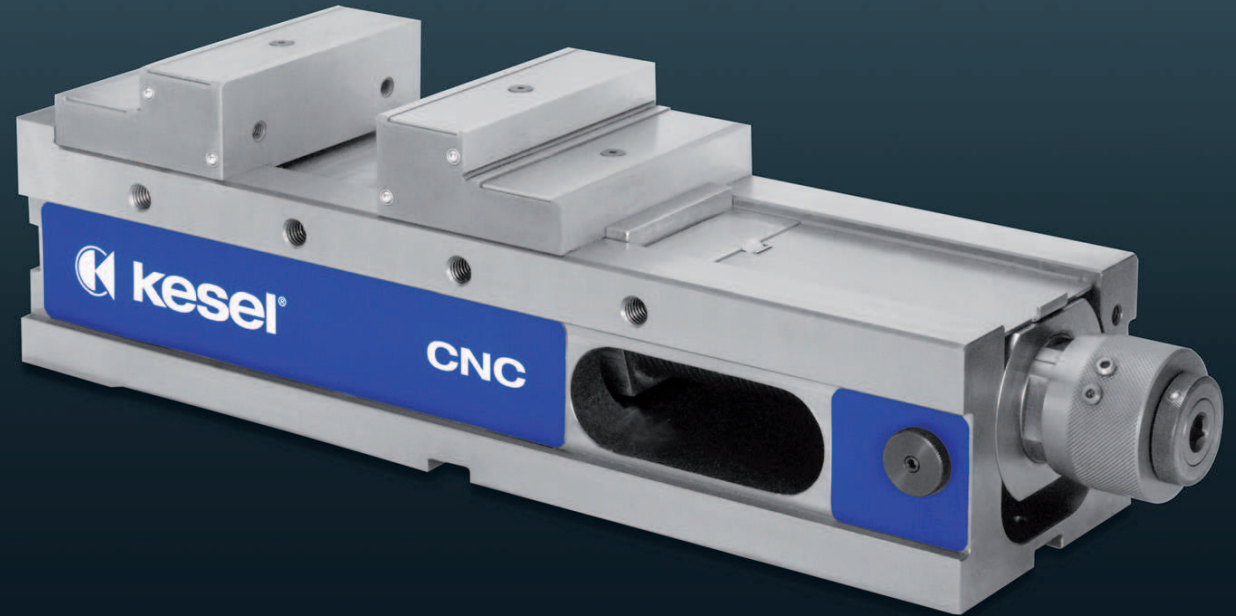


CNC

High pressure machine vice

CNC high pressure vice with constant length for high precision workpieces on machining centres, for horizontal and vertical use.

- > Strong body of spheroidal graphite iron GJS-600
- > Guide rails hardened and precision grinded
- > Longitudinal and lateral grooves 20 H7 for aligning on the machine table as well as 2 locating holes \varnothing 25 H7 for mounting on zero point clamping systems
- > Precise, fine clamping force pre-selection
- > Connection thread on both sides for side stop
- > Step jaws for wide clamping ranges
- > Quick release system for optional step ledges
- > Mechanical-hydraulic spindle fully encapsulated, low-wear and maintenance-free
- > Threaded holes for screwing on facing jaws (accessories)
- > Spindle with bayonet mounting for quick removal
- > Possibility of direct clamping with operating key provided
- > Stable exchangeable cover plates



Scope of delivery:

4 clamping claws, 1 manual crank, 1 operating key

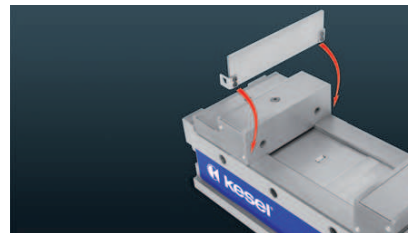
Variants:

Horizontal range of application

> The vice is clamped on the base plate

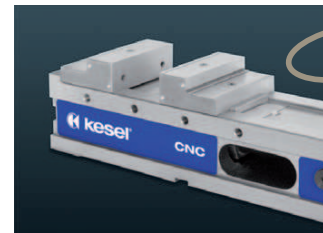
All-round range of application

> The vice can be fitted on the front of the base plate for vertical attachments, or lying on its side



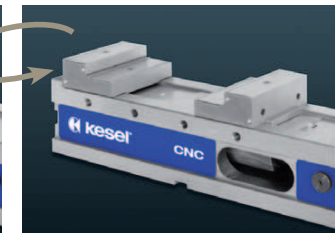
Step ledge quick release system

- > Step ledges are simply "clicked" in by hand, with no need for tools
- > No penetration of chips beneath the step ledge
- > Secure and stable hold, also with the use of compressed air
- > Available in a range of heights (accessories)



