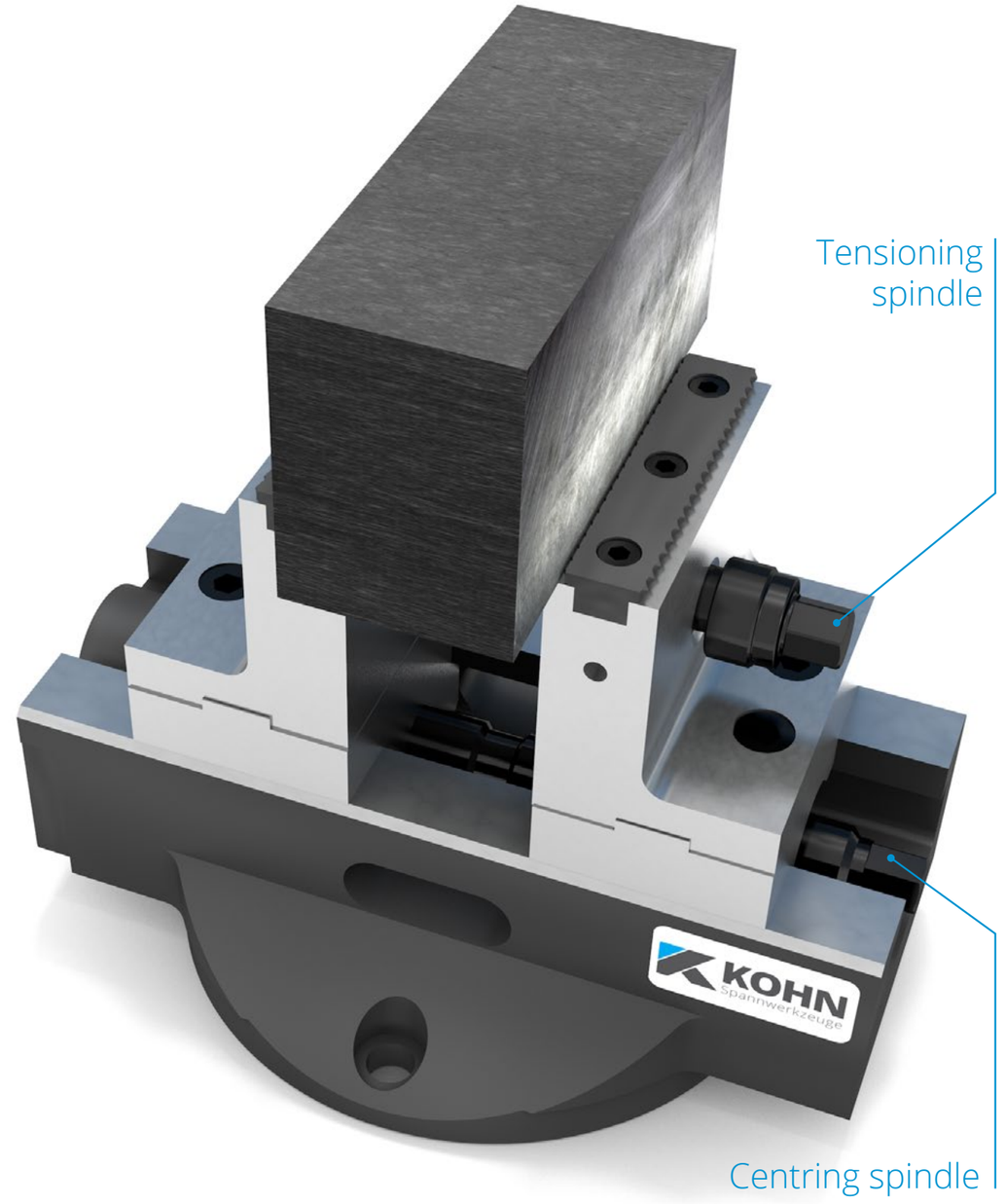
First, workpiece is clamped with the centring spindle, then with the clamping spindle.

incl. 3 clamping spindles

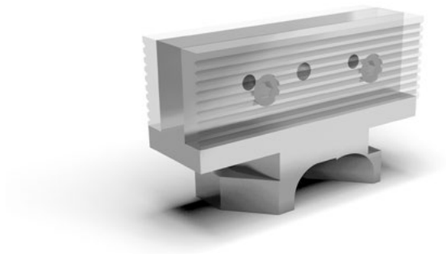


Size	Order No.	A	B	C	D	E	F	P	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	03310028	80	53	62	65	3	3	12						✓	

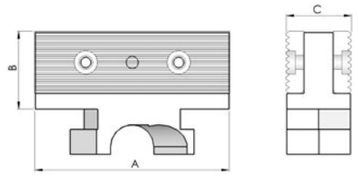
*Dimensions ± 0.01 mm



Changeover slider
without screw-in jaws

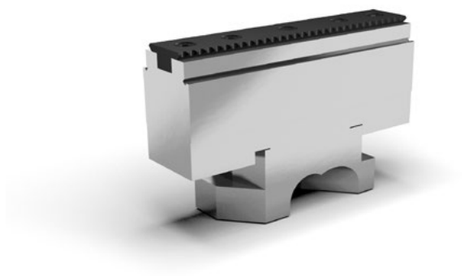


Changeover sliders enable multi-clamping for workpieces. No tools required for assembly.



