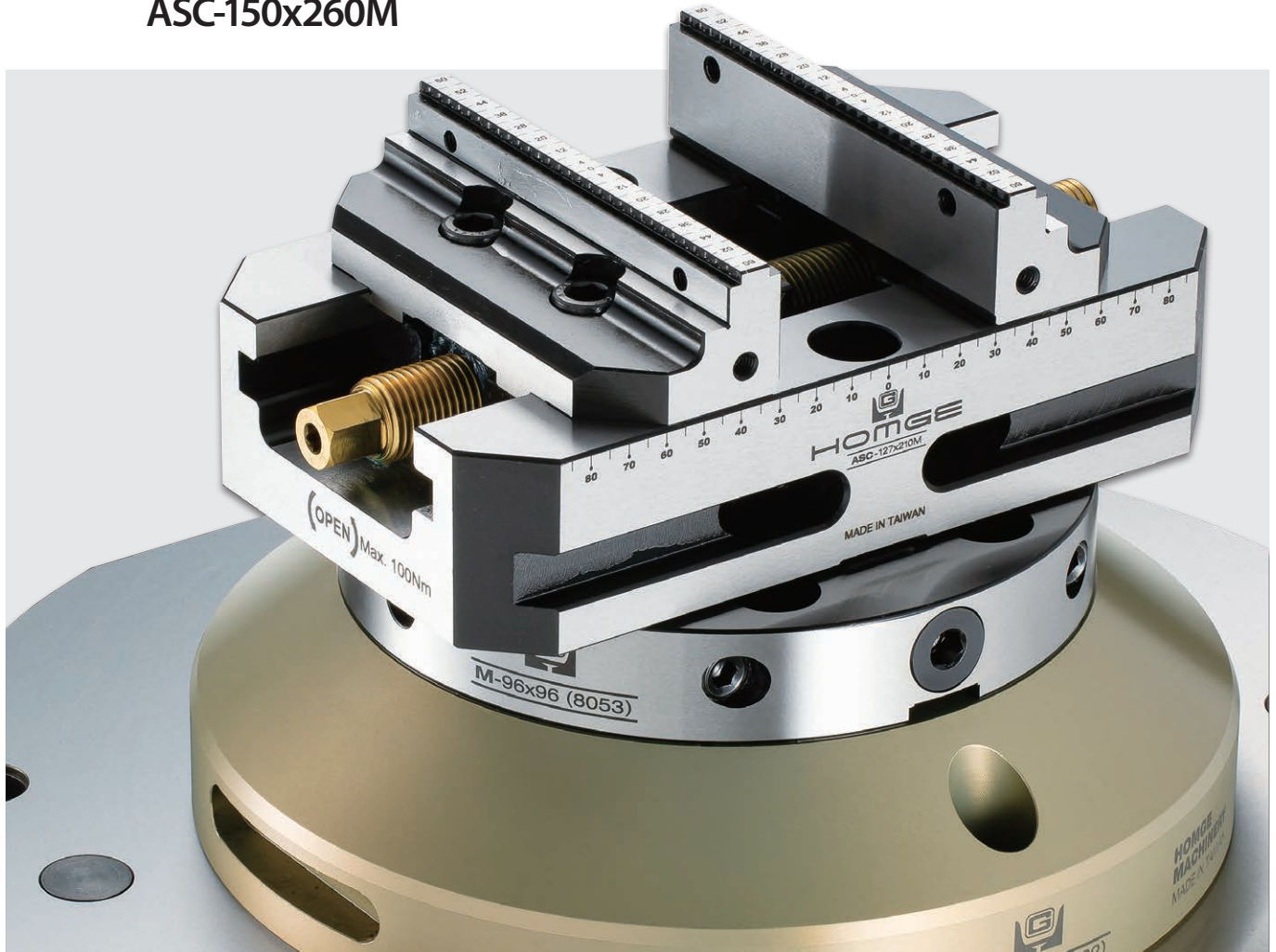


FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

Model: ASC-77x102M, ASC-77x130M, 77x170M,
ASC-127x130M, 127x160M, 127x210M, 127x260M,
ASC-150x260M



