

FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

Significantly upgrade CNC Machines



ASC-M Series



SCAN To Learn More

- Special 45° dovetail structure with teeth
- A pair of mounting holes can be directly fixed on machine bed

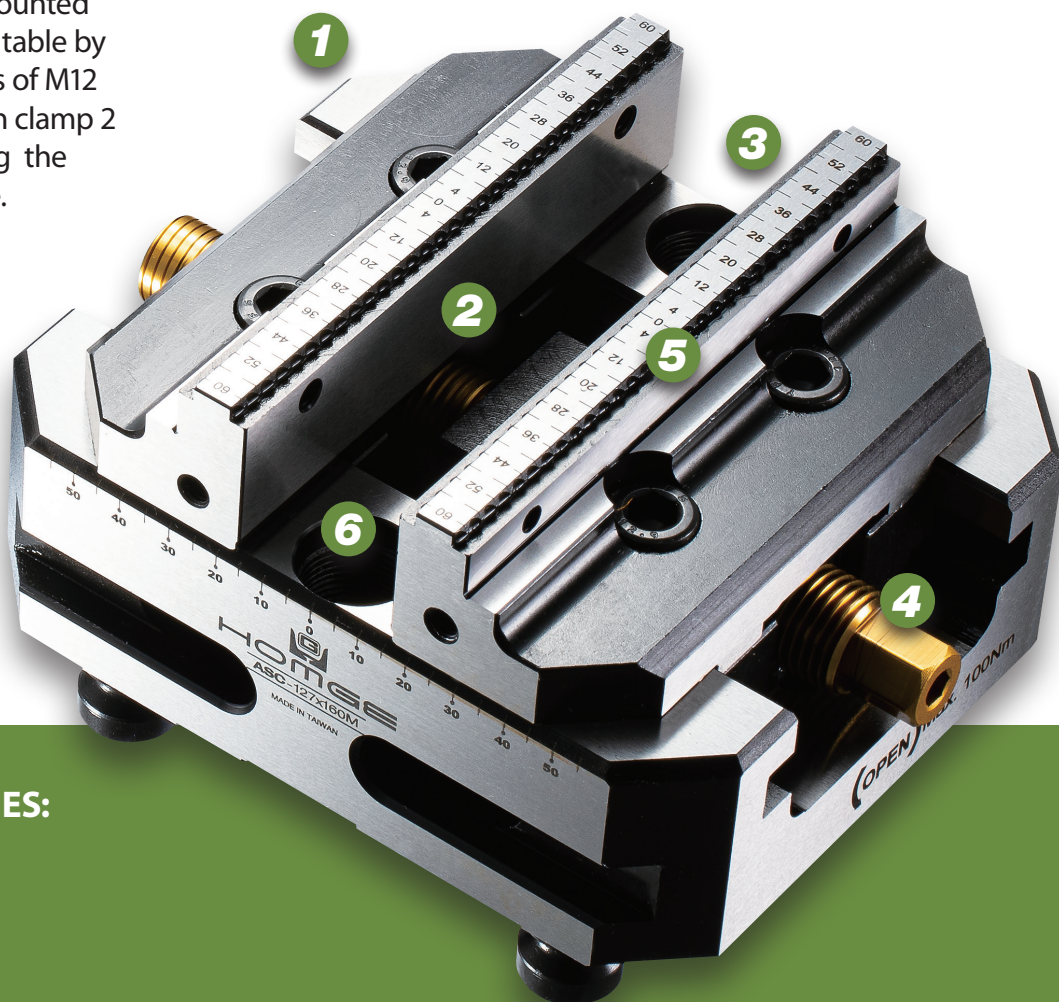
HOMGE
MACHINERY IND. CO., LTD.

FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

PATENTED

**Model: ASC-127x130M, 127x160M,
ASC-127x210M, 127x260M,
ASC-150x260M**

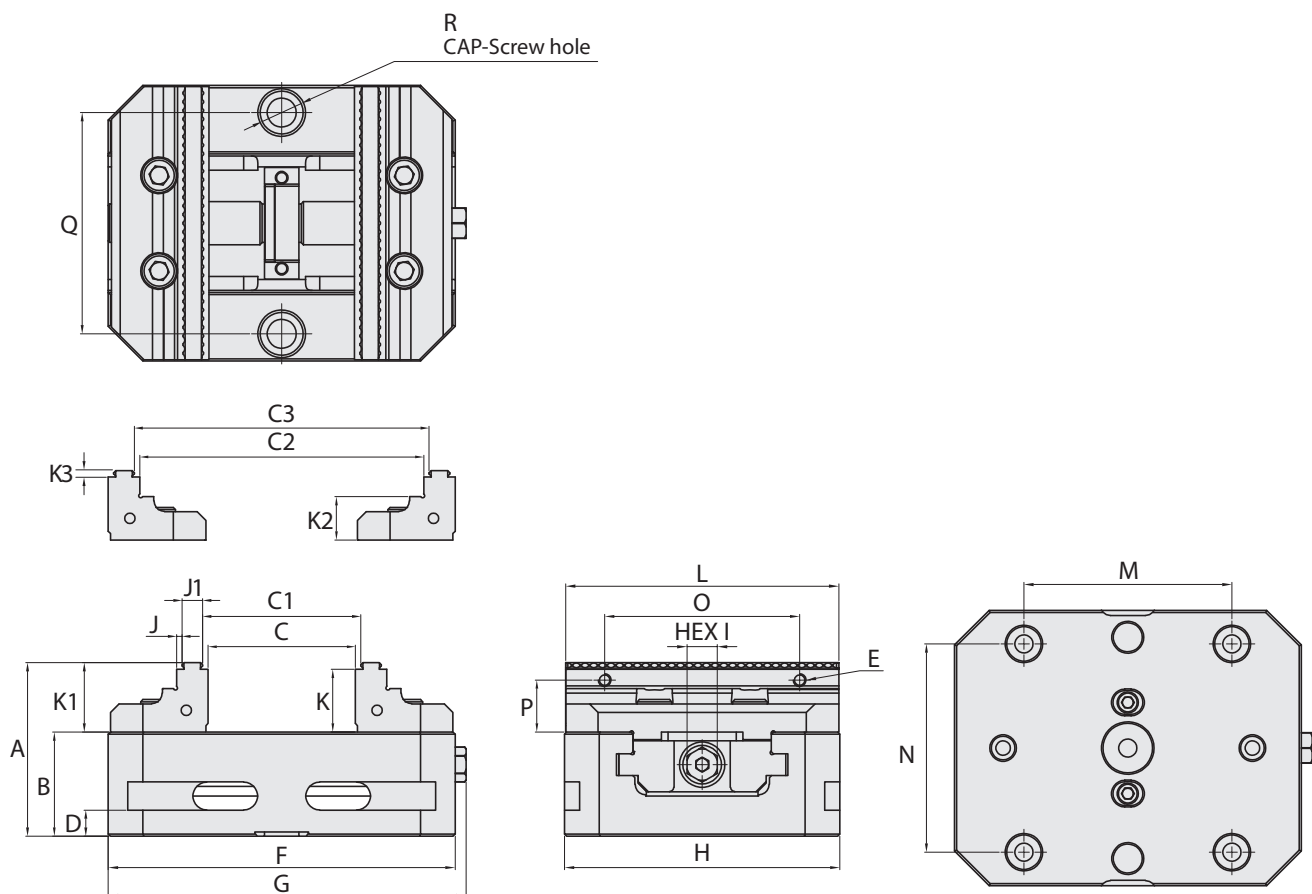
- With a pair of mounting holes, ASC-M series can be directly fixed on the 3rd, 4th or 5th-Axis machine bed.
 - Purchase an additional Fixed Jaw to enable dual clamping.
1. Vise body is made of **High quality Steel (S50C)** and its slideways gone through high-frequency hardening to achieve **HRC 50**, which makes the whole part durable.
 2. Detachable jaws are made of **High quality Tool Steel (SCM440)** and gone through carburizing to achieve **HRC 55**. Since both sides are fixed size and able to be used as a datum, users can reverse them to increase clamping range.
 3. The vise's clamping force can achieve **1300KG**, the repeatability positioning precision of its clamping center is within **$\pm 0.02\text{mm}$** .
 4. Users can calibrate the clamping center of vise by adjusting the nut in the middle.
 5. The **45° dovetail structure with teeth** on the upper jaws ensure the bottom of the workpiece to be firmly clamped.
 6. The vise body can be mounted directly on the machine table by the middle with 2 pieces of M12 screws. This vise also can clamp 2 workpieces by mounting the centre jaw in the middle.