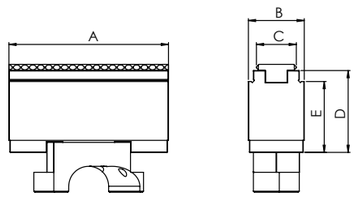
Size	Order No.	A	B	C ±0.02	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	02310030	80	32	30		✓	✓	✓			
100	02410030	100	44	36		✓	✓	✓			
125	02510030	125	50	42		✓	✓	✓			
160	02610030	160	54	52		✓		✓			

Changeover slider
complete set with grip bar



Changeover sliders enable multi-clamping for workpieces. No tools required for assembly.

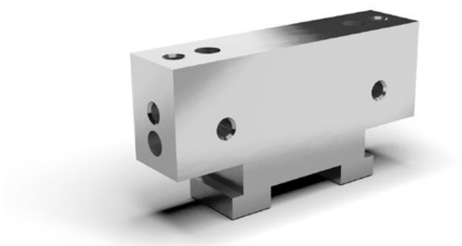
Form-locked clamping of workpieces up to 35 HRC.



Size	Order No.	A	B	C	D*	E*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	03310234G	80	28	20	47	33						✓	✓
125	03510234G	125	35	23	48	40						✓	

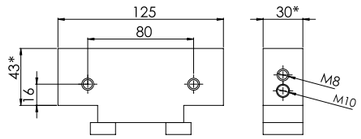
KOHN Spannwerkzeuge
solid. connections.

Changeover slider



- ✓ hardened and ground
- ✓ without screw-in jaws

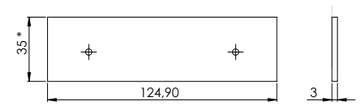
Changeover sliders enable multi-clamping for workpieces. No tools required for assembly



Size	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	09520030	✓						

Shim strip
for changeover slider (NCS) nitrified

Can be used as a stepped jaw.

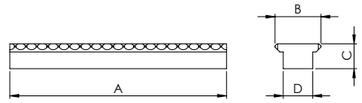


Size	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	09520031	✓						

*Dimensions ± 0.01 mm

Grip bar
with grip on both sides

Form-locked clamping of workpieces up to 35 HRC.

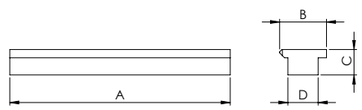


Size	Order No.	A	B	C	D	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	03210002	65	17	9.2	11						✓	
80	03310550	80	17	9.2	11		✓	✓	✓		✓	✓
80	03310551*	80	20	9.2	11						✓	✓
80/40	03310040	40	17	9.2	11						✓	✓
80/50	03310050	50	17	9.2	11						✓	✓
100	03310100	100	17	9.2	11		✓	✓	✓	✓	✓	✓
125	03510550	125	17	9.2	11	✓	✓	✓	✓	✓	✓	✓
125	03510551*	125	23	9.2	11						✓	
160	02610550	160	17	9.2	11		✓		✓			

False stepped jaw for changeover slider

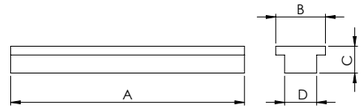
Grip bar
one side with grip, one side smooth

Form-locked clamping of workpieces up to 35 HRC.



Size	Order No.	A	B	C	D	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	03210552	65	17	9.2	11						✓	
80	03310552	80	17	9.2	11		✓	✓	✓		✓	✓
80/40	033140552	40	17	9.2	11						✓	✓
80/50	033150552	50	17	9.2	11						✓	✓
100	03410552	100	17	9.2	11		✓	✓	✓	✓	✓	✓
125	03510552	125	17	9.2	11	✓	✓	✓	✓	✓	✓	✓

