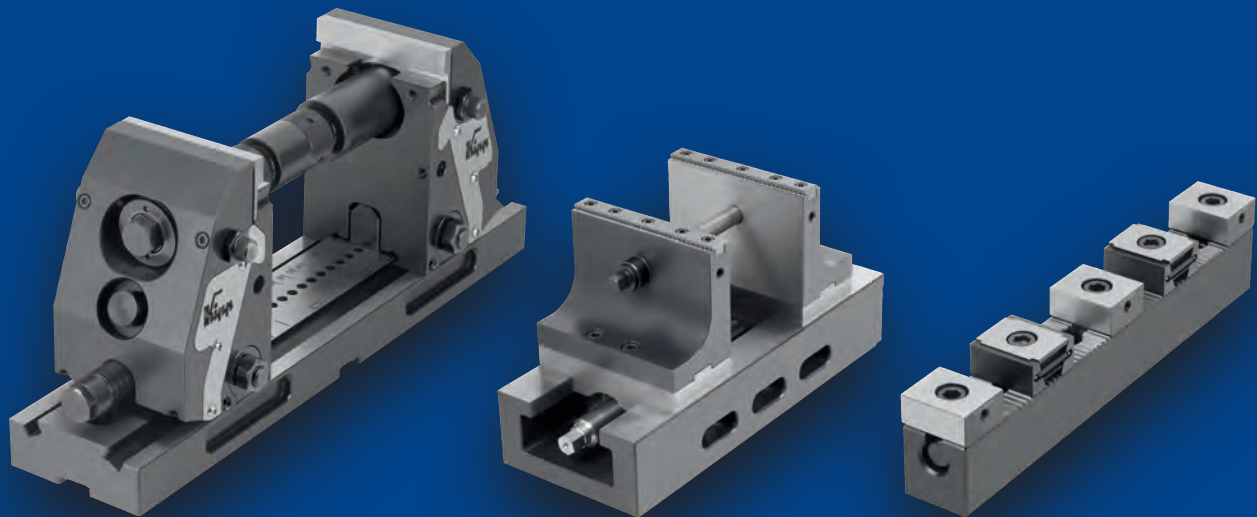




HEINRICH KIPP WERK

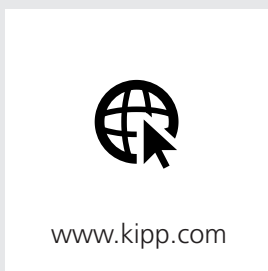
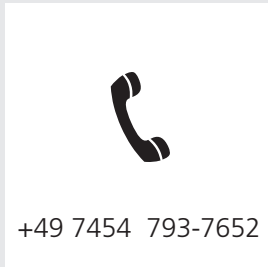


# VICE Clamping Technology

Edition 09 2019



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Reg. Nr. 002081 QM

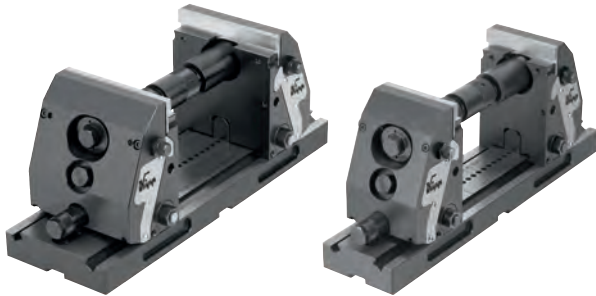


## SERVICE HOURS (CET)

MONDAY-THURSDAY	7.00 am - 5.30 pm
FRIDAY	7.00 am - 3.30 pm



## 5-axis clamping system compact



Adapter shafts  
**K0991**



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Base plates  
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5-axis clamping system compact  
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**K0976**



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Jaw plates smooth  
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**K0988**



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Jaw plates smooth  
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**K1001**



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Jaw plates  
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Jaw plates with pins  
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**K1001**



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Seating ledges  
**K0974**



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Centre jaws  
**K0987**



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Seating ledges  
screw-on  
**K0974**



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Jaw plates smooth  
for centre jaws  
**K1002**



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Extension shafts  
**K0990**



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Jaw plates with pins  
for centre jaws  
**K1002**



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## 5-axis clamping system compact

Jaw pins  
**K0946**



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Cylinder clamping sets  
**K0989**



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Couplings  
for cross-clamping  
**K0992**



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**K0993**



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Clamping claw sets  
**K1008**



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Torque wrench  
for 5-axis clamping system, compact  
**K1489**



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## 3-axis and 5-axis vices



Jaw plates machinable  
**K0944**



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Draw-down jaws  
**K0953**



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Jaw adapters  
for round workpieces  
**K0945**



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Jaw pins  
**K0946**



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Extension shafts  
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**K0947**



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Stop set  
**K0948**



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Shoulder screws  
Form B  
**K0815**



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Fastening set  
for T-slots  
**K0951**



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T-slot plate  
**K0952**



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3-axis clamping system  
for grid plates  
**K0939**



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3-axis clamping system  
for T-slots  
**K0940**



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5-axis clamping system  
for grid plates  
**K0939**



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5-axis clamping system  
for T-slots  
**K0940**



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Riser plates  
**K0941**



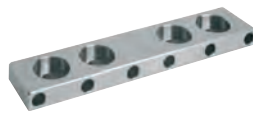
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Seating ledges  
**K0942**



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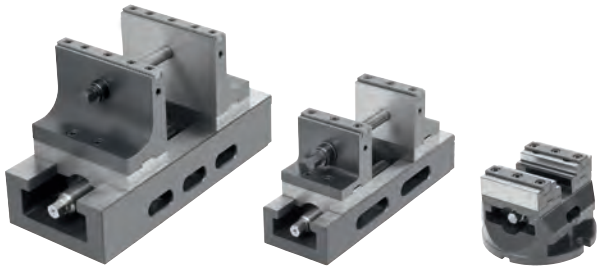
Jaw plates standard  
**K0943**



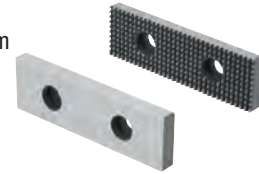
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## Centric vices



Jaw pads  
for centric vice 65-80-125 mm  
**K0598**



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Prism jaw pads  
for centric vice,  
65-80-125 mm  
**K1375**



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Hinged stops  
**K0607**



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Baseplate  
for centric vice  
**K1247**



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Centric vices  
jaw width 65 mm  
**K1236**



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Centric vices  
jaw width 80-125 mm  
**K1237**



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Attachment jaws  
stepped, with grip rail  
**K0587**



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Step jaw attachment  
for 5-axis machining  
**K1115**



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Inserts  
for stepped jaw  
**K0591**



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Attachment step jaws  
for centric vice,  
jaw width 65 mm  
**K1383**



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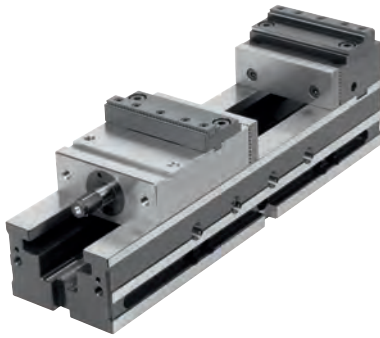
Attachment step jaws  
for centric vice,  
jaw width 80-125 mm  
**K1384**



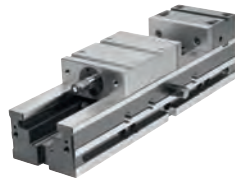
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## NC vices



NC vice  
jaw width 125 mm  
**K1238**



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Attachment step jaw  
with gripper for NC vice  
**K1273**



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Prism jaws  
for NC vice  
**K1376**



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Hold-down jaw pads  
with spring blade  
for NC vice  
**K0601**



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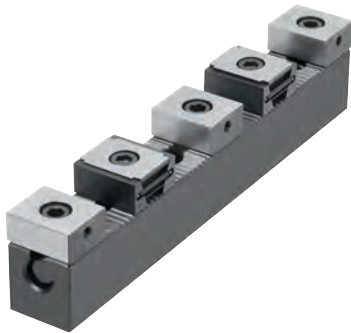
Angle drives  
for NC vice  
**K1377**



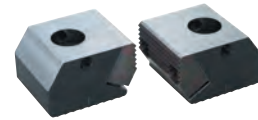
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## Multi-clamping system



Stop with positive down force  
**K0907**



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Base rails  
**K0904**



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Multi-clamping system  
hard stops  
**K0902**



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Seating ledges  
**K0908**



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Multi-clamping system  
soft stops  
**K0903**



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Keyway nuts round  
**K0909**



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Wedge clamps  
jaw face smooth or serrated  
**K0039**



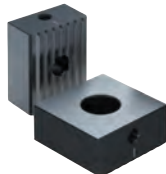
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Wedge clamps  
machinable  
**K0649**



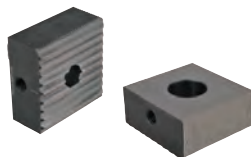
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Stops  
**K0905**



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Stop  
carbide-coated and serrated  
**K0905**



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Stop prism  
**K0906**



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## 5-axis clamping system compact



# 5-axis clamping system compact



## Function

We are setting standards with the new „KIPP 5-axis clamping system compact“ in this field. The system was specifically designed for the optimal machining of complex workpieces on modern 5-axis machines.

The intelligent clamping technology increases clamping rigidity for the highest cutting and feed forces. The optimal accessibility to the workpiece allows short, standard tooling to be used. Tooling costs are significantly reduced.



- 1** Positioning unit with jaw plate
- 2** Clamping element
- 3** Fine adjustment with knurled screw
- 4** Clamping screw
- 5** Extension shafts
- 6** Base plate

### ADVANTAGES:

- Very high tractive force
- High stiffness in the system
- Pull-down function of the jaw plates on both sides
- Optimum fine adjustment of the jaw plates on the workpiece
- Increased tool service life
- The workpiece is always centred due to the systematic construction
- Large clamping width, 20 mm to 320 mm, freely extendable
- Clamping depth adjustable from 3 to 20 mm using seating ledges
- Best tool accessibility from all sides
- Easy to clean

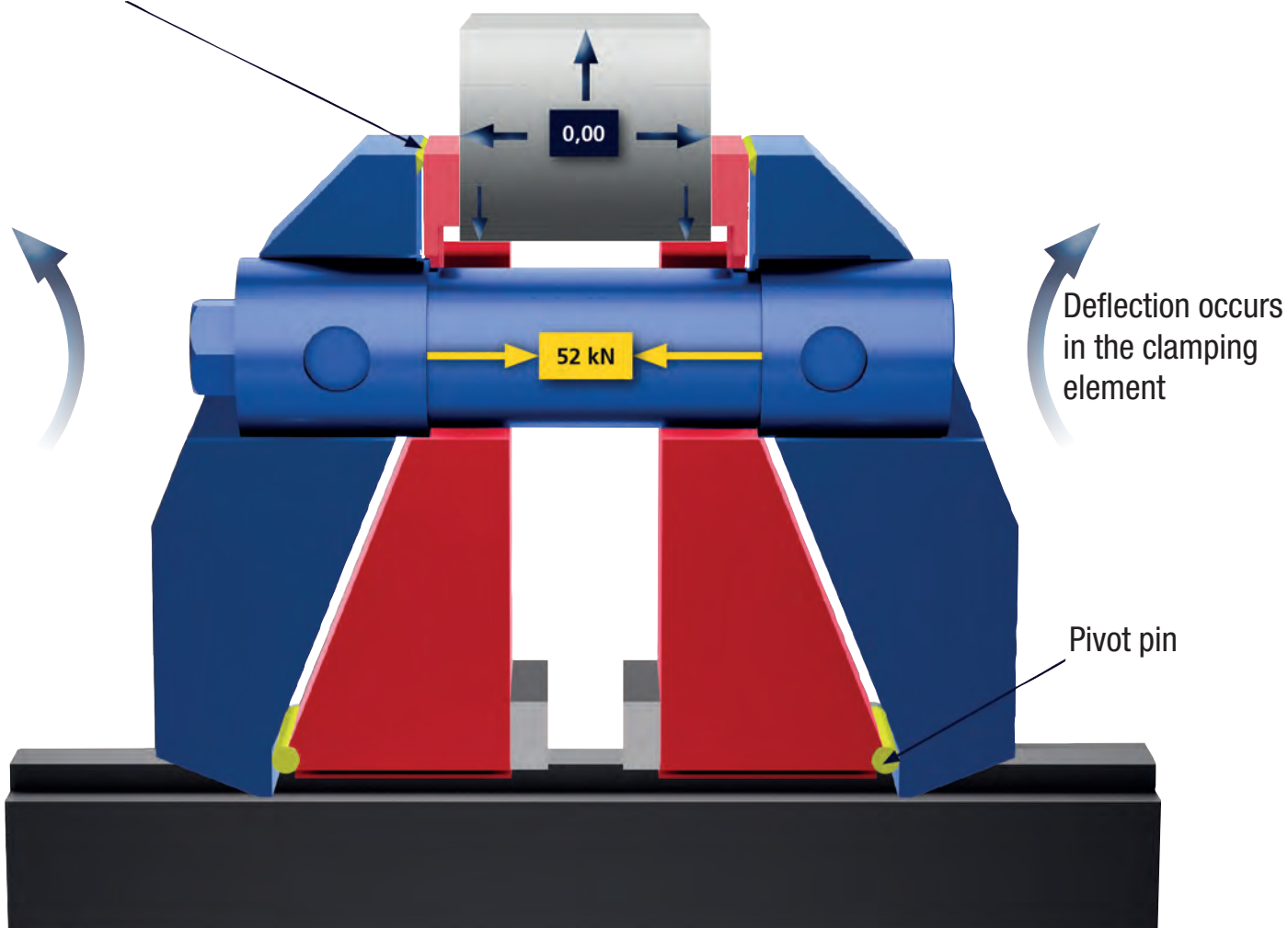
## Forces

The new clamping technology ensures force flow separation and workpiece positioning. The intelligent force distribution in the system allows only weak forces to be transferred to the machine table.

### NEW CLAMPING TECHNOLOGY PATENT PENDING

- Division of force flow and positioning
- Highest clamping force on the workpiece
- Maximum stiffness
- Centric tension

Thrust point

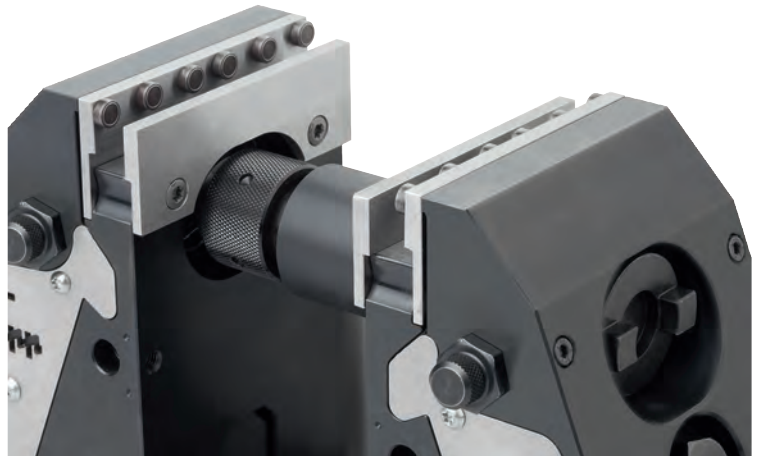


- Clamping elements
- Locators

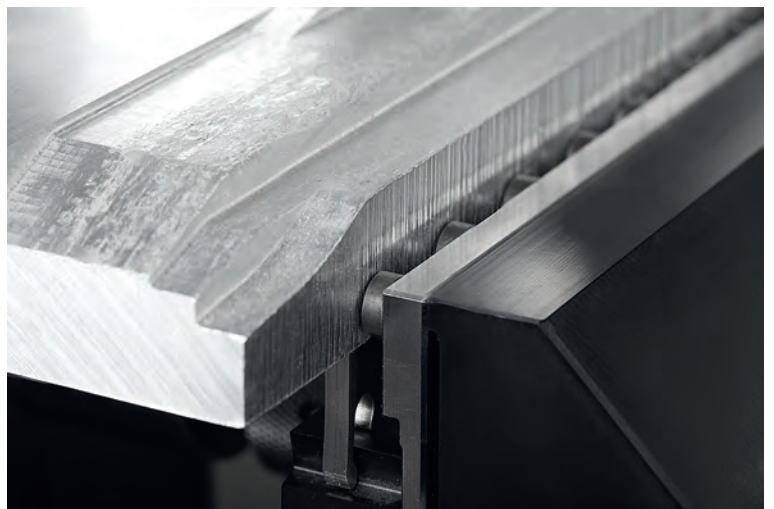
# Applications



5-axis clamping system compact incl. jaw with pins for clamping unmachined parts, and screw-on seating ledges. The clamping depth can be determined by machining the ledge.



Clamped blank. Sure set-up through positive clamping pins.

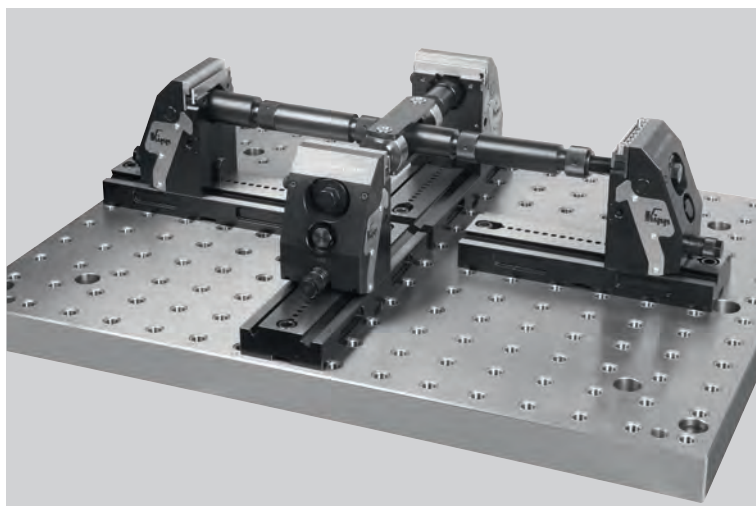


Blank after clamping. Clamping pin imprint is visible on the edge of the workpiece.





With the coupling for cross-clamping, two 5-axis clamping systems can be compactly connected with each other offset by 90 degrees. Setups for workpieces with different dimensions of 4 sides are possible.



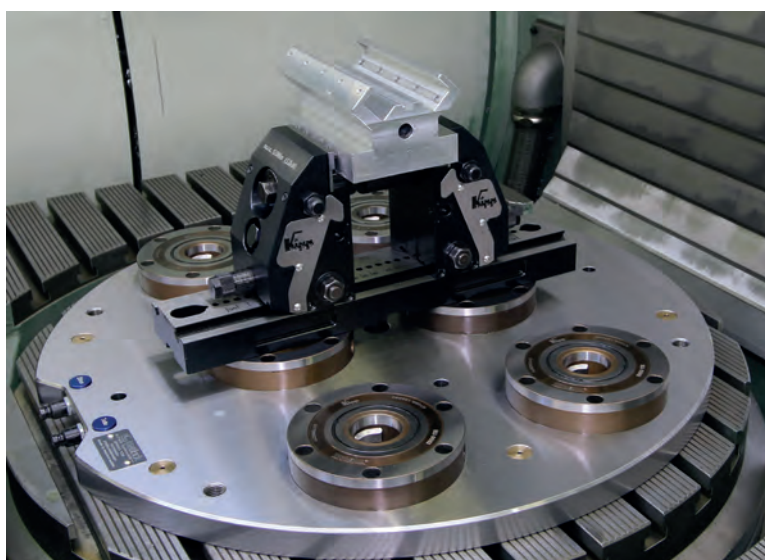
5-axis clamping system compact positioned directly on the machine table.

Use of pendulum jaws which also act as fixed jaws.

Workpiece clamping with smooth jaws.

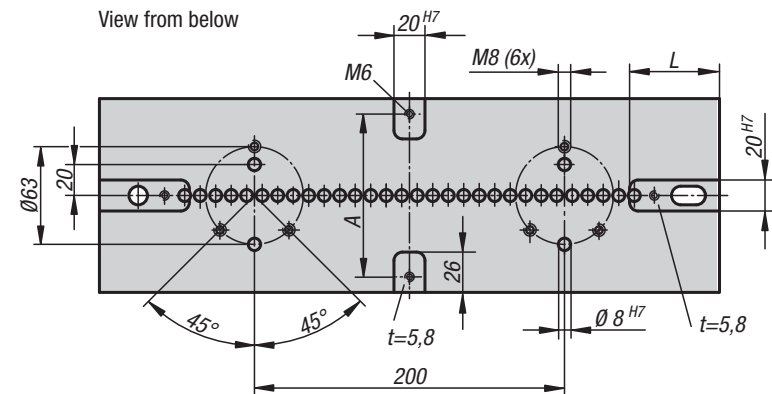
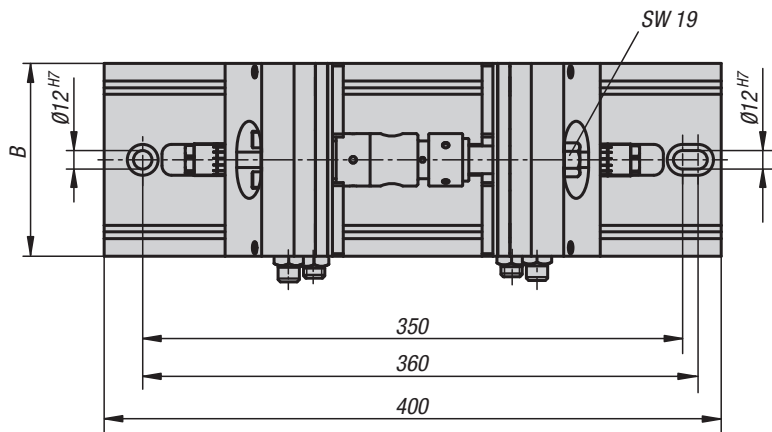
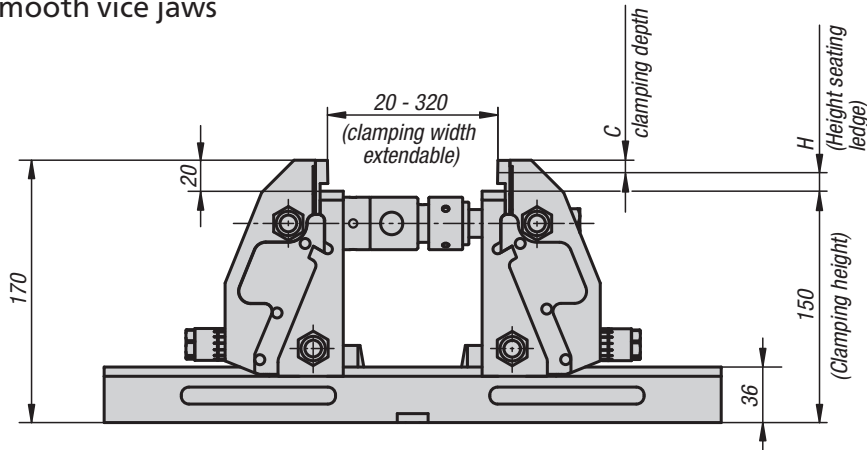
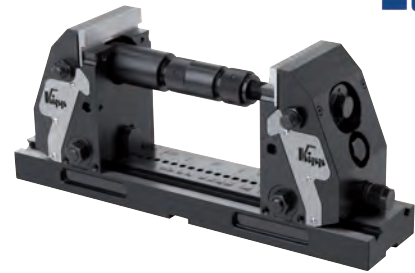


Platzierung direkt auf KIPP Nullpunktspannsystem über integrierte Spannbolzen in der 5-Achs Spanner kompakt Grundplatte.



## 5-axis clamping system compact

smooth vice jaws



**Material:**

Base plate and jaw hardened steel.  
Vice jaws tool steel.

**Version:**

Jaws black oxidised.  
Jaw plates bright.

**Sample order:**

K0973.124000901500

**Note:**

The easy operability and rapid adjustment using a scale means that the clamping jaws can be quickly and surely adapted to new workpieces. The workpiece is always centred through the systematic construction of the 5-axis compact clamping system. The optimal accessibility to the workpiece allows short, standard tooling to be used. Tooling costs are significantly reduced.

Positive down force by a clamping depth of >5 mm. Clamping widths of 20 mm to 320 mm are possible.

**Assembly:**

The 5-axis clamping system compact can be mounted on T-slot tables, grid systems or, using an adapter flange on conventional zero-point clamping systems.

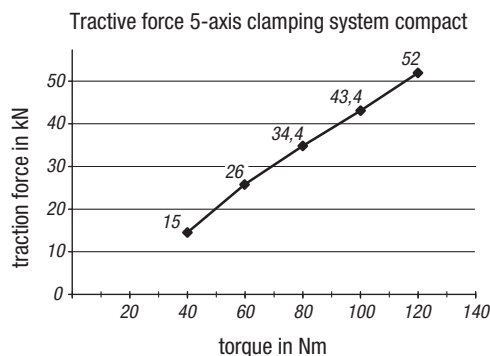
**Supplied with:**

- Baseplate K0994
- Clamping jaw K0976
- Extension shaft K0990.060
- Extension shaft K0990.120
- Adapter shaft K0991.060
- Adapter shaft K0991.120
- Threaded spindle K0940.999.002
- Spindle nut K0940.999.003

**Accessories:**

- Seating ledges K0974
- Jaw plates K0975
- Pendulum jaws K0988
- Centre jaws K0987
- Coupling for cross-clamping K0992

Order the seating ledges and jaw plates with pins separately.