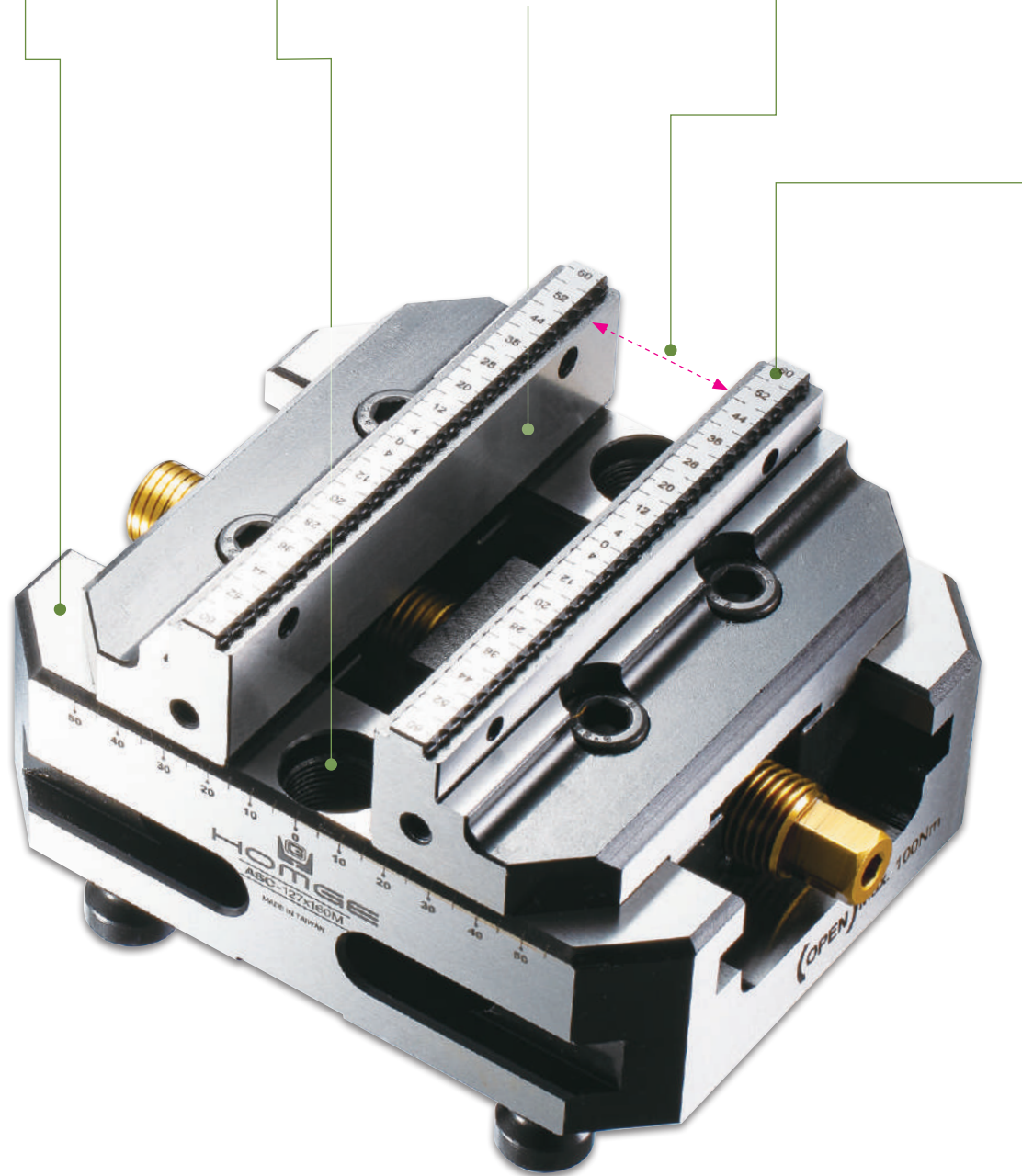
- Special 45° dovetail structure with teeth
- With a pair of mounting holes, ASC-M series can be directly fixed on the 3rd, 4th or 5th-Axis machine bed.
- Purchase an additional Center Jaw to enable dual clamping.

