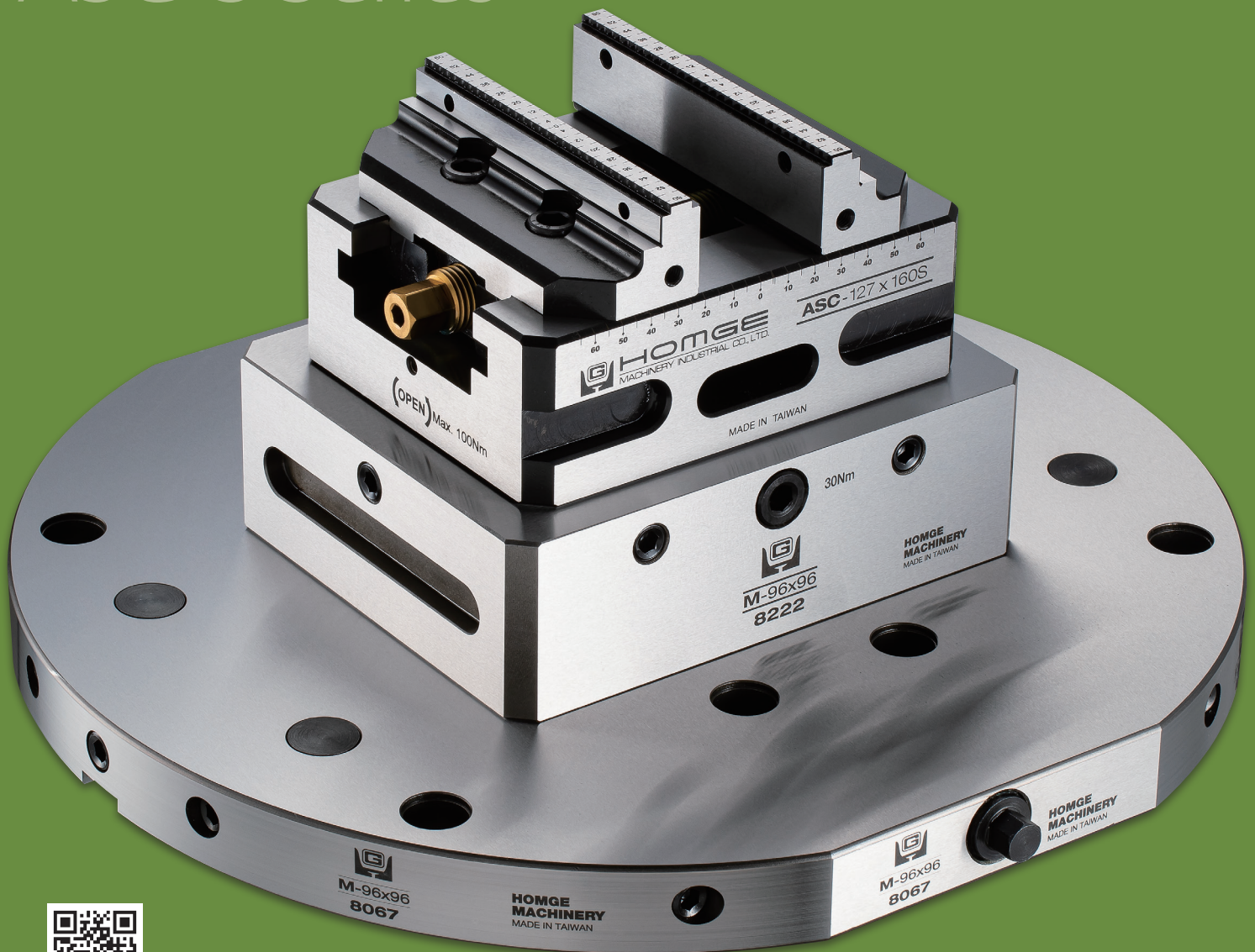




FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

Significantly upgrade CNC Machines

ASC-S Series



- Special 45° dovetail structure with teeth
- The patented calibration system can regulate clamping center easily and rapidly

HOMGE
MACHINERY IND. CO., LTD.

