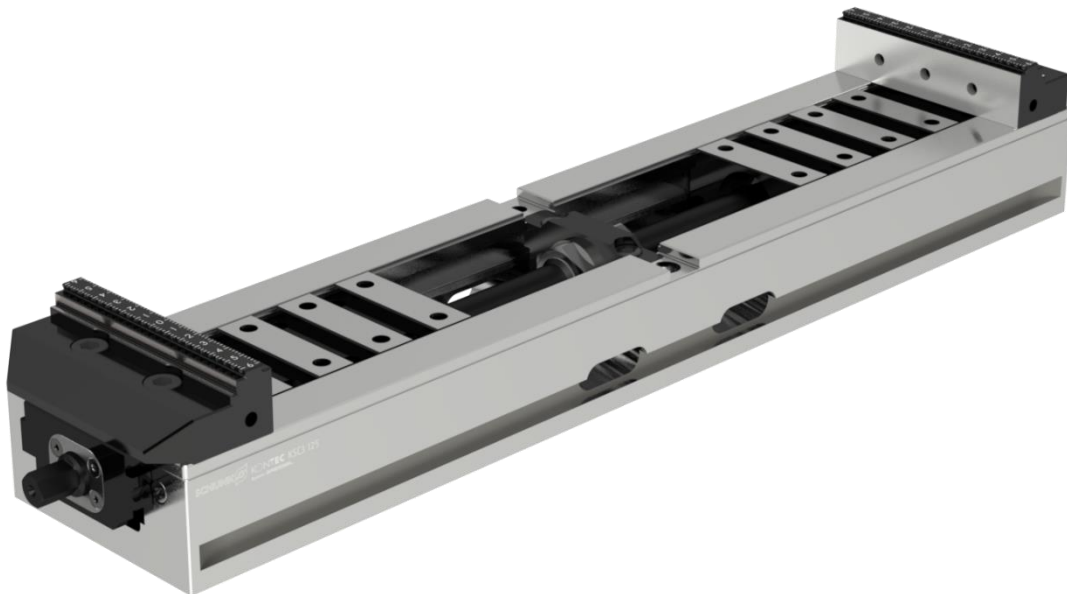


Montage- und Betriebsanleitung
Installation- and operating instruction

Zentrischspanner
Centric vise

KSC3 125 XL



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1 User information

1.1 Purpose of document

These instructions are an integral part of the product supplied and contain important information for the safe installation, commissioning, operation, servicing and maintenance. These instructions must be read before using the product and must be observed during operation, in particular the "General safety instructions" section.

1.2 Illustration of safety instructions

DANGER	
	Indicates imminent danger. If the information is ignored, death or serious injuries (permanent disability) will result.
WARNING	
	Indicates a potentially dangerous situation. If the information is ignored, it is possible that death or serious injury (permanent disability) will result.
WARNING	
	Indicates a potentially dangerous situation. If the information is ignored, it is possible that material damage and light to medium injuries will result.
NOTE	
	Indicates general information, useful tips for users and work recommendations which do not impact on the health and safety of operators. ... underscores useful tips and recommendations as well as information for efficient and trouble-free operation.
CAUTION	
	Indicates a potentially dangerous situation. If the information is ignored, material damage will result. ... points out a potentially dangerous situation that can lead to material damage if it is not avoided.

2 General safety instructions

2.1 Intended use

The clamping device may only be used in accordance with the technical data. The clamping device has been designed for stationary application on milling machines in an industrial environment.

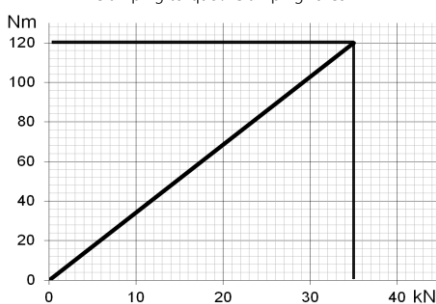
Using the device in accordance with the intended purpose includes compliance with the commissioning, installation and operating instructions, and with the environmental and service conditions as provided by the manufacturer.

The manufacturer accepts no liability for damage resulting from non-intended use.

2.1.1 Technical data

Version	max. torque	max. clamping force
KSC3 125-XL	120 Nm	35 kN

Clamping torque / Clamping force



Exceeding the max. torque results in damage to the spindle.