ASC-M Series

STANDARD ACCESSORIES:

- 4 pcs of Clamp
- 1 pc of Wrench

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.	The vise body can be mounted directly on the machine table by the middle with 2 pieces of M12 screws. This vise also can clamp 2 workpieces by mounting the centre jaw in the middle.	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 ±0.02mm.	The 45° dovetail structure with teeth on the upper jaw ensures the bottom of the workpiece to be firmly clamped.
1	2	3	4	5



ASGM Series

Model: ASC-77x102M, ASC-77x130M, 77x170M
 ASC-127x130M, 127x160M, 127x210M, 127x260M,
 ASC-150x260M



ASC-77x102M

Size 107x77x70 mm

Weight (kg) 2.8



ASC-77x130M

Size 135x77x70 mm

Weight (kg) 3.3



ASC-77x170M

Size 175x77x70 mm

Weight (kg) 3.9



ASC-127x130M

Size 135x127x80 mm

Weight (kg) 7.3



ASC-127x160M

Size 165x127x80 mm

Weight (kg) 7.5



ASC-127x210M

Size 215x127x80 mm

Weight (kg) 8.5



ASC-127x260M

Size 265x127x80 mm

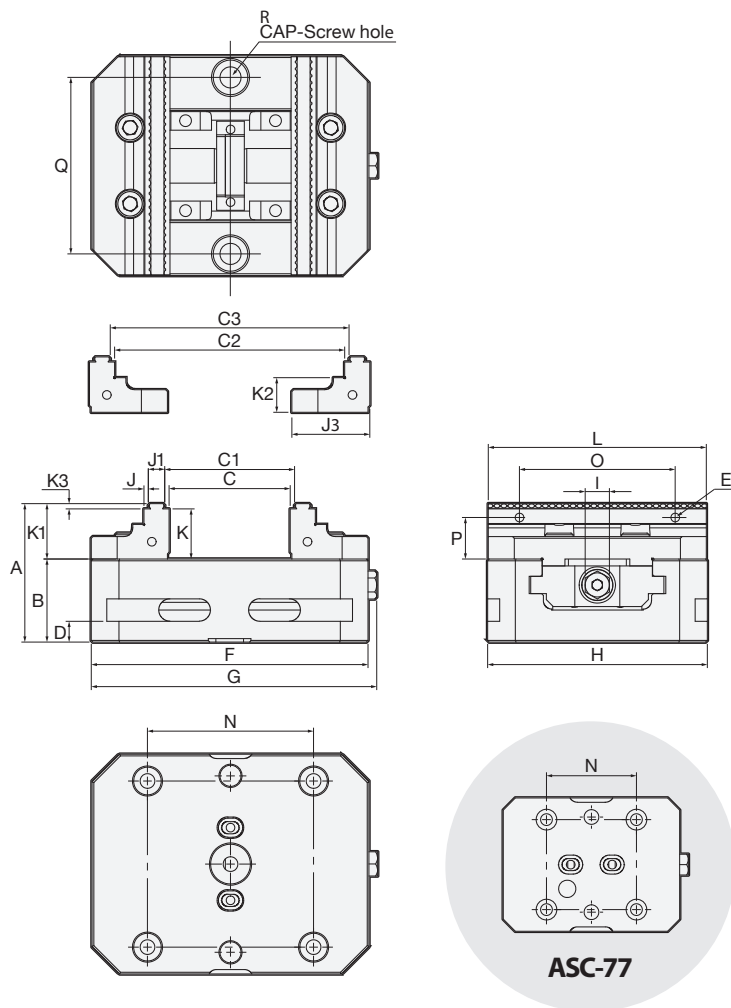
Weight (kg) 10



ASC-150x260M

Size 265x150x80 mm

Weight (kg) 13.5



OPTIONAL ACCESSORIES:

- Rectangular Plate
- Round Plate
- Pull Studs

Please refer to Page 34
Zero Point Quick Change Devices

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

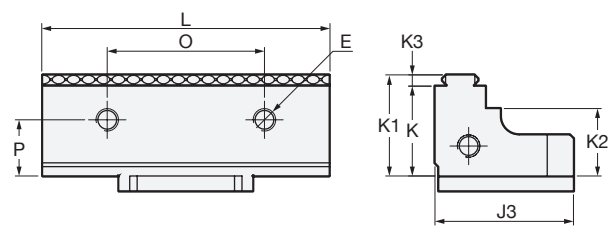
Unit: mm

Model	A	B	C	C1	C2	C3	D	E	F	G	H	I	J	J1
ASC-77X102M	70	43	28	32	85	89	10	M6	102	107	77	12	2	9.5
ASC-77X130M	70	43	56	60	113	117	10	M6	130	135	77	12	2	9.5
ASC-77X170M	70	43	96	100	153	157	10	M6	170	175	77	12	2	9.5
ASC-127X130M	80	48	40	45	103	108	12	M6	130	135	127	14	2.5	9.5
ASC-127X160M	80	48	70	75	133	138	12	M6	160	165	127	14	2.5	9.5
ASC-127X210M	80	48	120	125	183	188	12	M6	210	215	127	14	2.5	9.5
ASC-127X260M	80	48	170	175	233	238	12	M6	260	265	127	14	2.5	9.5
ASC-150X260M	80	48	170	175	233	238	12	M6	260	265	150	14	2.5	9.5