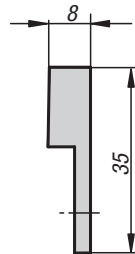
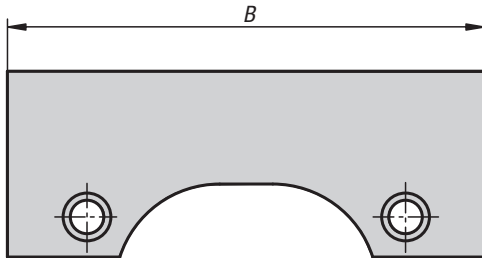


**KIPP 5-axis clamping system compact, smooth vice jaws**

Order No.	A	B	C	H	L	Tractive force max. kN	Suitable shoulder screw	weight kg
K0973.124000901500	70	90	8/3	12/17	57,5	52	K0815.12055	21,96
K0973.124001251500	105	125	8/3	12/17	58	52	K0815.12055	30,16



## Jaw plates smooth



**Material:**  
Tool steel.

**Version:**  
Hardened, bright.

**Sample order:**  
K0975.0900

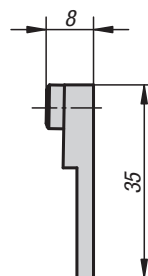
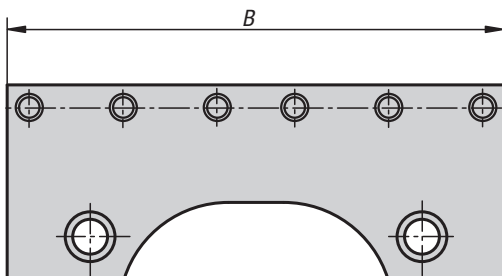
**Note:**  
For clamping pre-machined workpieces and for final machining.

Supplied singly.

### KIPP Jaw plates smooth

Order No.	B
K0975.0900	90
K0975.1250	125

## Jaw plates with pins



**Material:**  
Tool steel.

**Version:**  
Plate hardened, bright.  
Pins hardened, black oxidised.

**Sample order:**  
K0975.0901

**Note:**  
For positive clamping without preforming, e.g. rough pieces, heavy cutting, castings etc.

Supplied singly.

### KIPP Jaw plates with pins

Order No.	B	No. of pins
K0975.0901	90	6
K0975.1251	125	8

## Jaw plates

machinable



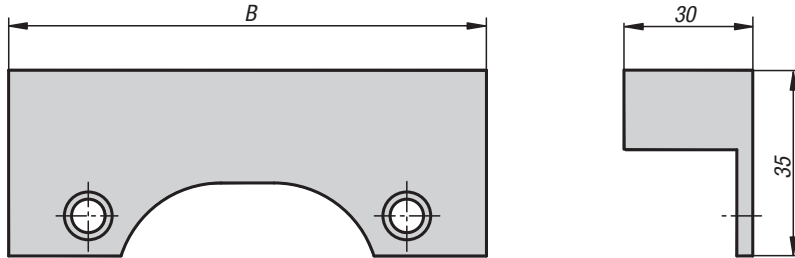
**Material:**  
Carbon steel.

**Version:**  
Black oxidised.

**Sample order:**  
K0975.0902

**Note for ordering:**  
Supplied singly.

**Note:**  
Machinable jaw plates are ideal for gripping on workpiece contours and machining in steps.



### KIPP Machinable jaw plates

Order No.	B
K0975.0902	90
K0975.1252	125

# K0974

## Seating ledges



**Material:**  
Hardened steel

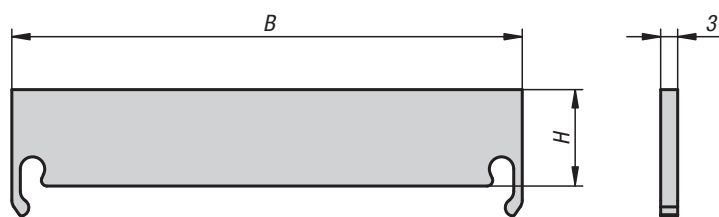
**Version:**  
Bright.

**Sample order:**  
K0974.0900312

**Note:**  
The seating ledges are suitable for adjusting the clamping depth of the workpiece on the compact 5-axis clamping system. The 12 mm version does not interfere with the positive-down effect. By the 17 mm version, the positive-down force is reduced but causes less edge deformation.

Supplied in pairs.

**Accessories:**  
for K0973

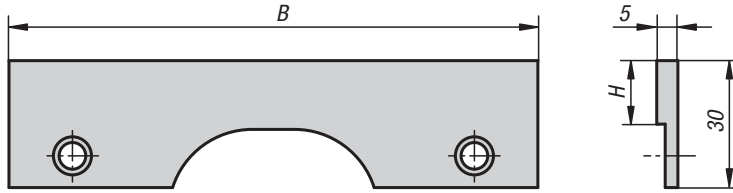


### KIPP Seating ledges

Order No.	B	H
K0974.0900312	90	12
K0974.0900317	90	17
K0974.1250312	125	12
K0974.1250317	125	17

## Seating ledges

screw-on



**Material:**  
Steel.

**Version:**  
Bright.

**Sample order:**  
K0974.0900515

**Note:**

Screw-on seating ledges are used to set the seating height of the workpiece. The desired seating height is achieved by milling over the screwed on ledges. A very high accuracy of the height to the machine table can be achieved.

Supplied in pairs.

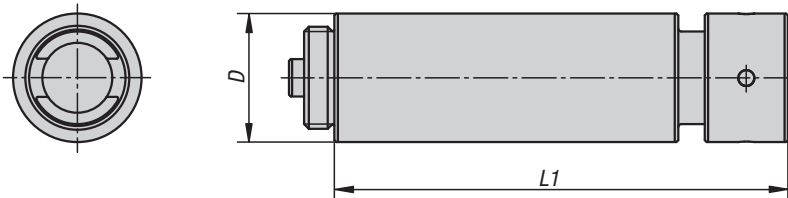
**Accessories:**  
for K0973

### KIPP Seating ledges, screw-on

Order No.	B	H
K0974.0900515	90	15
K0974.1250515	125	15

# K0990

## Extension shafts



**Material:**  
Carbon steel.

**Version:**  
Black oxidised.

**Sample order:**  
K0990.060

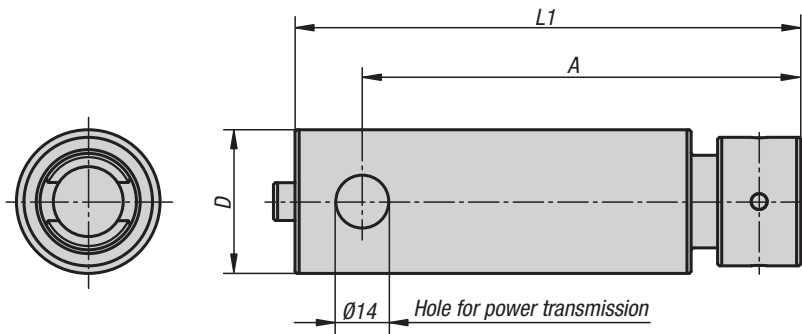
**Note:**

For setting the clamping width.  
Supplied with union nut.  
The extension shafts can be combined as required.

### KIPP Extension shafts

Order No.	D	L1	Clamp range
K0990.060	34	60	Extension by 60 mm
K0990.120	34	120	Extension by 120 mm
K0990.240	34	240	Extension by 240 mm
K0990.480	34	480	Extension by 480 mm

## Adapter shafts



**Material:**

Carbon steel.

**Version:**

Black oxidised.

**Sample order:**

K0991.060

**Note:**

For setting the clamping width.

Supplied with union nut.

The adapter shafts are linked to the vice jaws by the lateral holes.

An adapter shaft must be mounted in every compact 5-axis clamp.

**Drawing reference:**

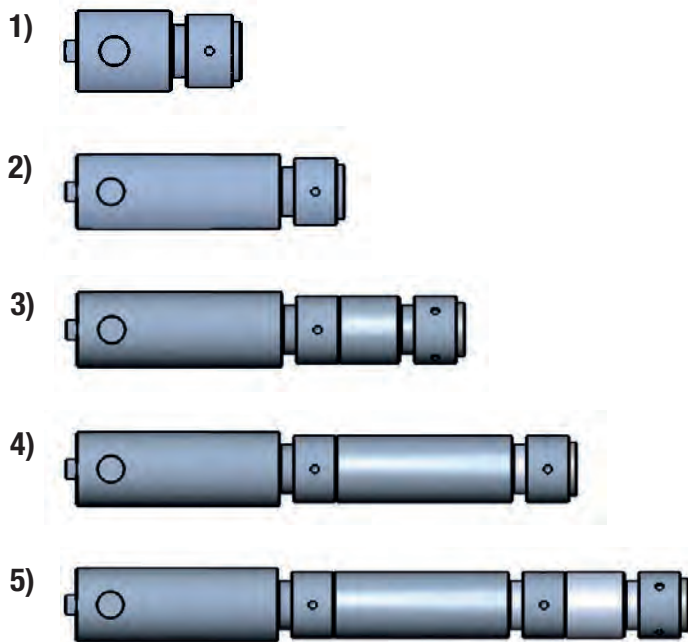
1) Clamping width 20 - 80 mm Adapter shaft 60 mm + threaded spindle

2) Clamping width 80 - 140 mm Adapter shaft 120 mm + threaded spindle

3) Clamping width 140 - 200 mm Adapter shaft 120 mm + expansion rod 60 mm + threaded spindle

4) Clamping width 200 - 260 mm Adapter shaft 120 mm + extension rod 120 mm + threaded spindle

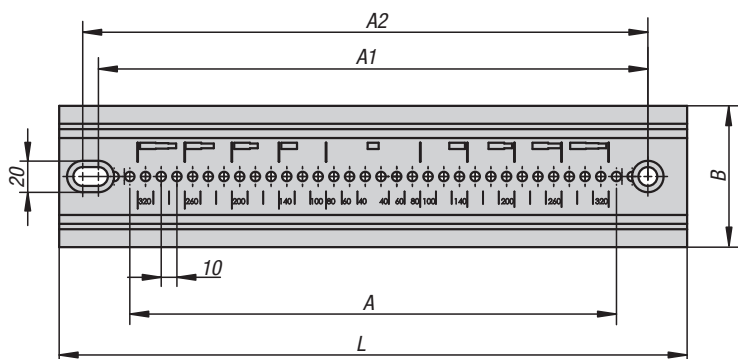
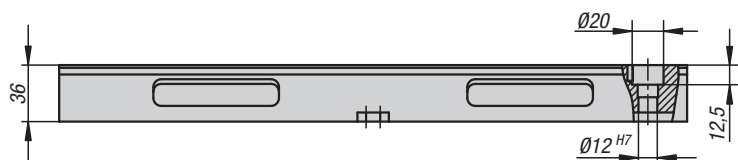
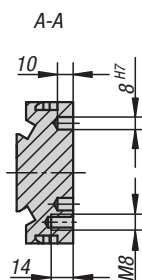
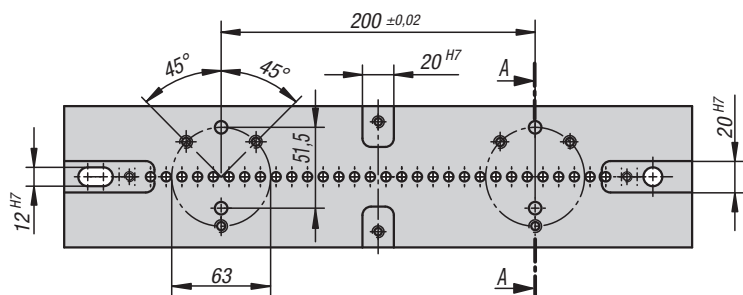
5) Clamping width 260 - 320 mm Adapter shaft 120 mm + extension rod 120 mm + extension rod 60 mm + threaded spindle



### KIPP Adapter shafts

Order No.	A	D	L1	Clamp range
K0991.060	56	38	74	20-80
K0991.120	116	38	134	80-140

## Base plates



**Material:**

Steel.

**Version:**

Black oxidised.  
Function faces ground.

**Sample order:**

K0994.090280

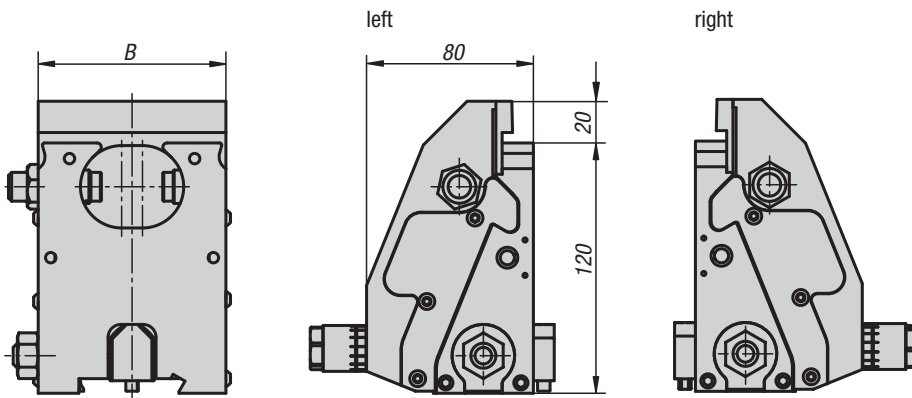
**Note:**

Base plates with locating slots on the underside for easy alignment of the plate on the machine table. Securing via grid holes 12F7 for 40 mm and 50 mm grid spacing possible. Lateral recesses provided for separate clamping means.

### KIPP Base plates

Order No.	A	A1	A2	B	L	Suitable shoulder screw	weight kg
K0994.090280	20x10	240	250	90	280	K0815.12055	6,14
K0994.125280	20x10	240	250	125	280	K0815.12055	8,86
K0994.090400	31x10	350	360	90	400	K0815.12055	8,58
K0994.125400	31x10	350	360	125	400	K0815.12055	12,24

## Vice jaws complete



**Material:**

Jaws mild steel.  
Jaw plates tool steel.

**Version:**

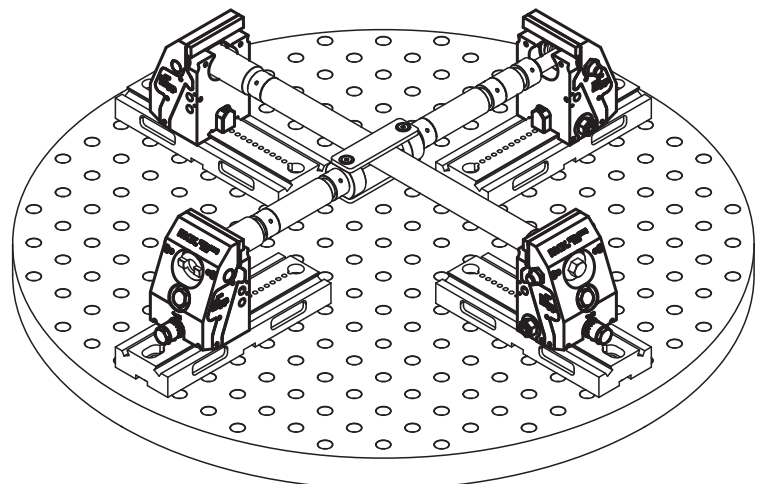
Jaws black oxidised.  
Vice jaws bright.

**Sample order:**

K0976.09015010

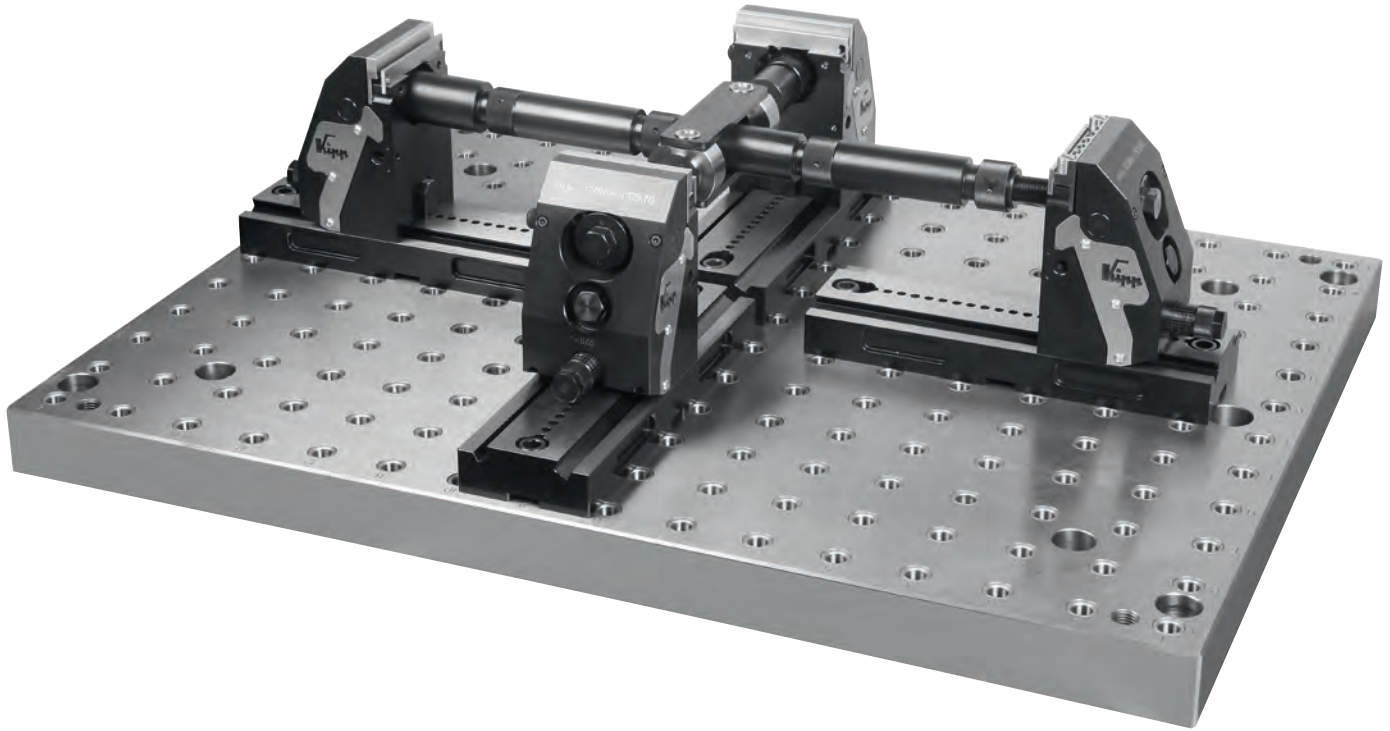
**Note:**

These vice jaws are for expanding the 5-axis clamping system compact. With these vice jaws large workpieces can be held on all four sides by cross clamping. Base plates, extension shafts and the coupling for cross-clamping are also needed for this set up.

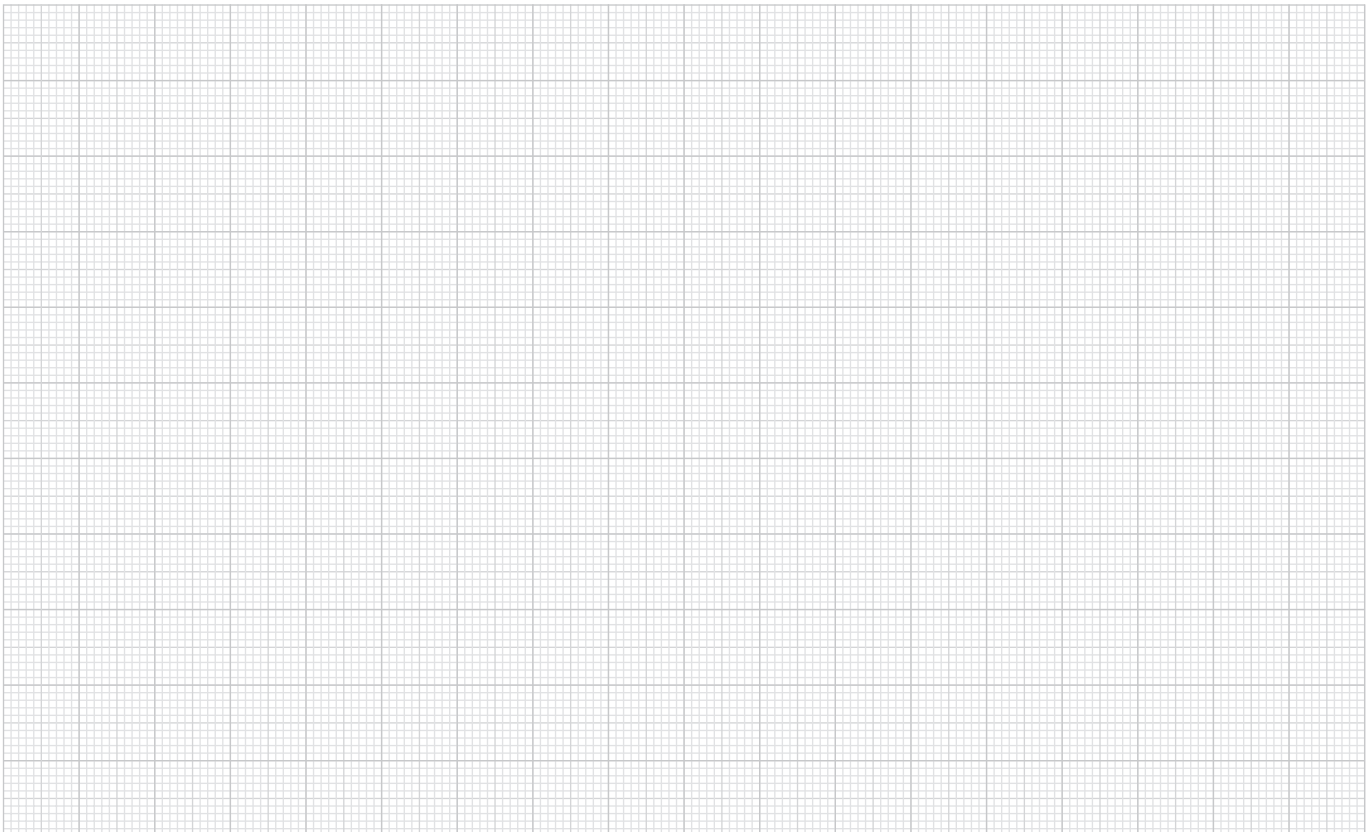


### KIPP Vice jaws, complete

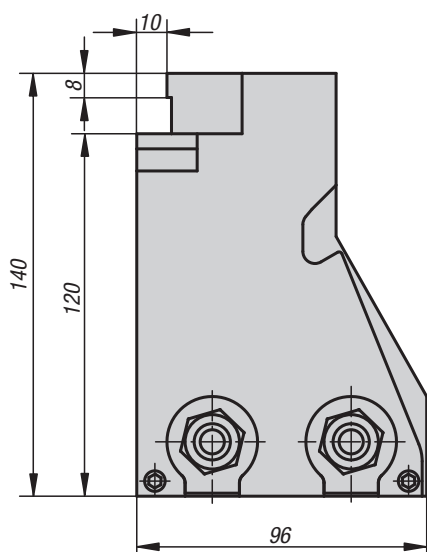
Order No.	Version	B	weight kg
K0976.09015010	right	90	5,18
K0976.09015020	left	90	5,4
K0976.12515010	right	125	7,42
K0976.12515020	left	125	7,42



## Notes



## Pendulum jaws



**Material:**

Body mild steel.  
Jaw plates tool steel.

**Version:**

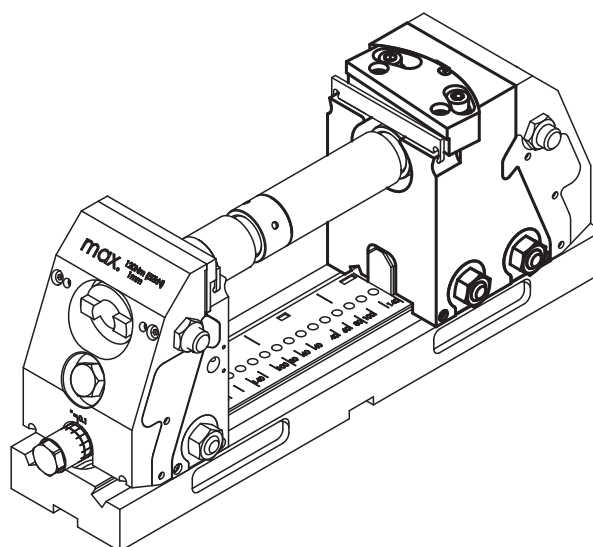
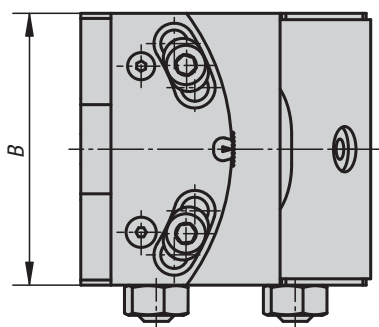
Body black oxidised.  
Vice jaws hardened, bright.

**Sample order:**

K0988.09015010

**Note:**

Pendulum jaws are used to hold oblique workpieces.  
The jaw plates of the pendulum jaws can be swivelled by  $\pm 4^\circ$ .  
Pendulum jaws can also be used as fixed jaws.  
Rigid design with 2 fastening screws.



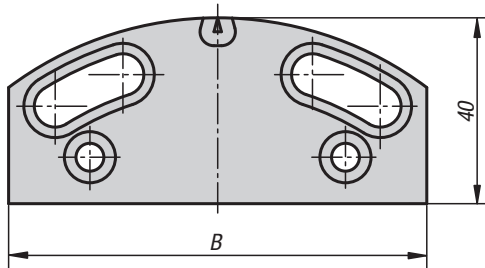
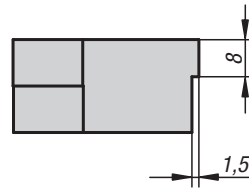
### KIPP Pendulum jaws

Order No.	B	weight kg
K0988.09015010	90	6
K0988.12515010	125	8,77



## Jaw plates smooth

for pendulum jaws



**Material:**  
Tool steel.

**Version:**  
Hardened, bright.

**Sample order:**  
K1001.0900

**Note:**  
For clamping pre-machined and ground workpieces.

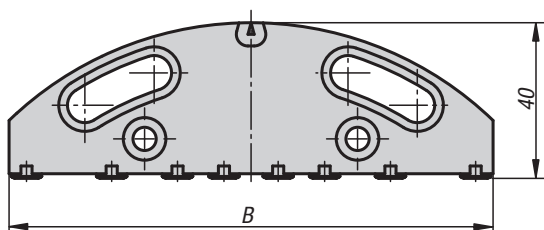
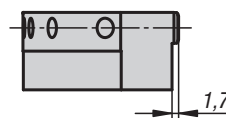
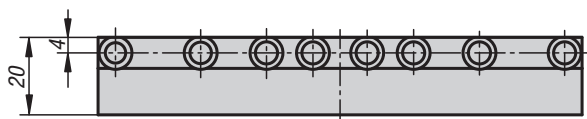
Supplied singly.

