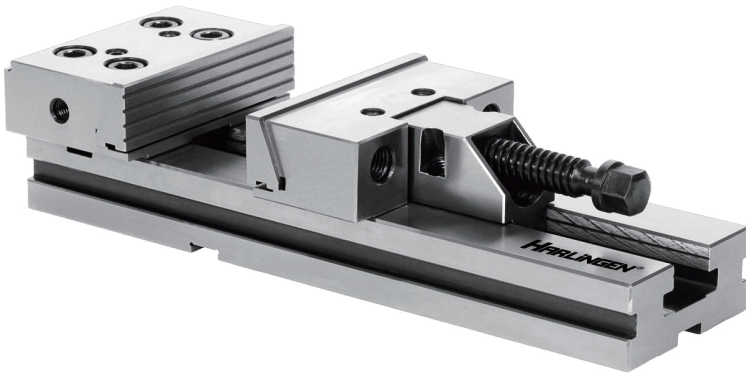


# HARLINGEN®

## MODULAR VICE



Please read this instruction carefully before using. You should be in accordance with the located safety rules besides the above instructions.

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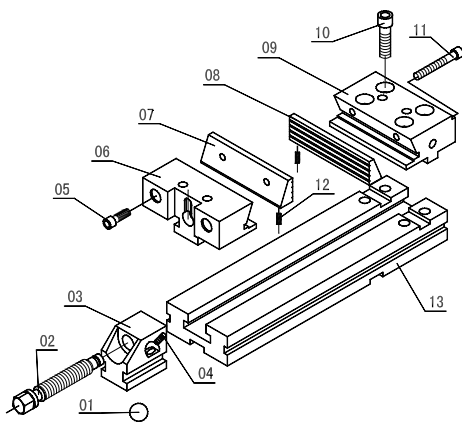
## ● Summary

**HARLINGEN® MODULAR VICE** is made from best quality alloy steel. Work surface is hardened with fine roughness. With changeable base, fixed jaw, Live jaw, it facilitates the operation of clamping, and is widely used in CNC and precise machines for clamping work in ray.

## ● Model Instruction

ORDER NO.	JAW WIDTH	JAW DEPTH	JAW OPENING	OVERALL LENGTH
41-089-001	100	30	100	270
41-089-002	125	40	150	345
41-089-003	150	50	200	420
41-089-004	150	50	300	520
41-089-005	175	60	200	455
41-089-006	175	60	300	555
41-089-007	175	60	400	655
41-089-008	200	65	200	495
41-089-009	200	65	300	595
41-089-010	200	65	400	695

## ● Part No. & Exploded View



- 01. steel ball      02.lead screw
- 03. rack
- 04. hex head socket set screw
- 05. round head hex socket screw
- 06. live jaw      07.live jaw plate
- 08. fixed jaw plate
- 09. fixed jaw
- 10. round head hex socket screw
- 11. round head hex socket screw
- 12. spring      13.body

## ● Operation

Fix the vise on the worktable, put the workpiece between fixed jaw and the live jaw, push the sliding part forward. Insert the pin into a hole in the body to fix the rack roughly.

After fixing the rack(13), rotate lead screw(14) to make live jaw(09) to go further, and so you can clamp the workpiece tightly.

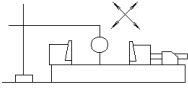
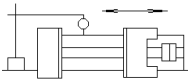
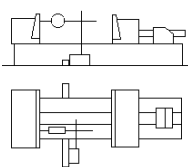
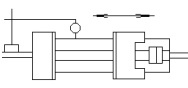
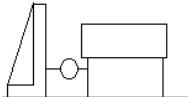
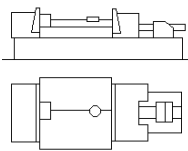
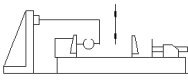
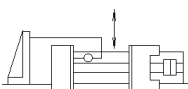
## ● Note

1. This is a precision vise. Worktable accuracy should be within 0.005mm
2. It is suggested that the vise is fixed to work table by clamping inserts.
3. When fixing the vise to work table through the hole on the base with bolts and nuts, it is warn that excessive torque might tort the body of the vise ,which will result in difficulty in moving the live jaw. In this case, the torque on the bolts should be less than the listed.

## ● Maintenance

Rotary parts and sliding parts should be often lubricated. For long time storing, they should be cleaned, coated with oil and packed in plastic bags.

# INSPECTION LIST

No	Description	Item	Tolerance	Mea.
1		Parallelism of upper body upper body surface to base surface	0.005/100	
2		Parallelism of two sides in spread direction	0.005/100	
3		Parallelism of fixed jaw plate to transverse slot of bottom	0.01/100	
4		parallelism of length wise slot' s center surface to sides	0.01/100	
5		Squareness of two sides to base surface	0.008	
6		Parallelism error of jaw plates	0.005/100	
7		Squareness of two jaw plates to base surface	0.02	
8		squareness of fixed jaw plate to sides	0.02	

Order No.: \_\_\_\_\_ Inspector: \_\_\_\_\_ Date: \_\_\_\_\_

## ● Packing List

1. Type GT vise	1
2. Box Wrench	1
3. T-wrench	1
4. Vise holding clamps	4
5. Work stop with main bolt	1
6. Positioning key-nuts	2
7. Technical documents	
Operation instruction	1
Certificate of Quality	1
Packing List	1