FIVE-AXIS ADJUSTABLE SELF-CENTERING VISE

PATENTED

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

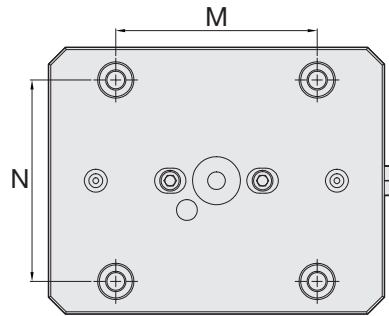
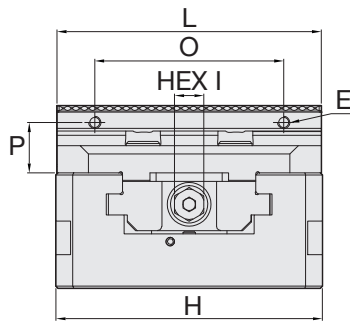
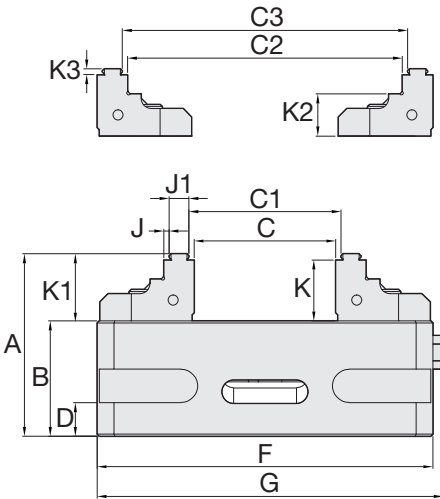
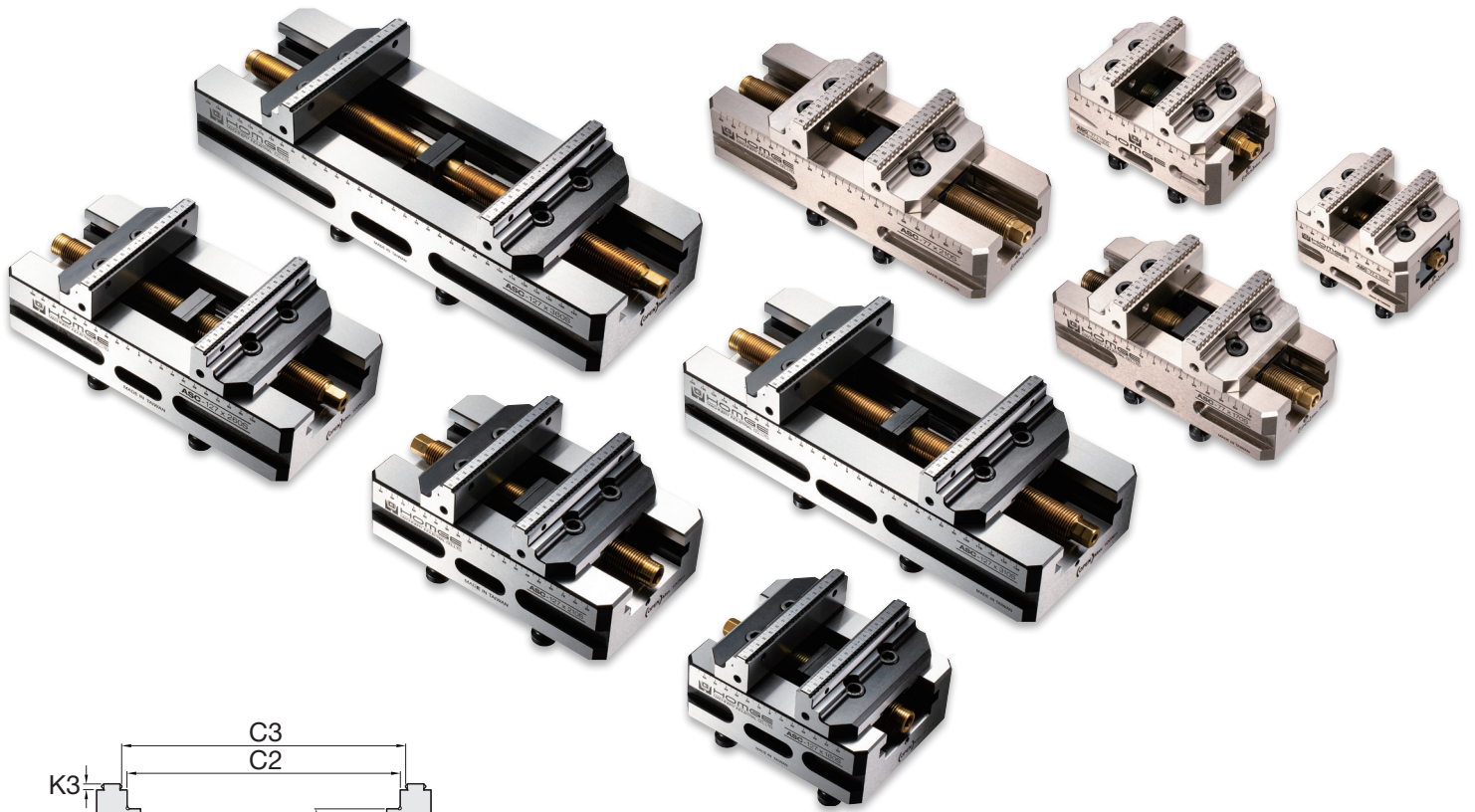
- Patented stud bolt seat design can efficiently calibrate the clamping center.
- It is recommended to operate with a Master Plate on a five-axis machine.
- Compatible with Robotic Arms.