### KIPP Jaw plates smooth for pendulum jaws

Order No.	B
K1001.0900	90
K1001.1250	125

## Jaw plates with pins

for pendulum jaws



**Material:**  
Tool steel.

**Version:**  
Vice jaw hardened, bright.  
Pins hardened, black oxidised.

**Sample order:**  
K1001.0901

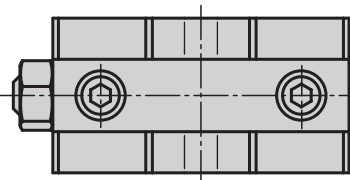
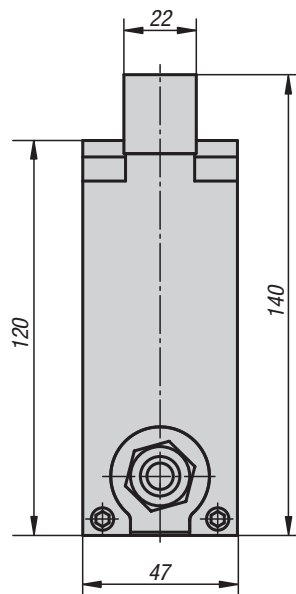
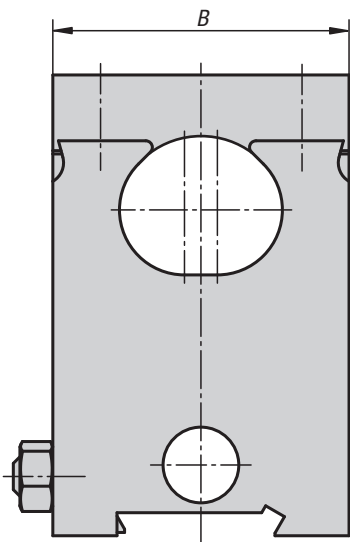
**Note:**  
For positive clamping without preforming, e.g. rough pieces, heavy cutting, castings etc.

Supplied singly.

### KIPP Jaw plates with pins for pendulum jaws

Order No.	B	No. of pins
K1001.0901	90	6
K1001.1251	125	8

**Centre jaws**

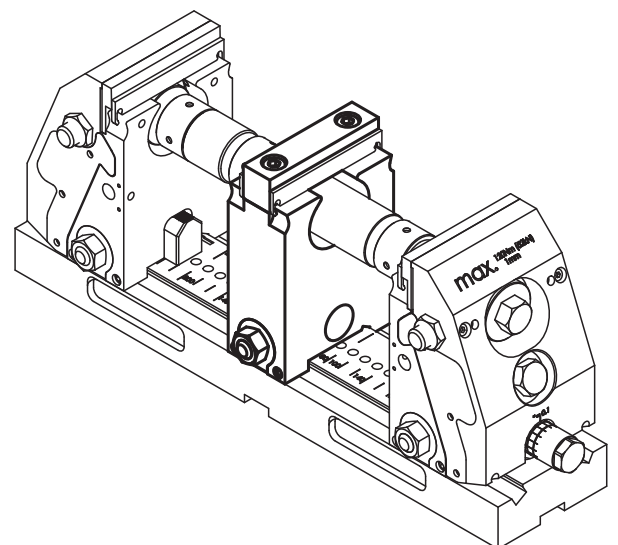


**Material:**  
 Body mild steel.  
 Jaw plates tool steel.

**Version:**  
 Body black oxidised.  
 Vice jaws hardened, bright.

**Sample order:**  
 K0987.0901500

**Note:**  
 Centre jaws are used to clamp 2 workpieces simultaneously.  
 The centre jaws can be moved to suit the size of the workpiece. 2 different sized workpiece can be clamped.



**KIPP Centre jaws**

Order No.	B	weight kg
K0987.0901500	90	3,38
K0987.1251500	125	5,1

# K1002

## Jaw plates smooth

for centre jaws



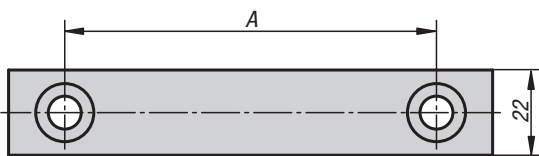
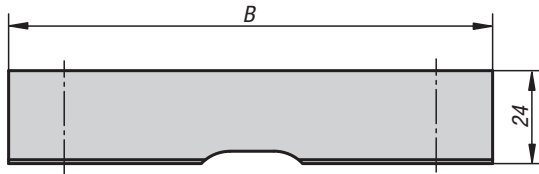
**Material:**  
Tool steel.

**Version:**  
Hardened, bright.

**Sample order:**  
K1002.0900

**Note:**  
For clamping pre-machined and ground workpieces.

Supplied singly.



### KIPP Jaw plates smooth for centre jaws

Order No.	A	B
K1002.0900	61	90
K1002.1250	96	125

# K1002

## Jaw plates with pins

for centre jaws



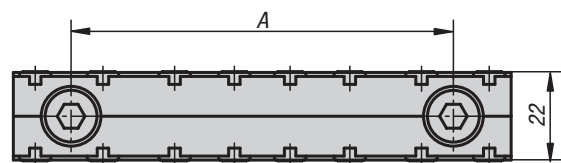
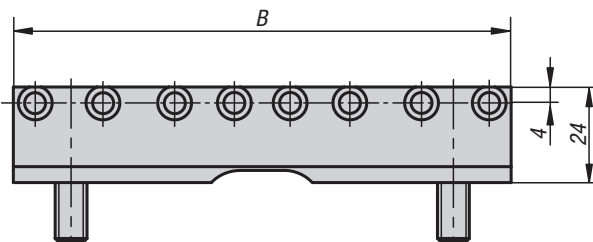
**Material:**  
Tool steel.

**Version:**  
Vice jaw hardened, bright.  
Pins hardened, black oxidised.

**Sample order:**  
K1002.0901

**Note:**  
For positive clamping without preforming, e.g. rough pieces, heavy cutting, castings etc.

Supplied singly.



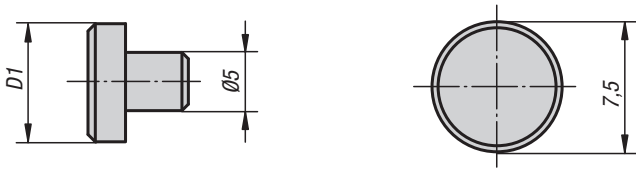
### KIPP Jaw plates with pins for centre jaws

Order No.	A	B	No. of pins
K1002.0901	61	90	6
K1002.1251	96	125	8

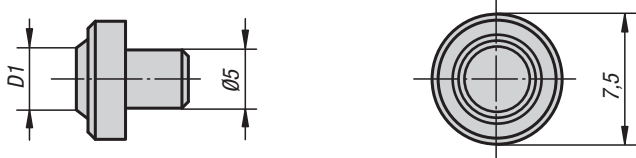
## Jaw pins



flattened



cup point



**Material, version:**  
Tool steel, hardened.

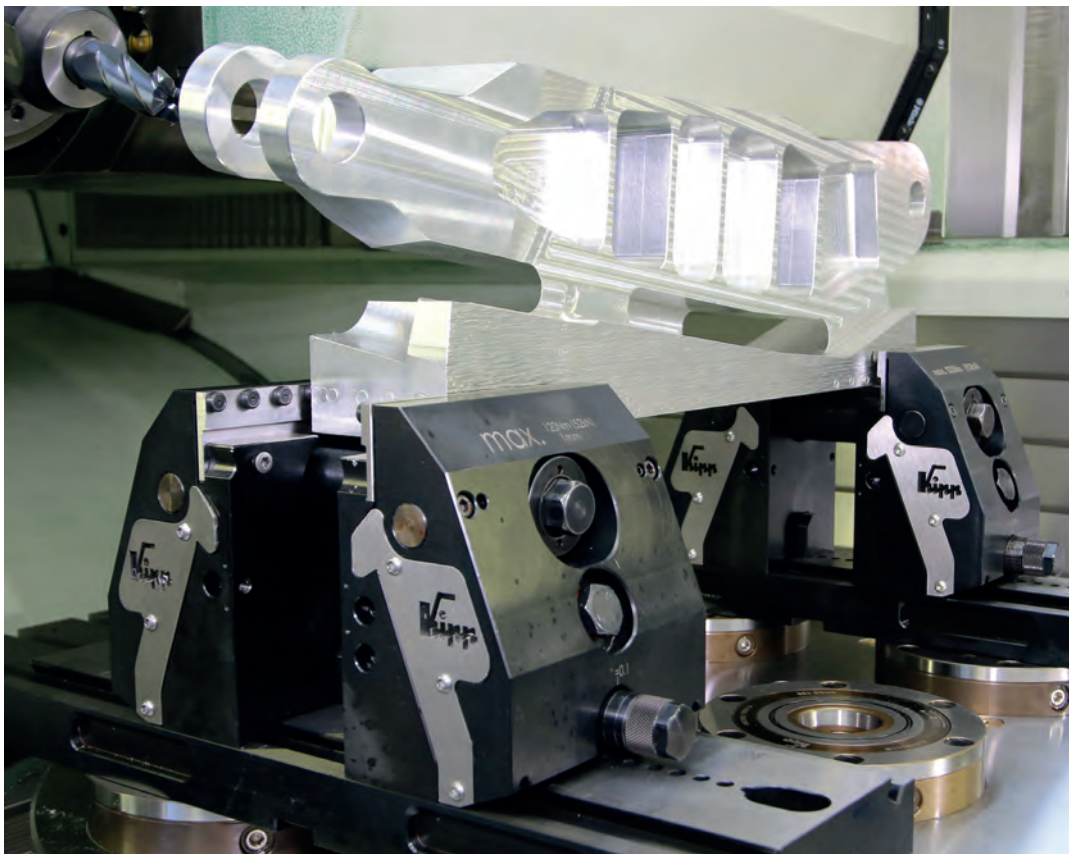
**Sample order:**  
K0946.05600

**Note:**  
Suitable for standard jaw plates and jaw adapters of round workpieces.  
Installed by pressing in.

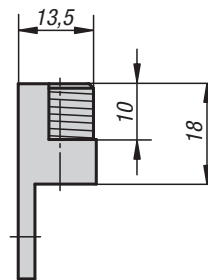
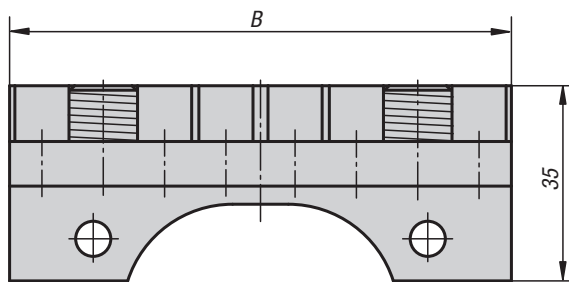
### KIPP Jaw pins

Order No.	Version	D1	Application
K0946.05000	flattened	7,5	Material over 1000 N/mm <sup>2</sup> tensile strength
K0946.05400	cup point	4	Material up to ca. 1000 N/mm <sup>2</sup> tensile strength
K0946.05600	cup point	6	Material up to ca. 1000 N/mm <sup>2</sup> tensile strength

## Application example



## Cylinder clamping sets



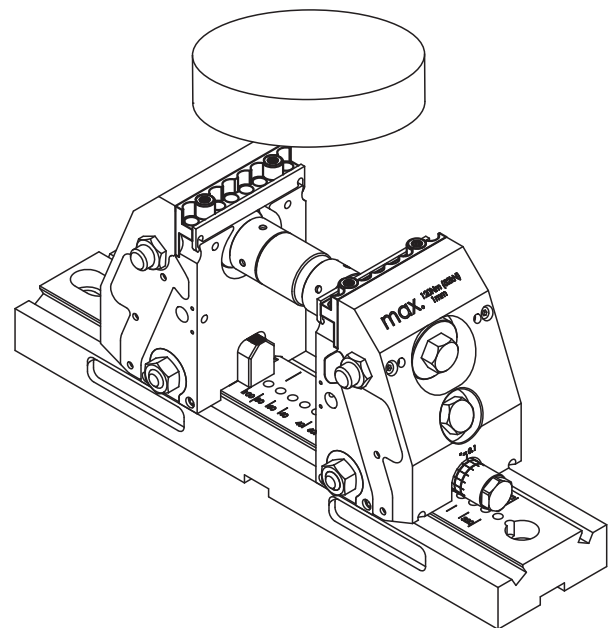
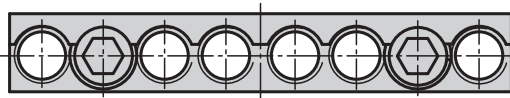
**Material:**  
Tool steel.

**Version:**  
Vice jaw hardened, bright.  
Pins hardened, black oxidised.

**Sample order:**  
K0989.09035

**Note:**  
For holding round workpieces.

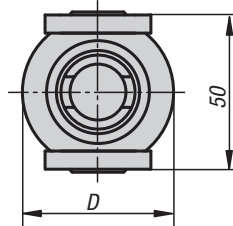
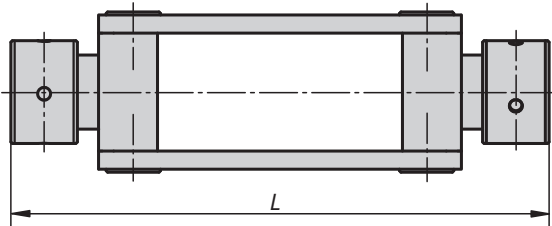
Supplied in pairs.



### KIPP Cylinder clamping sets

Order No.	B	Clamping range min. - max.
K0989.09035	90	20 mm - 250 mm
K0989.12535	125	20 mm - 320 mm

## Couplings for cross-clamping

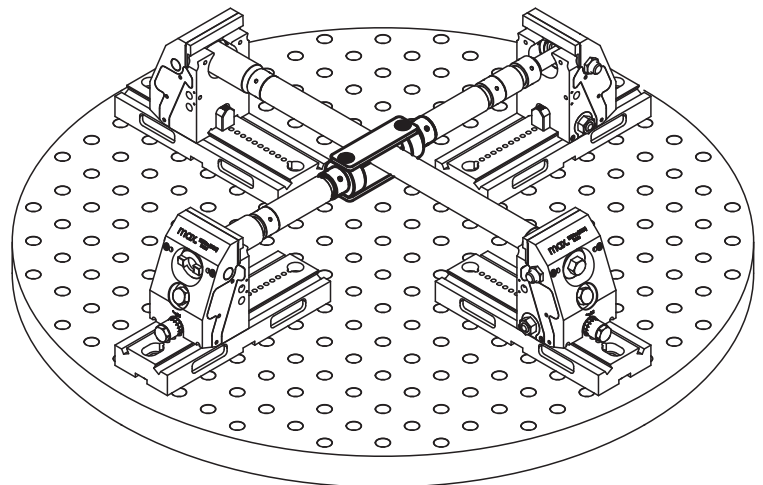
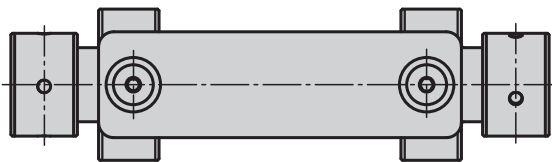


**Material:**  
Carbon steel.

**Version:**  
Black oxidised.

**Sample order:**  
K0992.178

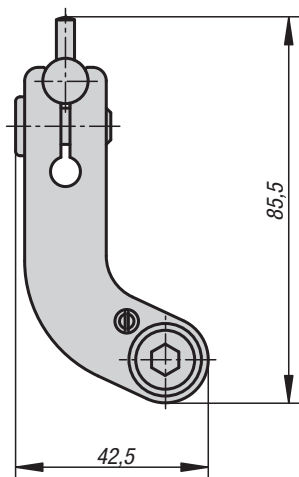
**Note:**  
Two 5-axis clamping systems can be connected using a coupling for cross-clamping, allowing a workpiece to be held on four sides.



### KIPP Couplings for cross-clamping

Order No.	D	L
K0992.178	50	178

## Stop sets



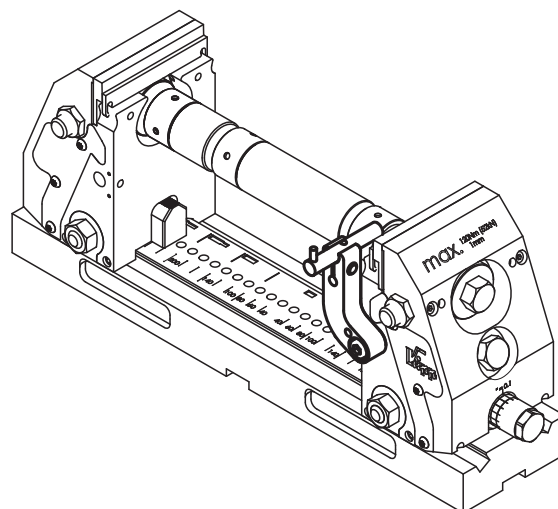
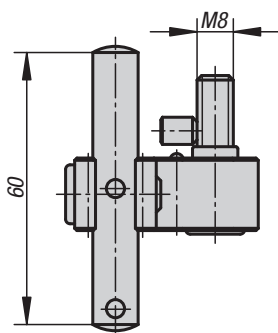
**Material:**  
Steel.

**Version:**  
Swivel arm, black oxidised.  
Stop pin bright.

**Sample order:**  
K0993.150

**Note:**  
Stop set for direct fastening to jaws. The stop can be swivelled aside for machining the workpiece without losing the stop dimension.

Supplied complete with attachment parts.



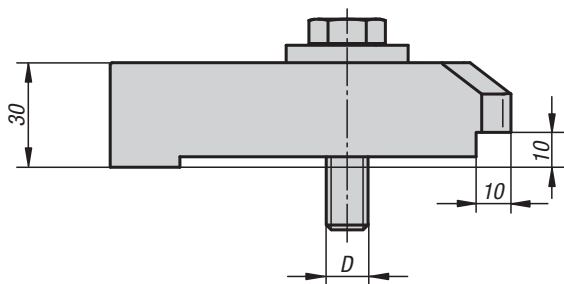
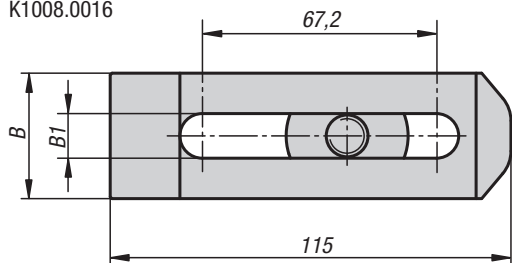
### KIPP Stop sets

Order No.	Suitable for
K0993.150	5-axis vice

## Clamping claw sets



K1008.0012  
K1008.0016



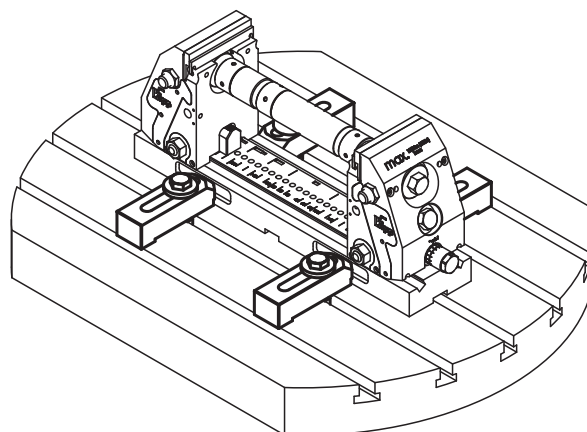
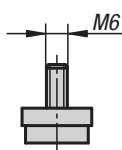
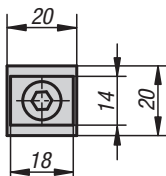
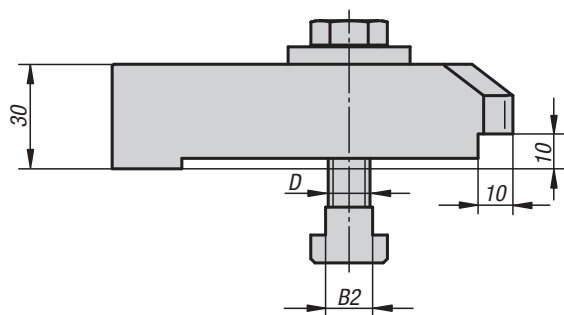
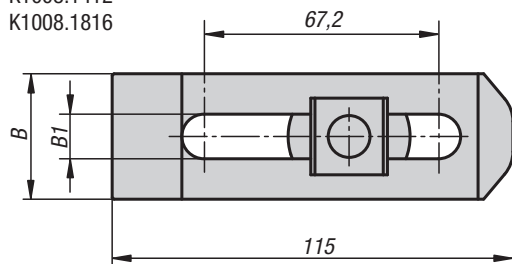
**Material:**  
Carbon steel.

**Version:**  
Black oxidised.

**Sample order:**  
K1008.0012

**Note:**  
Clamping claw set for compact 5-axis clamping system.  
All common T-slots, grid and fastening hole spacings can be covered.

K1008.1412  
K1008.1816



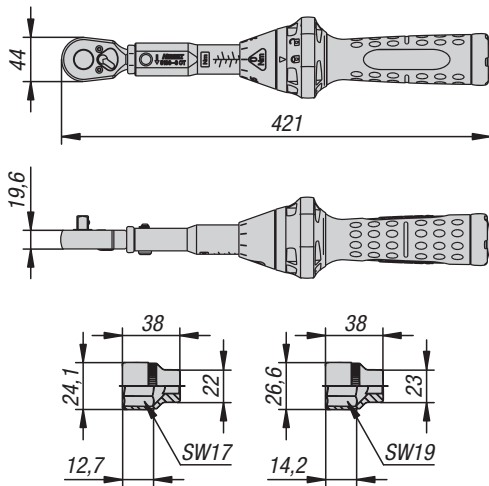
### KIPP Clamping claw sets

Order No.	B	B1	B2	D
K1008.0012	36	12,8	-	M12
K1008.0016	40	16,8	-	M16
K1008.1412	36	12,8	13,5	M12
K1008.1816	40	16,8	17,5	M16



## Torque wrench

for 5-axis clamping system, compact



### Supplied with:

Set comprising:  
Torque wrench  
Key insert SW17  
Key insert SW19

### Functional principle:

Operating principle of torque wrench handles

- Unlocking.
- Press handle approximately 8 mm forward and rotate in the desired direction.
- Continue to turn handle up to the desired torque.
- Turn the handle back a bit.
- Locking.

### Suitable for:

3 Axis clamping system  
5 Axis clamping system  
5 Axis Clamping system compact

### Material:

Steel.

### Version:

Surface: hard chromed

### Sample order:

K1489.01

### Note:

Torque wrench 20-120 set:

- Precision +/- 3% of the scale value (in direction of actuation) (5107-3 CT +/- 4% release precision)
- Secure: - haptic (shortcut release)
- acoustic (buckling element)
- Designed for rough workshop use.
- Broad spectrum of use for controlled screw tightening. Applications in industry and trades.
- Optimised sealing ring for protection from foreign matter.
- Ratchet repair set for customer-oriented self-assembly permits use for decades.
- Handle with roll protection for easier power transmission through more grip.
- Adjustment aid through indexing points for optimised operator guidance guarantees secure and fast setting of the desired torque value by turning the handle.
- Secure locking of the setting values through detent on the swivel head.
- Lock symbols signal the respective locking condition.
- Possibility to fasten rope loop through openings on the locking mechanism swivel head.
- Easily readable, contrast-rich scale.
- Permanent readability through laser labelling of the scale sleeve.
- Integrated switch lever.
- Certified acc. to DIN EN ISO 6789-2:2017.
- With calibration certificate and serial number.
- Delivery in stable hexagonal rotary box.
- Square acc. to DIN 3120, ISO 1174-1, DIN EN ISO 6789-2:2017.

### Key insert (hex):

- With knurling
- Surface: chrome-plated, polished
- DIN 3124, ISO 2725-1

### Recommendation:

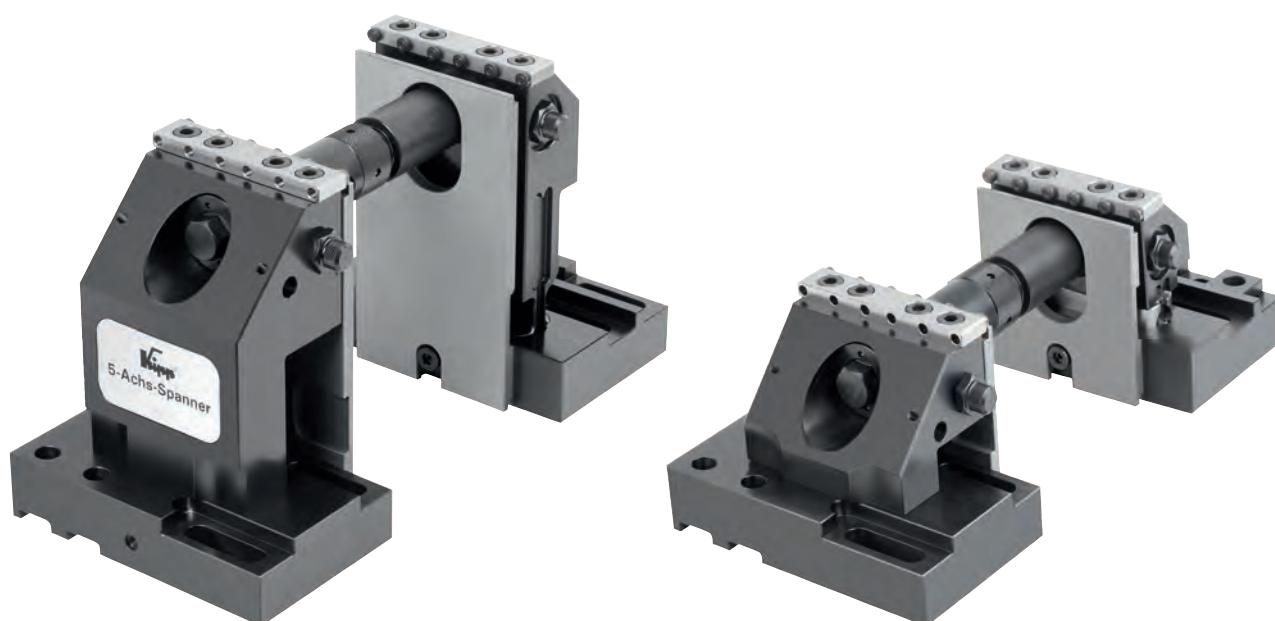
Annual check interval for torque wrenches, in which the upper limit is 5,000 load cycles.