Weight:

KSC3 125-390	without system jaws: 17.0 kg
KSC3 125-460	without system jaws: 20.0 kg
KSC3 125-530	without system jaws: 24.0 kg
KSC3 125-600	without system jaws: 27.0 kg
KSC3 125-670	without system jaws: 30.5 kg
KSC3 125-740	without system jaws: 34.0 kg

For further data, please see homepage >> schunk.com <<

2.2 Reasonably foreseeable misapplication

Any application that is not in accordance with the "Intended use" or exceeds such intended use is considered not in accordance with the regulations, and is forbidden. Any other use of the device is subject to confirmation from the manufacturer.

Examples of foreseeable misapplication

- Clamping device used on rotating systems.
- Clamping widely protruding workpieces.
- Clamping workpieces with a weight of over 20 kg in vertical position without an additional protection against the workpiece falling out as a protective measure for the operator.

2.2.1 Alterations and modifications

In the case of unauthorised alterations and modifications of the clamping device, the manufacturer's liability ceases and any warranty is voided.

2.2.2 Spare and wear parts and auxiliary material

Only use original parts or parts approved by the manufacturer. Using spare and wear parts by third party manufacturers may lead to risk.

2.3 Residual risk

The user is responsible for applying the correct workpiece clamping.

New clampings have to be carefully checked by qualified personnel with relevant training.

One always needs to allow for the risk that the workpiece may slip or be dislodged, even when the clamping device is functioning correctly. This is due to the different geometries to be clamped, contact surfaces, clamping friction values, processing force, wrong manipulation of the milling machine etc. Protective devices are to be attached to the processing machine that will protect the operator from any tool or workpiece parts that may be ejected. It is mandatory that operators and others in the proximity of the processing machine wear protective goggles.

Do not use methods of operation that impair the function and operational safety.

2.3.1 Jaw change

Damage may result if system jaws are insufficiently tightened.

2.3.2 Notes on clamping technology

The operator is responsible for ensuring that the clamping geometry and clamping forces are suitable for the intended processing.

We recommend that clamping be carried out with a torque wrench in order to achieve consistent clamping results.

The clamping forces can only be achieved if the clamping device functions correctly and the workpiece is correctly held in the device.

Regular servicing and cleaning in accordance with the operating instructions is mandatory in order to ensure correct function.

When clamping thin-walled elastic workpieces, e.g. tubes or packages, it is possible that the clamping force is significantly reduced due to yielding of the workpiece.

When clamping with a high degree of force, the clamping force is significantly reduced due to the increased frictional forces in the sliders.

2.4 Duties of the organisation in charge

The organisation in charge of the device undertakes to only allow operatives to work on the device:

- who are familiar with the basic health and safety regulations and regulations for the prevention of accidents.
- who have completed appropriate induction for working with the machine.
- who have read and understood these operating instructions.

The requirements of the EC Directive 2007/30/EC on the use of work machinery must be complied with.

2.5 Operator duties

All persons who have been instructed to work with the machine undertake to:

- observe the basic regulations for health and safety and for the prevention of accidents.
- read and understand the section on safety and the safety instructions in these operating instructions prior to working with the machine, and to observe these instructions.

2.6 Operator qualification

The installation, initial setup, fault analysis and periodic monitoring have to be carried out by competent personnel with the relevant qualifications.

2.7 Personal protective equipment

WARNING	
	Ejected hot fragments can lead to serious eye injury. The regulations for safety at work and the prevention of accidents always have to be observed when working with the machine. Personal protection equipment must be worn at all times, in particular safety boots, gloves and safety goggles.

2.8 Warranty

Warranty	24 months
Maximum service life	50'000 clamping cycles

The warranty periode is valid from the date of delivery ex-works, provided the machine is used as intended and subject to the following conditions:

- Compliance with concurrent documents.
- Compliance with environmental and operating conditions.
- Compliance with the specified maintenance and lubrication intervals.
- Observance of the maximum service life.

Parts in contact with workpieces are not covered by the warranty.

3 Description of the clamping device

The KSC3 has been designed for centric clamping of unprocessed and finished workpieces.

3.1 Function

Direct vise with a mechanical drive via a capsuled thread.

The clamping force is generated mechanically and the clamping force transmission is linear across the whole clamping range.

Both jaws and sliders close respectively open synchronously and are symmetrical with respect to the position holes in the base body.

