

# FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

Model: ASC-77x102S, 77x130S, 77x170S, 77x210S  
ASC-127x160S, 127x210S, 127x260S, ASC-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 **HRC55**. 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.

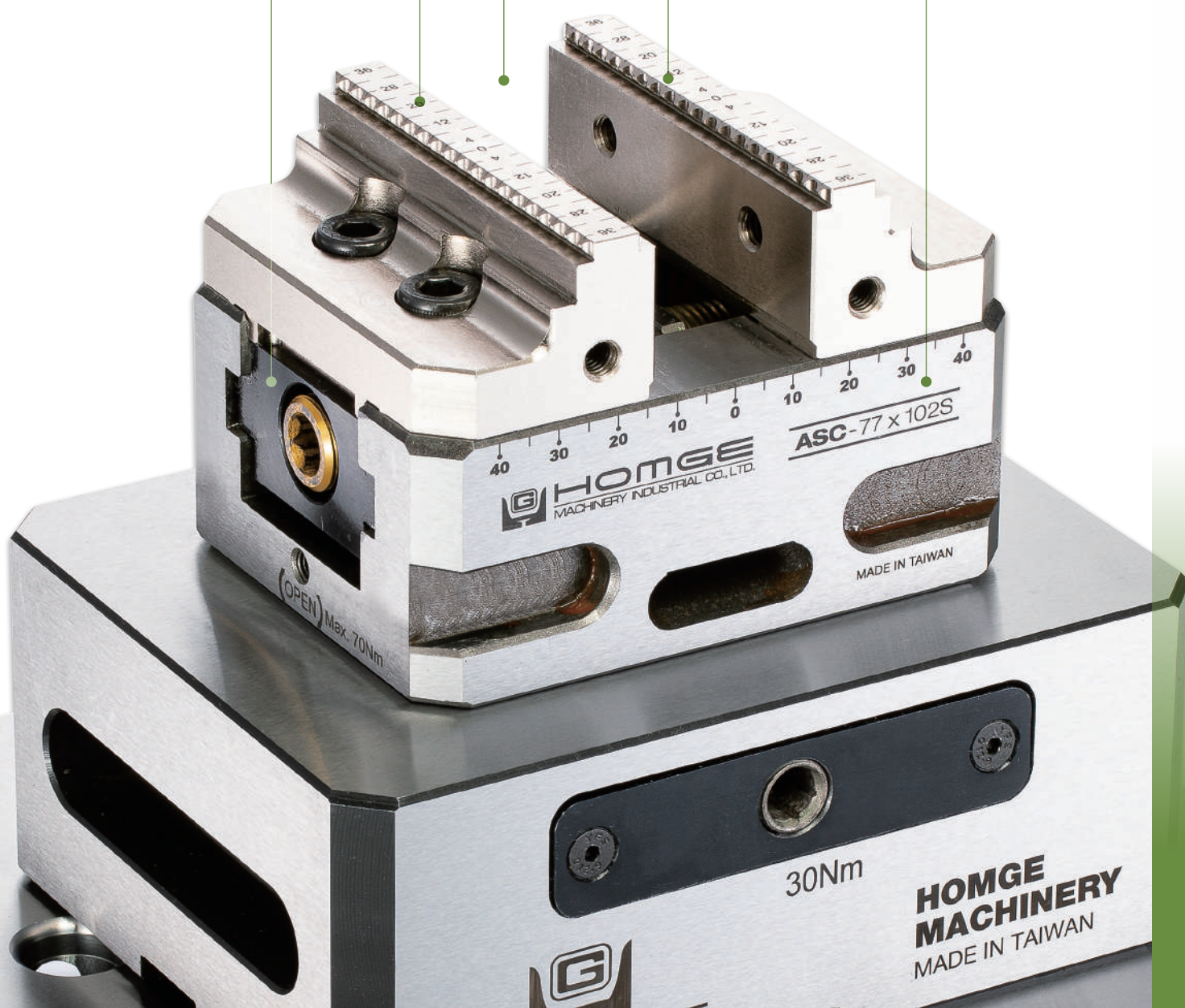
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# ASC-S Series