## KIPP Torque wrench for 5-axis clamping system compact

Order No.	Item	Version	Product type	Torque Nm
K1489.01	Torque wrench	set	Revolving grip	20 - 120



**3-axis clamping system**  
**5-axis clamping system**



# 5 Axis clamping system



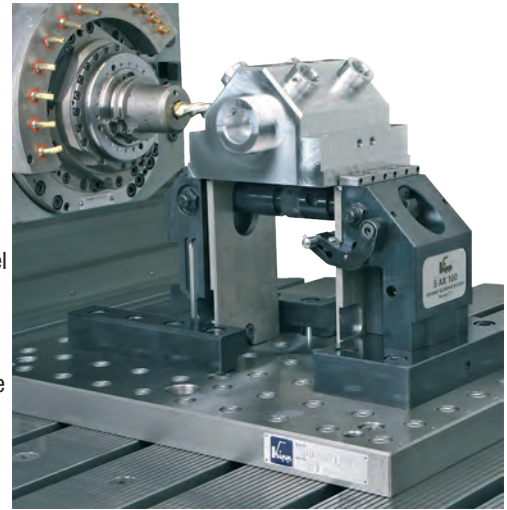
## Trend-setting clamping concept for 5-sided machining

The 5-axis clamping system complements modern milling centres to produce an unbeatable overall concept.

Many products are becoming more complicated than ever, and also have to be produced in an extremely short time and with maximum precision. To satisfy these criteria workpieces must more often be completely machined in one set-up. Modern manufacturing technology adopted by machine tool manufacturers is the development of 5-axis machining. Complete machining of workpieces on 5-axis centres transfers the entire high precision to the workpiece.

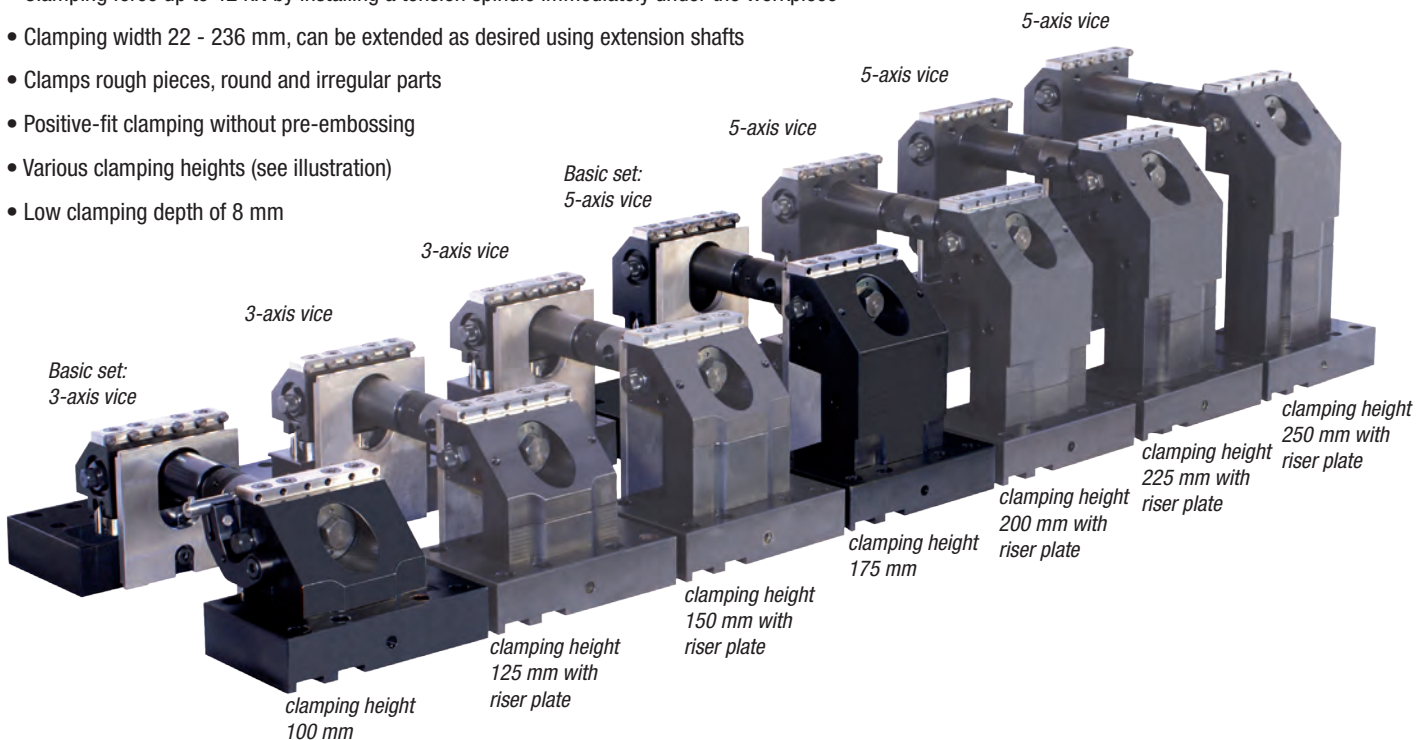
Due the greater configuration options for workpieces provided by 5-axis machining, a high-performance clamping system is an essential precondition for the efficient use of these machines. Among other things, an optimised clamping system helps guarantee that the machine's complex travel can produce a high-precision workpiece.

The 5-axis clamping systems allow machining free of interfering edges and vibration, with extremely high cutting and feed forces. They enable the application of extremely short tools in order to guarantee the required tolerances and surfaces.



## 5 and 3 axis vices for trouble-free 5-sided machining with a single setup

- Can be set up on grid hole plates, on T-slot plates and on your own fixtures
- Clamping force up to 42 kN by installing a tension spindle immediately under the workpiece
- Clamping width 22 - 236 mm, can be extended as desired using extension shafts
- Clamps rough pieces, round and irregular parts
- Positive-fit clamping without pre-embossing
- Various clamping heights (see illustration)
- Low clamping depth of 8 mm



# 5 Axis clamping system



## Special technical features - clamping process



before clamping

The clamping process involves the penetration of hardened, exchangeable clamping pins in to the workpiece. This guarantees positive-fit clamping without pre-embossing. Optionally, flattened clamping pins are available for

clamping workpieces with sensitive surfaces. Additional flexible applications are possible using accessories, including clamping jaws for specific clamping tasks and round clamping elements for clamping round parts.

The 5 axis clamping systems provides you with a universal clamping element that is able to clamp workpieces with a clamping width of 22 - 236 mm. The clamping width can be extended as desired through the use of extension shafts.

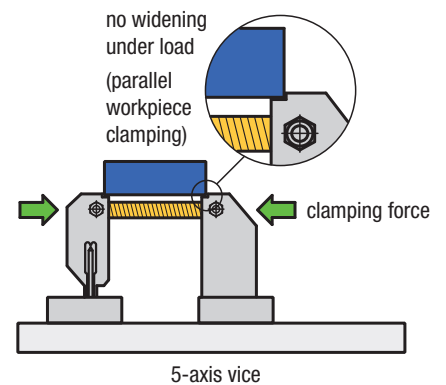
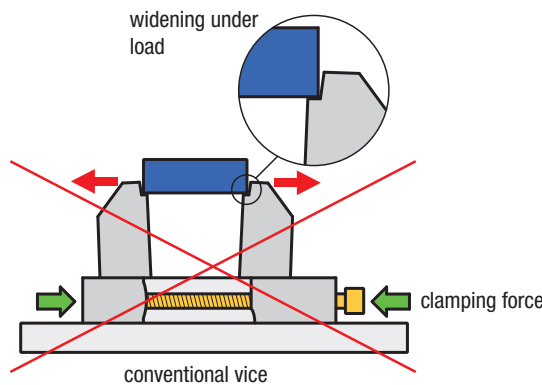


after clamping

## High clamping forces up to 42 kN that are not lost due to flexing

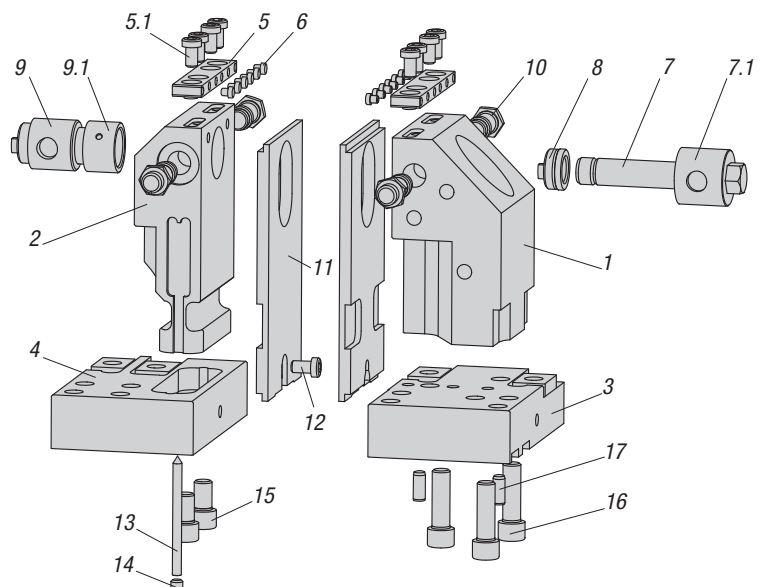
By installing a tension spindle directly under the workpiece support the clamping force is generated where it is required.

- no widening the jaws under load
- no distortion of the machine table
- extreme rigidity allows highest cutting forces



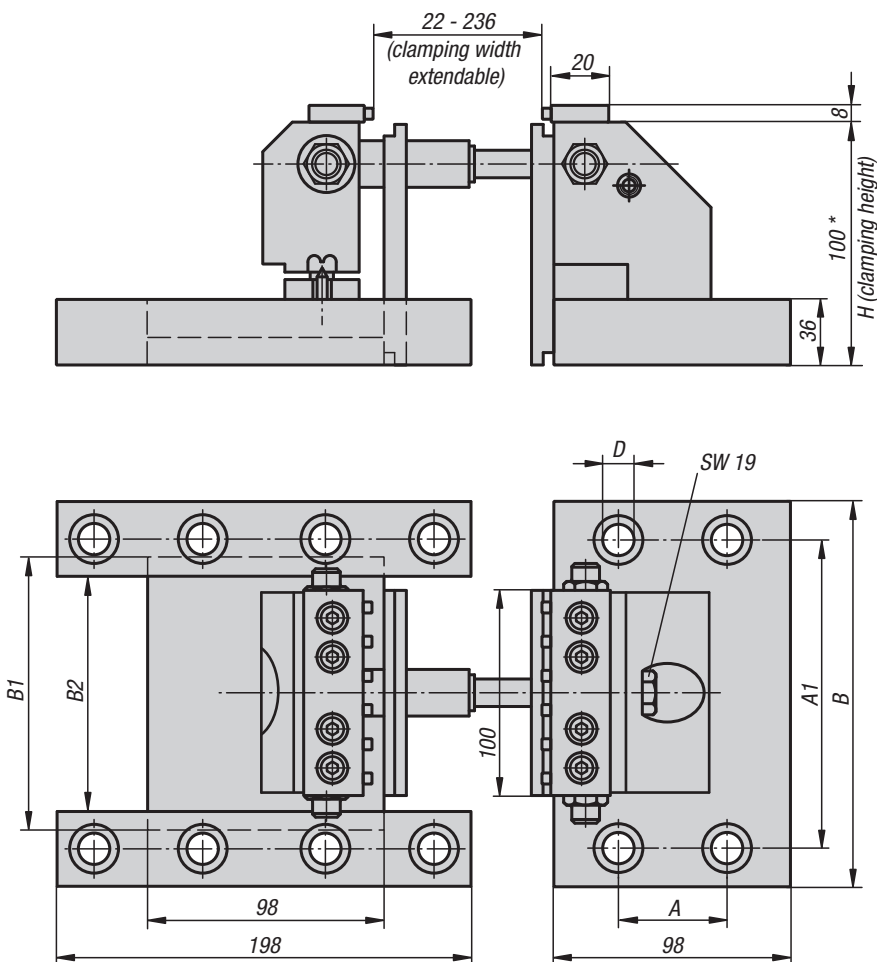
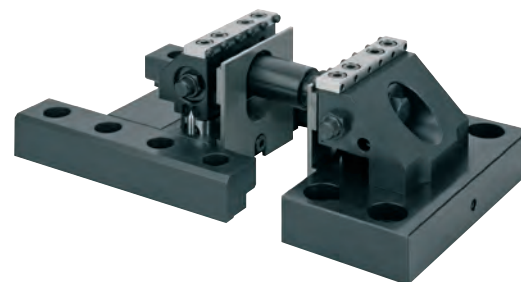
## 5-axis vice - system design

pos.	description	pcs.
1	fixed jaws	1
2	moveable jaws	1
3	base plate for fixed jaws	1
4	base plate for movable jaws	1
5	standard jaw pads with cap screws (5.1)	2
6	clamping pin	12
7	threaded spindle (7) with tension housing (7.1)	1
8	spindle nut	1
9	extension shaft (9) with union nut (9.1)	1
10	fastening screw	4
11	seating ledge	2
12	DIN 6912 M8x12 cap screw	2
13	pointer	1
14	DIN 913 M8x8 grub screw	1
15	DIN 912 M12x20 cap screw	2
16	DIN 912 M12x40 cap screw	3
17	DIN 7979 8x20 dowel pin	2



## 3-axis clamping system

for grid plates



### Material:

Base plates and jaws low-carbon steel.  
Seating ledges steel.  
Jaw plates special steel.  
Clamping pins tool steel.

### Version:

Base plates and jaws black oxidised.  
Seating ledges hardened, bright.  
Jaw plates bright.  
Clamping pins hardened, bright.

### Sample order:

K0939.4012100

### Note:

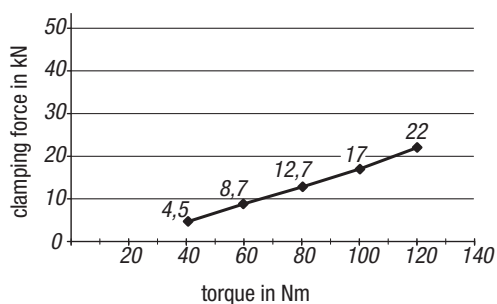
3-axis vices for mounting on grid plates.  
These vices enable 3-sided machining free of interfering edges with a clamping depth of only 8 mm. With this clamping system, clamping widths of 22 - 236 mm are possible, and can be extended as desired using the optionally available K0947 extension shafts.  
By installing a tension spindle immediately under the workpiece support, a force of up to 22 kN is applied to the workpiece; this is not lost due to flexing. The use of clamping pins with a 4 mm cup point allows positive-fit clamping without pre-embossing.  
The shoulder screws K0815 are recommended for mounting the vices on grid hole plates.  
The set includes one extension shaft with L = 60 mm and one with L = 120 mm.

\* The clamping height can be extended with the riser plates K0941 and seating ledges K0942.

### Accessories:

Stop set K0948  
Shoulder screws K0815

clamping force 3 axis clamping system



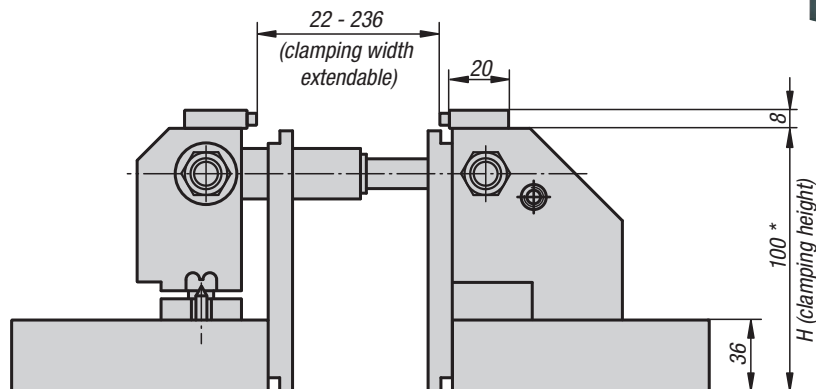
## KIPP 3 Axis clamping system for grid plates

Order No.	Grid spacing	A	A1	B	B1	B2	D	H	Clamping force max. kN	weight kg
K0939.4012100	40x40 (M12)	40	160	190	148	124	12	100 *	22	18,88
K0939.5012100	50x50 (M12)	50	150	190	138	114	12	100 *	22	19,445
K0939.5016100	50x50 (M16)	50	150	190	134	110	16	100 *	22	18,74



## 3-axis clamping system

for T-slots



**Material:**

Base plates and jaws low-carbon steel.  
Seating ledges steel.  
Jaw plates special steel.  
Clamping pins tool steel.

**Version:**

Base plates and jaws black oxidised.  
Seating ledges hardened, bright.  
Jaw plates bright.  
Clamping pins hardened, bright.

**Sample order:**

K0940.063100

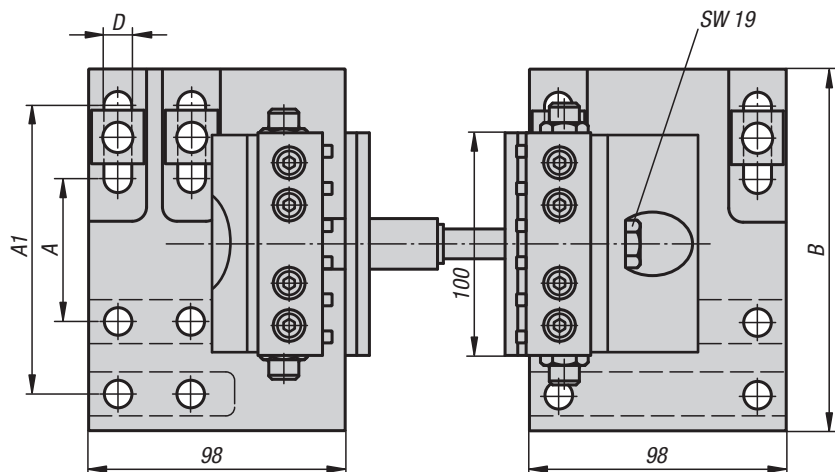
**Note:**

3-axis vices for mounting on machine tables with T-slots. These vices enable 3-sided machining free of interfering edges with a clamping depth of only 8 mm. With this clamping system, clamping widths of 22 - 236 mm are possible, and can be extended as desired using the optionally available K0947 extension shafts. By installing a tension spindle immediately under the workpiece support, a force of up to 22 kN is applied to the workpiece, this is not lost due to flexing. The use of clamping pins with a 4 mm cup point allows positive-fit clamping without pre-embossing. The fastening set K0951 is recommended for mounting the vices on T-slot tables. The set includes one extension shaft with L = 60 mm and one with L = 120 mm.

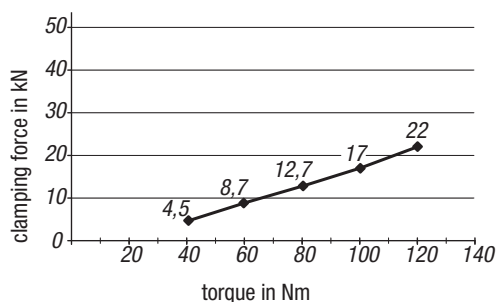
\* The clamping height can be extended with the riser plates K0941 and seating ledges K0942.

**Accessories:**

Stop set K0948  
Fastening set K0951



clamping force 3 axis clamping system

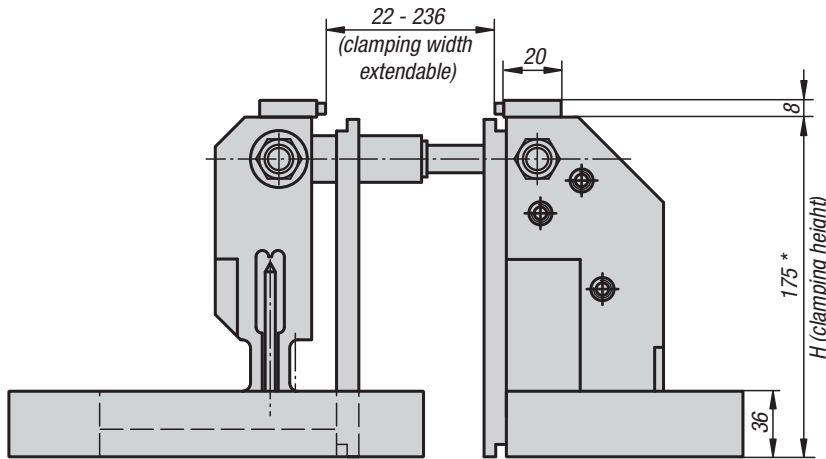


### KIPP 3 Axis clamping system for T-slots

Order No.	Suitable for	A	A1	B	D	H	Clamping force max. kN	weight kg
K0940.063100	Slot spacing 63 - 126	63	126	158	12,5	100 *	22	14,8

## 5-axis clamping system

for grid plates



**Material:**

Base plates and jaws low-carbon steel.  
Seating ledges steel.  
Jaw plates special steel.  
Clamping pins tool steel.

**Version:**

Base plates and jaws black oxidised.  
Seating ledges hardened, bright.  
Jaw plates bright.  
Clamping pins hardened, bright.

**Sample order:**

K0939.4012175

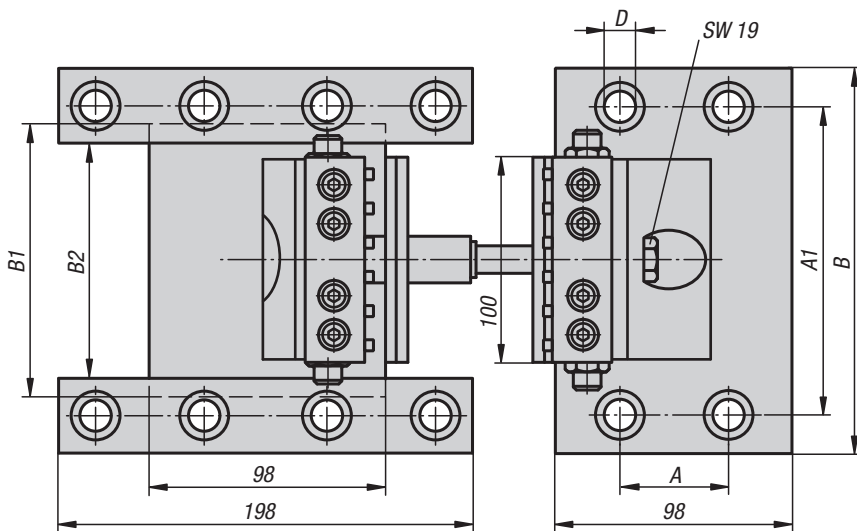
**Note:**

5-axis vices for mounting on grid plates. These vices enable 5-sided machining free of interfering edges with a clamping depth of only 8 mm. With this clamping system, clamping widths of 22 - 236 mm are possible, and can be extended as desired using the optionally available K0947 extension shafts. By installing a tension spindle immediately under the workpiece support, a force of up to 42 kN is applied to the workpiece; this is not lost due to bending. The use of clamping pins with a 4 mm cup point allows positive-fit clamping without pre-embossing. The shoulder screws K0815 are recommended for mounting the vices on grid hole plates. The set includes one extension shaft with L = 60 mm and one with L = 120 mm.

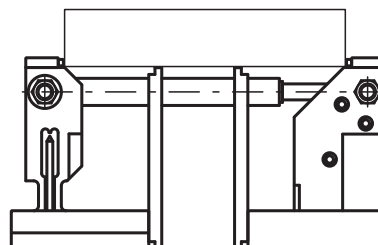
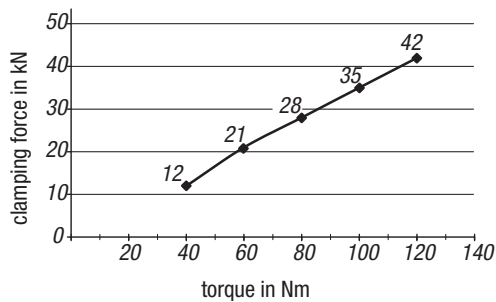
\* The clamping height can be extended with the riser plates K0941 and seating ledges K0942.

**Accessories:**

Stop set K0948  
Locating bolts K0815



clamping force 5 axis clamping system



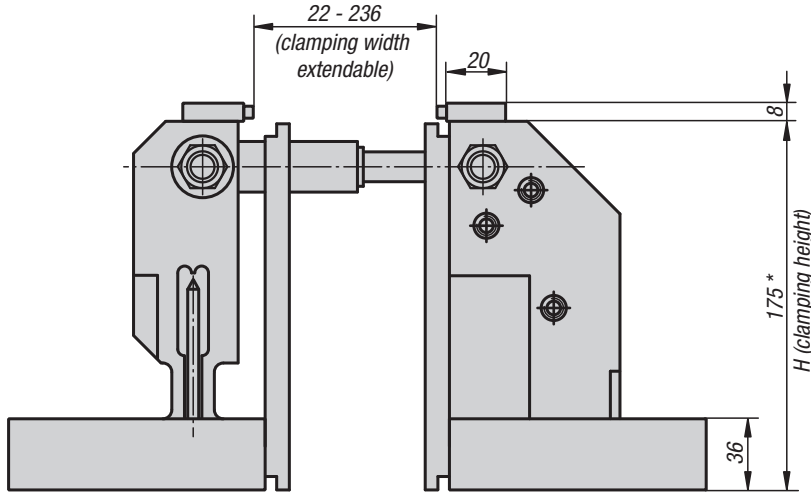
### KIPP 5 Axis clamping system for grid plates

Order No.	Grid spacing	A	A1	B	B1	B2	D	H	Clamping force max. kN	weight kg
K0939.4012175	40x40 (M12)	40	160	190	148	124	12	175 *	42	25,095
K0939.5012175	50x50 (M12)	50	150	190	138	114	12	175 *	42	25,232
K0939.5016175	50x50 (M16)	50	150	190	134	110	16	175 *	42	25



## 5-axis clamping system

for T-slots



**Material:**  
 Base plates and jaws low-carbon steel.  
 Seating ledges steel.  
 Jaw plates special steel.  
 Clamping pins tool steel.