Model	J3	K	K1	K2	K3	L	N	O	P	Q	R	Pull Stud	Weight (kg)
ASC-77X102M	37	24	27	18	3	77	52	42	15	55	M8	M-52X52PS	2.8
ASC-77X130M	37	24	27	18	3	77	52	42	15	55	M8	M-52X52PS	3.3
ASC-77X170M	37	24	27	18	3	77	52	42	15	55	M8	M-52X52PS	3.9
ASC-127X130M	45	29	32	20	3	126	96	90	24	102	M12	M-96X96PS	7.3
ASC-127X160M	45	29	32	20	3	126	96	90	24	102	M12	M-96X96PS	7.5
ASC-127X210M	45	29	32	20	3	126	96	90	24	102	M12	M-96X96PS	8.5
ASC-127X260M	45	29	32	20	3	126	96	90	24	102	M12	M-96X96PS	10
ASC-150X260M	45	29	32	20	3	149	96	90	24	120	M12	M-96X96PS	13.5

Optional Accessories

Clamping Jaws

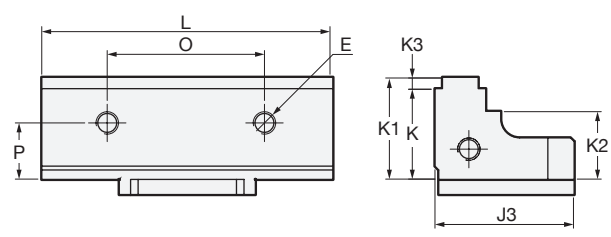


SPECIFICATIONS

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

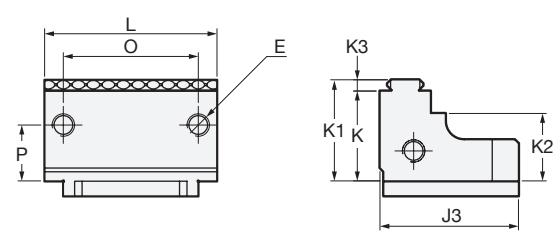


SPECIFICATIONS

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	1.2
ASC-127	M6	126	29	32	20	3	45	90	24	1.7

Flat Jaws



SPECIFICATIONS

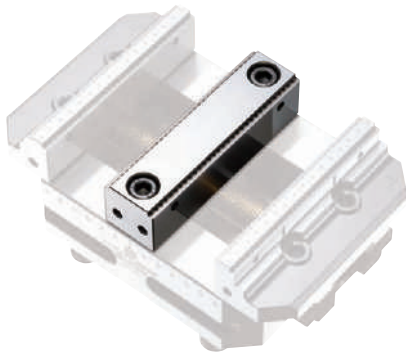
Unit: mm

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

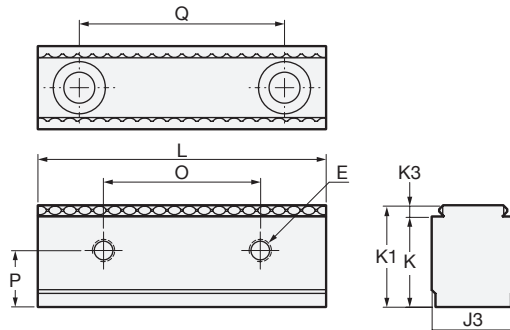
Narrow Jaws

Optional Accessories

Clamping Jaws



Center Jaw



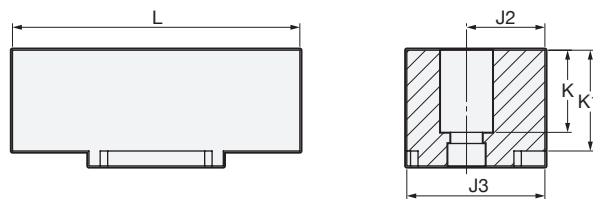
SPECIFICATIONS

Unit: mm

for Model	E	L	K	K1	K3	J3	O	P	Q	Weight (kg)
ASC-77	M6	77	24	27	3	22	42	15	55	0.4
ASC-127	M6	126	29	32	3	34	90	24	102	1
ASC-150	M6	149	29	32	3	34	90	24	120	1.2