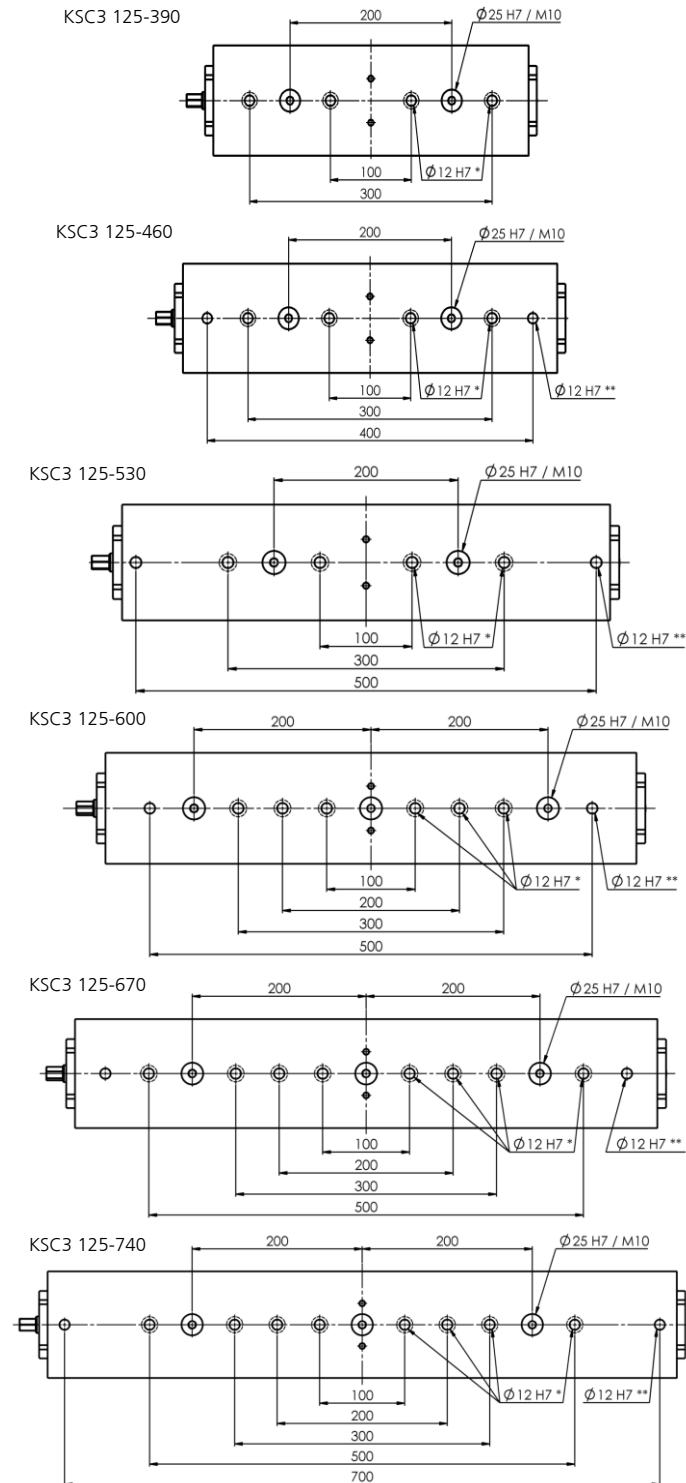
The vise is also suitable for workpiece clamping from the inside to the outside.

4 Operation (standard operation)

4.1 Aligning / Clamping

Important:

When using the Schunk quick-change pallet system, only the clamping pins VERO-S SPA 40-K ID: 0432369, SPB 40-K ID: 0432370 with short cylinder screw and the indexing bolt VERO-S IXB V1-K ID: 0432371 may be used.



* Position holes with cylinder counterbore Ø19 for cylinder screws.
** alignment hole 11 mm deep for cylinder pins.

4.2 Removing for mounting

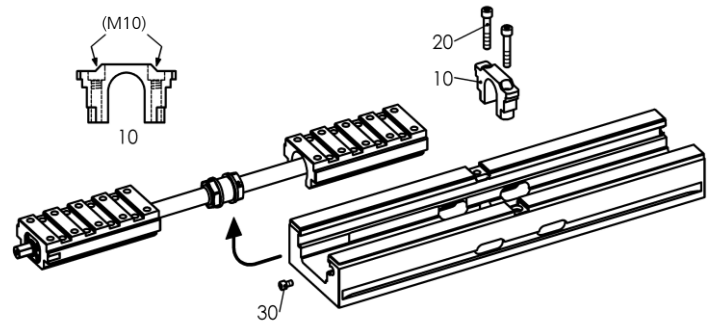
To be able to mount the KSC3 directly through the base body, the slider unit must be removed.
Remove cylinder screws (pos. 20) and the centering part (pos. 10).

