

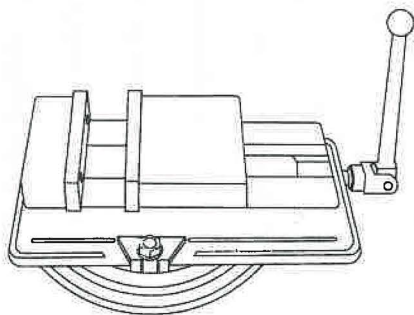
ACCU-LOCK MACHINE VICE

TECHNICAL DOCUMENT

OPERATION MANUAL

TEST CERTIFICATE

PACKING LIST



OPERATION MANUAL

I . MAIN USE AND PERFORMANCE

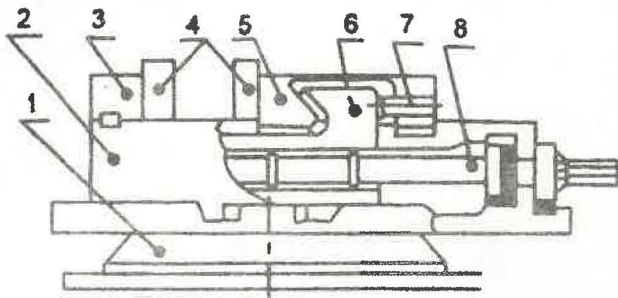
- 1、 This product is main attachments to precision millings grinders no machines,
- 2、 When active mouth of the tongs level migration, Above it half sphere can have a vertical downward pressure, therefore the clamp work piece cannot surface the boat.
- 3、 The mouth of the tongs opens the opening to be possible to act according to four direction changes.

II . Uses and maintains

- 1、 advert: Middle has an adjuster bolt in active mouth of the tongs behind, uses in eliminating the nut with pliers body between gap, enable between both to have a correct connection, if connects too tightly, on the active mouth of the tongs half sphere can shift, too loose, guide screw and nut not concentric, the guide screw passes time is difficult.
- 2、 In the transportation and the operation, forbid strictly the rap and the collision, otherwise the precision is unable to guarantee.
- 3、 In order to guarantee the operation is nimble, all active parts need to be lubricated frequently.

III. Main structure and explanation

1、Main structure(see beloweng figure)



1-Base

2-Body

3-Fixed mouth of the tongs

4-mouth of tongs

5-Active mouth of the tongs

6-Nut

7-Adjust screw

8-Screw

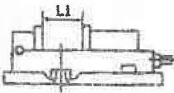
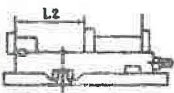
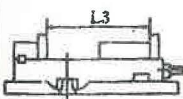
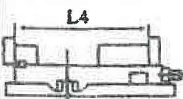
Main Specification

mm

	QM60	QM80	QM100	QM125	QM160	QM160L	QM200	QM200L	QM250	LV-6X
Mouth of the tongs width	60	80	100	125	160	160	200	200	260	224
Mouth of the tongs altitude	21	23	32	40	45	45	50	50	70	45
Biggest clamping force	12KN	14KN	19KN	24KN	29KN	29KN	34KN	34KN	39KN	34KN
Localization width of key	14	14	14	14	18	18	18	18	18	18
Screw rod six square head widths	12	12	14	14	19	19	19	19	25	19
Diameter of bolt	M12	M12	M12	M12	M16	M16	M16	M16	M22	M16
Foundation scale interval(°)	1°	1°	1°	1°	1°	1°	1°	1°	1°	1°
Chassis two set grove center distances	140	160	200	230	275	275	310	400	325	375
External dimensions (LxWxH)	230x140 x80	245x162 x97	237x191 x118	240x275 x136	450x298 x157	489x298 x159	540x340 x179	620x340 x179	725x365 x170	480x230 x121
weight(KGS)	6	9	17	22	35	36	52	60	88	34

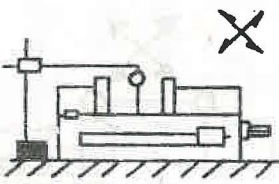
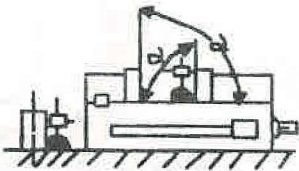
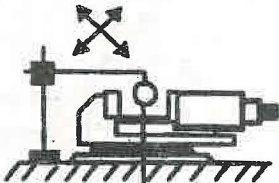
The mouth of the tongs opens the opening

mm

	QM60	QM80	QM100	QM125	QM160	QM160L	QM200	QM200L	QM250
	60	75	100	125	170	200	220	220	290
	100	118	145	180	230	260	300	380	355
	140	160	200	255	296	326	376	456	500
	180	203	245	310	359	389	447	527	615

