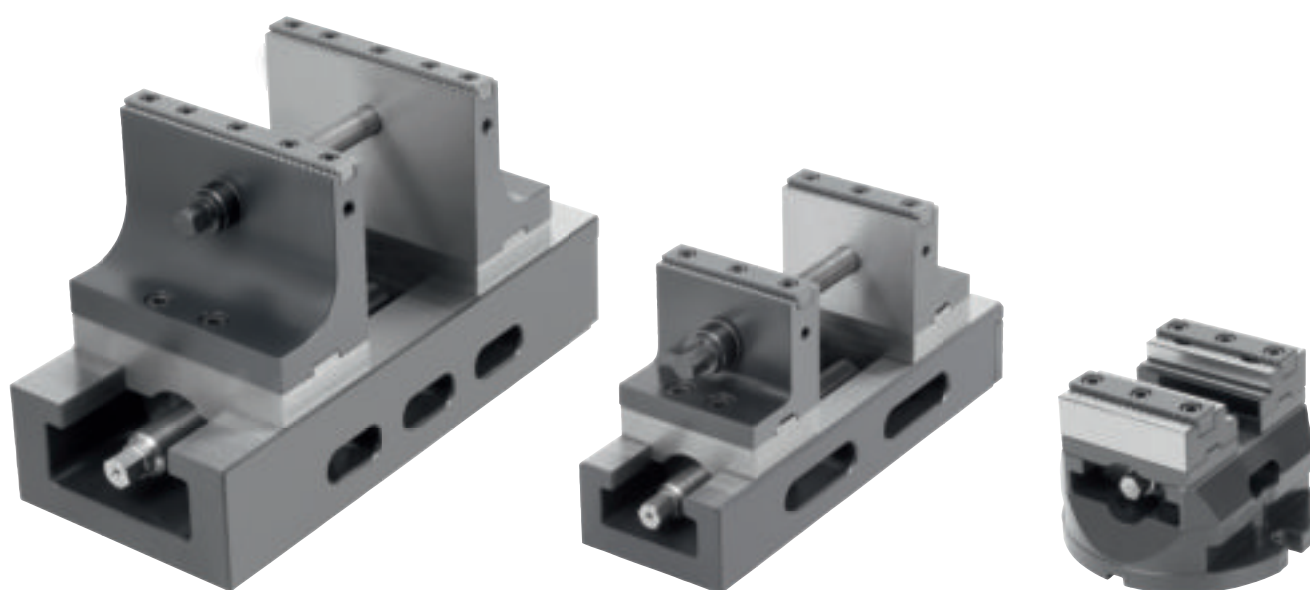


## Centric vices



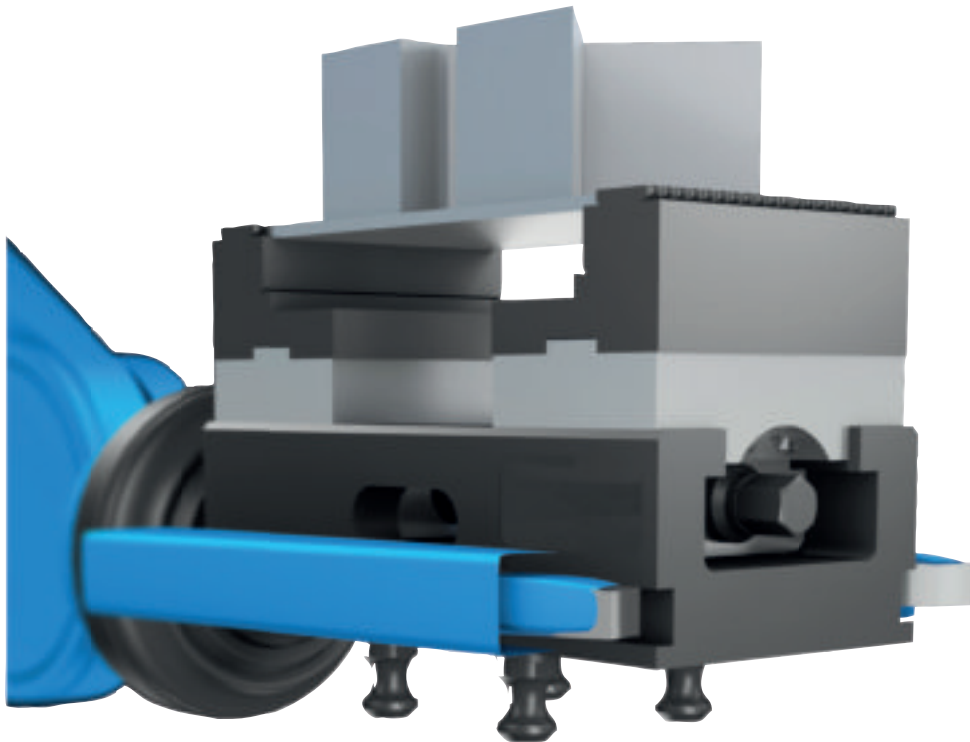
# Technical information for centric vices



