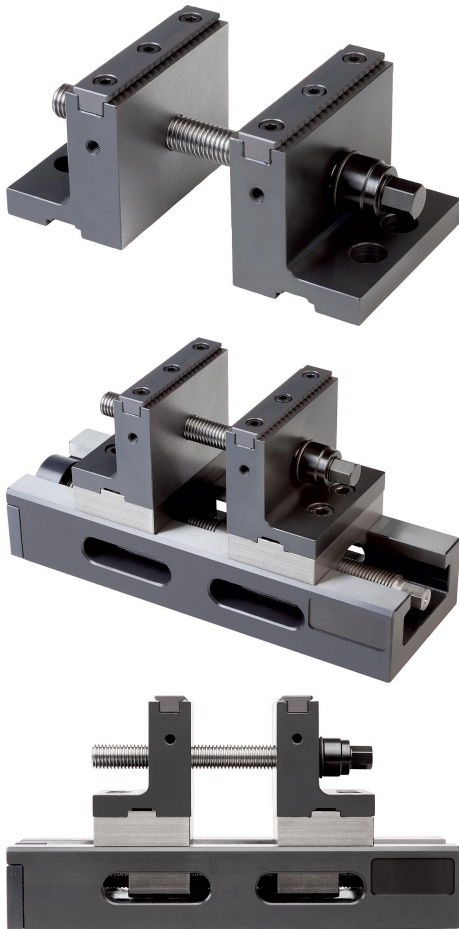


## Step jaw attachment for 5-axis machining

### Item description/product images



### Description

#### Material:

Steel.

#### Version:

Stepped jaws hardened, clamping faces ground.

Grip rail hardened.

#### 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.

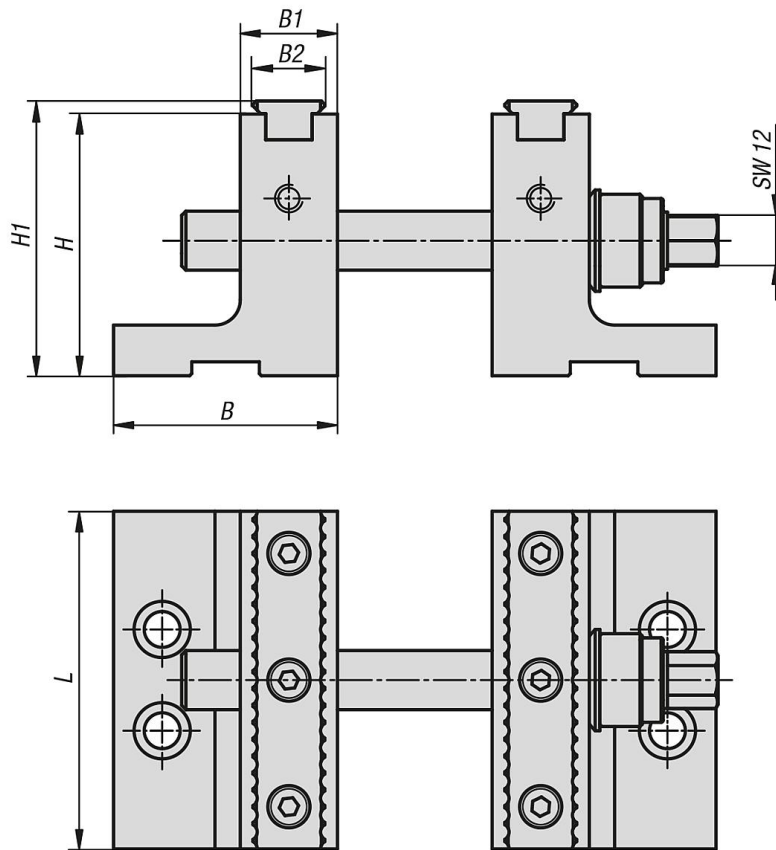
#### Advantages:

Ideal for 5-side machining. High setup on the machine table for 5-axis machines.

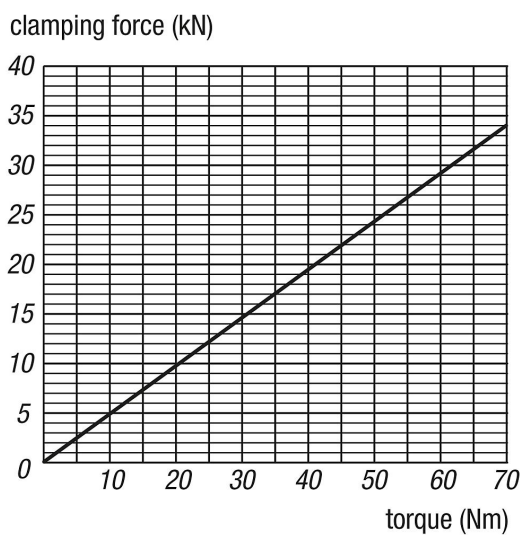
Clamping force directly under the workpiece. The attachment jaws can be retrofitted for the 80 mm and 125 mm centric vices. The workpiece is first centred using the lower centring spindle, then finally clamped using the upper clamping spindle.

# Step jaw attachment for 5-axis machining

## Drawings



clamping force diagram



## Overview of items

### Step jaw attachment for 5-axis machining

Order No.	Version 1	B	B1	B2	H	H1	L	weight kg
K1115.0801	for 5-axis machining	53	23	17	62	65,1	80	2,689

## Step jaw attachment for 5-axis machining

### Overview of items

Order No.	Version 1	B	B1	B2	H	H1	L	weight kg
K1115.1251	for 5-axis machining	67	23	17	90	93,1	125	6,32