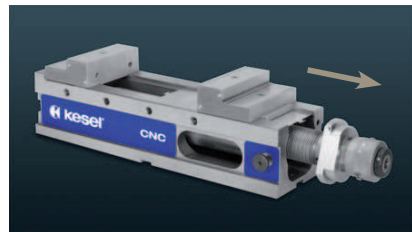
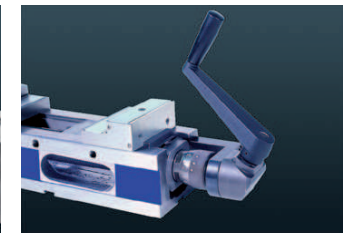
Jaw quick release system

- > Quick rotation or change of the serial top jaws (it is only necessary to turn and open 2 fastening screws)
- > Quick replacement of custom jaws produced in-house



Angle drive

- > Operation via table with pre-screwed angle drive (accessory)
- > Optimum accessibility for force adjustment



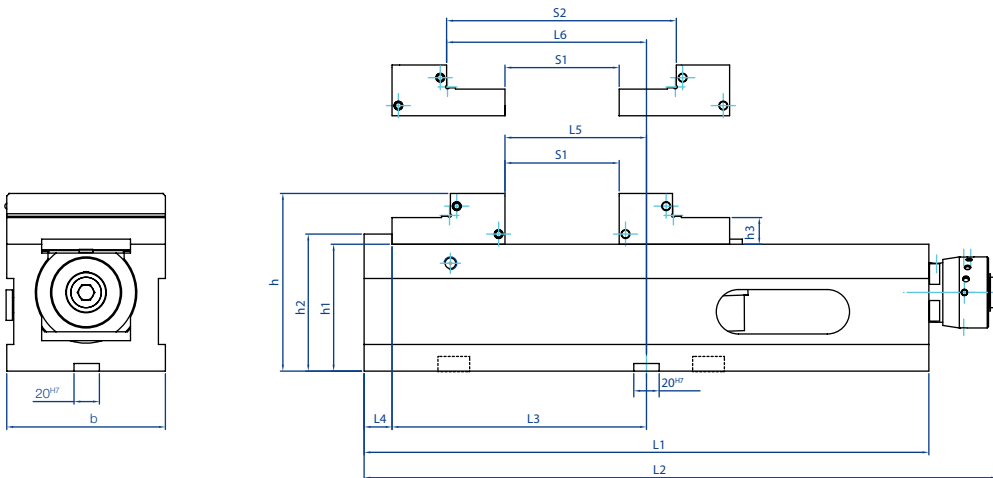
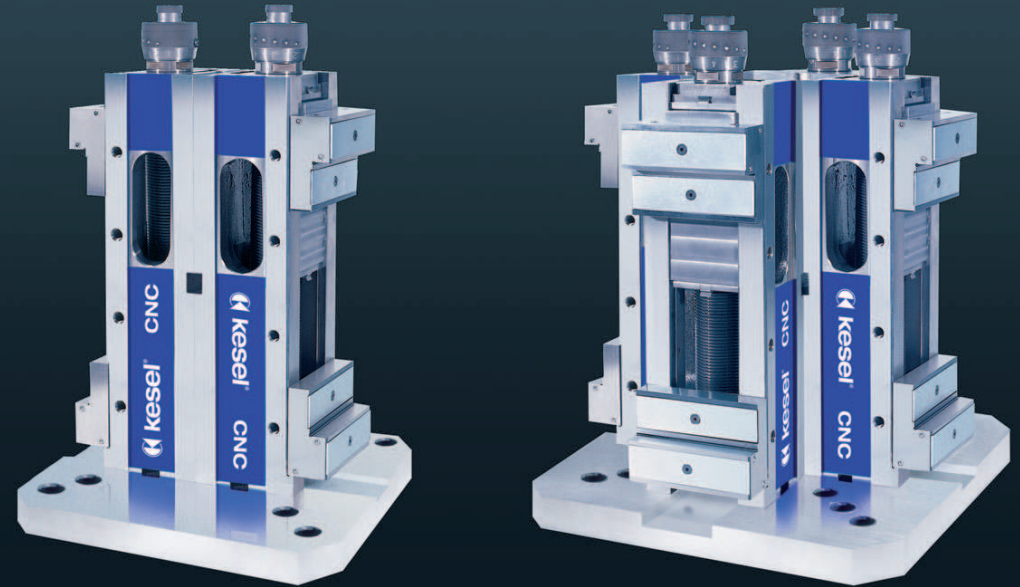
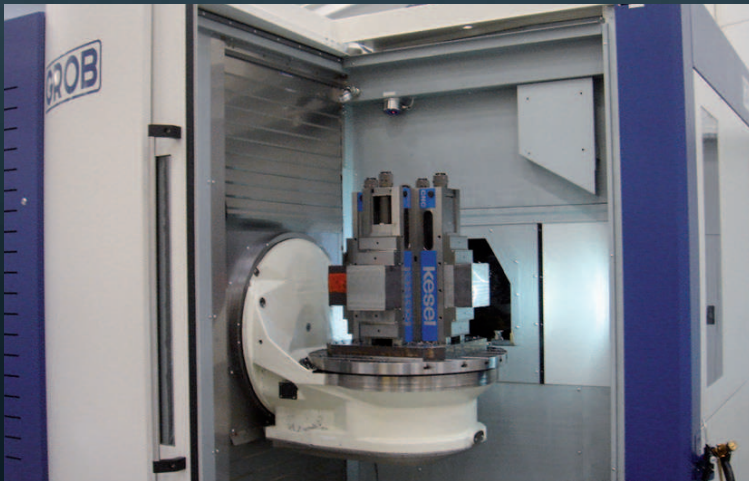
Quick removal of the spindle unit possible:

- > Possible to screw on the vice through the body
- > Optimum cleaning possibilities



CNC pendulum jaw (accessories)

- > With corrugation and spring sheet
- > 360° pivoting
- > For non-parallel workpieces



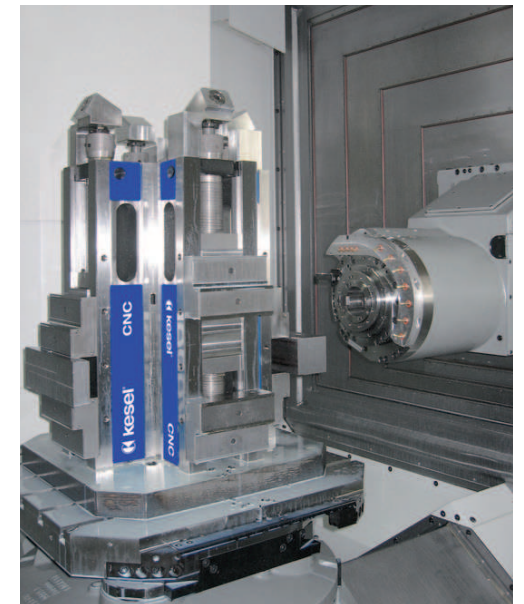
Size b	Order number		Body width b	Clamping range		Clamping force in kN	Weight in kg
	for horizontal use	can be clamped on 3 planes		Stufe 1	Stufe 2		
125	04.25.160.050.9	04.25.160.001.9	126	0 - 210	91 - 301	40	34
160	04.25.260.050.9	04.25.260.001.9	162	0 - 289	113 - 402	60	60

h	h1 ±0,01	h2	h3	L1	L2	L3	L4	L5	L6	L7	L8
140	100	108	22	445	499	200,5	22	111,5	157,5	150	50
165	115	123	30	580	655	288,5	25	176,5	233,5	-	-

Attachments

We offer you the optimum attachment for your special requirements

- > The vertical arrangement of individual vices enables optimum accessibility of the machine spindle
- > In comparison to the single-part monoblock construction, star set-ups can be flexibly aligned with the respective needs and then dismantled into the individual vices again as necessary
- > Flexible base plates fit with your machine



CNC accessories



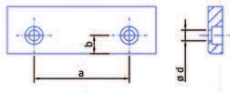
Manual crank standard version with snap ring to prevent it falling out due to machine vibrations

Size	Order no.	Length	Width
160-200	03.15.203.002.4	160	127



Manual crank in shortened version for use in place of the standard manual crank, if the throughput height to the machine table is too small

Size	Order no.	Length	Width
125-160	03.15.103.001.4	110	90
200	03.15.303.001.4	130	125



Dimensional drawing of the fastening holes of all facing jaws

Size	a	b	ø d
125	80	15	9,0
160	100	20	9,0



Smooth clamping jaw hardened, grinded, standard equipment

Smooth clamping jaw soft (1.2842), milled, for the fabrication of moulding jaws

Clamping jaw with linear grooves for firmly gripping the workpieces

Size	Order no.	Height	Thick-ness
	Smooth clamping jaw hardened		
125	01.11.105.002.5	39,2	12
160	01.11.205.002.4	49,2	16
Clamping jaw with linear grooves			
125	01.11.105.001.5	39,2	12
160	01.11.205.001.5	49,2	16