Mechanically actuated centric vice

Centring precision  $\pm 0.02$  mm across the entire clamping range.

We recommend using a torque wrench for controlling the clamping force.



## Flexible connection options:

1. Support for the zero point clamping system. Fitting 25H6/M12.  
Reamed and tapped holes for fixing clamping pins for zero point clamping systems are integrated into each centric vice. These vices can therefore be used on conventional zero point clamping systems.
2. Support for handling systems / suitable for automation.  
There is also the option of transporting the centric vice using handling systems.
3. Support with adapter plate for grid system M12/Ø12F7, grid spacing 50 mm.  
Assembly with an adapter plate suitable for grid systems M12/Ø12F7 ensures flexible positioning on basic elements with a grid system.
4. Support directly on the machine table.  
Using the lateral fastening slots, the centric vices can also be fixed to the machine table as required.



# Centric vices

jaw width 65 mm



## Material:

Body and jaw holder mild steel.  
Spindle high-strength special steel.

## Version:

Body and jaw holder hardened and ground.

## Sample order:

K1236.065100

## Note for ordering:

Supplied with hexagon crank handle.  
Order jaw plates separately.

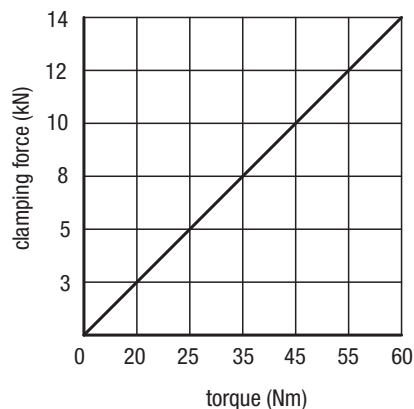
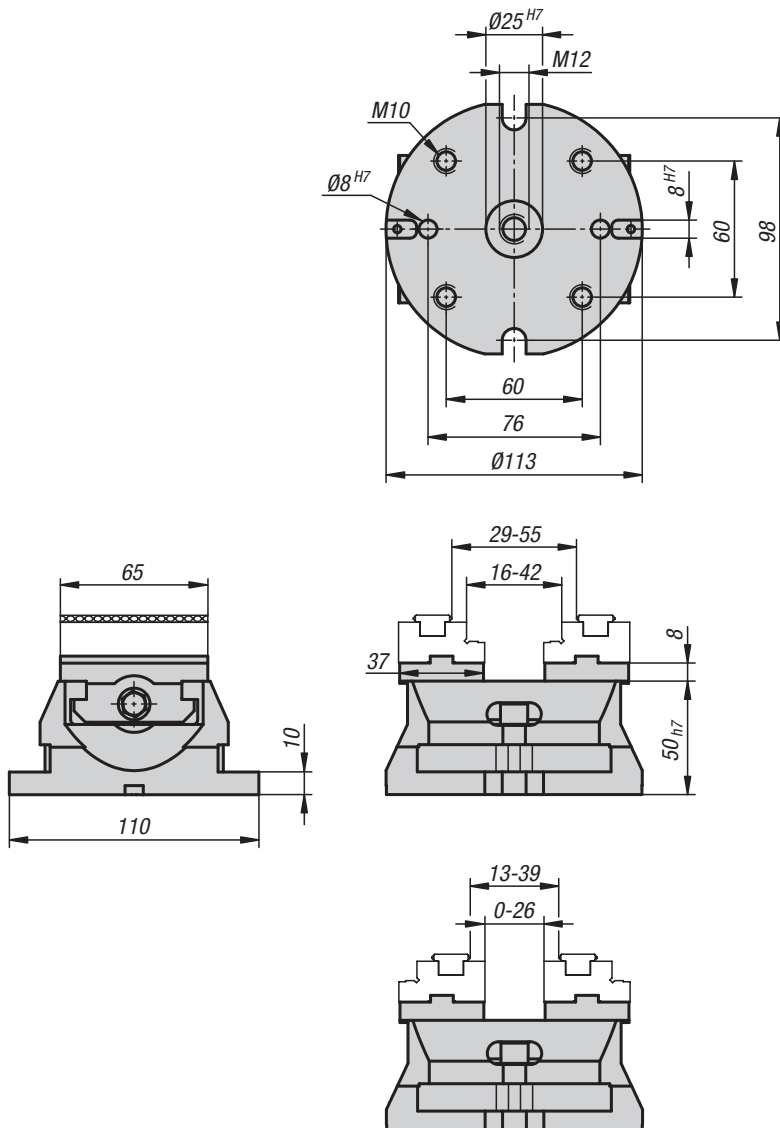
## Note:

Mechanically operated centric vice.  
Suitable for automation: prepared with gripper slot for handling systems.  
Flexible mounting: suitable for zero-point systems, mounting on machine tables or on custom systems via a baseplate.  
Centring precision:  $\pm 0.02$  mm.

The use of a torque wrench is recommended to achieve a controlled clamping force.

## Features:

- Clamping slide and spindle nut in one piece
- Slots and fastening threads for mounting attachment jaws
- Reversible jaws (accessories) with lateral thread for workpiece stop enables a wider clamping range
- Good swarf and coolant removal



## KIPP Centric vice jaw width 65 mm

Order No.	Dimensions	weight kg
K1236.065100	see drawing	3.2

# Centric vices

jaw width 80–125 mm



## Material:

Body and jaw holder mild steel.  
Spindle high-strength special steel.

## Version:

Body and jaw holder hardened and ground.

## Sample order:

K1237.080200

## Note for ordering:

Supplied with hexagon crank handle.  
Order jaw plates separately.

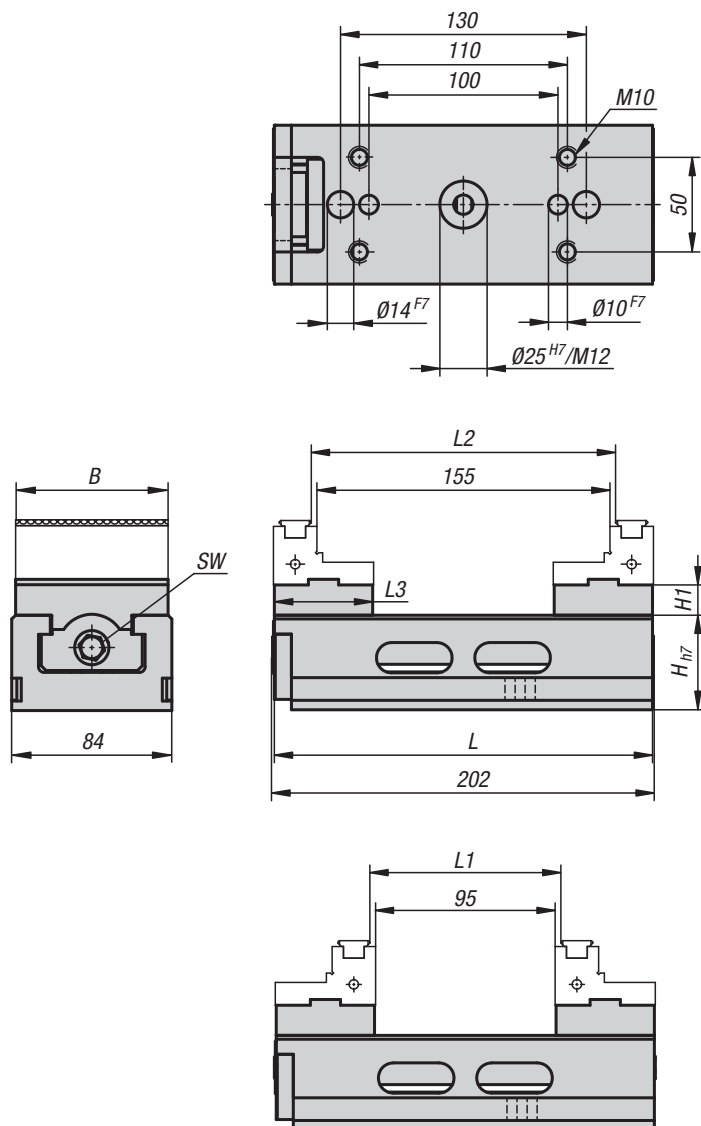
## Note:

Mechanically operated centric vice.  
Suitable for automation: prepared with gripper slot for handling systems.  
Flexible mounting: suitable for zero-point systems, mounting on machine tables or on custom systems via a baseplate.  
Centring precision:  $\pm 0.02$  mm.