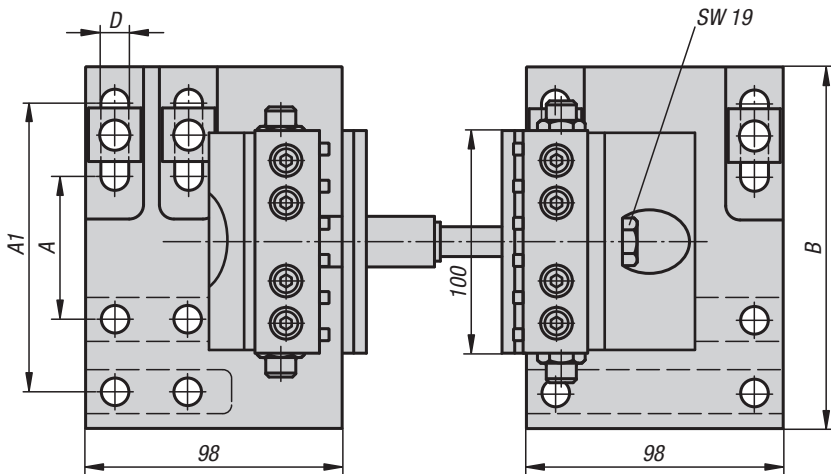
**Version:**  
 Base plates and jaws black oxidised.  
 Seating ledges hardened, bright.  
 Jaw plates bright.  
 Clamping pins hardened, bright.

**Sample order:**  
 K0940.063175

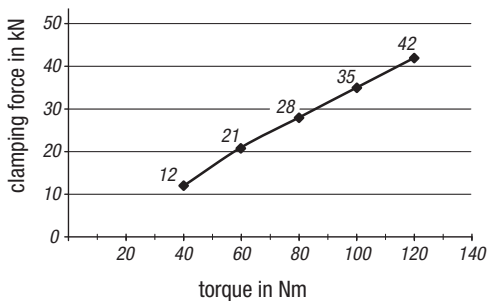
**Note:**  
 5-axis vices for mounting on machine tables with T-slots. These vices enable 5-sided machining free of interfering edges with a clamping depth of only 8 mm. With this clamping system, clamping widths of 22 - 236 mm are possible, and can be extended as desired using the optionally available K0947 extension shafts. By installing a tension spindle immediately under the workpiece support, a force of up to 42 kN is applied to the workpiece, this is not lost due to flexing. The use of clamping pins with a 4 mm cup point allows positive-fit clamping without pre-embossing. The fastening set K0951 is recommended for mounting the vices on T-slot tables. The set includes one extension shaft with L = 60 mm and one with L = 120 mm.

\* The clamping height can be extended with the riser plates K0941 and seating ledges K0942.

**Accessories:**  
 Stop set K0948  
 Fastening set K0951



clamping force 5 axis clamping system



### KIPP 5 Axis clamping system for T-slots

Order No.	Suitable for	A	A1	B	D	H	Clamping force max. kN	weight kg
K0940.063175	Slot spacing 63 - 126	63	126	158	12,5	175 *	42	21,32

## Riser plates



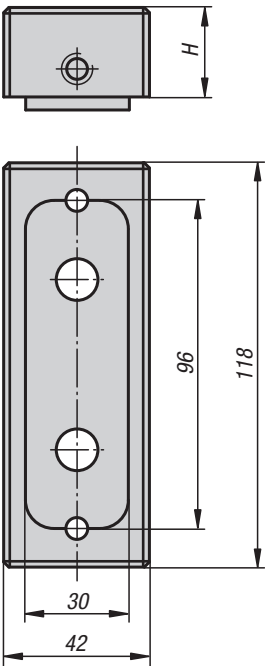
**Material, version:**  
Steel, black oxidised.

**Sample order:**  
K0941.025  
(supplied in pairs)

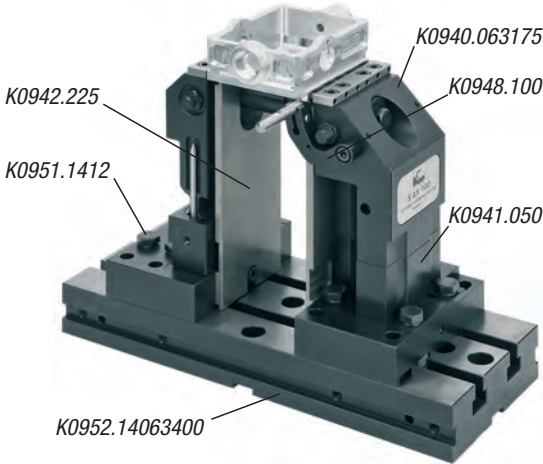
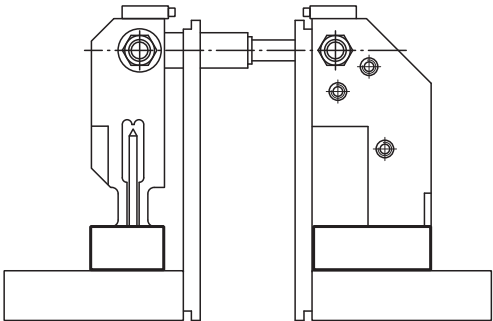
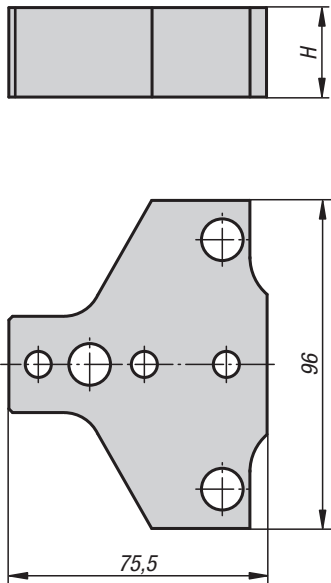
**Note:**  
The riser plates are mounted between the base plate and the jaw body, raising the 3-axis vices to 125 or 150 mm. The 5-axis vices can be raised to 200, 225 or 250 mm. When using the riser plates the matching seating ledges K0942 must also be installed.

Supplied with fastening screws and cylindrical pins.

risers for moveable side



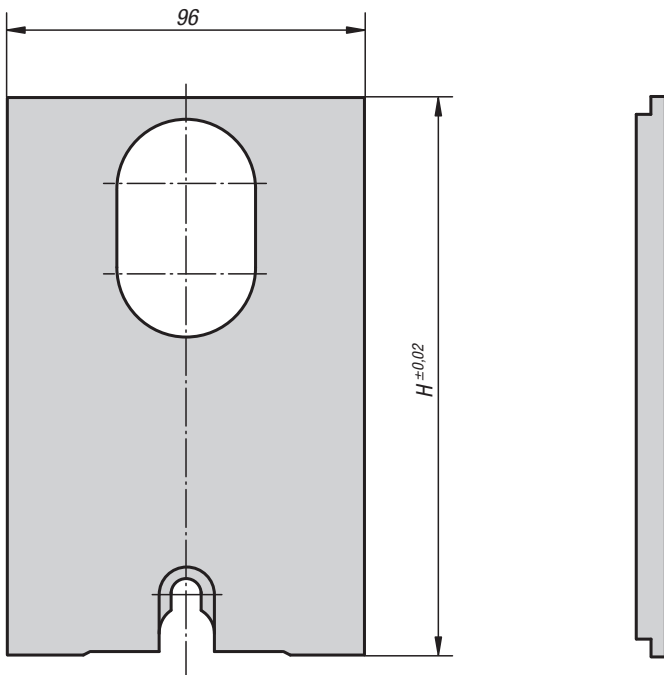
risers for fixed side



### KIPP Riser plates

Order No.	H	weight kg
K0941.025	25	1,945
K0941.050	50	3,68
K0941.075	75 (25 + 50)	5,271

## Seating ledges

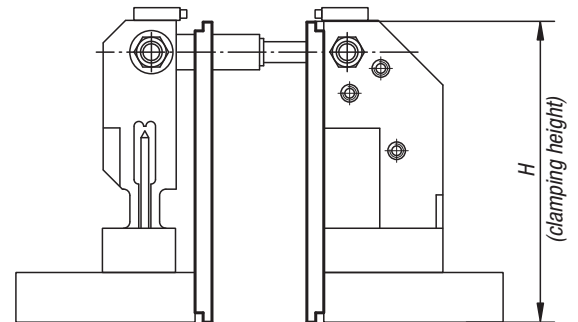


**Material, version:**  
Steel hardened, bright.

**Sample order:**  
K0942.100  
(supplied in pairs)

**Note:**  
If the riser plates K0941 are used to raise the height, the seating ledges must be changed to suit.

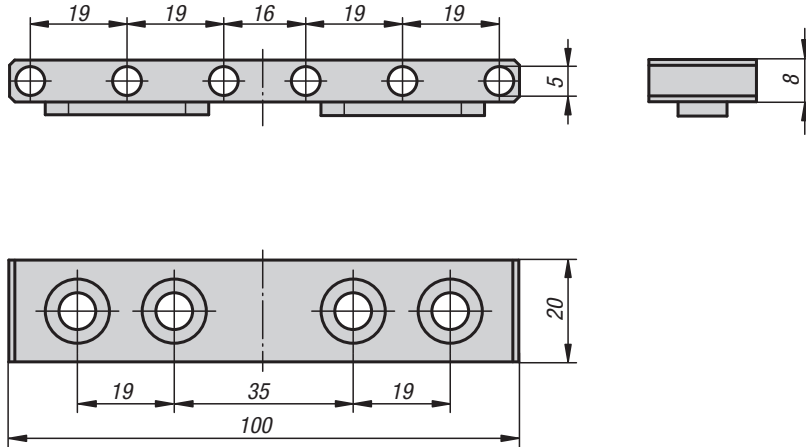
\*Including 12 jaw pins K0946.05600.



### KIPP Seating ledges

Order No.	H	Suitable for
K0942.100	100	3-axis vice basic set
K0942.105*	105	3-axis vice basic set
K0942.125	125	3-axis vice with 25 mm riser plate
K0942.150	150	3-axis vice with 50 mm riser plate
K0942.175	175	5-axis vice basic set
K0942.180*	180	5-axis vice basic set
K0942.200	200	5-axis vice with 25 mm riser plate
K0942.225	225	5-axis vice with 50 mm riser plate
K0942.250	250	5-axis vice with 75 mm riser plate (25 + 50)

## Jaw plates standard



**Material, version:**  
Special steel, bright.

**Sample order:**  
K0943.110008

**Note:**  
Jaw plates with holes to press the jaw pins into.  
Suitable for all 3-axis and 5-axis vices.

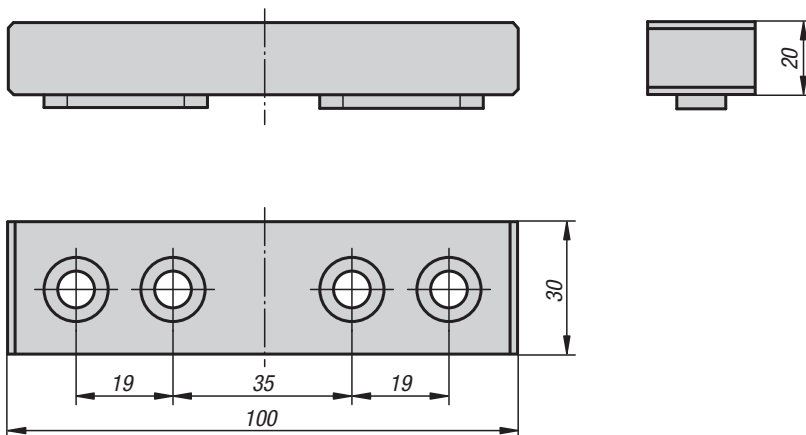
**Accessories:**  
Jaw pins K0946

### KIPP Jaw plates, standard

Order No.	Suitable for
K0943.110008	all 3-axis and 5-axis vices

# K0944

## Jaw plates machinable



**Material, version:**  
Steel 1.0503, bright.

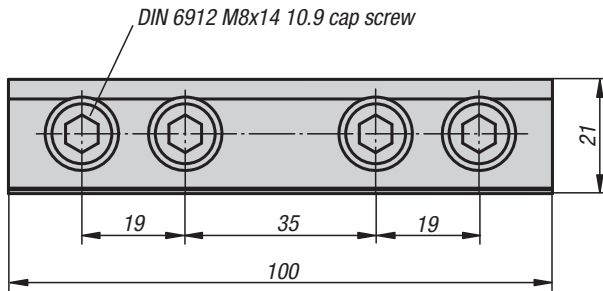
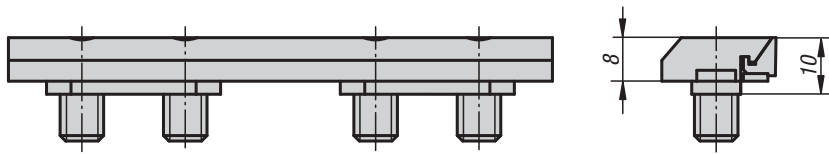
**Sample order:**  
K0944.210020

**Note:**  
Machinable jaw plates can be machined to suit  
specific workpieces. Suitable for all 3-axis and 5-axis  
vices.

### KIPP Jaw plates machinable

Order No.	Suitable for
K0944.210020	all 3-axis and 5-axis vices

## Draw-down jaws



**Material, version:**  
Special steel, bright.

**Sample order:**  
K0953.110008

**Note:**  
Positive down jaw plates for clamping pre-machined workpieces.  
Suitable for all 3-axis and 5-axis vices.

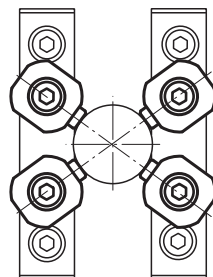
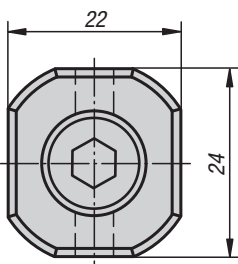
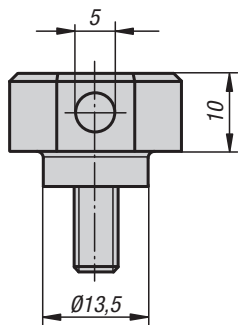
Supplied in pairs.

### KIPP Draw-down jaws

Order No.	Suitable for
K0953.110008	all 3-axis and 5-axis vices

## Jaw adapters

for round workpieces



**Material, version:**  
Adapter blocks carbon steel, black oxidised.  
Cap screw, grade 10.9.

**Sample order:**  
K0945.135010  
(supplied in sets of 4)

**Note:**  
For clamping round workpieces with a diameter of 30 - 200 mm. Screwed directly into the standard or machinable jaw plates.

**Accessories:**  
Jaw pins K0946



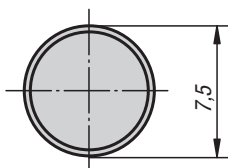
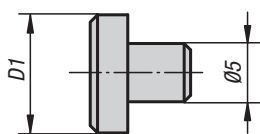
### KIPP Jaw adapters for round workpieces

Order No.	Suitable for
K0945.135010	all 3-axis and 5-axis vices

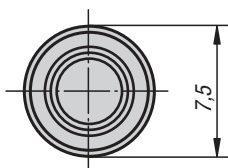
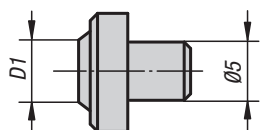
## Jaw pins



flattened



cup point



**Material, version:**  
Tool steel, hardened.

**Sample order:**  
K0946.05600

**Note:**  
Suitable for standard jaw plates and jaw adapters of round workpieces.  
Installed by pressing in.

### KIPP Jaw pins

Order No.	Version	D1	Application
K0946.05000	flattened	7,5	Material over 1000 N/mm <sup>2</sup> tensile strength
K0946.05400	cup point	4	Material up to ca. 1000 N/mm <sup>2</sup> tensile strength
K0946.05600	cup point	6	Material up to ca. 1000 N/mm <sup>2</sup> tensile strength

## Application example



## Extension shafts

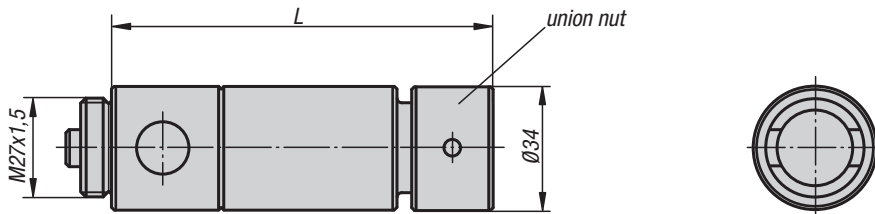
with union nut



**Material, version:**  
Carbon steel, black oxidised.

**Sample order:**  
K0947.060

**Note:**  
To extend the clamping width.  
Supplied with union nut. The extension shafts can be combined as desired.

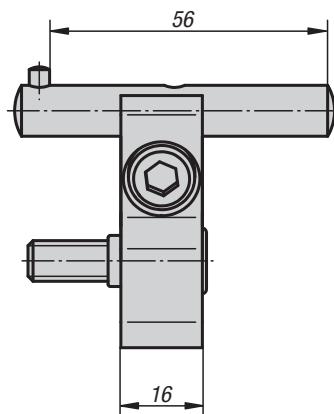
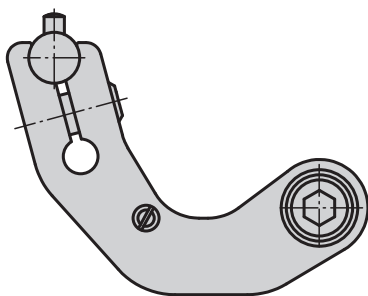


### KIPP Extension shafts with union nut

Order No.	L	Clamp range
K0947.060	60	22-82
K0947.120	120	82-142
K0947.240	240	Extension by 240 mm
K0947.480	480	Extension by 480 mm

# K0948

## Stop set



**Material:**  
Steel.

**Version:**  
Swivel arm, black oxidised.  
Stop pin bright.

**Sample order:**  
K0948.100

**Note:**  
Stop set for direct fastening to fixed jaws. The stop can be swivelled aside for machining of the workpiece without losing the stop dimension. Supplied complete with attaching parts.



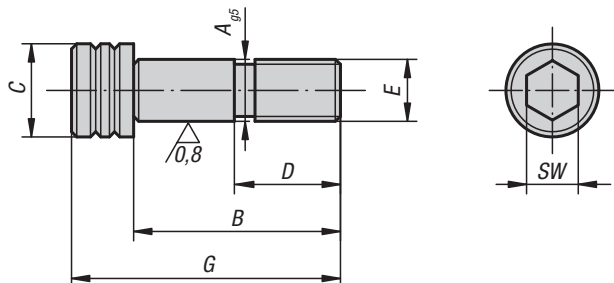
### KIPP Stop set

Order No.	Suitable for
K0948.100	all 3-axis and 5-axis vices



## Shoulder screws

Form B



**Material:**  
Carbon steel.

**Version:**  
Tempered, black oxidised.  
Precision diameters ground.

**Sample order:**  
K0815.12055

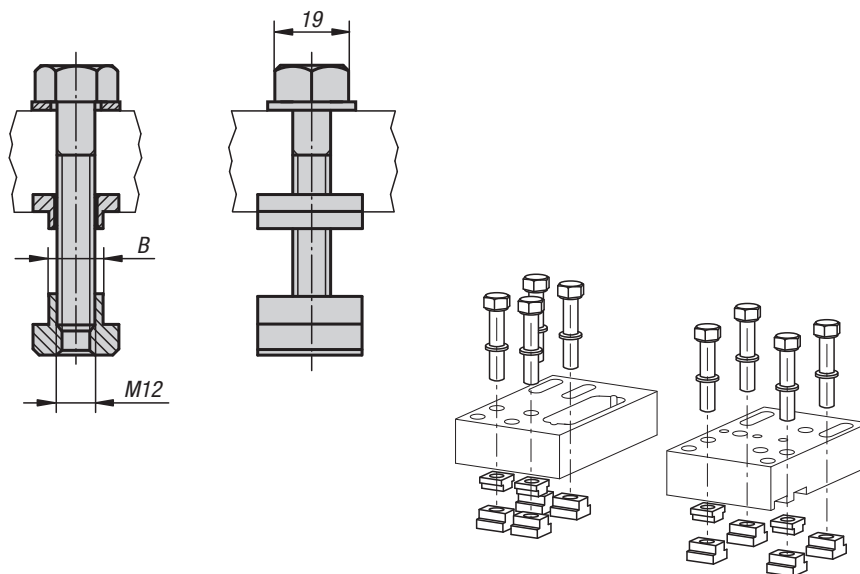
### KIPP Shoulder screws Form B

Order No.	A	B	C	D	E	G	SW
K0815.12055	12	55	18	22	M12	67	10
K0815.16055	16	55	24	25	M16	71	14

# K0951

## Fastening set

for T-slots



**Material, version:**  
Carbon steel, black oxidised.

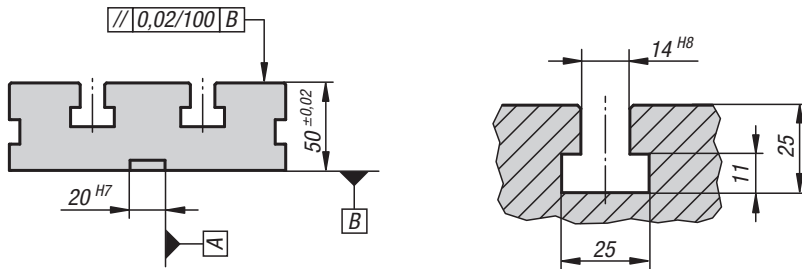
**Sample order:**  
K0951.1412

**Note:**  
Fastening sets for aligning and securing 3 and 5 axis vices on tables with T-slots sizes 14 or 18.  
Sets consisting of:  
8x ISO 4014 M 12x60 12.9 hex head bolts  
8x DIN 508 T-slot nuts  
8x washers  
4x slot keys

### KIPP Fastening set for T-slots

Order No.	Version	B
K0951.1412	Slot width 14	14
K0951.1812	Slot width 18	18

## T-slot plate



**Material, version:**

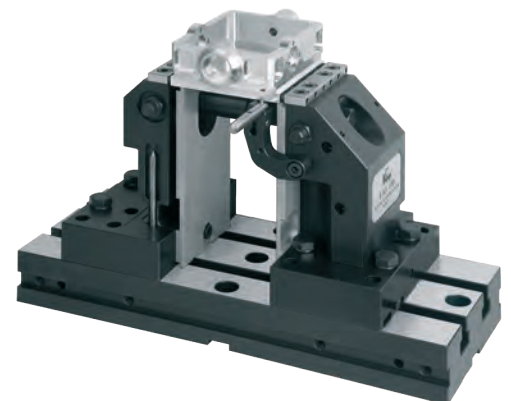
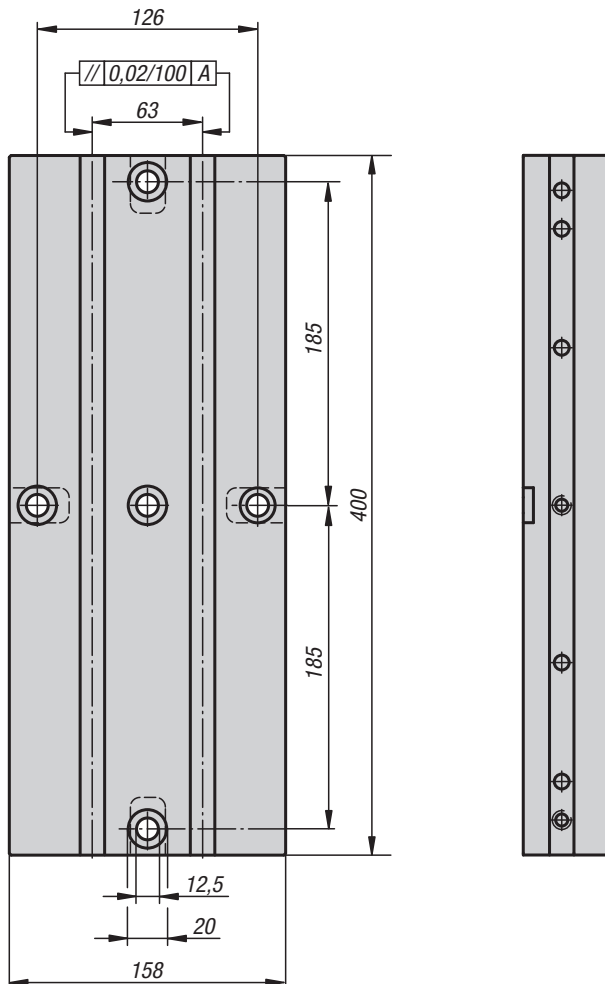
Carbon steel, black oxidised.  
Contact faces ground.

**Sample order:**

K0952.14063400

**Note:**

T-slot plates with locating slots on the underside for easy alignment of the plate on the machine table.