Note:

When the cylinder screws (pos. 20) are removed, two screws M10 can be inserted in the fixing holes to make it easier to remove the centering piece (pos. 10).
Remove cylinder screw (pos. 30) and pull the complete slide unit with spindle out of the base body.

Important:

The two sliders must not be twisted relative to each other, otherwise the center position will change after reassembly.

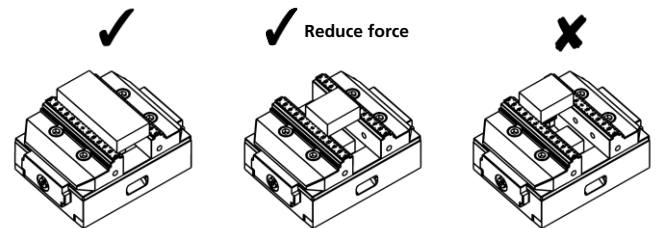


Install the slider unit in reverse order and tighten the cylinder screws (pos. 20) with 25 Nm.

4.3 Range of jaw

The reliable function of the clamping device is significantly affected by the selection of the correct top jaws.

4.4 Clamping



Important:

The clamping force must be adapted to the jaw and workpiece width.



4.5 Jaw change

- Release cylinder screws and remove the jaws.
- Clean and oil the contact surfaces, e.g. with MOTOREX Supergliss 68 K.
- Changing the jaws or moving them in the sliders, tightened the cylinder screw to the prescribed torque.

Failure to comply with this rule can result in insufficient workpiece clamping and hence to workpieces loss and damage.

4.6 Maximum sliders opening

The maximum opening of the sliders is limited by cylinder screws at both ends of the base body.



5 Servicing, cleaning and maintenance

Make sure that the sliding surface between the system jaws as well as the spindle is free of chips when adjusting the clamping range.
Clean and oil the running surfaces and guides of the vise regularly, e.g. with MOTOREX Supergliss 68 K.



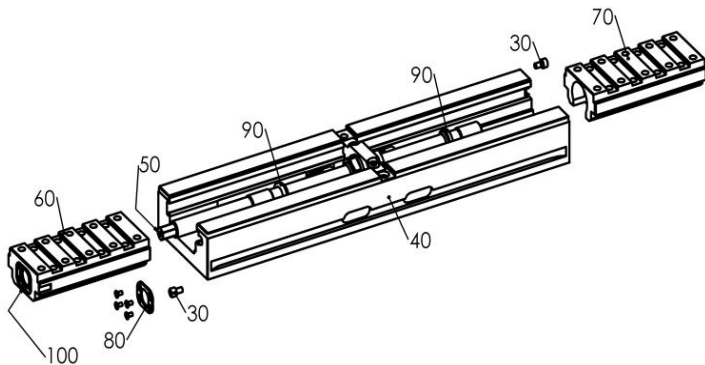
6 Troubleshooting / Eliminating faults

Device is hard to operate

Disassemble system jaws and clean the entire devices.
If this does not result in an improvement of the function, the device can be further dismantled in accordance with the description below.

Removing

- Remove cover (pos. 80).
- Remove cylinder screws (pos. 30) at both ends of the base body (pos. 40).
- Turn the spindle (pos. 50) counterclockwise to move both sliders (pos. 20 and 70) out of the base body until they can be pulled out. During this process, the two inner wipers (pos. 90) are usually also pulled out of the sliders and remain on the inside of the spindle.
- Pay attention to o-ring seal (pos. 100).



Important:

The high degree of precision of the KSC3 is achieved using a processing step while it is mounted.

The components of different vises must not be interchanged.

This is imperative in order to ensure the consistent central position of the system

and the fitting of the guide between the sliders and base body.

Further dismantling by the user is not permitted but can be carried out by the manufacturer or an authorised service agent.

Non-compliance with this rule invalidates the warranty.