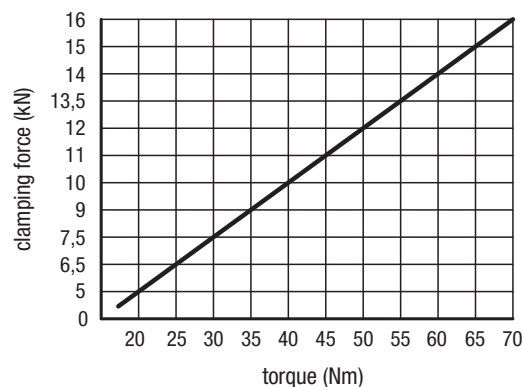
The use of a torque wrench is recommended to achieve a controlled clamping force.

## Features:

- Clamping slide and spindle nut in one piece
- Slots and fastening threads for mounting attachment jaws
- Reversible jaws (accessories) with lateral thread for workpiece stop enables a wider clamping range
- Good swarf and coolant removal



B = 80 mm

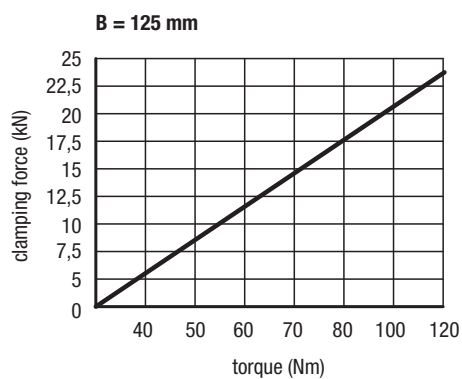
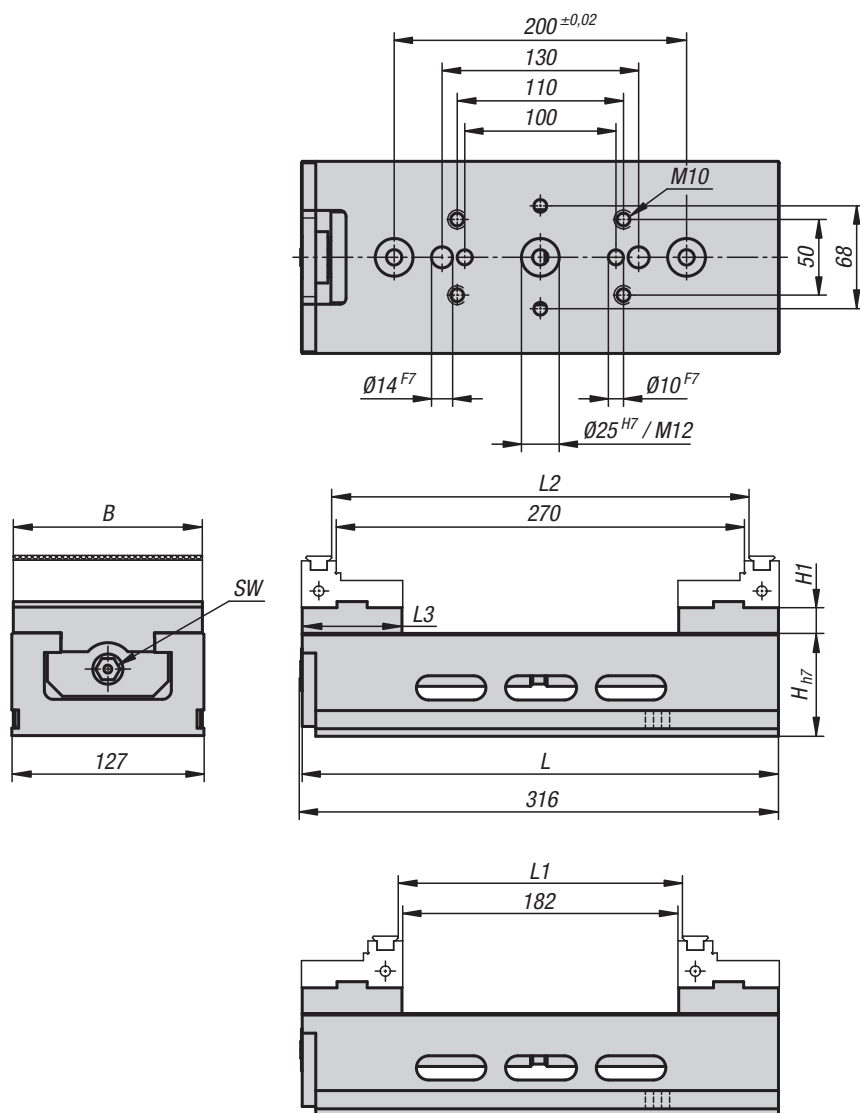