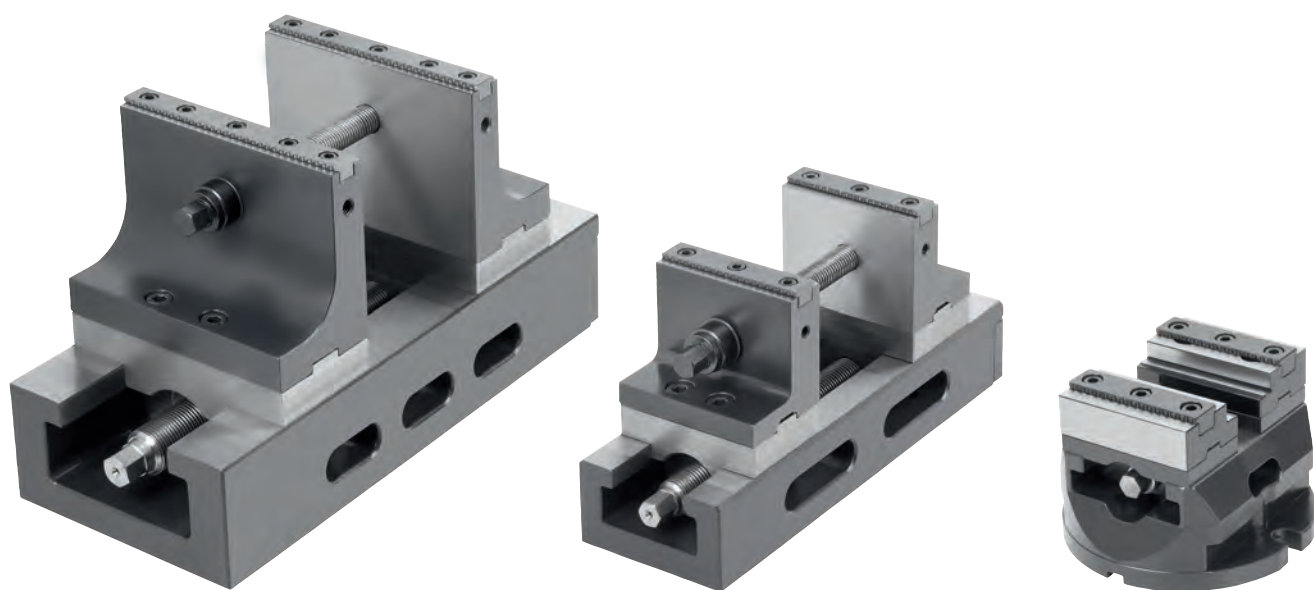


### KIPP T-slot plate

Order No.	Version	weight kg
K0952.14063400	Slot width 14 / slot spacing 63	21,135



## Centric vices



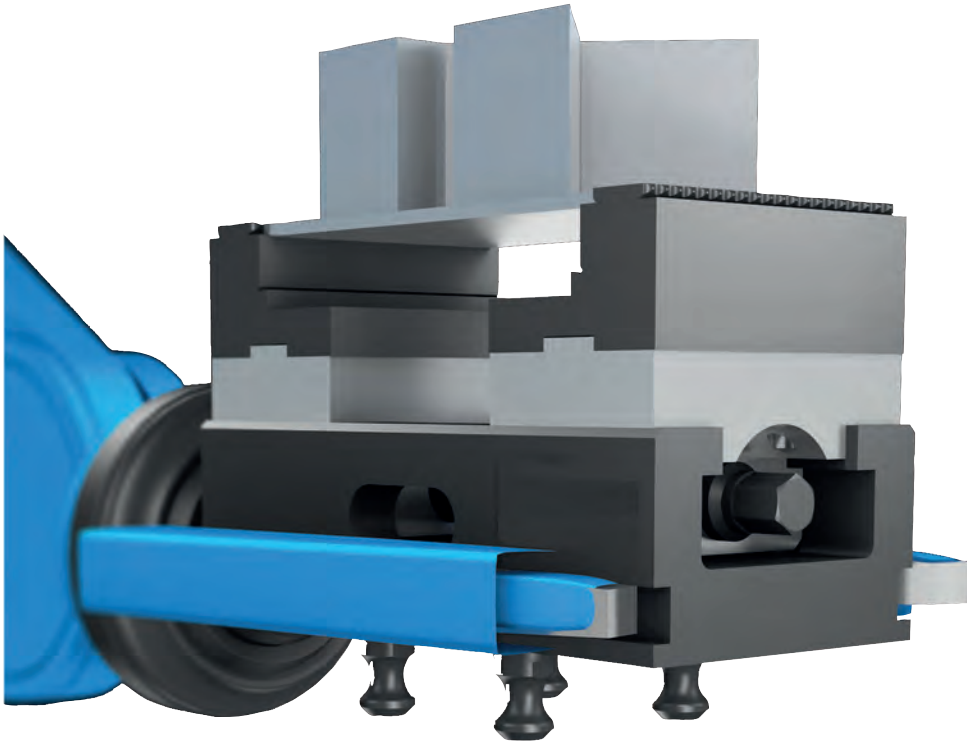
# Technical information for centric vices



Mechanically actuated centric vice

Centring precision +/- 0.02 mm across the entire clamping range.

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



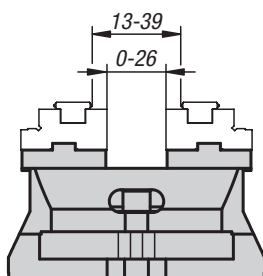
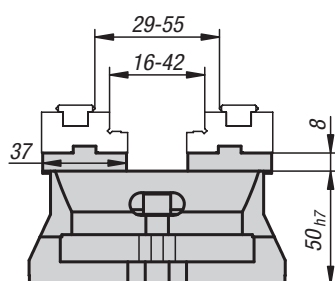
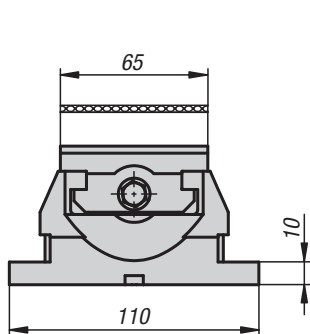
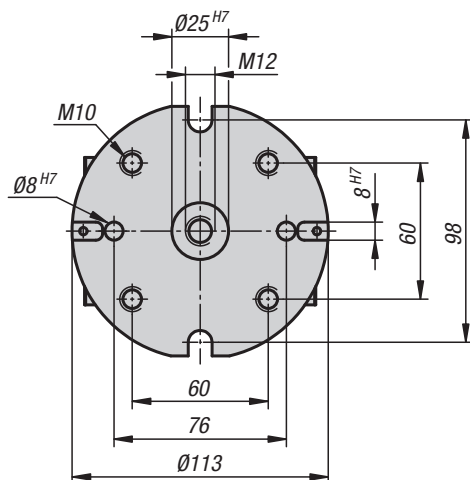
## Flexible connection options:

1. Support for the zero-point clamping system. Fitting 25H6/M12.  
Reamed and tapped holes for 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 vices 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 mounted on 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.

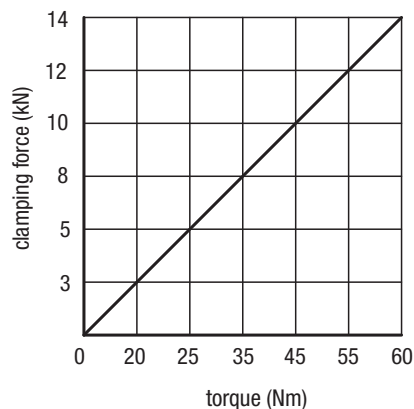
**Note:**

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: +/- 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	2,95

## 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.

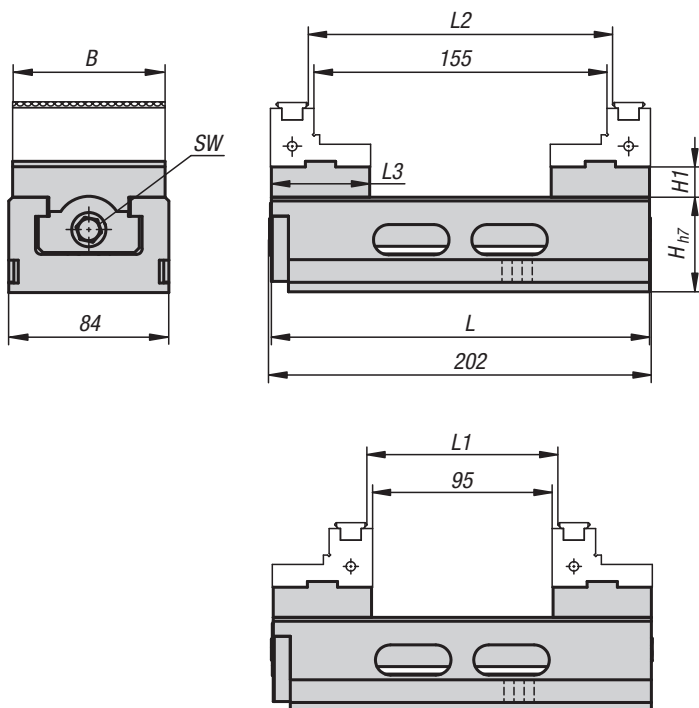
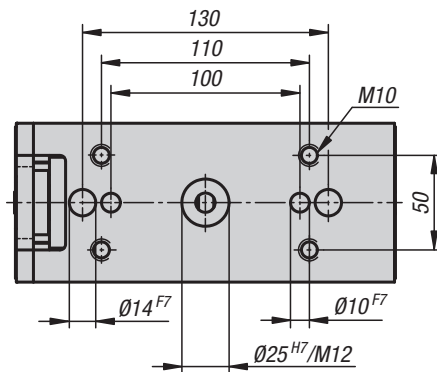
**Note:**

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: +/- 0.02 mm.

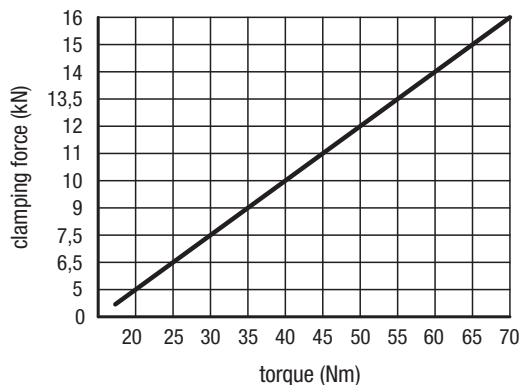
The use of a torque wrench is recommended to achieve a controlled clamping force.

**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



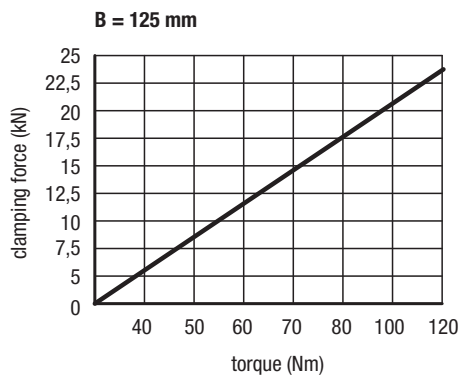
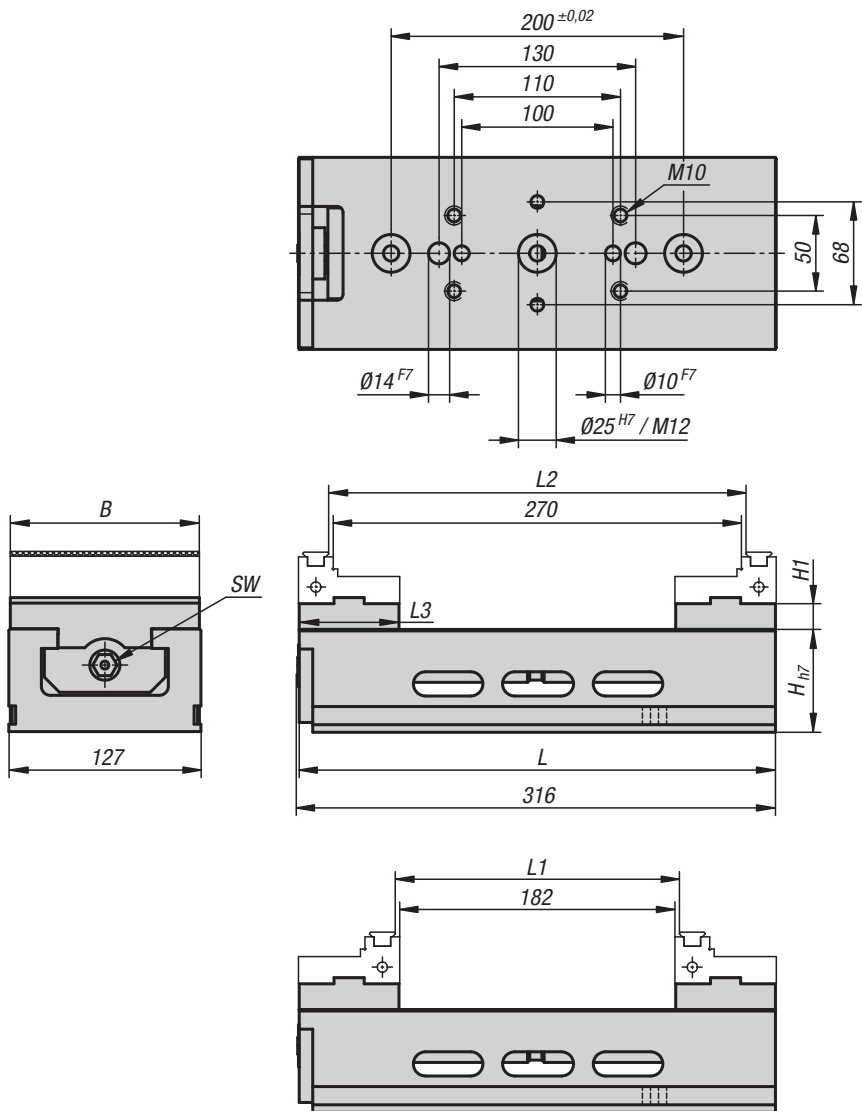
**KIPP Centric vices, jaw width 80 mm**

Order No.	B	H	H1	L	L1	L2	L3	SW	weight kg
K1237.080200	80	50h7	16	200	6-101	66-161	52	12	5,82



## Centric vices

jaw width 80–125 mm

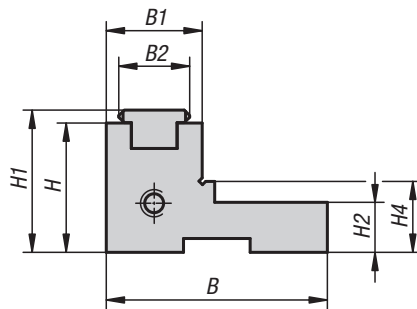
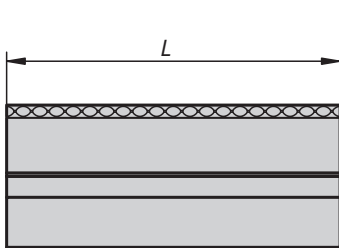


### KIPP Centric vices, jaw width 125 mm

Order No.	B	H	H1	L	L1	L2	L3	SW	weight kg
K1237.125315	125	68h7	17	315	6-188	94-276	66	14	16,85

# Attachment jaws

stepped, with grip rail



**Material, version:**

Step jaw hardened steel, clamping faces ground.  
Grip strip hardened steel

**Sample order:**

K0587.0801

**Note:**

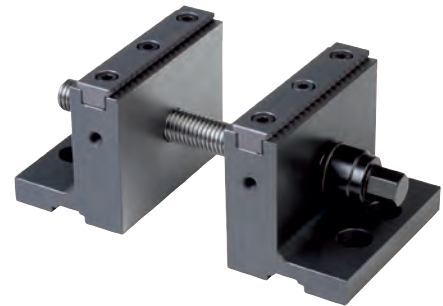
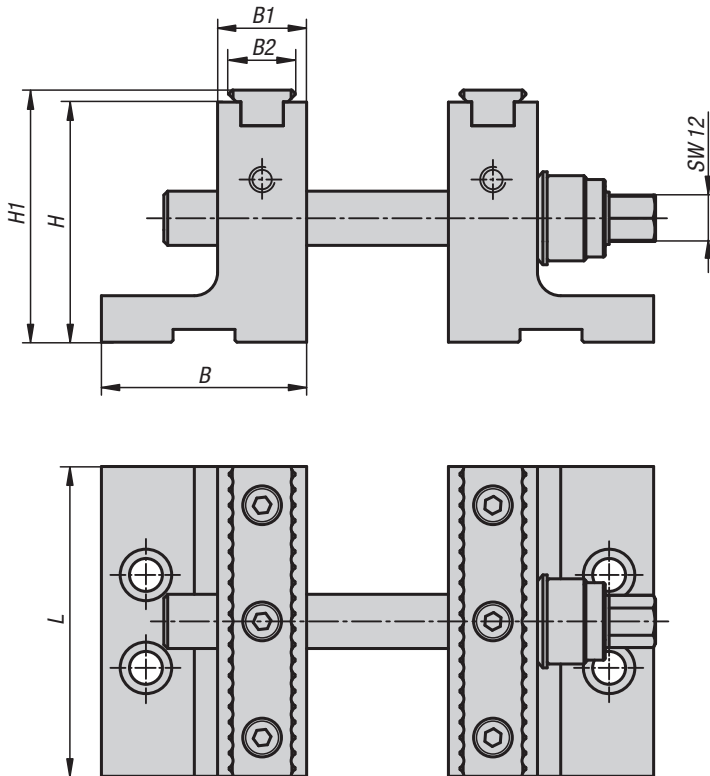
These attachment step jaws are suitable for centric vices. The clamping width can be increased or decreased by reversing the jaws. The gripper jaw pads can also be exchanged for smooth jaw pads.

**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	21,1	9	9,5	65	0,354
K0587.0801	53	23	17	31	34,1	12	17	80	0,5
K0587.1251	67	23	17	31	34,1	18	23	125	1,55

## Step jaw attachment

for 5-axis machining



**Material, version:**

Step jaw hardened steel, clamping faces ground.  
Grip strip hardened steel

**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:**

For 80 mm jaw width.

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

For jaw width 125 mm.

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

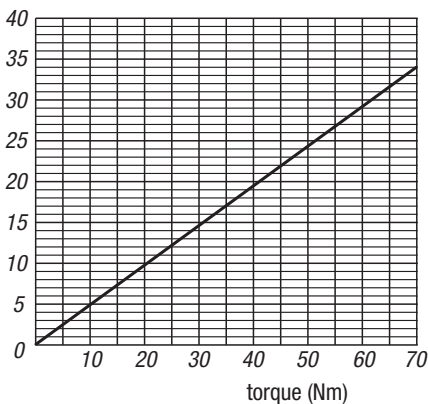
1. Length 110 mm, clamping range 6 mm – 60 mm.
2. Length 245 mm, clamping range 6 mm – 200 mm.
3. Length 315 mm, clamping range 6 mm – 270 mm.

**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)

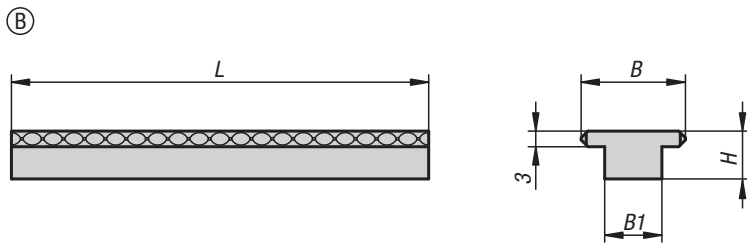
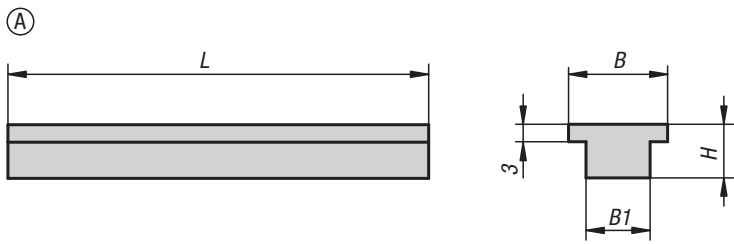


**KIPP Step jaw attachment for 5-axis machining**

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	67	23	17	90	93,1	125	6,32

## Inserts

for stepped jaw



**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.

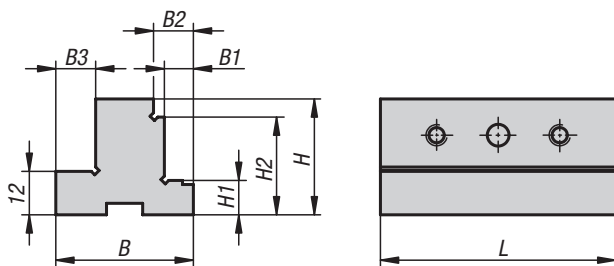
### KIPP Inserts for stepped jaws

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

# K1383

## Attachment step jaws

for centric vice, jaw width 65 mm



**Material:**  
Steel.

**Version:**  
Hardened.

**Sample order:**  
K1383.06532

**Note:**  
Attachment step jaws are the base onto which the jaw pads are screwed. They in turn are screwed directly onto the centric vice base. They enable various jaw plates to be exchanged quickly.

Suitable for K1236

### KIPP Attachment step jaws for centric vice, jaw width 65 mm

Order No.	B	B1	B2	B3	H	H1	H2	L
K1383.06532	38	8	11	11	32	9,5	27	65

## Attachment step jaws

for centric vice, jaw width 80–125 mm



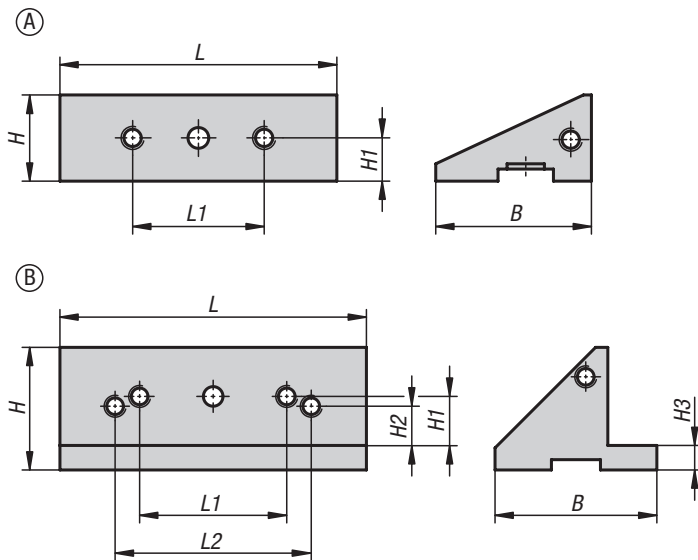
**Material:**  
Steel.

**Version:**  
Hardened.

**Sample order:**  
K1384.08025

**Note:**  
Attachment step jaws are the base onto which the jaw pads are screwed. They in turn are screwed directly onto the centric vice base. They enable various jaw plates to be exchanged quickly.

Suitable for K1237

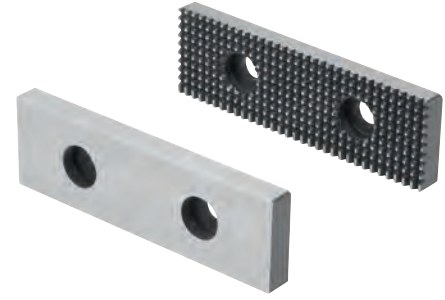


### KIPP Attachment step jaws for centric vice, jaw width 80–125 mm

Order No.	Form	B	H	H1	H2	H3	L	L1	L2
K1384.08025	A	45	25	12,5	-	-	80	38	-
K1384.12550	B	66	50	20	16	10	125	60	80

## Jaw pads

for centric vice 65-80-125 mm



**Material:**  
Steel hardened.

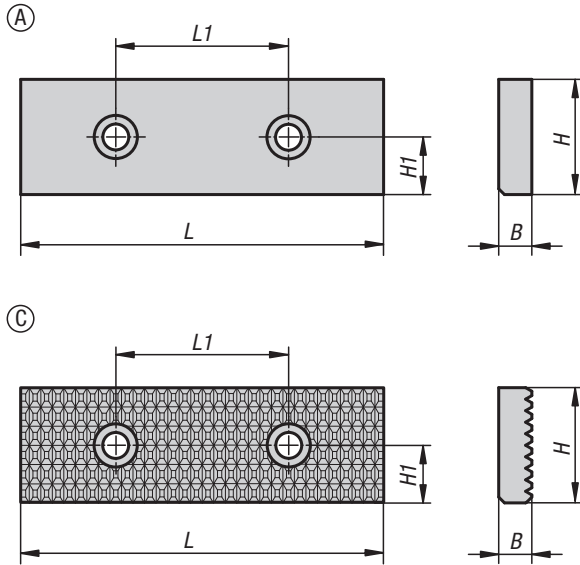
**Version:**  
Clamping faces ground.

**Sample order:**  
K0598.0651

**Note:**  
These jaw pads can be used for clamping various workpiece types. Depending on the pad used, rough or pre-machined workpieces can be held. The jaw pads are screwed onto the attachment jaws.

Suitable for K1236, K1237

**Drawing reference:**  
Form A: smooth  
Form C: serrated

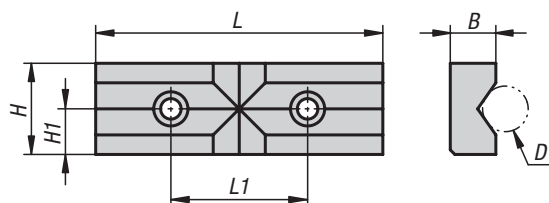


### KIPP Jaw pads for centric vice 65-80-125 mm

Order No.	Form	B	H	H1	L	L1
K0598.0651	A	7,5	20	10	66	34
K0598.0801	A	7,5	25	12,5	81	38
K0598.1251	A	11,5	40	20	126	60
K0598.0653	C	7,5	20	10	66	34
K0598.0803	C	7,5	25	12,5	81	38
K0598.1253	C	11,5	40	20	126	60

## Prism jaw pads

for centric vice, 65–80–125 mm



**Material:**  
Steel.

**Version:**  
Hardened.

**Sample order:**  
K1375.065

**Note:**  
Prism jaws are used for clamping round material, tubes, rods, profiles, etc. The prisms are machined in horizontally and vertically.  
The prism jaw pads are screwed onto the attachment jaws.

