

FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

Model: ASC-77x102S, 77x130S, 77x170S, 77x210S
ASC-127x160S, 127x210S, 127x260S, 127x310S, 127x360S



- Patented stud bolt seat design can efficiently calibrate the clamping center.
- It is recommended to operate with a Master Plate on a five-axis machine.
- Compatible with Robotic Arms.



ASCS Series

STANDARD ACCESSORIES:

- 4 pcs of Clamp
- 1 pc of Wrench



Users can calibrate the clamping center of vise by adjusting the screws on both ends.

Detachable jaws are made of **High quality Tool Steel (SCM440)** and gone through carburizing to achieve **HRC50**. Since both sides are fixed size and able to be used as a datum, users can reverse them to increase clamping range.

The vise's clamping force can achieve **1300KG**, the repeatability positioning precision of its clamping center is within **$\pm 0.02\text{mm}$** .

The **45° dovetail structure with teeth** on the upper jaw ensures the bottom of the workpiece to be firmly clamped.

Vise body is made of **High quality Steel (S50C)** and its slideways gone through high-frequency hardening to achieve **HRC50**, which makes the whole part durable.

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ASC-S Series

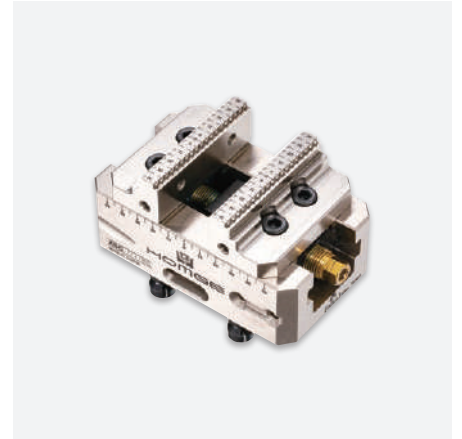
Model: ASC-77x102S, 77x130S, 77x170S, 77x210S
ASC-127x160S, 127x210S, 127x260S, 127x310S, 127x360S



ASC-77x102S

Size 107x77x70 mm

Weight (kg) 2.8



ASC-77x130S

Size 135x77x70 mm

Weight (kg) 3.5



ASC-77x170S

Size 175x77x70 mm

Weight (kg) 4.2



ASC-77x210S

Size 215x77x70 mm

Weight (kg) 4.9



ASC-127x160S

Size 165x127x87 mm

Weight (kg) 9



ASC-127x210S

Size 215x127x87 mm

Weight (kg) 11



ASC-127x260S

Size 265x127x87 mm

Weight (kg) 13



ASC-127x310S

Size 315x127x87 mm

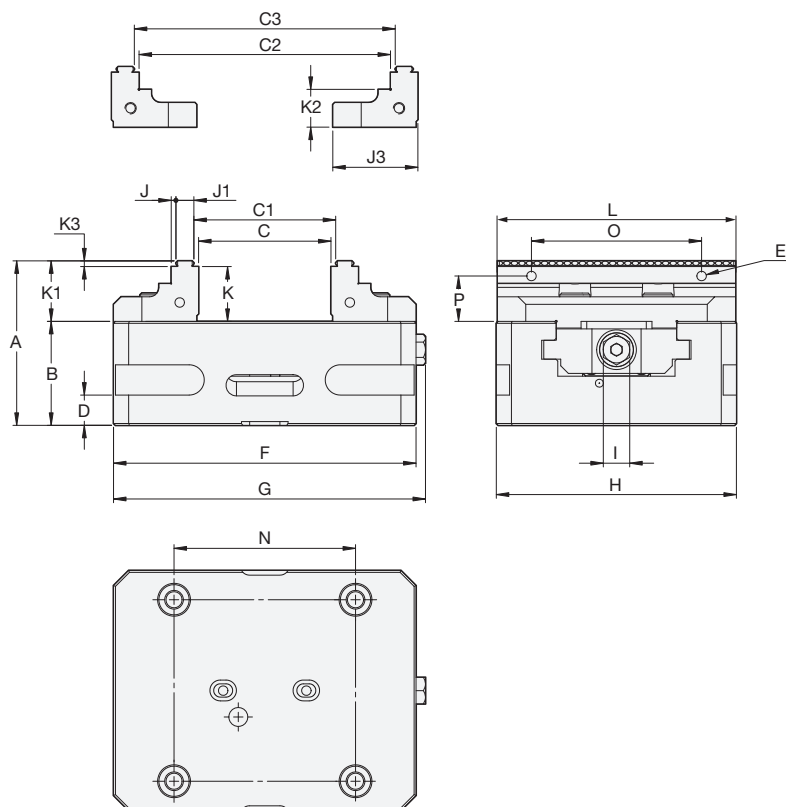
Weight (kg) 15



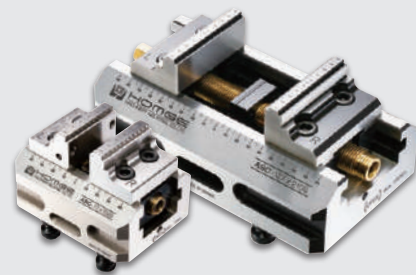
ASC-127x360S

Size 365x127x87 mm

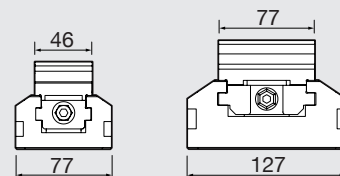
Weight (kg) 17



Narrow Version :