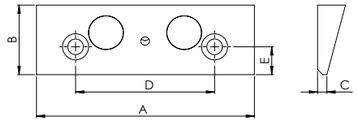
Insert
smooth on both sides



Size	Order No.	A	B	C	D	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	03210553	65	17	9.2	11						✓	
80	03310553	80	17	9.2	11		✓	✓	✓		✓	✓
80	03310554*	80	20	9.2	11						✓	✓
80/40	03310558	40	17	9.2	11						✓	✓
80/50	03310557	50	17	9.2	11						✓	✓
100	03410553	100	17	9.2	11		✓	✓	✓	✓	✓	✓
125	03510553	125	17	9.2	11	✓	✓	✓	✓	✓	✓	✓
125	03510554*	125	23	9.2	11						✓	

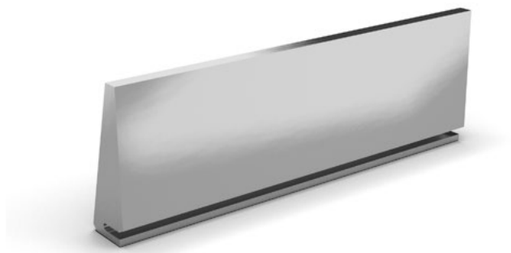
False stepped jaw for changeover slider

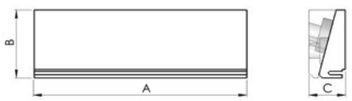
Main jaw
with two permanent magnets



Size	Order No.	A	B*	C	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08520502	125	40	6	80	16		✓	✓	✓		✓	
125	07520502	125	43	6	80	16	✓						

Smooth exchangeable jaw
for machined workpieces

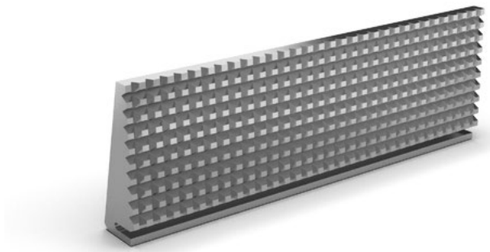


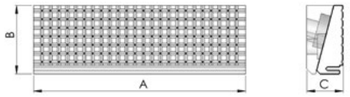


Size	Order No.	A	B*	C	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08520505	125	40	21.5		✓	✓	✓		✓	
125	07520505	125	43	21.5	✓						

KOHN Spannwerkzeuge
solid. connections.

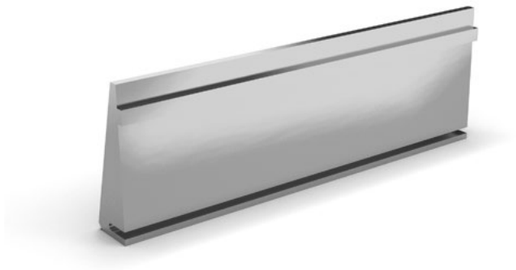
Ribbed exchangeable jaw
for raw work pieces

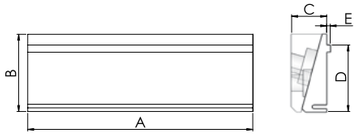




Size	Order No.	A	B*	C	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08520508	125	40	21.5		✓	✓	✓		✓	
125	07520508	125	43	21.5	✓						

Line exchangeable jaw
for machined workpieces with angle errors

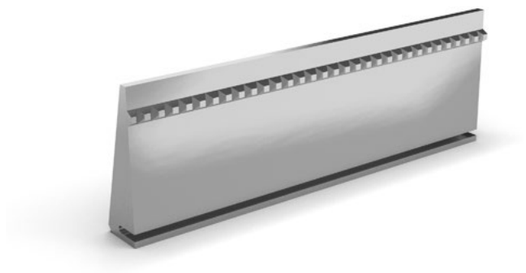


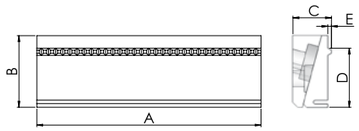


Size	Order No.	A	B*	C	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08520511	125	40	21.5	33	2		✓	✓	✓		✓	
125	07520521	125	43	21.5	37	2	✓						

*Dimensions ± 0.01 mm

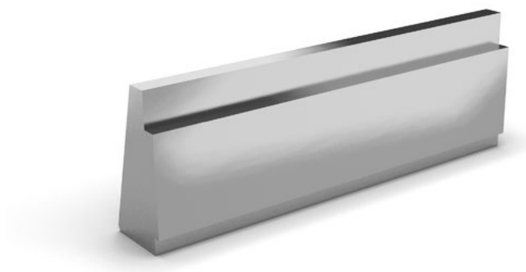
Ribbed line exchangeable jaw
for raw workpieces with angle errors



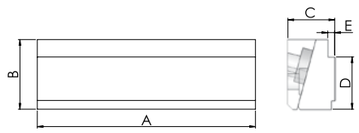


Size	Order No.	A	B*	C	D	E	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08520514	125	40	21.5	33	2		✓	✓	✓		✓	
125	07520522	125	43	21.5	37	2	✓						