## KIPP Centric vice, jaw width 80 mm

Order No.	B	H	H1	L	L1	L2	L3	SW	weight kg
K1237.080200	80	50h7	16	200	6-101	66-161	52	12	6.7

## Centric vices

jaw width 80–125 mm

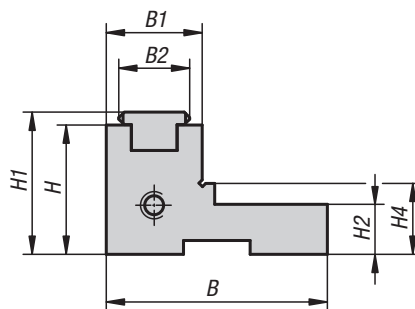
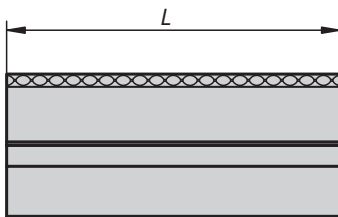


### KIPP Centric vice, jaw width 125 mm

Order No.	B	H	H1	L	L1	L2	L3	SW	weight kg
K1237.125315	125	62h7	17	315	6-188	94-276	66	14	15.5

# Attachment jaws

stepped, with grip rail



## Material, version:

Step jaw steel, hardened, clamping surfaces ground.  
Grip rail steel, hardened

## Sample order:

K0587.0801

## Note:

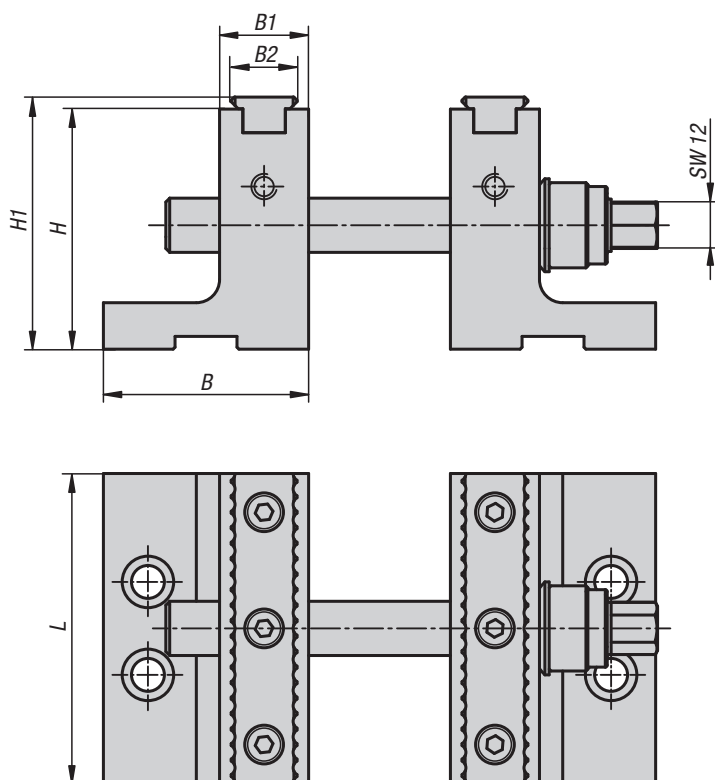
These attachment step jaws are suitable for centric vices. The clamping width can be increased or decreased by reversing the jaws. The gripper jaw pads can also be exchanged for smooth jaw pads.