The Narrow Version of our Vise Body and Jaw Sets is a solution designed specifically to manage interference problems. All of our ASC-S series models are readily available.



SPECIFICATIONS (Material: Vise body S50C. Rail hardness: HRC 50 / Jaws SCM440. Hardness: HRC 48-50)

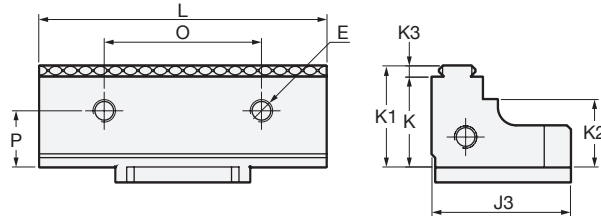
Unit: mm

Model	A	B	C	C1	C2	C3	D	E	F	G	H	I	J	J1
ASC- 77X102S	70	43	28	32	85	89	10	M6	102	107	77	12	2	9.5
ASC- 77X130S	70	43	56	60	113	117	10	M6	130	135	77	12	2	9.5
ASC- 77X170S	70	43	96	100	153	157	10	M6	170	175	77	12	2	9.5
ASC- 77X210S	70	43	136	140	193	197	10	M6	210	215	77	12	2	9.5
ASC- 127x160S	87	55	70	75	133	138	16	M6	160	165	127	14	2.5	9.5
ASC- 127x210S	87	55	120	125	183	188	16	M6	210	215	127	14	2.5	9.5
ASC- 127x260S	87	55	170	175	233	238	16	M6	260	265	127	14	2.5	9.5
ASC- 127X310S	87	55	220	225	283	288	16	M6	310	315	127	14	2.5	9.5
ASC- 127X360S	87	55	270	275	333	338	16	M6	360	365	127	14	2.5	9.5

Model	J3	K	K1	K2	K3	L	N	O	P	Pull Stud	Weight (kg)
ASC- 77X102S	37	24	27	18	3	77	52	42	15	M-52x52PS	2.8
ASC- 77X130S	37	24	27	18	3	77	52	42	15	M-52x52PS	3.5
ASC- 77X170S	37	24	27	18	3	77	52	42	15	M-52x52PS	4.2
ASC- 77X210S	37	24	27	18	3	77	52	42	15	M-52x52PS	4.9
ASC- 127x160S	45	29	32	20	3	126	96	90	24	M-96x96PS	9
ASC- 127x210S	45	29	32	20	3	126	96	90	24	M-96x96PS	11
ASC- 127x260S	45	29	32	20	3	126	96	90	24	M-96x96PS	13
ASC- 127X310S	45	29	32	20	3	126	96	90	24	M-96x96PS	15
ASC- 127X360S	45	29	32	20	3	126	96	90	24	M-96x96PS	17

Optional Accessories

Clamping Jaws

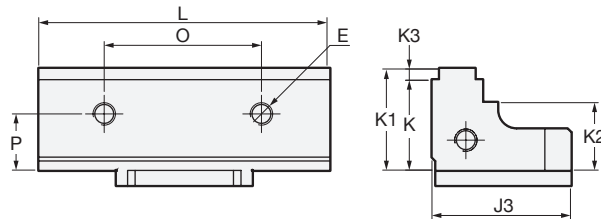


SPECIFICATIONS

Unit: mm

for Model	E	L	K	K1	K2	K3	J3	O	P	Weight (kg)
ASC-77	M6	77	24	27	18	3	37	42	15	0.8
ASC-127	M6	126	29	32	20	3	45	90	24	1.7

Standard Hard Jaws

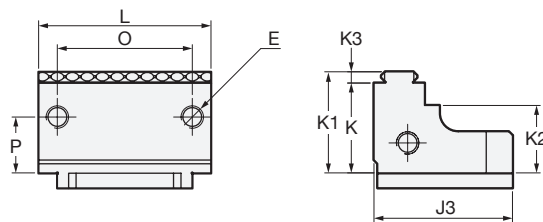


SPECIFICATIONS

Unit: mm

for Model	E	L	K	K1	K2	K3	J3	O	P	Weight (kg)
ASC-77	M6	77	24	27	18	3	37	42	15	0.8
ASC-127	M6	126	29	32	20	3	45	90	24	1.7