Exchangeable stepped jaw

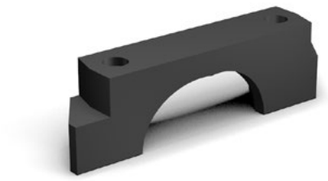


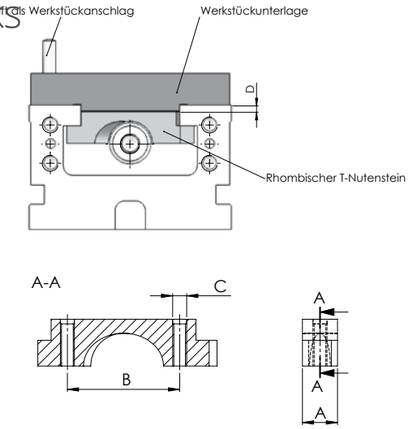
Other customised steps
available upon request



Size	Order No.	A	B*	C	D*	E*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	08520517	125	40	26.9	30	4		✓	✓	✓		✓	
125	07520517	125	43	26.9	33	4	✓						

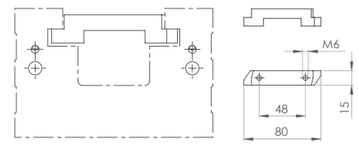
Rhombic T-shaped tenon blocks
for secure fastening
of workpiece material





Size	Order No.	A	B	C	D	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210700	8	25	M4	4		✓	✓				
80	02310700	10	34	M5	4.5		✓	✓	✓		✓	✓
100	02410700	12	37	M5	3		✓	✓	✓			
125	02510700	15	48	M6	4		✓	✓	✓		✓	
160	02610700	18	75	M6	4		✓		✓			

Rhombic T-shaped tenon block
for secure fastening of workpiece material

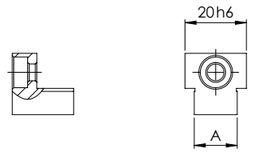


Size	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
125	09522700	✓						

*Dimensions ± 0.01 mm

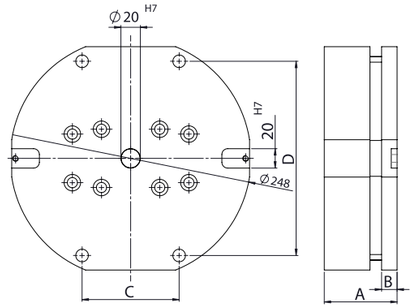
Tenon block

for quick and accurate positioning of the vice on the machine table.



Size	Order No.	A	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
20 h6	01310800	14 h6	✓	✓	✓	✓	✓		
20 h6	01310801	18 h6	✓	✓	✓	✓	✓		
20 h6	01310802	20 h6	✓	✓	✓	✓	✓		
20 h6	01310803	22 h6	✓	✓	✓	✓	✓		
20 h6	01310804	16 h6	✓	✓	✓	✓	✓		

Console

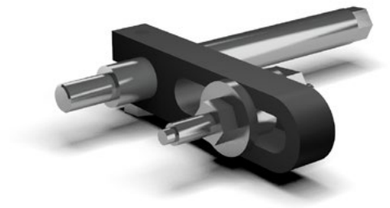


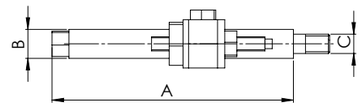
Size	Order No.	A*	B	C	D	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65 / 80 / 125	104100000018	75	16	100	200						✓	

*Dimensions ± 0.01 mm

Workpiece stop

is attached to the vice, in the clamping slider or in the central jaw

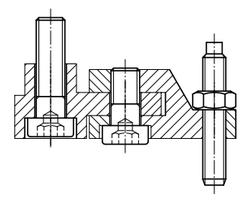




Size	Order No.	A	B	C	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210701	65	8	M6		✓	✓				
80	02310701	80	10	M7		✓	✓	✓			
100	02410701	100	12	M8		✓	✓	✓	✓		
125	02510701	125	16	M10	✓	✓	✓	✓	✓		

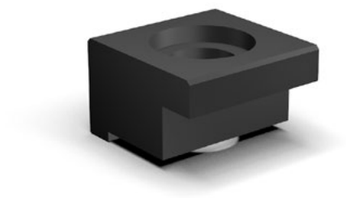
Joint stop

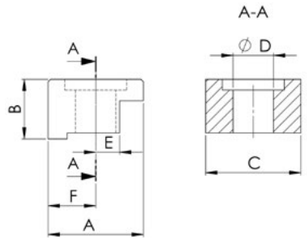
The joint stop is attached to the central jaw or the clamping slider