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 screws on both ends.
5. The **45° dovetail structure with teeth** on the upper jaws ensure the bottom of the workpiece to be firmly clamped.

STANDARD ACCESSORIES:

- 4 pcs of Clamp
- 1 pc of Wrench





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

Unit: mm

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

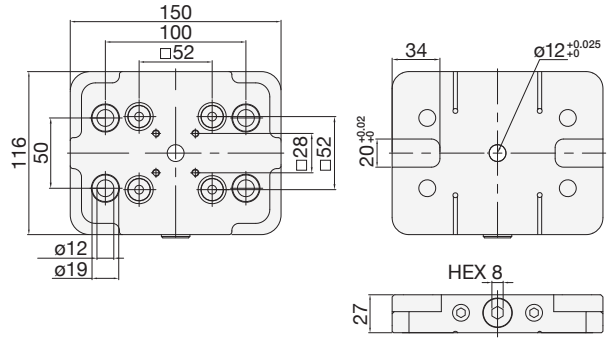
Model	K	K1	K2	K3	L	M	N	O	P	Pull Stud	Weight (kg)
ASC-77X102S	24	27	18	3	77	52	52	42	15	M-52x52PS	2.8
ASC-77X130S	24	27	18	3	77	52	52	42	15	M-52x52PS	3.5
ASC-77X170S	24	27	18	3	77	52	52	42	15	M-52x52PS	4.2
ASC-77X210S	24	27	18	3	77	52	52	42	15	M-52x52PS	4.9
ASC-127x160S	29	32	20	3	126	96	96	90	24	M-96x96PS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

OPTIONAL ACCESSORIES

Rectangular Plate

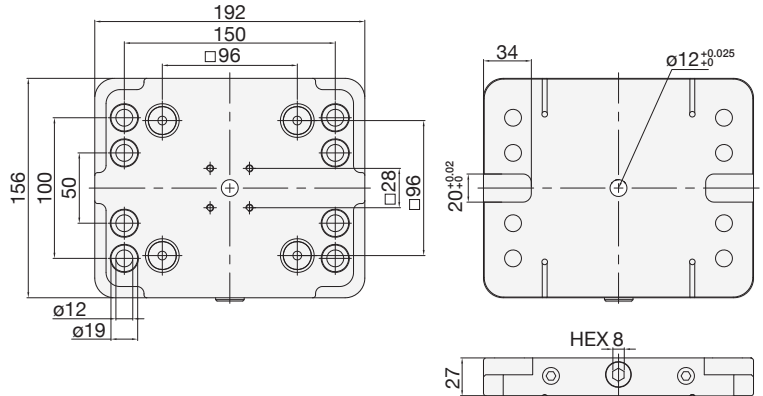
Model: M-52x52 (8001)

- Size: 150x116x27 mm
- Pull Stud: M-52x52PS
- Weight: 3 kg
- Suitable for
ASC-77x102S
ASC-77x130S
ASC-77x170S
ASC-77x210S



Model: M-96x96 (8051)

- Size: 192x156x27 mm
- Pull Stud: M-96x96PS
- Weight: 5.5 kg
- Suitable for
ASC-127x160S
ASC-127x210S
ASC-127x260S
ASC-127x310S
ASC-127x360S



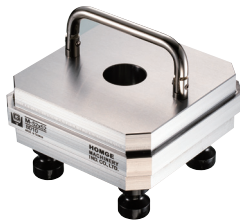
To visit <http://www.homge.com.tw> for more related Plates, Raisers, Multi Plates, Clamping Bridges, Clamping Unit and Applications

Master Gauging Pallet

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

Model: M-52x52 (8010)

- Size: 86x86x30 mm
- Pull Stud: M-52x52PS
- Weight: 1.5 kg



Model: M-96x96 (8058)

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



Pull Studs

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

Model: M-52x52PS

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



Model: M-96x96PS

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



Spacer Studs

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

Model: M-52x52SS

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



Model: M-96x96SS

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



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