## KIPP Attachment jaws, stepped, with grip rail

Order No.	B	B1	B2	H	H1	H2	H4	L	weight kg
K0587.0651	38	30	17	18	21	9	9,5	65	0.3
K0587.0801	53	23	17	31	34	12	17	80	0.5
K0587.1251	67	23	17	31	34	18	23	125	0.7

# Step jaw attachment

for 5-axis machining



## Material, version:

Step jaw steel, hardened, clamping surfaces ground.  
Grip rail steel, hardened

## Sample order:

K1115.0801

## Note for ordering:

High attachment step jaws in pairs with two gripper inserts and three different lengths of clamping spindle.

## Note:

The workpiece is first centred using the lower centring spindle, then finally clamped using the upper clamping spindle.

## Basic set:

Supplied with a pair of high add-on step jaws with 2 gripper inserts and 3 clamping spindles in various lengths.

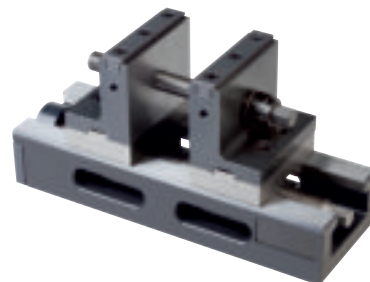
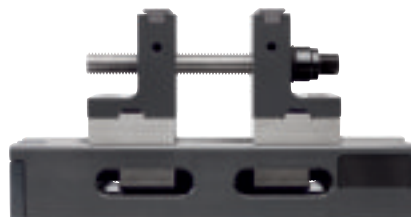
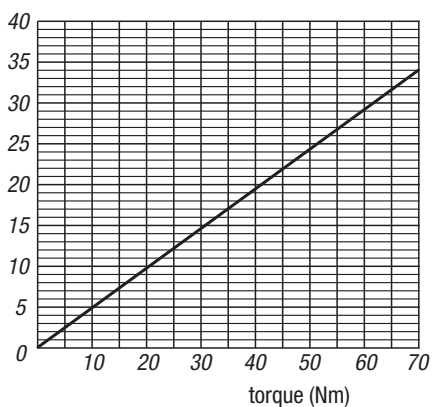
1. length 80 mm clamping range 6 mm - 35 mm.
2. length 140 mm clamping range 6 mm - 95 mm.
3. length 200 mm clamping range 6 mm - 155 mm.

## Advantages:

Ideal for 5-side machining. High setup on the machine table for 5-axis machines. Clamping force directly under the workpiece. The attachment jaws can be retrofitted for the 80 mm and 125 mm centric vices. The workpiece is first centred using the lower centring spindle, then finally clamped using the upper clamping spindle.

## clamping force diagram

clamping force (kN)

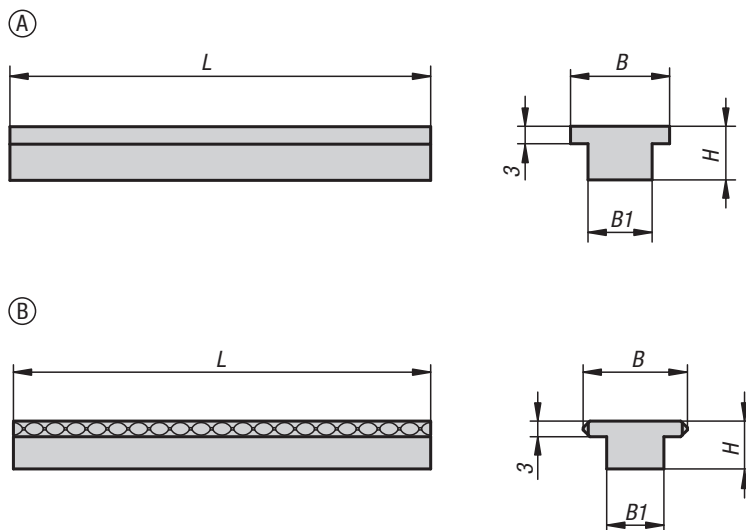


## KIPP Step jaw attachment for 5-axis machining

Order No.	Version	B	B1	B2	H	H1	L	weight kg
K1115.0801	for 5-axis machining	53	23	17	62	65,1	80	2.689
K1115.1251	for 5-axis machining	53	23	17	90	93,1	125	2.5