Size	Order No.	Thread	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	02310709	M6		✓	✓	✓		✓	
100/125	02510709	M8		✓	✓	✓	✓	✓	
NCS/160	09520709	M10	✓	✓		✓			

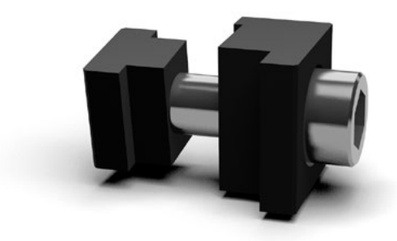
Metal clamp
for attaching the vice to the machine table





Size	Order No.	A	B	C	D	E	F	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
65	02210710	30	16	23	11	7	16		✓	✓				
80	02310710	30	20	28	11	7	14		✓	✓	✓		✓	
100	02410710	35	20	32	13	8	18		✓	✓	✓	✓		
125	02510710	40	25	38	17	10	20	✓	✓	✓	✓	✓	✓	

Metal clamp set
suitable for clamping vices with a jaw width of 125



each consisting of 4x:

✓ metal clamps
✓ Nut for T-slot
✓ fixing screw

Note:
Other quantities required for larger bed lengths.

Other jaw widths and sizes available upon request

Size	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
Table slot 14	09540900	✓	✓	✓	✓	✓	✓	
Table slot 18	09540901	✓	✓	✓	✓	✓	✓	
Table slot 20	09540903	✓	✓	✓	✓	✓	✓	
Table slot 22	09540902	✓	✓	✓	✓	✓	✓	

Hand crank straight

Size	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
SW 10	02210660		✓	✓			✓	
SW 12	02310660		✓	✓	✓		✓	✓
SW 14	02410660		✓	✓	✓		✓	
SW 17	02510660		✓	✓	✓	✓		
SW 19	07520660		✓		✓	✓		

Hand crank bent

Size	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
SW 10	03210662		✓	✓			✓	
SW 12	08310662		✓	✓	✓		✓	✓
SW 14	02410662		✓	✓	✓		✓	
SW 17	07520664		✓	✓	✓	✓		
SW 19	07520662		✓		✓	✓		

Double ended socket wrench

Size	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
SW 10	K03210		✓	✓			✓	
SW 12	K03312		✓	✓	✓		✓	✓

Special combination wrench (ratchet)

for size	Order No.	SW	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	08330013	SW9		✓		✓			
100	08430013	WAF10		✓	✓	✓			
125	08530013	AF14		✓	✓	✓			

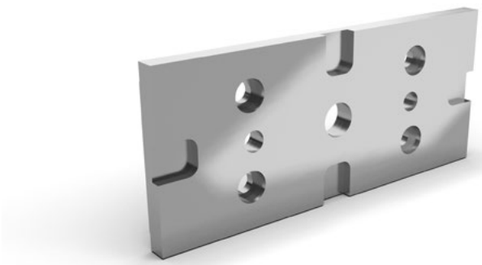
Torque wrench ½“
and nut driver inserts

Torque wrench with 20-200 Nm adjustment range (with left and right selector / clamping and release) for a controlled clamping force during tightening.

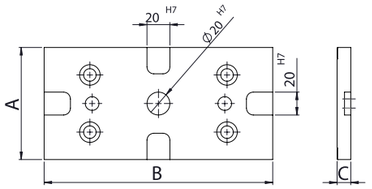
Type	Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
Torque wrench ½“	10100015	✓	✓	✓	✓	✓	✓	✓
SW 10 nut driver insert	10100006							
SW 12 nut driver insert	10100005							
SW 14 nut driver insert	10100004							
SW 17 nut driver insert	10100008							

By specifying the vice type (for example, ZSS 80) we supply suitable nut driver insert

Base



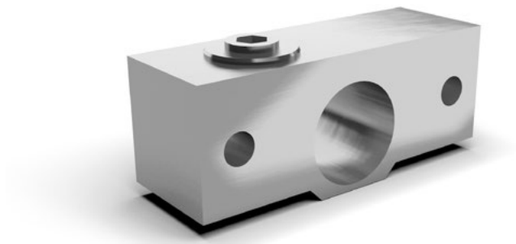
Base as an adapter between vice and machine table.