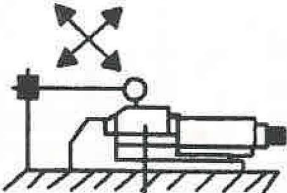
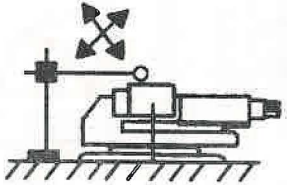
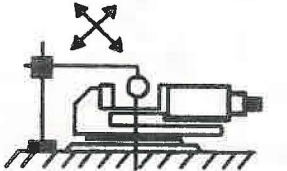
Precision check list

mm

Examination project	Testing sketch	Accuracy
Vice body guide rail first tone facing bottom plan parallelism		In 100 survey lengths 0.02
Fixed mouth of the gongs surface and active mouth of the tongs facing guide rail on plane verticality		In 100 survey lengths $0.05\alpha < 90^\circ$
Guide rail first tone facing bottom plane plane parallelism		In 100 survey lengths 0.02

Precision check list

mm

Examination project	Testing sketch	Accuracy
Examination block frist tone facing vice body bottom surface parallelism		In 100 survey lengths
		0.03
Examination block frist tone facing foundation buttum plane parallelism		In 100 survey lengths
		0.04
On examination block plane gradient		0.04

PACKING LIST

NO.	NAME	ITEM									QUANTITY
1	Accu-Lock machine vice	QM60	QM80	QM100	QM125	QM160	QM160L	QM200	QM200L	QM250	1
2	Handle	12	12	14	14	19	19	19	19	25	1
3	Locating key	14	14	14	14	18	18	18	18	18	2
4	Bolt	M6×12	M6×12	M6×12	M6×12	M6×12	M6×12	M6×12	M6×12	M6×12	2
5	Technical Document: Operation Manual Test Certificate Packing List										1

TEST CERTIFICATE

Name: Machine Vice

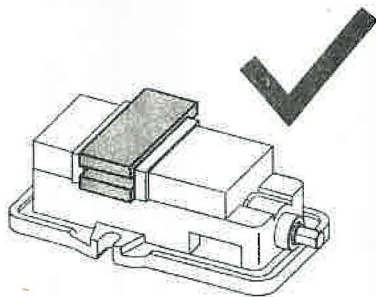
Model:

The product conforms to the standard
qualified after the examination, permits the
exwor.

Inspector:

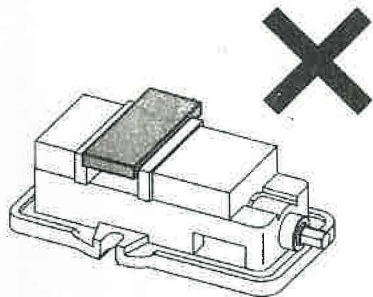
Date

Schematic diagram of the clamping workpiece



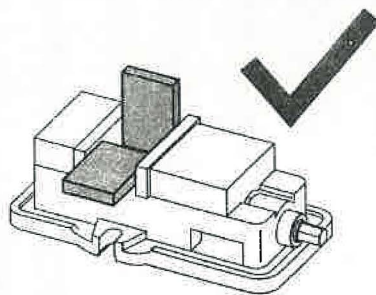
Correct clamping:

This clamping can make the jaws uniform force, will not be damaged jaws and body structure.



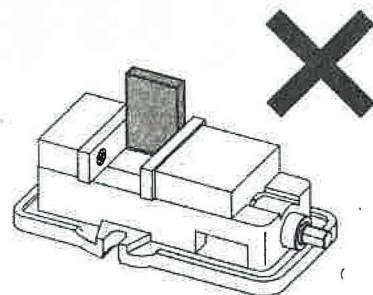
Error clamping:

Clamping directly in the air, there is no simultaneous force point below, resulting in the jaw tilting force, easy to damage the body structure.



Correct clamping:

This clamping can make the jaws uniform force, will not be damaged jaws and body structure.



Error clamping:

One side clamping, and no gasket clamping at the same time on the other side force, will lead to uneven force on the jaws, resulting in the jaws change shape, damage.