Smooth clamping jaw with step, hardened and grinded, for saving clamping supports

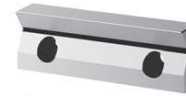
Size	Order no.	Step	Thick-ness	Height
125	01.11.105.003.5	3 x 6	12	39,2
125	01.11.105.008.5	5 x 10	12	39,2
160	01.11.205.003.4	5 x 8	16	49,2



Clamping jaw with corrugation hardened and grinded

Size	Order no.	Height	Thick-ness	Gripper Order no.	Thread
125	01.26.160.035.3	40	12	01.26.160.048.4	M10
160	01.26.260.030.3	50	16	01.26.260.080	M12

CNC accessories



Prism jaws with horizontal prism 120° hardened and grinded

Size l	Order no.	Height	Thick-ness	Clamping diameter	
				with 1 jaw	with 2 jaw
125	01.11.105.005.4	39,2	20	ø 9-50	ø 14-50



Prism jaws with horizontal and vertical prism 90° hardened and grinded

Size l	Order no.	Height	Thick-ness	Clamping diameter	
				with 1 jaw	with 2 jaw
125	01.11.105.004.4	39,2	28	ø 15-42	ø 24-42
160	01.11.205.004.3	49,2	32	ø 18-50	ø 28-50



Pendulum jaws with smooth slide, hardened and grinded, for clamping conical workpieces

Size	Order no.	Height	Thickness
125	04.13.125.150.9	39,2	43
160	04.13.160.150.9	49,2	52



Pull-down jaws with inset spring leaf for clamping raw parts. The spring leaves establish a secure hold and deep drawing effect

Size	Order no.	Height	Thickness
125	04.13.125.200.9	39,2	25
160	04.13.160.200.9	49,2	28



Pull-down jaws for raw parts with inset spring leaf for clamping raw parts. The spring leaves establish a secure hold and deep drawing effect

Size	Order no.	Height	Thickness
125	04.13.125.250.9	40	21
160	04.13.160.250.9	50	24



Grip ledge for improved hold of the workpieces on the step (4.5 mm deep, 2.5 mm wide)

Scope of delivery: 2 units per order no.

Size	Grip ledge	Order no.	Height	Step w x h
125	High	04.25.150.055	39,5	1,4 x 4,5

CNC accessories



Universal top jaws with angle adjustment
possibility hardened and grinded

Size	Order no.	Height	Thickness
125	04.13.125.400.9	42	10
160	04.13.160.400.9	52	10



Angle drive for high pressure machine vices Kesel CNC

For size	Order no.
125	03.26.160.001.9
160	03.26.260.001.9



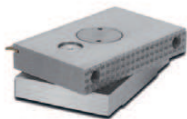
Workpiece stop adjustable

For size	Order no.	Thread
125	03.11.008.001.4	M 12



Step ledges

For size	Order no.	Height	Thickness
125	03.25.160.022.9	13	3
125	03.25.160.023.9	22	3
125	03.25.160.024.9	35	3
125	03.26.160.002.9	39	3
125	04.25.150.060	35	3
125	04.25.150.061	15	3
160	03.25.260.022.9	14	3
160	03.25.260.023.9	30	3
160	03.25.260.024.9	44	3
160	03.26.260.0001	49	3



Pendulum jaws CNC with corrugation and spring sheet,
360° pivoting

Size	Order no.	Height	Thickness
125	03.26.160.005.3	40	80
160	03.26.260.005.3	50	104

Kesel machine vices

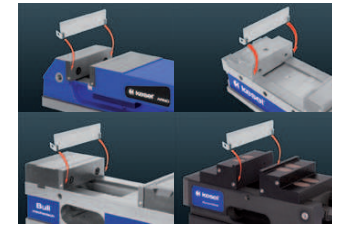
Basic information

Design:

- > High quality spheroidal graphite iron GJS-600 (ZS: 16 MnCr 4)
- > Functional surfaces hardened and grinded
- > Longitudinal and lateral grooves 20H7 for alignment
- > Step-click ledge quick-release system with hold-down effect for Arno, CNC, Bull mechanical, Bull 5-S, Syncroline, NCA and ZS

Application:

EUse on machining centres and conventional machines



Kesel accessories for machine vices

on request

Step-click ledges with hold-down retainer

Grip ledges

Jaws and further accessories



Repairs and services

on request

- > Quick, reliable (2-3 days)
- > Renewed warranty after repair
- > Functional check (e.g. clamping force)
- > Billing according to actual work required!

Clamping solutions according to customer wishes

on request

- > Competent realisation
- > Short delivery times
- > Fair prices