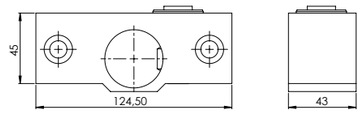
Size	Order No.	A	B	C*	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
80	033101041	98	200	12						✓	
80	033101042	98	230	12						✓	
80	033101043	98	246	12						✓	
80	033101044	98	315	12						✓	
125	035101041	147	245	16						✓	
125	035101042	147	315	16						✓	

*Dimensions ± 0.01 mm

Angle drive

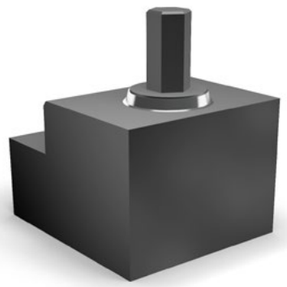


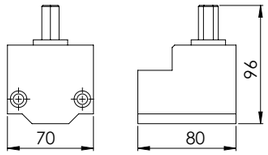
Protrudes at maximum spans over the bottom part.



Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
09520800	✓						

Angle drive
for MFS-HD

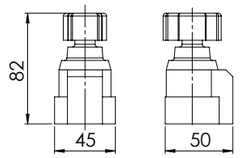




Order No.	for type	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
08330800	MFS 80 HD				✓			
08430800	MFS 100 HD				✓			
08530800	MFS 125 HD				✓			

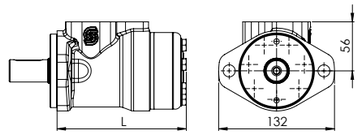
Hand-seat valve

Mechanical operation directly on the vice. The design of the hand-seat valve matches the application.



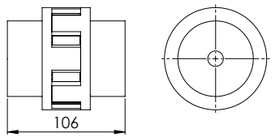
Order No.	for type	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
10054050	D 3-1 R	✓	✓		✓			
10054053	VP 1 Z	✓	✓		✓			

OMP hydraulic motor



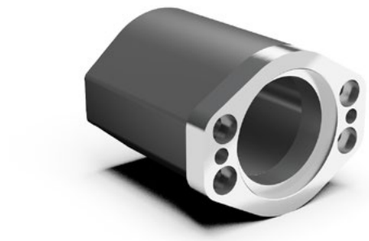
Order No.	Size	L	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
10051001	80	135		✓			✓		
10052001	100	137.5		✓			✓		
10052002	125	141		✓			✓		
10053001	160	145.5		✓			✓		

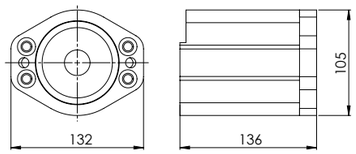
Elastic clutch



Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
K60404202		✓			✓		

Clutch body
with flange

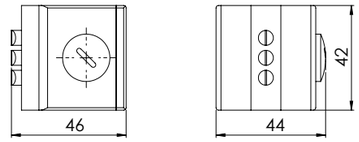




Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
03550004		✓			✓		

KOHN Spannwerkzeuge
solid. connections.

Multiple limit switches

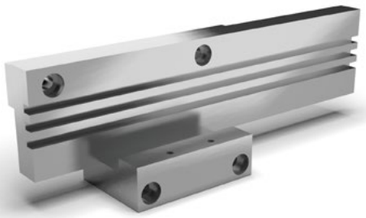


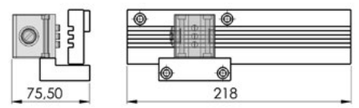
Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
K201500		✓			✓		

Mounting kit for position monitoring
complete set

consisting of:

- ✓ Mounting plate for multiple limit switches
- ✓ Groove-array
- ✓ Distance plate for groove-array
- ✓ Control cam





Order No.	NCS	ESS	DSS	MFS	ZSS	UNI	VZA
03550005		✓			✓		

Hydraulic unit
single

Order No.	10054130
Description:	hydraulic one-circuit unit **without** return valve. With pressure limiter and pressure switch.

NCS	ESS	DSS	MFS	ZSS	UNI	VZA
✓	✓		✓		✓	

Hydraulic unit
1-circuit

Order No.	10054131
Description:	hydraulic one-circuit unit **with** return valve. With pressure limiter and pressure switch.

NCS	ESS	DSS	MFS	ZSS	UNI	VZA
✓	✓		✓		✓	

Hydraulic unit
2-circuit

Order No.	10054132
Description:	Hydraulic two-circuit unit **with** return valve. With pressure limiter and pressure switch.

NCS	ESS	DSS	MFS	ZSS	UNI	VZA
✓	✓		✓		✓	

Pressure gauge

Order No.	10054072
Description:	Includes pressure gauge, straight threaded male fitting, adjustable L-fitting, adjustable W-fitting

NCS	ESS	DSS	MFS	ZSS	UNI	VZA
✓	✓		✓		✓	

Pressure booster
with medium converter

Order No.	10061022
Description:	Converts 6.5 bar of pneumatic pressure into 400 bar of hydraulic pressure. Medium converter for opening vice in MFS-HD. Compatible with vice.