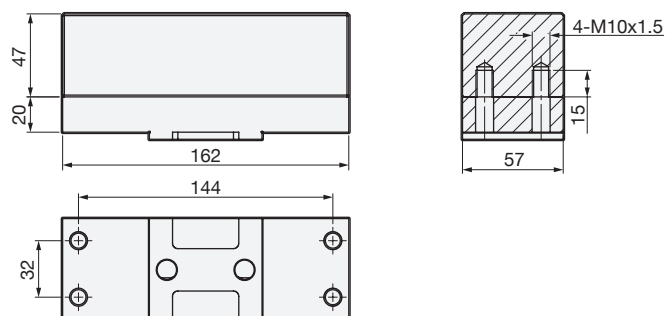
Soft Jaws



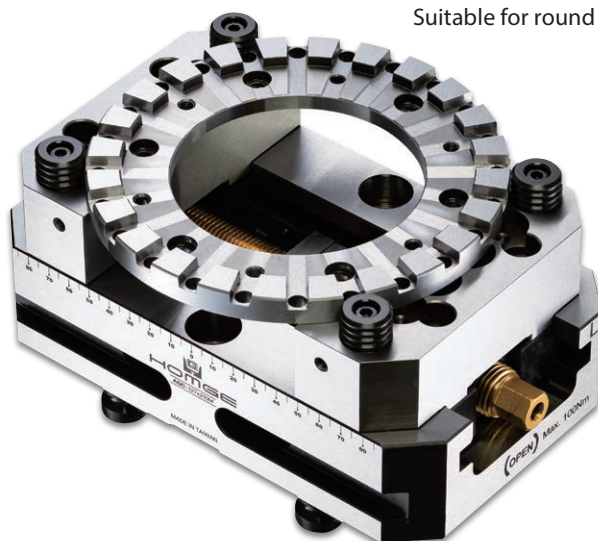
SPECIFICATIONS

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

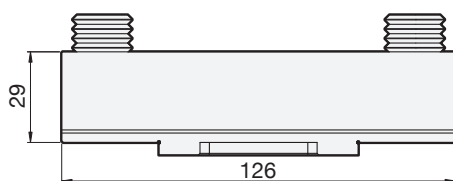
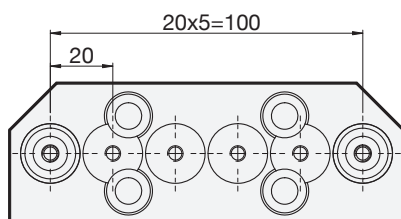


Soft Jaws Set (for ASC-127, WEIGHT: 1.7KG)

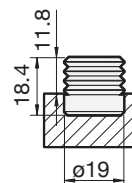


Suitable for round workpiece

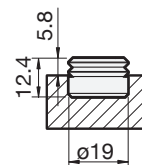
Flexi Jaws (WEIGHT: 2.6KG)



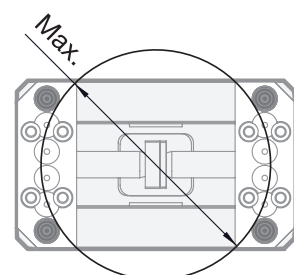
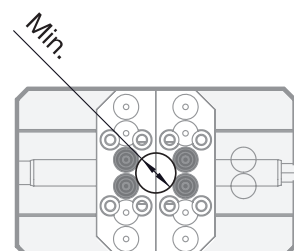
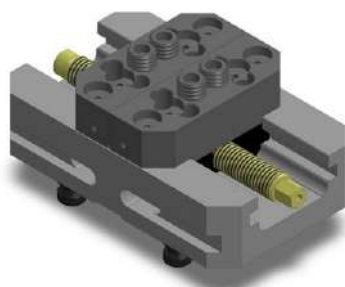
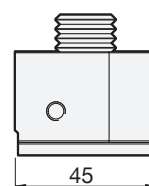
Two sizes of Grippers are available.



Long type



Short type



CLAMPING RANGE

Unit: mm

for Model	Max.	Min.
ASC- 127x130M	Ø112	Ø30.2
ASC- 127x160M	Ø133	Ø30.2
ASC- 127x210M	Ø173	Ø30.2
ASC- 127x260M	Ø218	Ø30.2
ASC- 150x260M	Ø218	Ø30.2