STANDARD ACCESSORIES:

- 4 pcs of Clamp
- 1 pc of Wrench

DIMENSIONS



SPECIFICATIONS (Material: Vise body S50C. Hardness: HRC 50/ Detachable Jaws SCM440. Hardness: HRC 55)

Unit: mm

Model	A	B	C	C1	C2	C3	D	E	F	G	H	I	J	J1
ASC-127x130M	80	48	40	45	101	106	12	M6	130	135	127	14	2.5	9.5
ASC-127x160M	80	48	70	75	131	136	12	M6	160	165	127	14	2.5	9.5
ASC-127x210M	80	48	120	125	181	186	12	M6	210	215	127	14	2.5	9.5
ASC-127x260M	80	48	170	175	231	236	12	M6	260	265	127	14	2.5	9.5
ASC-150x260M	80	48	170	175	231	236	12	M6	260	265	150	14	2.5	9.5

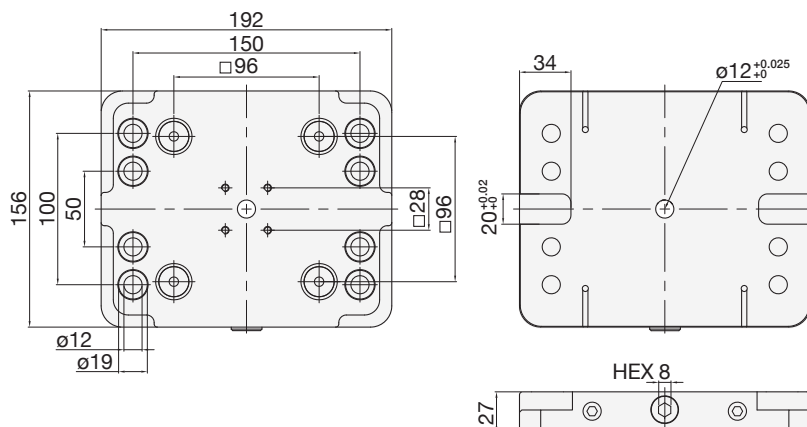
Model	K	K1	K2	K3	L	M	N	O	P	Q	R	Pull Stud	Weight (kg)
ASC-127x130M	29	32	20	3	126	96	96	90	24	102	M12	M-96x96PS	7.3
ASC-127x160M	29	32	20	3	126	96	96	90	24	102	M12	M-96x96PS	7.5
ASC-127x210M	29	32	20	3	126	96	96	90	24	102	M12	M-96x96PS	8.5
ASC-127x260M	29	32	20	3	126	96	96	90	24	102	M12	M-96x96PS	10
ASC-150x260M	29	32	20	3	149	96	96	90	24	120	M12	M-96x96PS	13.5

OPTIONAL ACCESSORIES

Rectangular Plate

Model: M-96x96 (8051)

- Size: 192x156x27 mm
- Pull Stud: M-96x96PS
- Weight: 5.5 kg



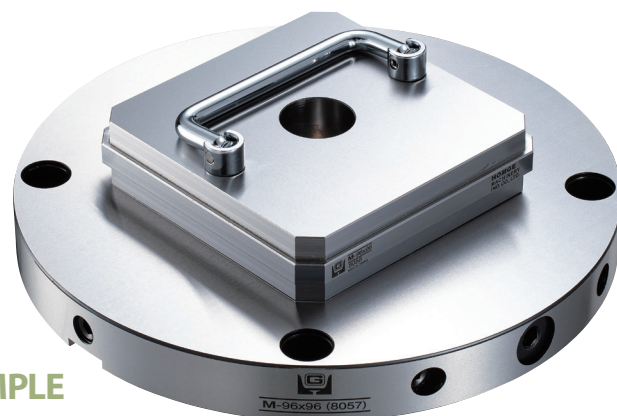
To visit <http://www.homge.com.tw> for more related Plates, Raisers, Multi Plates, Clamping Bridges, Clamping Unit and Applications

Master Gauging Pallet

Model: M-96x96 (8058)

- Size: 130x130x30 mm
- Pull Stud: M-96x96PS
- Weight: 3.4 kg

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



EXAMPLE

Pull Studs

Model: M-96x96PS

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

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



Spacer Studs

Model: M-96x96SS

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

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



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