NCS	ESS	DSS	MFS	ZSS	UNI	VZA
✓	✓		✓		✓	

Hydraulic hose
with quick-release coupling

Order No.	10054099
Description:	High pressure hydraulic hose up to 500 bar for connecting the vices. With wire braiding. Length available with millimetre precision.

NCS	ESS	DSS	MFS	ZSS	UNI	VZA
✓	✓		✓		✓	

Pressure booster

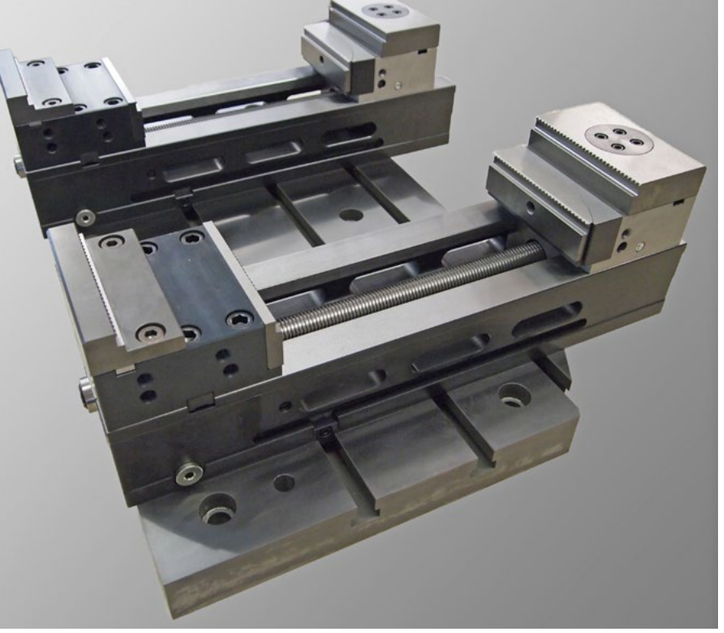
Order No.	10061021
Description:	Converts 6.5 bar of pneumatic pressure into 400 bar of hydraulic pressure. Compatible with vice.