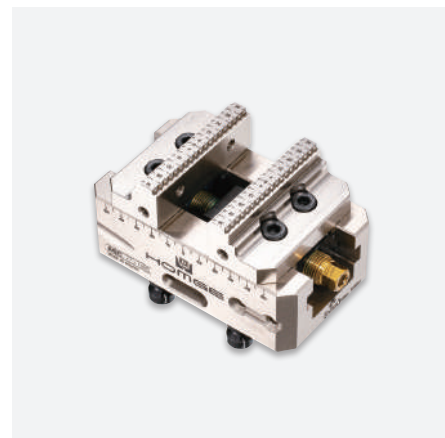
Model: ASC-77x102S, 77x130S, 77x170S, 77x210S  
ASC-127x160S, 127x210S, 127x260S, 127x310S, 127x360S



**ASC-77x102S**

Size 107x77x70 mm

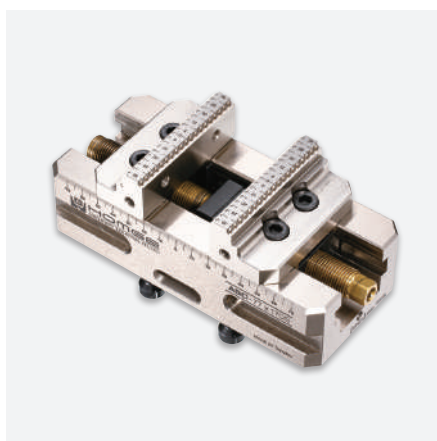
Weight (kg) 2.8



**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

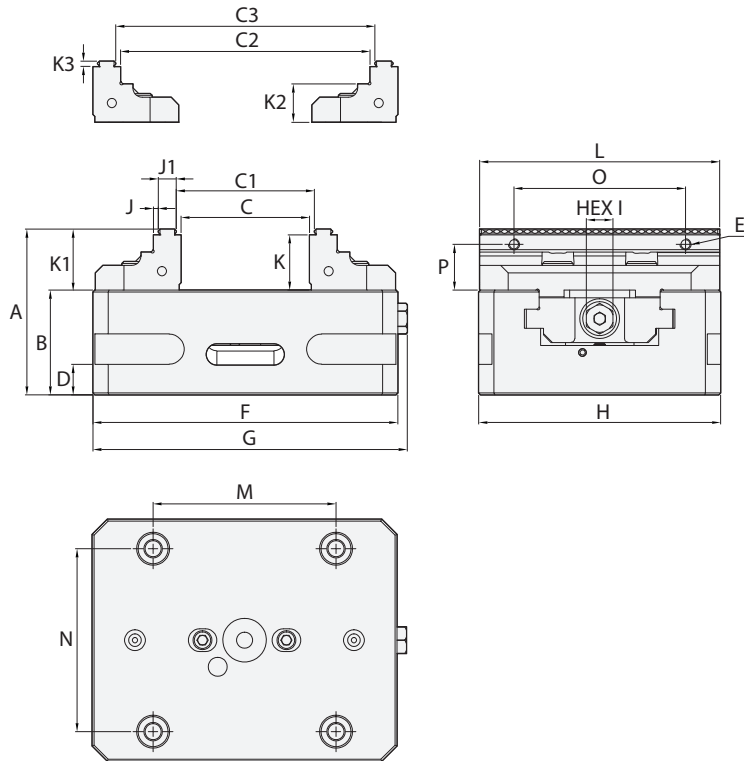
Weight (kg) 15



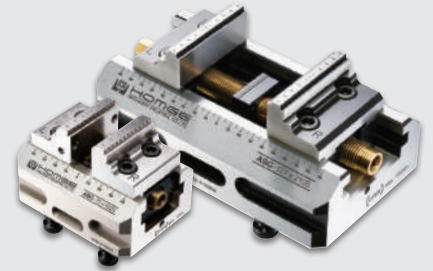
**ASC-127x360S**

Size 365x127x87 mm

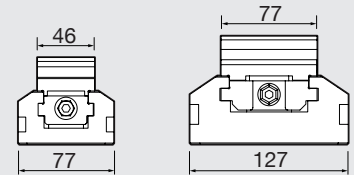
Weight (kg) 17



## 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, Hardness: HRC 50/ Detachable Jaws SCM440, Hardness: HRC 55)

Unit: mm

Model	A	B	C	C1	C2	C3	D	E	F	G	H	I	J	J1
ASC- 77X102S	70	43	28	32	75	80	10	M6	102	107	77	12	2	9.5
ASC- 77X130S	70	43	56	60	103	108	-	M6	130	135	77	12	2	9.5
ASC- 77X170S	70	43	96	100	143	148	10	M6	170	175	77	12	2	9.5
ASC- 77X210S	70	43	136	140	183	188	10	M6	210	215	77	12	2	9.5
ASC- 127x160S	87	55	70	75	131	136	16	M6	160	165	127	14	2.5	9.5
ASC- 127x210S	87	55	120	125	181	186	16	M6	210	215	127	14	2.5	9.5
ASC- 127x260S	87	55	170	175	231	236	16	M6	260	265	127	14	2.5	9.5
ASC- 127X310S	87	55	220	225	281	286	16	M6	310	315	127	14	2.5	9.5
ASC- 127X360S	87	55	270	275	331	336	16	M6	360	365	127	14	2.5	9.5

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

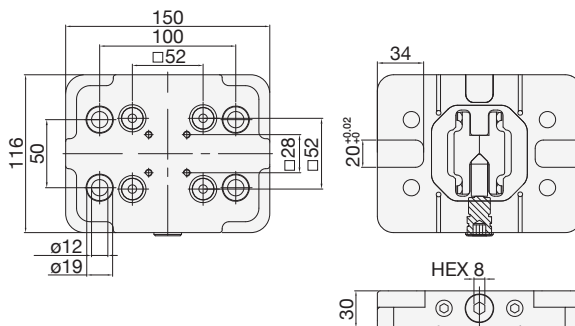
