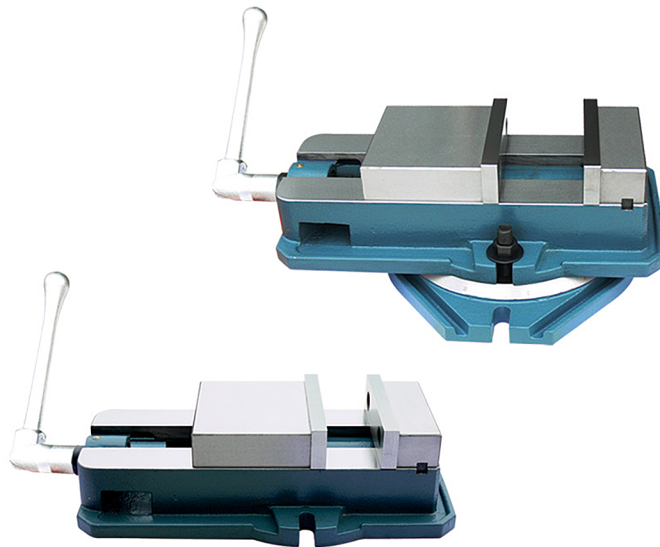


HIGH MILLING MACHINE VISES

ANGLE-PRESS-STRUCTURE HEAVY DUTY PRECISION MILLING VICE

Operation Manual



- Parallelism between slideway and base 0.008/300mm.
- Verticality of jaw plate towards slideway 0.015/100mm.
- Quick release handle improves clamping efficiency.
- Hardened jaw plate and sliding screw.
- special structure ensures excellent clamping.



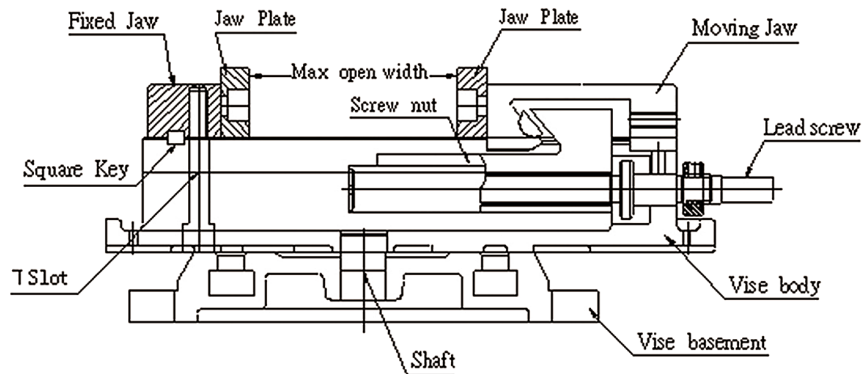
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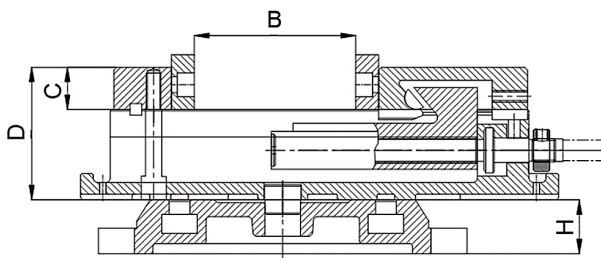
Product Structure and Technical Parameters

1. Product Structure

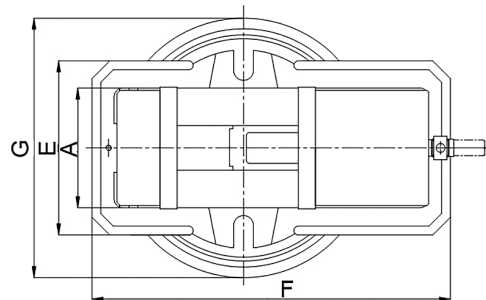


(Fig. 1)

2. Technical Parameters



(Fig. 2)



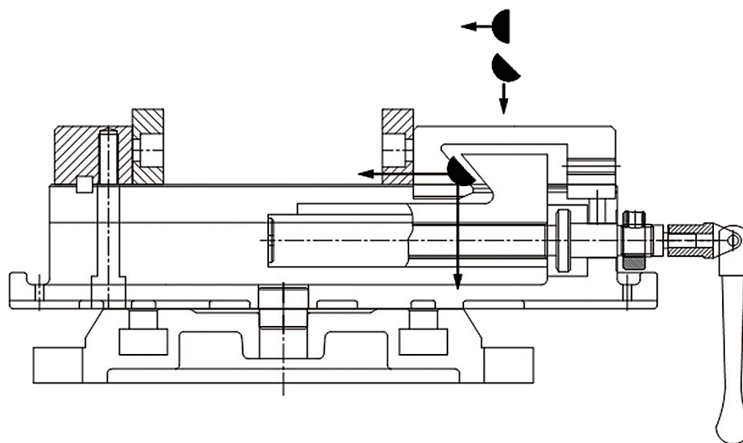
(Fig. 3)