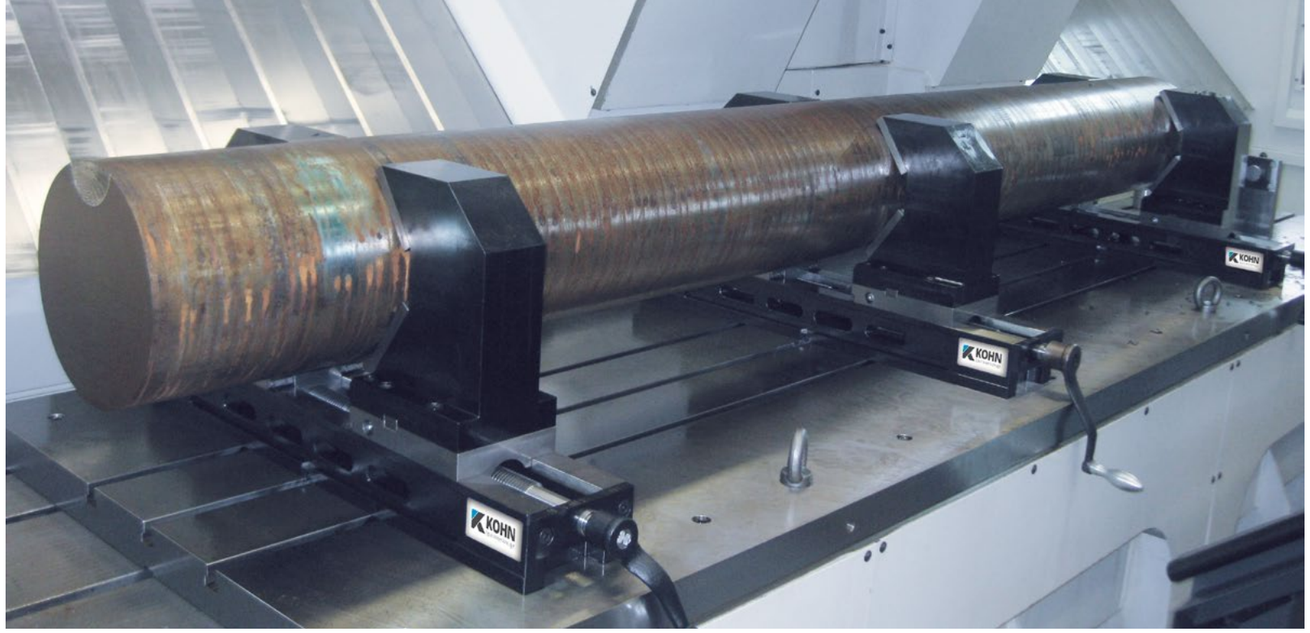
NCS	ESS	DSS	MFS	ZSS	UNI	VZA
✓	✓				✓	

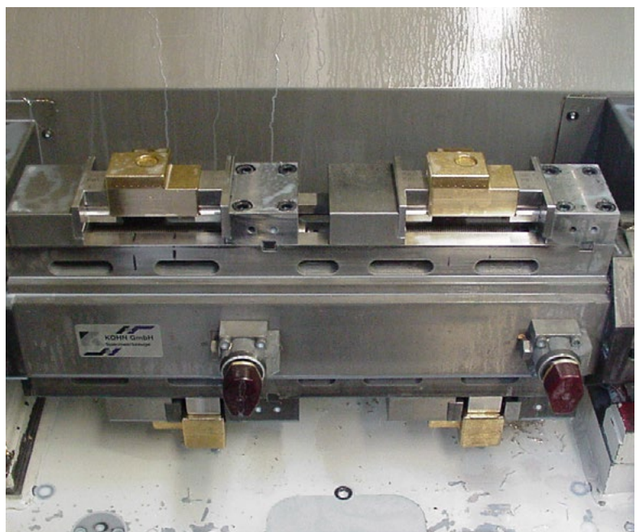
Control box

Order No.	10055300
Description:	For monitoring the hydraulic system, manual control of the vices and connection to the machine control for automatic clamping.

NCS	ESS	DSS	MFS	ZSS	UNI	VZA
✓	✓		✓		✓	







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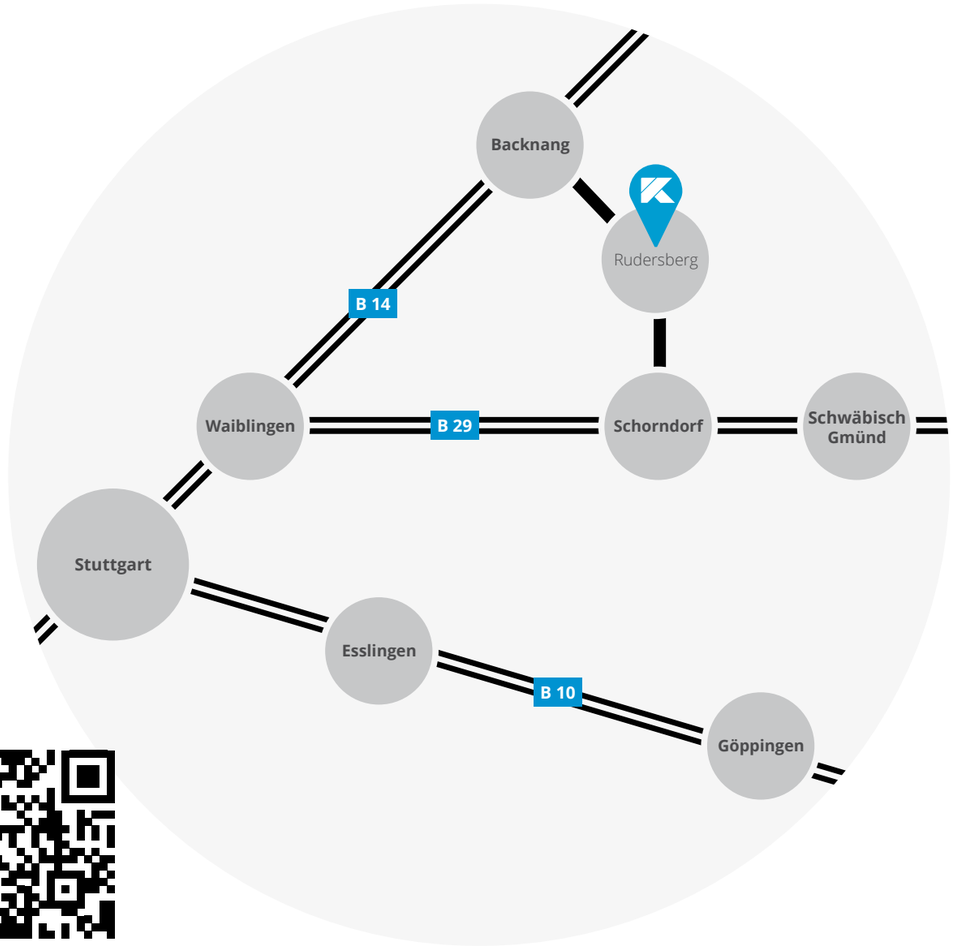
How to find us:



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KOHN Spannwerkzeuge

SKÄRPVERKTYG AB

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We look forward to hearing from you.
Your KOHN team

Your trade partner:

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