# Optional Accessories

Please refer to Page 22~53 Zero Point Quick Change Devices

## Rectangular Plate

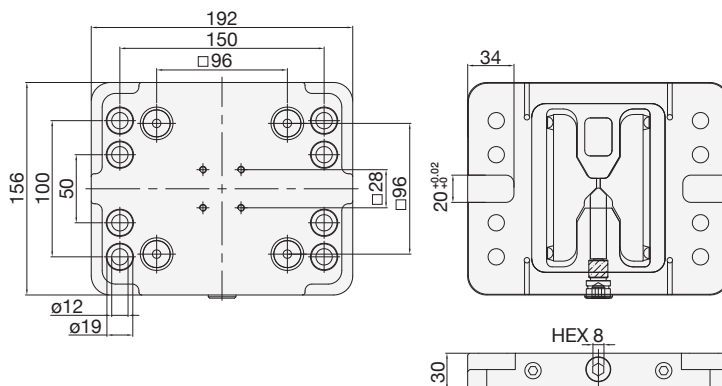
### Model: M-52x52 (8001G)

- Size: 150x116x30 mm
- Pull Stud: M-52x52PS
- Weight: 3.2 kg
- Suitable for  
ASC-77x102S  
ASC-77x130S  
ASC-77x170S  
ASC-77x210S



### Model: M-96x96 (8051G)

- Size: 192x156x30 mm
- Pull Stud: M-96x96PS
- Weight: 6.4 kg
- Suitable for  
ASC-127x160S  
ASC-127x210S  
ASC-127x260S  
ASC-127x310S  
ASC-127x360S



## Master Gauging Pallet

Suitable for quick checking the precise alignment of Quick Changing Plates and for concentric alignment of rotary or chucks.

### Model: M-52x52 (8010)

- Size: 80x80x27 mm
- Pull Stud: M-52x52PS
- Weight: 1.1 kg



### Model: M-96x96 (8058)

- Size: 126x126x27 mm
- Pull Stud: M-96x96PS
- Weight: 2.6 kg



## Pull Studs

Can be adapted onto vises or workpieces to use together with any Quick Change Device.

### Model: M-52x52PS

- 4 pcs / set
- Weight: 0.16 kg / set



### Model: M-96x96PS

- 4 pcs / set
- Weight: 0.28 kg / set



## Spacer Studs

Improve the machining accessibility of edges or angles by making a through space between workpieces and Quick Change Devices.

### Model: M-52x52SS

- 4 pcs / set
- Weight: 0.27 kg / set



### Model: M-96x96SS

- 4 pcs / set
- Weight: 0.4 kg / set