Installation

- Clean the system completely.
- Re-grease the threads of the spindle (pos. 50) and at the sliders (pos. 60 and 70), using e.g. EP high-performance grease, such as LAGERMEISTER WHS 2002, NLGI class 1-2.
- Oil the running surfaces and bearing of the vise, using e.g. with MOTOREX Supergliss 68 K.
- Insert both sliders into the base body up to the thread beginnings of the spindle. Both sliders must come together and engage in the threads at the same time. This is imperative in order to ensure the consistent central position of the system.

Important:

The components of different vises must not be interchanged.

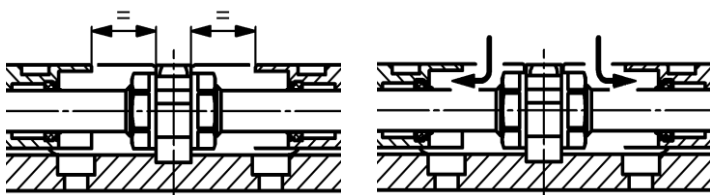
This is imperative in order to ensure the consistent central position of the system and the fitting of the guide between the sliders and base body.

- Screw in the threads by turning the spindle clockwise and pressing on both sliders ends at the same time.

Checking the central position

Move the sliders together completely and check whether the distance between the sliders slot and the middle centering part is identical. (= / =)

If this is not the case, remove the sliders again and repeat the process.



- Make sure that the two wipers (pos. 90) engage again in the receiving groove of the sliders, if necessary press them in with an auxiliary tool.
- Reinsert and tighten the cylinder screws (pos. 30) at both ends of the base body (pos. 40).
- Mount o-ring (pos. 100) and cover (pos. 80) with the countersunk screws.



7 Swivel and adapter plate

Processing the first side

Clamping with grip clamping steps of 3, 8 or 18 mm.

Processing the second side

Clamping on tungsten carbide coated side. When clamping the system jaws may yield slightly. The workpiece position must be measured.

7.1 Fitting the swivel and adapter plate

With the KSC3, the workpieces are clamped asymmetrically to the base body.

For reasons of stability, the swivel plate with the bearing journal must not be inserted in the outermost sliding groove.

7.2 Fitting the 6-fold reversible jaws

- Determine the mounting positions of the 6-fold reversible jaws. The best clamping results are achieved when clamping parts as far out as possible.
- Move the cover screws so that the selected clamping position is available.
- Position the 6-fold reversible jaws and loosely insert the cylinder screws.
- Turn the 6-fold reversible jaws on to the required clamping faces and slightly pre-clamp the workpiece so that the clamping faces are parallel to, and touch the workpiece.
- Use a torque of 80 Nm to tighten the cylinder screws of the 6-fold reversible jaws.



Important:

When the clamping faces of the 6-fold reversible jaws are not aligned parallel to the workpiece surface it is possible that the 6-fold reversible jaw becomes loose through the clamping force.



7.3 Servicing, cleaning and maintenance

The upper shoulder of the swivel peg must be greased regularly.

Turn the swivel plate once a week so that the lubrication film can be rebuilt.

Lubrication of the swivel peg is recommended once a year.

7.4 Troubleshooting / Eliminating faults

Swivel plate is difficult to turn

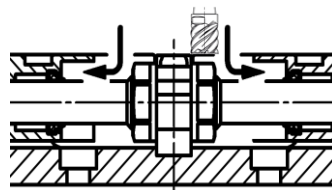
- Disconnect the swivel plate and push the swivel peg from below out of the swivel plate.
- Check the vise guide and swivel plate surface for indentations or deformations. If necessary, re-grind the plate and the vise guide.
- Check the peg for soiling.
- Check that the O-rings are correctly positioned. The upper O-ring must make good contact.
- Lubricate the entire system with grease and reassemble.

When handling, the swivel plate should not be turned upside down.



8 Aluminium jaws

The aluminium jaws are designed for producing workpiece-specific clamping contours. In order to achieve maximum precision of the contour, it is recommended that the contour milling is carried out with pre-clamping of the aluminium jaws. For this purpose, a narrow spacer piece can be clamped at the bottom and the pre-clamped aluminium jaws can then be milled to achieve the desired clamping contour.



Important:

Mill the system jaw to a maximum depth of the screw head. Ensure that the clamping cross-section is sufficient.



9 Service / Maintenance

Note:

It is not possible to supply spare parts for the slider, base body and spindle, as these are designed and fitted at the factory to work together. Repairs can be carried out by the manufacturer or an authorised service agent.



10 Taking out of service

The clamping device and all accessories can be disposed of as scrap metal without any risk.



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