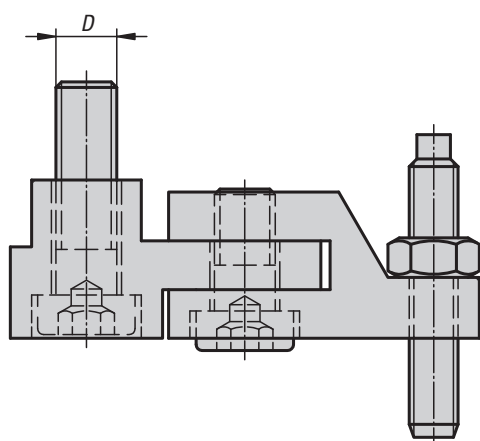
Suitable for K1236 and K1237

### KIPP Prism jaw pads for centric vice, 65–80–125 mm

Order No.	B	D	H	H1	L	L1
K1375.065	12,5	5-25	20	10	66	34
K1375.080	12,5	5-25	25	12,5	81	38
K1375.125	20	8-38	40	20	126	60

# K0607

## Hinged stops



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

**Sample order:**  
K0607.080

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

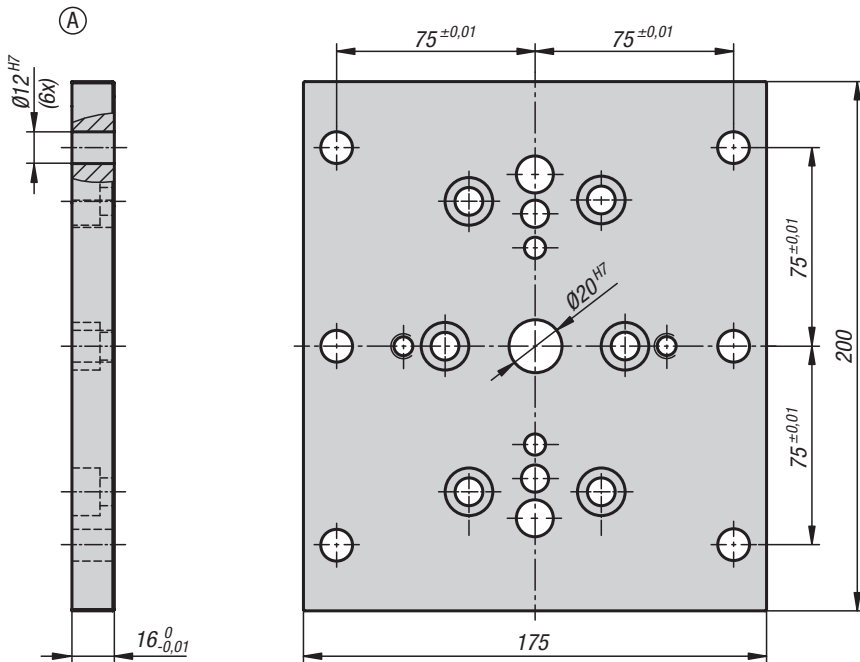
### KIPP Hinged stops

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:**  
Form A:  
The baseplate enables the centric vices (65 - 80 - 125) to be mounted onto 50 mm x M12/12F7 grid systems.

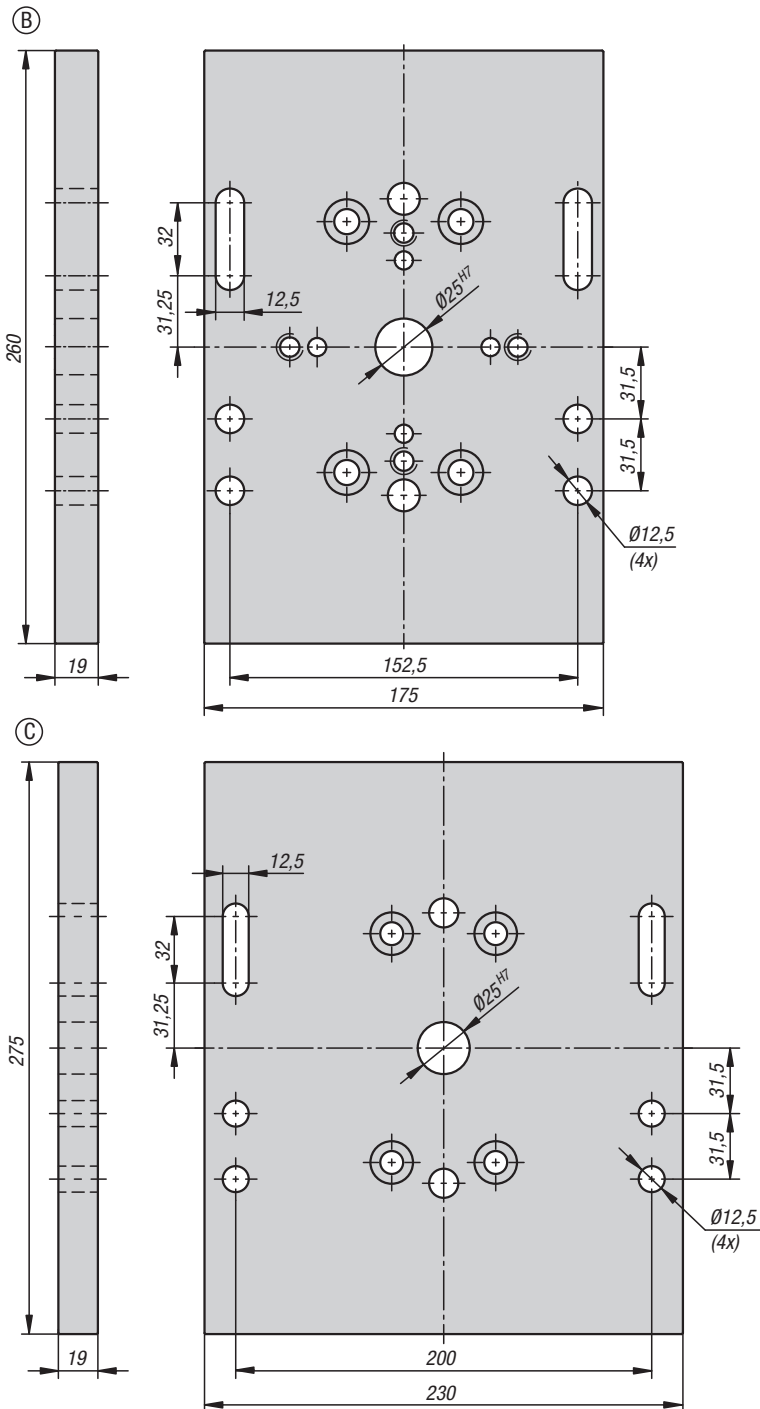
Form B+C:  
The baseplate enables the centric vices (65 - 80 - 125) to be mounted on machine tables with T-slots.

### KIPP Baseplate for centric vice

Order No.	Form	Suitable for	weight kg
K1274.12175200	A	centric vice 65, 80, 125	4,03

## Baseplate

for centric vice

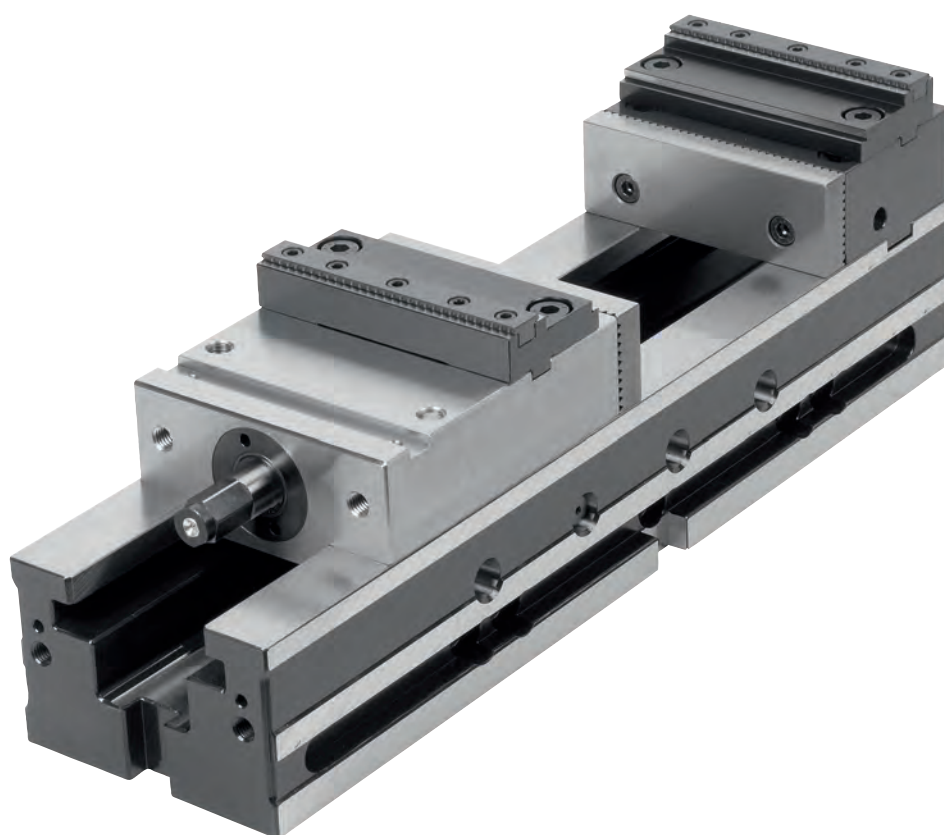


### KIPP Baseplate for centric vice

Order No.	Form	Suitable for	weight kg
K1274.00175260	B	centric vice 65, 80	6,3
K1274.00230275	C	centric vice 125	7,5



## NC Vices



## Adaptable

Slot and thread for attachment jaws and for grippers.

## Optional

### Multiple clamping

Several workpieces can be clamped using reversible jaws. Tools are not used for installation.

## Individual

Flexible – can be used for any machine table, ready to use immediately with clamp strap set and slot keys (optional).

## Optimum positioning

Cross slot for alignment.

## Quick pre-adjustment

Locking pins for quick pre-positioning.

## Spindle drive

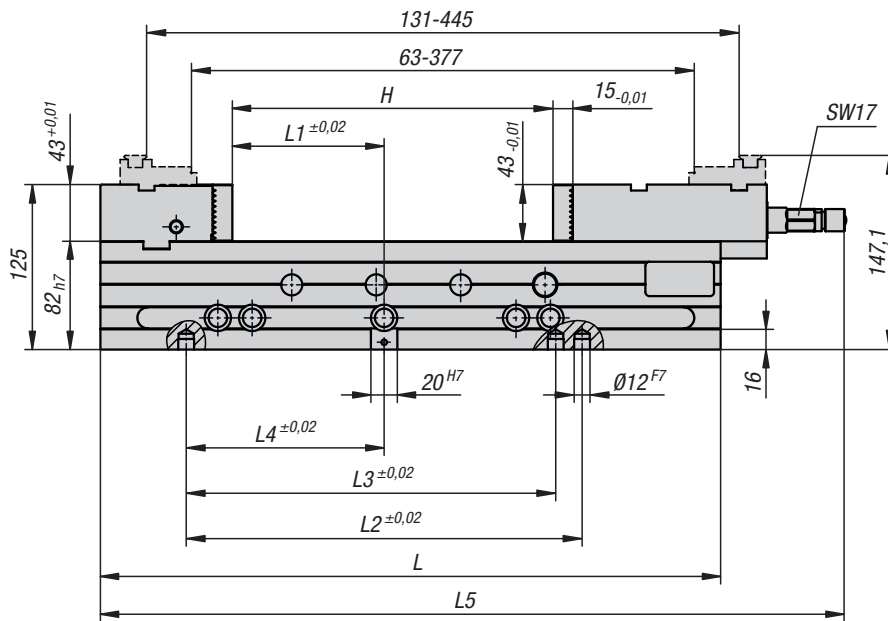
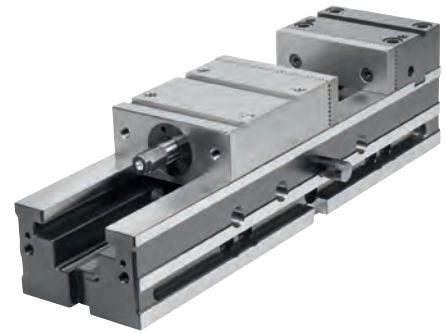
Mechanical-hydraulic version up to 40 kN or purely mechanical clamping up to 10 kN.

## Impressive advantages:

- Repeat accuracy  $\leq 0.01$  mm
- Fixed jaw fixed in all directions (X,Y,Z)
- Wide clamping range due to use of attachment step jaws
- Basic equipment: 2 reversible screw-on jaws and 1 crank handle
- Can be laid on the side, with fastening holes for slot spacing of 63 mm and 100 mm.

## NC vice

jaw width 125 mm



**Material:**

Body and jaw holder mild steel.

**Version:**

Hardened and ground all sides.

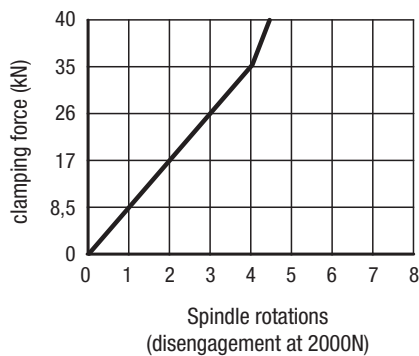
**Sample order:**

K1238.125470

**Features:**

NC vices can be used for a wide range of clamping tasks:

- Repeat accuracy  $\leq 0.01$  mm
- Fixed jaw locked in all axis (X,Y,Z)
- Vertical use directly on the machine table
- Wide clamping range by using attachment step jaws
- Can be laid on the side, with fastening holes for slot spacing of 63 mm and 100 mm
- Quick pre-adjustment of the clamping range using locking pins
- Basic equipment includes two reversible screw-on jaws and one crank handle

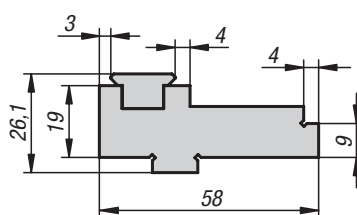
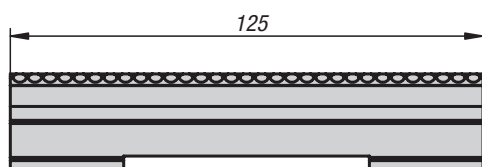


**KIPP NC vice jaw width 125 mm**

Order No.	B	L	L1	L2	L3	L4	L5	H clamping range	weight kg
K1238.125470	125	470	115	300	280	150	564	0-239	37.6

## Attachment step jaw

with gripper for NC vice



**Material:**

Steel.

**Version:**

Hardened and ground.

**Sample order:**

K1273.1251

**Note:**

The attachment step jaws are for expanding the NC vice clamping width. The gripper jaw pads can be exchanged for smooth jaw pads K0591.125117.

### KIPP Attachment step jaw with gripper jaw pad for NC vice

Order No.	Suitable for
K1273.1251	NC Vice 125



## Prism jaws

for NC vice



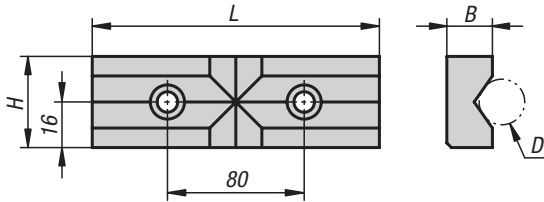
**Material:**  
Steel.

**Version:**  
Hardened.

**Sample order:**  
K1376.125

**Note:**  
Prism jaws for clamping round material, tubes, rods, profiles, etc. Prism machined horizontally and vertically.

Suitable for K1238.125470



### KIPP Prism jaws for NC vice

Order No.	B	D	H	L
K1376.125	20	8-38	43	125

# K0601

## Hold-down jaw pads with spring blade

for NC vice



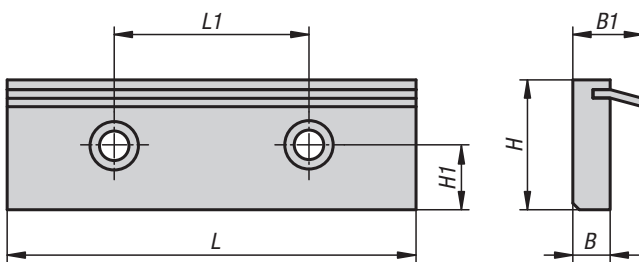
**Material:**  
Steel.

**Version:**  
Hardened.

**Sample order:**  
K0601.125

**Note:**  
The hold-down jaw pads with spring blade are used for clamping rough workpieces. The spring blade exerts extra pressure to the workpiece, forcing it onto the seating face.

Suitable for K1238.125470



### KIPP Hold-down jaw pads with spring blade for NC vice

Order No.	B	B1	H	H1	L	L1
K0601.125	11,5	21,5	43	16	125	80

## Angle drives

for NC vice



**Material:**

Housing steel.  
Drive, steel.

**Sample order:**

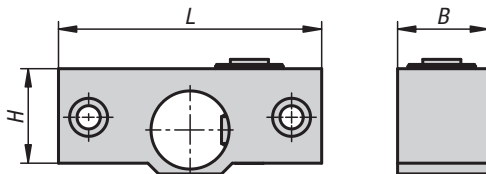
K1377.125

**Note:**

The angle drive is used to operate the NC vice from above or in tight spaces.

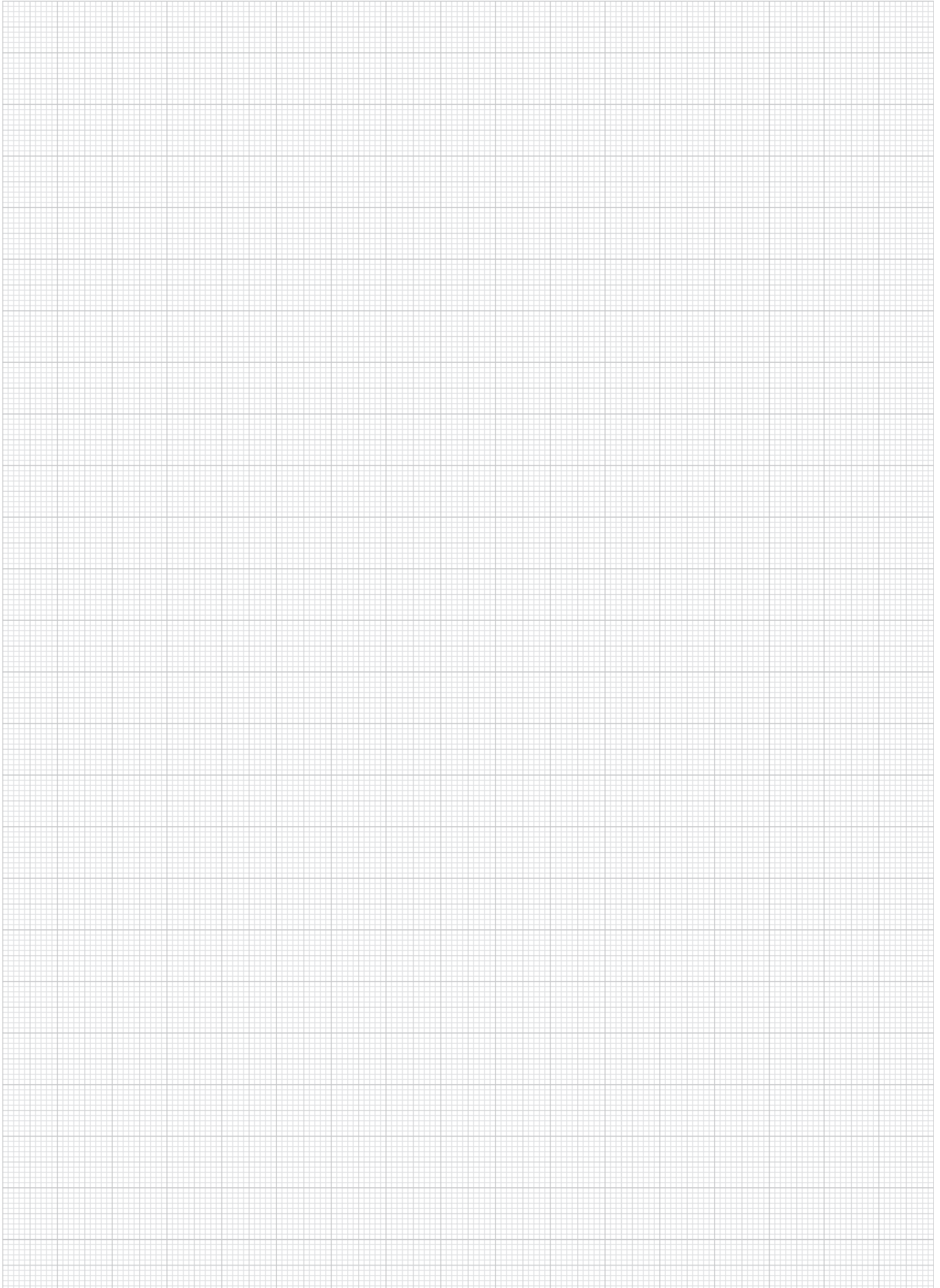
- The ratio is 1:1.4
- NC vice without angle drive max. 4.5 turns. With angle drive max. 6.3 turns.
- The angle drive is especially useful for horizontal use of NC vices, e.g. in the case of clamping cubes or workholding towers. The angle drive can also be used to operate the NC vice from above or in tight spaces.

