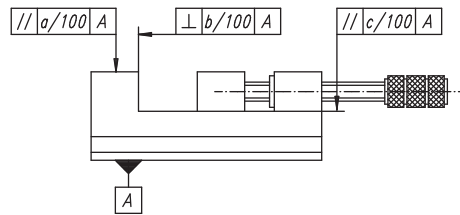


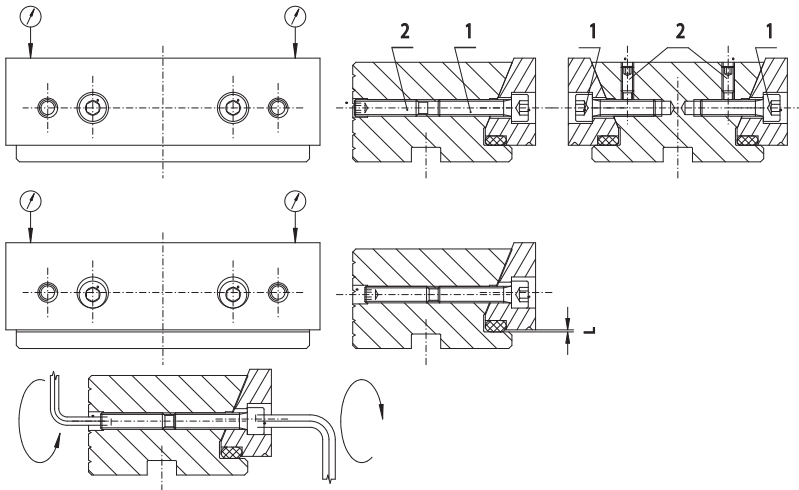
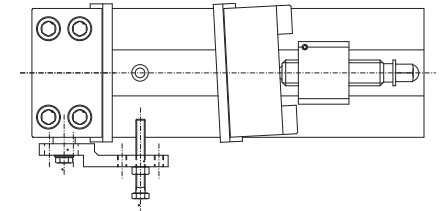
TOOLMAKER'S AND INSPECTION VISES

Type	a	b	c
	[mm]		
6552-63	0.005	0.003	0.005
6552-80	0.005	0.003	0.005
6552-100	0.007	0.005	0.005
6553-63	0.005	0.003	0.005
6553-80	0.005	0.003	0.005
6553-100	0.007	0.005	0.005
6554-63	0.005	0.003	0.005
6554-80	0.005	0.003	0.005
6554-100	0.007	0.005	0.005
6555-80	0.005	0.003	0.005



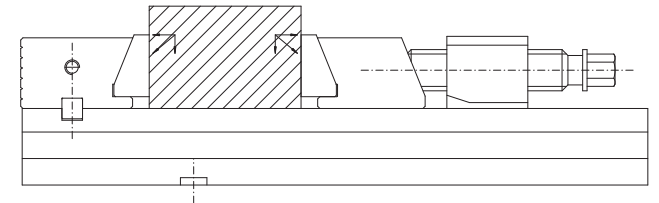
- For clamping the workpieces of irregular shape a swinging leading plate can be used which allows for swiveling of movable jaw by about $\pm 3^\circ$ angle.
- Side stop screwed to fixed jaw side enables positioning the workpieces parallel to jaw inserts surface

USAGE OF SIDE STOP



ADJUSTING THE POSITION OF JAW INSERTS

- Proper clamping of the workpiece will be obtained when jaw inserts are seated on the jaw guides. Only then the proper accuracy of the workpiece fixing will be ensured.



- Clamping inserts in the vise jaws have preset play, ensuring that workpieces are correctly clamped
- The amount of this play should be $L = 0.2$ mm with positioning accuracy of ± 0.01 mm
- The difference between "L" dimensions in movable and fixed jaws should not exceed 0.01 mm
- To obtain the required positioning of the clamping insert proceed as follows:
 - 1 - loosen set screws (2)
 - 2 - tighten the bolts (1) to make the clamping insert sit in the jaw guide
 - 3 - use the dial gauge to check the parallelism of the clamping insert to the vise base
 - 4 - set the required value of $L = 0.2$ (± 0.01 mm) by loosening the bolts (1)
 - 5 - use the dial gauge to check the parallelism of the clamping insert to the vise base, the parallelism of the clamping insert to the vise base should be the same as measured in point 3
 - 6 - secure bolts (1) by tightening set screws (2)
- Perform above steps for setting clamping inserts both in fixed and movable jaws

- 1
- 2
- 3
- 4
- 5
- 6

EXAMPLE OF USING MODULE VISE