Flat Jaws



SPECIFICATIONS

Unit: mm

for Model	E	L	K	K1	K2	K3	J3	O	P	Weight (kg)
ASC-77	M6	46	24	27	18	3	37	36	15	0.5
ASC-127	M6	77	29	32	20	3	45	63	24	1.1

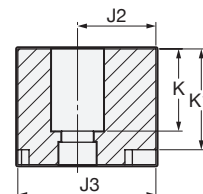
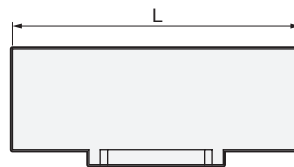
Narrow Jaws

Optional Accessories

Clamping Jaws

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FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE / ASC-S SERIES / OPTIONAL ACCESSORIES

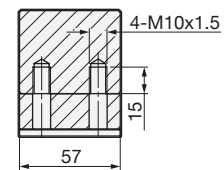
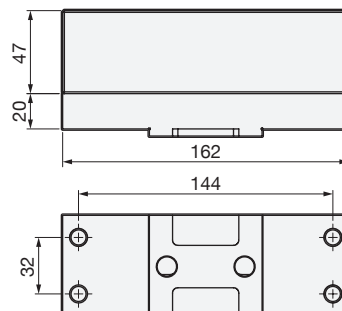


SPECIFICATIONS

Unit: mm

for Model	L	K	K1	J2	J3	Weight (kg)
ASC-77	77	22	27	21	37	1.3
ASC-127	126	27	32	23	45	1.4

Soft Jaws

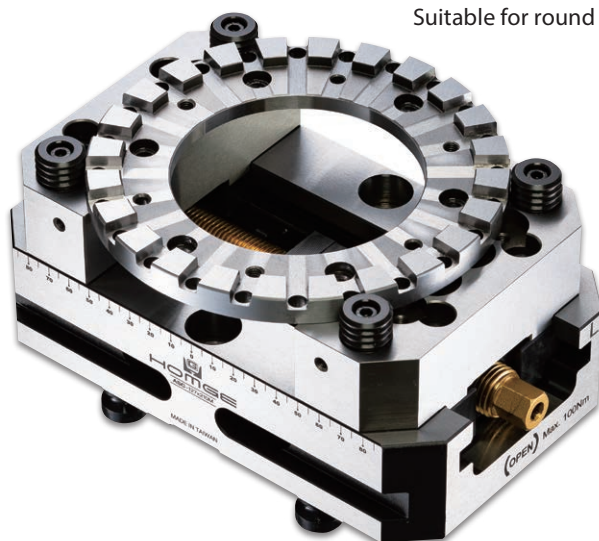


Soft Jaws Set (for ASC-127, WEIGHT: 1.7KG)

OPTIONAL ACCESSORIES:

- Rectangular Plate
- Round Plate
- Pull Studs

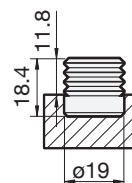
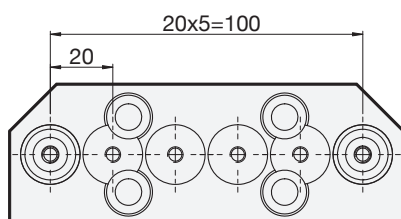
Please refer to Page 34
Zero Point Quick Change Devices



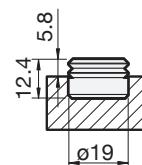
Suitable for round workpiece

Flexi Jaws (WEIGHT:2.6KG)

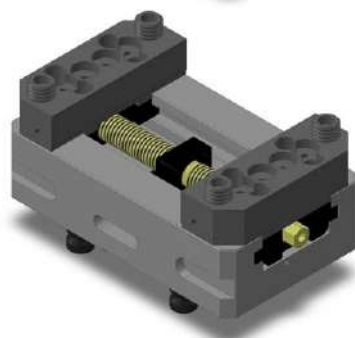
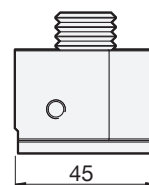
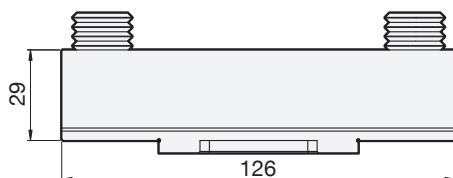
Two sizes of Grippers are available.



Long type



Short type



CLAMPING RANGE

Unit: mm

for Model	Max.	Min.
ASC- 127x160S	Ø133	Ø30.2
ASC- 127x210S	Ø173	Ø30.2
ASC- 127x260S	Ø218	Ø30.2
ASC- 127x310S	Ø264	Ø30.2
ASC- 127x360S	Ø311	Ø30.2