## Inserts

for stepped jaws



**Material:**  
Steel.

**Version:**  
Hardened and ground.

**Sample order:**  
K0591.080117

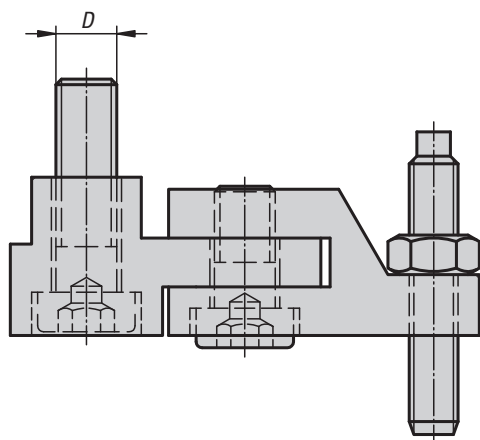
**Note:**  
Inserts Form A with smooth face Form B serrated face for maximum holding force.

### KIPP Inserts for stepped jaws

Order No. Form A	Order No. Form B	B	B1	H	L
K0591.065117	K0591.065217	17	11	9,2	65
K0591.080117	K0591.080217	17	11	9,2	80
K0591.125117	K0591.125217	17	11	9,2	125

# K0607

## Hinged stops



**Material, version:**  
Steel, black oxidised.

**Sample order:**  
K0607.080

**Note:**  
Hinged stop for fastening directly to the sliding or middle jaw.

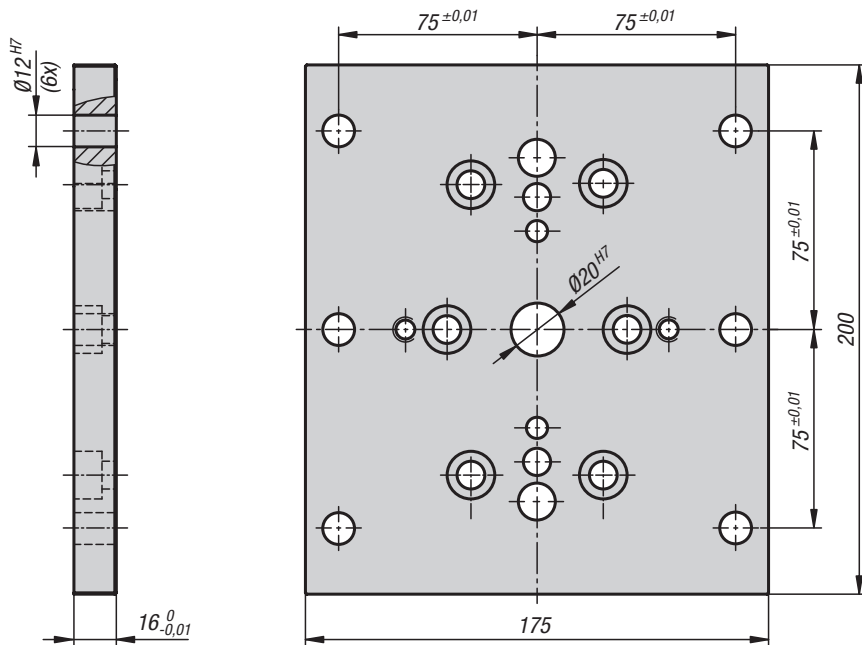
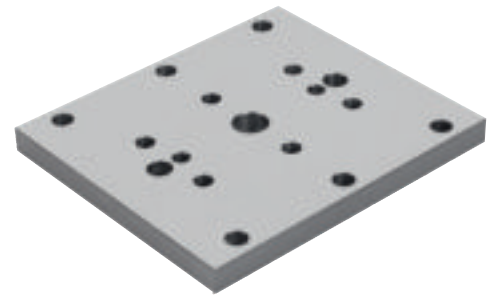
### KIPP Hinged stops

Order No.	D	Suitable for
K0607.080	M6	ZS 80-200
K0607.100	M8	ZS 100-350



## Baseplate

for centric vice



**Material:**  
Steel.

**Version:**  
Hardened and ground.

**Sample order:**  
K1274.12175200

**Note:**  
The base plate enables the centric vices (65 - 80 - 125) to be mounted on M12/12F7 grid systems with a grid spacing of 50 mm.

## KIPP Baseplate for centric vice

Order No.	Suitable for	weight kg
K1274.12175200	centric vices 65, 80, 125	5