Suitable for K1238.125470



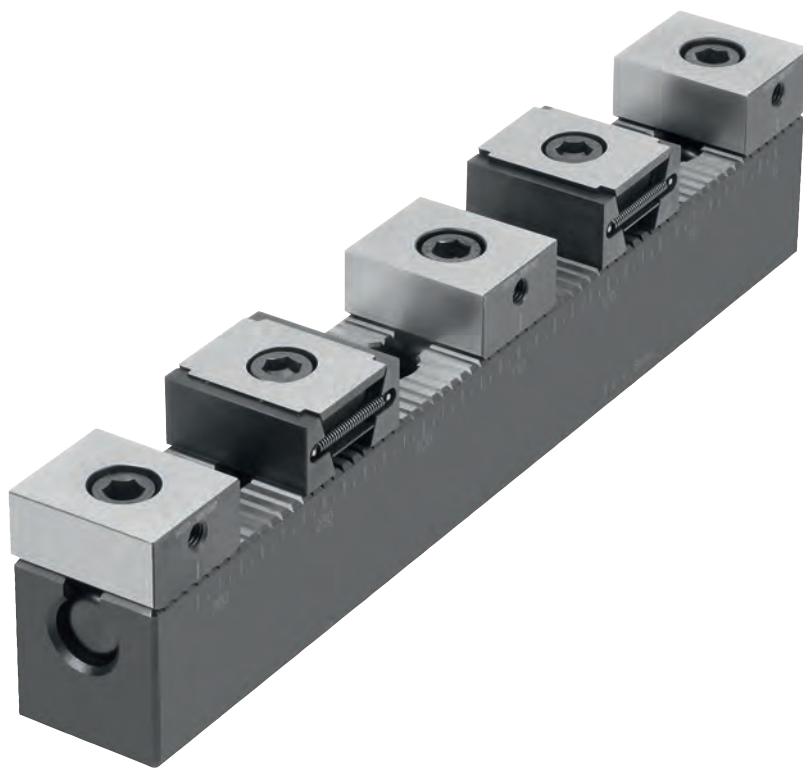
### KIPP Angle drives for NC vice

Order No.	B	H	L
K1377.125	43	45	124,5





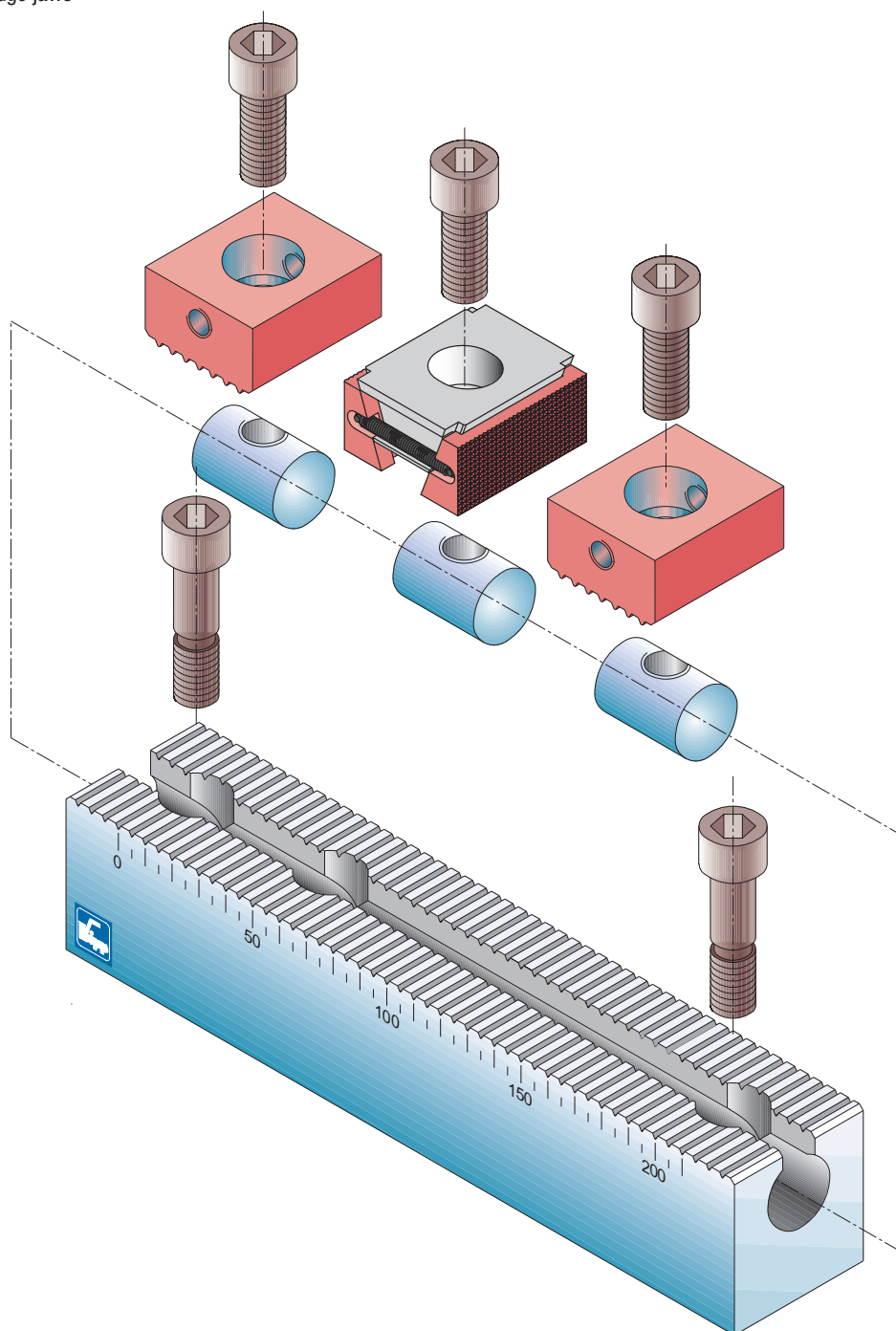
## Multi-clamping system



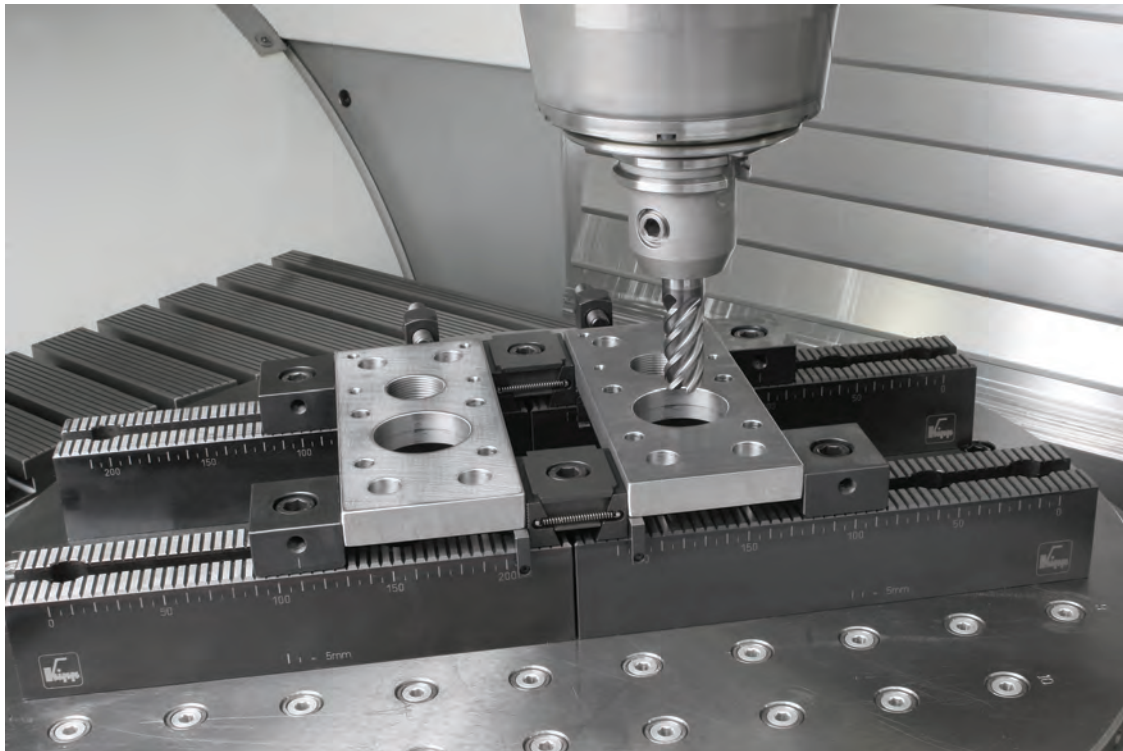
# Multi-clamping system



The multi-clamping system is used to clamp diverse workpieces on a base plate or directly on a machine table. The various elements of the multi-clamping system (base rails, stops and wedge clamps) allow workpieces of varied sizes to be held without difficulty. The serrations on the base rail guarantee a secure and exact fastening of the stops. The working area of a machine can be more effectively used by mounting a number of base rails along and across the work surface. The wedge clamps allow two workpieces to be held simultaneously from one clamping point. The transverse wedge design works in the vertical and horizontal plane, guaranteeing a secure hold in all directions. As the clamp is tightened the wedge jaws expand pressing the workpiece against the stops.

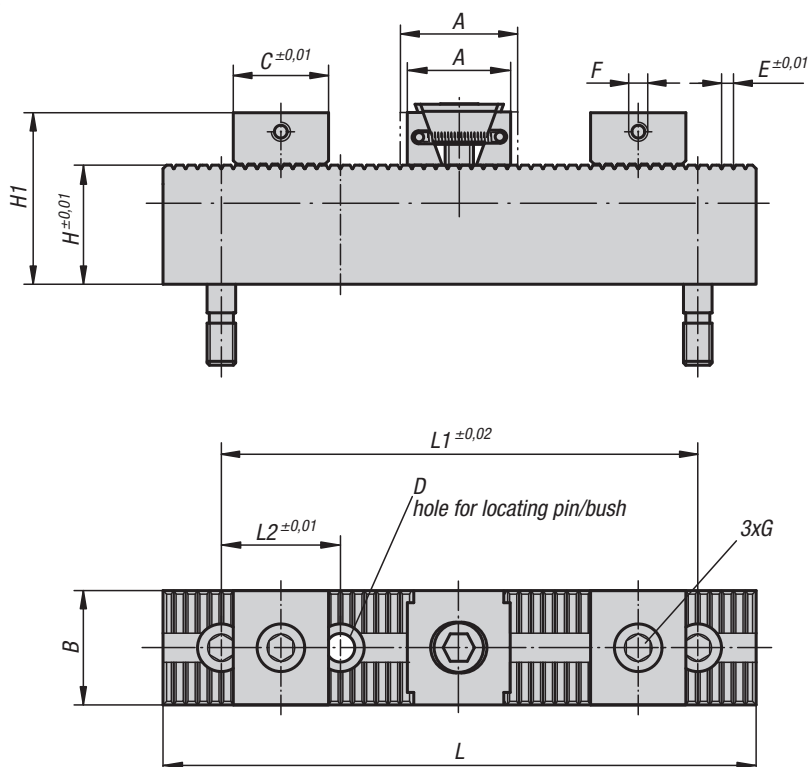
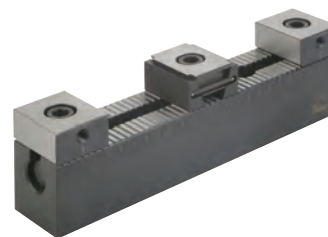


# Example of a multi-clamping system



## Multi-clamping system

hard stops



**Material:**

Base rail, stops and wedge clamp carbon steel.

**Version:**

Serrations case hardened and ground.

Stops tempered.

Clamping jaws hardened and black oxidised.

**Sample order:**

K0902.12

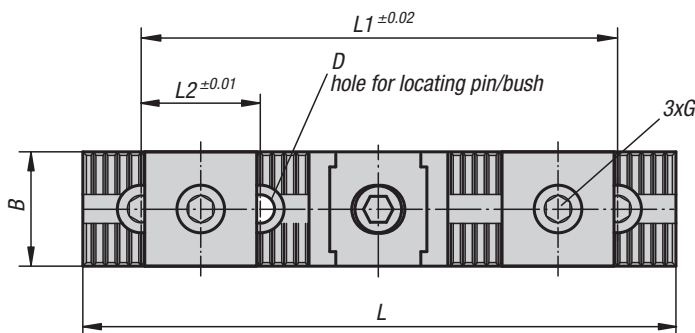
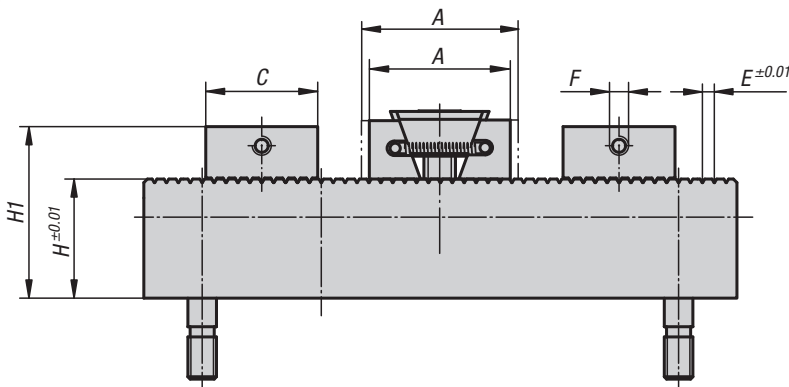
### KIPP Multi-clamping system hard stops

Order No.	A min.	A max.	B	C	D	E	F	G cap screw DIN 912	H	H1	L	L1	L2	Clamping force ca. kN	weight kg
K0902.08	30,5	33,5	24	25	12 H6	2,5	M5	M8x25	40	55	199	150	50	15	1,35
K0902.12	44	49,5	48	40	12 F7	5	M8	M12x30	50	72	249	200	50	30	4,961
K0902.16	55	62	48	40	16 F7	5	M8	M16x40	63	92	249	200	50	50	6,016



## Multi-clamping system

soft stops



**Material:**

Base rail, stops and wedge clamp carbon steel.

**Version:**

Serrations case hardened and ground.  
Clamping jaws hardened and black oxidised.

**Sample order:**

K0903.12

**Note:**

Depending on the size the clamping jaws have 3 mm (K0903.08) or 5 mm (K0903.12, K0903.16) machining allowance per jaw.

### KIPP Multi-clamping system, soft stops

Order No.	A min.	A max.	B	C	D	E	F	G cap screw DIN 912	H	H1	L	L1	L2	Clamping force ca. kN	weight kg
K0903.08	36,5	39,5	24	31	12 H6	2,5	M5	M8x25	40	55	199	150	50	11	1,397
K0903.12	54	59,5	48	50	12 F7	5	M8	M12x30	50	72	249	200	50	23	4,9
K0903.16	65	72	48	50	16 F7	5	M8	M16x40	63	92	249	200	50	38	6,522

## Wedge clamps

jaw face smooth or serrated



**Material:**

Wedge and jaw segments carbon steel.

**Version:**

Wedge and jaw segments hardened, black.

**Sample order:**

K0039.2208

**Note:**

The functioning principle make the wedge clamps ideal for series clamping. The wedge form can exert high clamping forces.

These wedge clamps can be mounted in grid holes or T-slots. Tightening the socket screw moves the wedge down and the jaws out pressing the workpieces against the fixtures fixed stops. The wedge has a slightly elongated hole allowing for movement to compensate for tolerances.

**Spread width:**

M8 = ±0.5 mm

M10 = ±1.0 mm

M12 = ±1.0 mm

M16 = ±1.5 mm

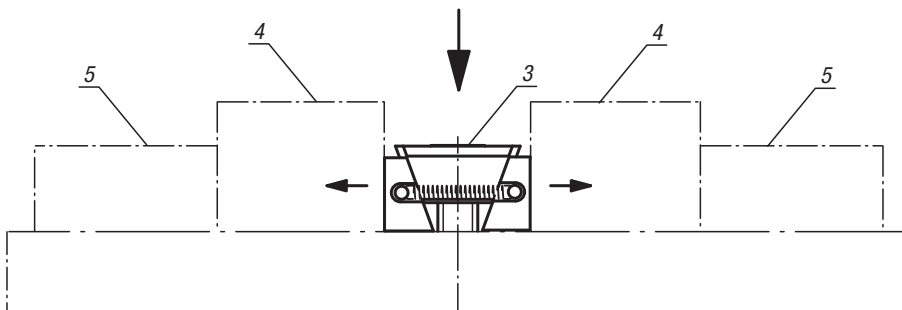
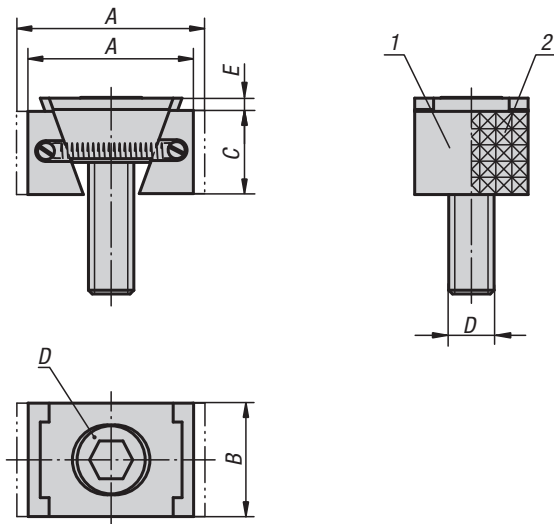
**Drawing reference:**

- 1) Jaw face smooth
- 2) Jaw face serrated
- D) DIN 6912 cap screw

3) Wedge clamps

4) Workpiece

5) Fixed stop



### KIPP Wedge clamps, narrow version

Order No. smooth version	Order No. serrated	A min.	A max.	B	C	D	E	Clamping force max. kN	Tightening torque max. Nm
K0039.1108	K0039.2108	30,5	33,5	24	15	M8X25	2	15	25
K0039.1110	K0039.2110	32	37	28	19	M10X25	3,5	20	49
K0039.1112	K0039.2112	44	49,5	30	22	M12X40	3,5	30	85
K0039.1116	K0039.2116	55	62	40	29	M16X60	4	50	210

### KIPP Wedge clamps, wide version

Order No. smooth version	Order No. serrated	A min.	A max.	B	C	D	E	Clamping force max. kN	Tightening torque max. Nm
K0039.1208	K0039.2208	30,5	33,5	30	15	M8X25	2	15	25
K0039.1210	K0039.2210	32	37	38	19	M10X25	3,5	20	49
K0039.1212	K0039.2212	44	49,5	48	22	M12X40	3,5	30	85
K0039.1216	K0039.2216	55	62	48	29	M16X60	4	50	210

# Wedge clamps

machinable



**Material:**

Wedge and jaw segments carbon steel.

**Version:**

Wedge and jaw segments hardened, black.

**Sample order:**

K0649.3110

**Note:**

These wedge clamps have extra long jaws. This extra material allows the jaws to be machined to suit the form of the workpiece.

The functioning principle makes the wedge clamps ideal for series clamping. The wedge form can exert high clamping forces.

These wedge clamps can be mounted in grid holes or T-slots. Tightening the socket screw moves the wedge down and the jaws out, pressing the workpieces against the fixtures fixed stops.

The wedge has a slightly elongated hole allowing for movement to compensate for tolerances.

**Spread width:**

M8 = ±0.5 mm

M10 = ±1.0 mm

M12 = ±1.0 mm

M16 = ±1.5 mm

**Attention:**

These wedge clamps have a machining allowance per jaw of 3 mm for version M8 and 5 mm for versions M10, M12 and M16.

**Drawing reference:**

D) DIN 6912 cap screw

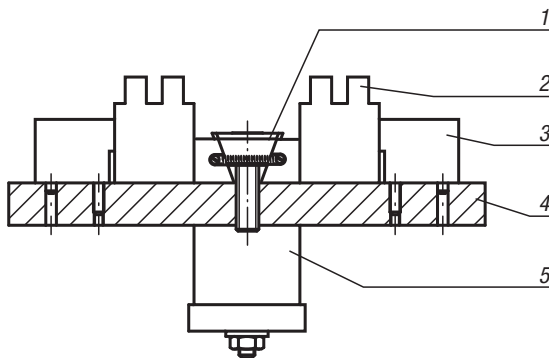
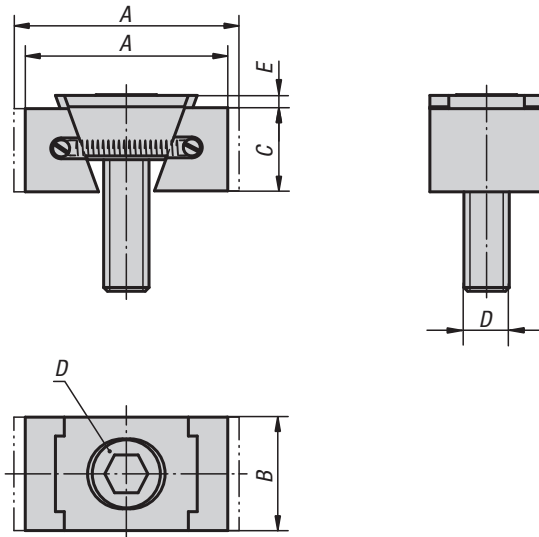
1) wedge clamps

2) workpiece

3) fixed stop

4) base plate

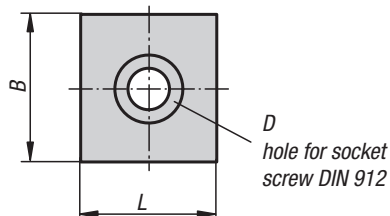
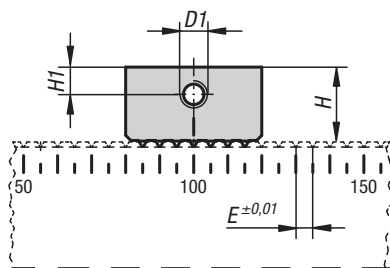
5) hydraulic/pneumatic cylinder



## KIPP Wedge clamps machinable

Order No.	Version	A min.	A max.	B	C	D	E	Clamping force max. kN	Tightening torque max. Nm
K0649.3108	narrow	36,5	39,5	24	15	M8X25	2	11	19
K0649.3110	narrow	42	47	28	19	M10X25	3,5	15	37
K0649.3112	narrow	54	59,5	30	22	M12X40	3,5	23	65
K0649.3116	narrow	65	72	40	29	M16X60	4	38	160
K0649.3208	wide	36,5	39,5	30	15	M8X25	2	11	19
K0649.3210	wide	42	47	38	19	M10X25	3,5	15	37
K0649.3212	wide	54	59,5	48	22	M12X40	3,5	23	65
K0649.3216	wide	65	72	48	29	M16X60	4	38	160

## Stops



### KIPP Stops

Order No.	Version	B	D	D1	E	H	H1	L
K0905.5000802	hard	24	M8x25	M5	2,5	15	6	25 ±0,01
K0905.5001202	hard	48	M12x30	M8	5	22	8	40 ±0,01
K0905.5001602	hard	48	M16x40	M8	5	29	12,5	40 ±0,01
K0905.5100802	soft	24	M8x25	M5	2,5	15	6	31 ±0,1
K0905.5101202	soft	48	M12x30	M8	5	22	8	50 ±0,1
K0905.5101602	soft	48	M16x40	M8	5	29	12,5	50 ±0,1



**Material:**  
Carbon steel 1.0503.

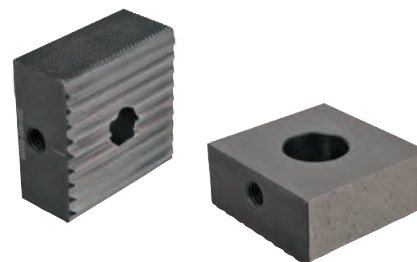
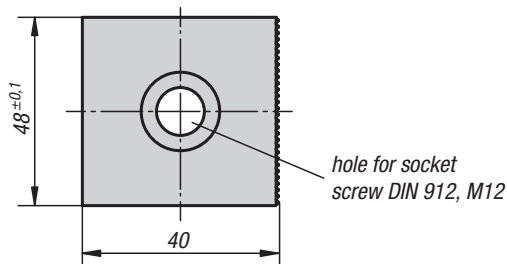
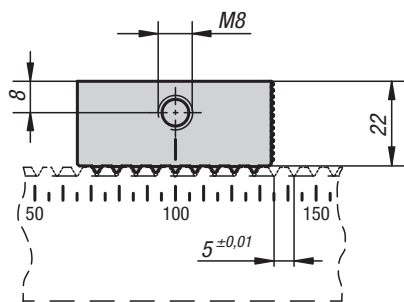
**Version:**  
Hard stop:  
Tempered to 1200-1400 N/mm<sup>2</sup>, black oxidised.  
Serrations and stop faces ground, bright.

Soft stop:  
Hardness HRC 30, black oxidised. Serrations case hardened and ground, bright.

**Sample order:**  
K0905.5000802

## Stop

carbide-coated and serrated



**Material:**  
Carbon steel 1.0503.

**Version:**  
Hard stop.  
Hardened to 58 +/2 HRC.  
Serrations ground, bright.

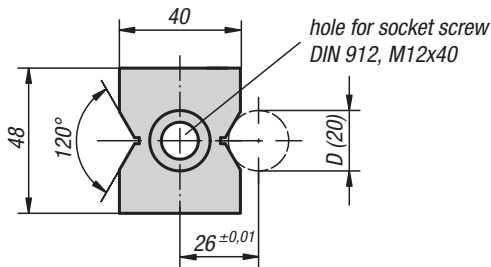
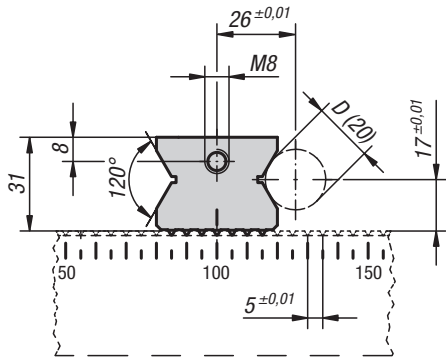
**Sample order:**  
K0905.5201202

**Note:**  
One stop face is serrated, the other side is carbide-coated.

### KIPP Stop, carbide-coated and serrated

Order No.	Dimensions
K0905.5201202	-

## Stop prism



**Material:**  
Carbon steel 1.0503.

**Version:**  
Prism tempered to 1200-1400 N/mm<sup>2</sup>, black oxidised.  
Serrations and prism ground, bright.

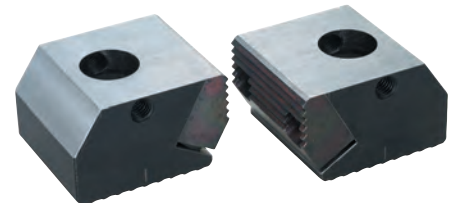
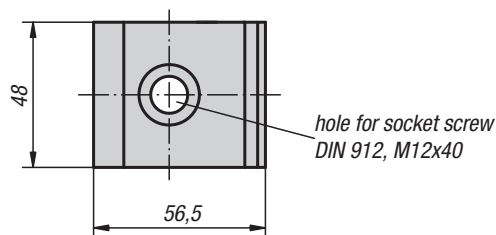
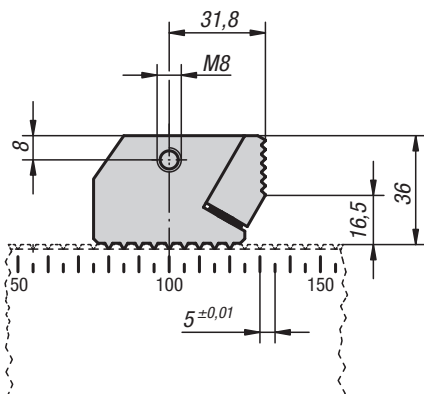
**Sample order:**  
K0906.5001265

### KIPP Stop prism

Order No.	D min. - max.
K0906.5001265	5 - 33

# K0907

## Stop with positive down force



**Material:**  
Stop and jaw carbon steel 1.0503

**Version:**  
Stop and jaw tempered to 1200-1400 N/mm<sup>2</sup>, black oxidised.  
Serrations ground, bright.

**Sample order:**  
K0907.5001273

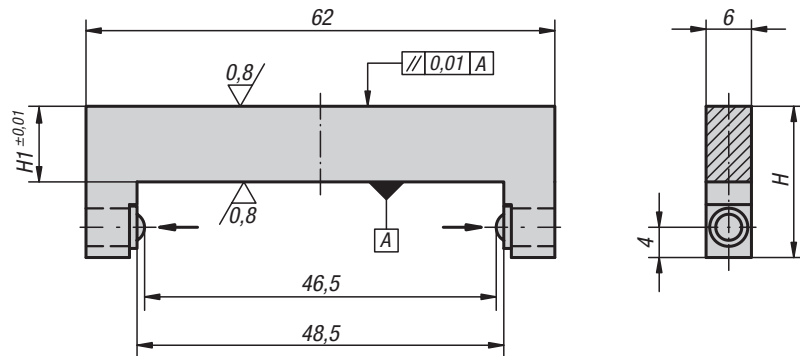
### KIPP Stop with positive down force

Order No.	Dimensions
K0907.5001273	-



# K0908

## Seating ledges



**Material:**  
Steel.

**Version:**  
Ledges hardened, black oxidised.  
Contact faces ground, bright.

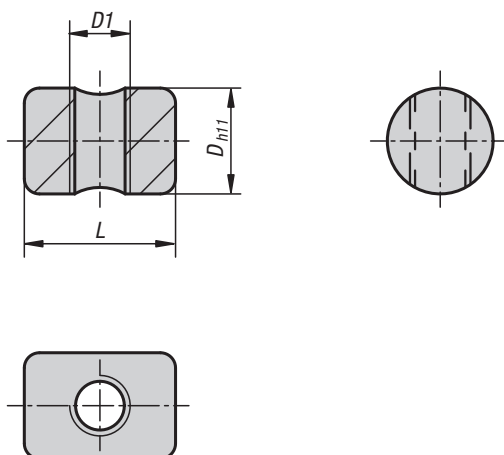
**Sample order:**  
K0908.5001295

### KIPP Seating ledges

Order No.	H	H1
K0908.5001295	20	10
K0908.5001298	27	17

# K0909

## Keyway nuts round



**Material:**  
Steel.

**Version:**  
Black oxidised.

**Sample order:**  
K0909.0802

### KIPP Keyway nuts round

Order No.	D	D1	L
K0909.0802	14	M8	20
K0909.1202	20	M12	30
K0909.1602	24	M16	35











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