MODEL	A	B	C	D	E	F	G	H	Weight
LV-3"(75)	3-1/16" (78)	3" (76)	63/64" (25)	3-5/32" (80)	4-1/4" (108)	15/32" (266)	6-7/64" (155)	1-3/16" (30)	28lb (12.8Kg)



Operational Principle and Features

- 1 Special design to hold the workpiece firmly
 - 2 Replaceable cranks help to hold the workpiece fast and easy
 - 3 Ensurance of parallelism and perpendicularity when holding firmly
- Principles Demostration:**



Icons	Remarks
	<p>Each pound of horizontal force Induces 1/2 pound of vertical force.</p>
	<p>Semispherical design can stabilize and lock the workpiece, eliminate floating and leaning of jaws cushion.</p>



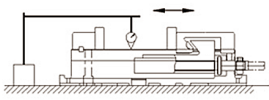
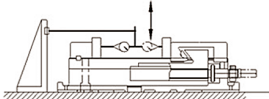
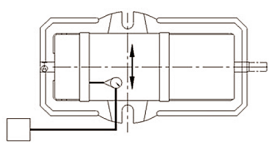
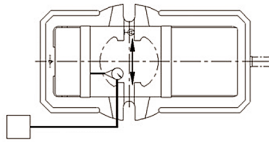
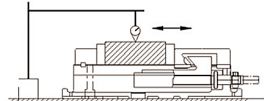
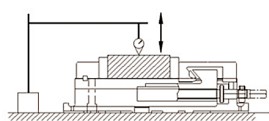
Detailed Parts and Process Features

Names of Parts	Materials	Technical Requirement	Parts Figure
Pliers	FC300	Pliers (guide railside) Hardening 38-42	
Bed	FC300	Aging Treatment	
Jaws Cushion	40Cr	HB269-302 Hardening 48-52	
	50Cr	HB269-302 Hardening 55-60	
Fixed Jaws	FC300	Aging Treatment	
Movable Jaws	FC300	Aging Treatment	
Movable Nut	FCD500	Aging Treatment	
Screw	45#	HB248-285 Hardening 40-45	



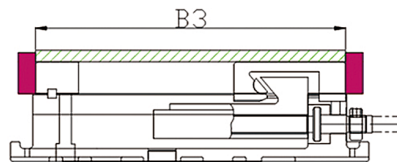
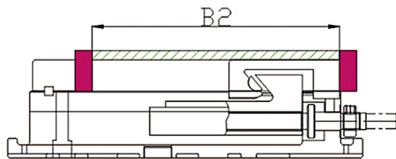
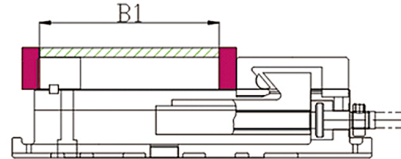
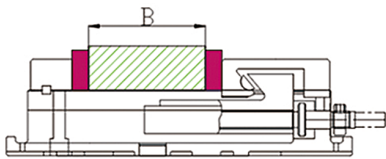
Quality and Inspection Specification

Detailed Inspection Specification:

No.	Inspection Aspects	JIS Standard Grade 0	Inspection Results	Sketch Maps
1	Parallelism of the pliers face and the pliers bed	0.0008"/4"	0.0003"/4"	
2	Perpendicularity of the fixed (movable) jaws and pliers bed	0.0012"/4"	0.0004"/4"	
3	Perpendicularity of the pliers bed Tgroove and movable jaws	0.0006"/4"	0.0004"/4"	
4	Parallelism of the pliers bed T-groove and movable jaws	0.0006"/4"	0.0004"/4"	
5	Parallelism of the workpiece's upper surface and the pliers bed (workpiece is holded)	0.0008"/4"	0.0006"/4"	
6	Degree of workpiece floating (workpiece is holded)	0.0012"/4"	0.0006"/4"	



Four Different Holding Manners



For workpiece with different size, different holding manners can be selected:

MODEL	B	B1	B2	B3
LV-3"(75)	3" (76)	5-1/32" (128)	6-15/16" (176)	7-27/32" (199)



PACKING LIST CERTIFICATE

PACKING LIST

PART	DESCRIPTION	UNIT	QUANTITY	REMARK
PRECISION TOOLING VICE		PC	1	
BASEMENT		PC	1	
HANDLE		SET	1	
T-SCREW		SET	2	
POSITIONING KEY		SET	2	
CLEANING CLOTH		PC	1	

CERTIFICATE

*WE HEREBY CERTIFY THAT EACH STATISTICS OF THIS PRODUCT
COMPLIES WITH TECHNICAL STANDARDS FOR SALE IN THE INSPECTION.*

MODEL: _____

INSPECTION DATE: _____

INSPECTOR: _____