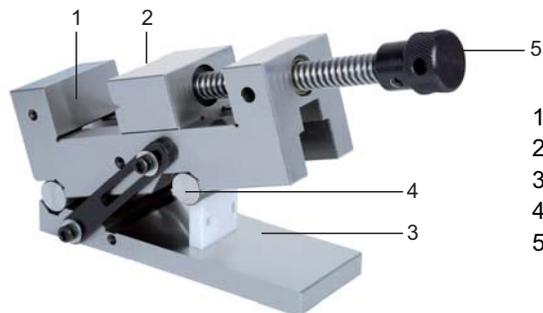
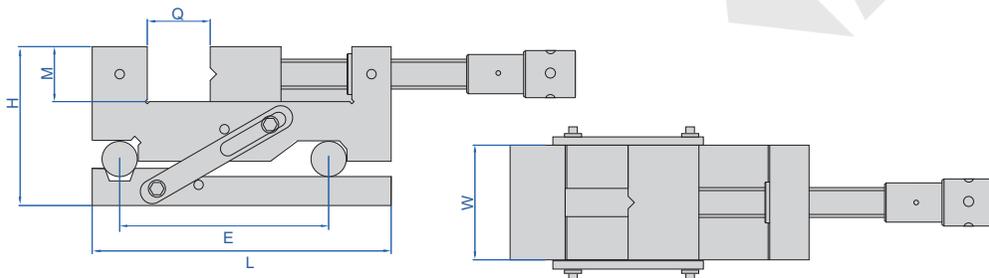


Parallelism: 5µm/100mm  
 Squareness: 5µm/100mm  
 Adjustable angle: 0-55°  
 Accuracy of angle: ±20 seconds



- 1-Regular jaw
- 2-Movable jaws (with V-groove)
- 3-Base plate
- 4-Column
- 5-Jaw adjustment handle

Code	Jaw opening (Q)	Jaw width (W)	Roller distance(E)	L	H	M
6513-65	0-65	50	100	150	85	25
6513-85	0-85	63	100	185	91.5	32
6513-100	0-100	73	150	205	105	35
6513-1001	0-100	80	150	215	108	40
6513-125	0-125	88	150	245	108	40
6513-1251	0-125	100	200	255	116	45
6513-160	0-160	125	200	295	125	50
6513-175	0-175	150	200	315	125	50



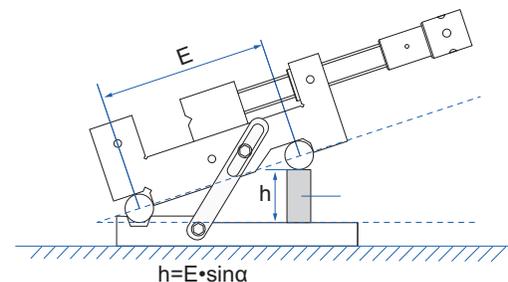
1. Suitable for milling machine, drilling machine, grinding machine, etc. to clamp the workpiece and adjust to a certain angle for cutting processing.

### 2. Use:

- (1). To use, wipe the bottom surface of the vise, the base plate, the cylindrical and work surfaces, and the work surface of the machine tool before reattaching the vise to the magnetic table of the machine tool.
- (2). Counterclockwise rotate the handle of the vise to adjust movable jaw, so that the jaw open, put the clean workpiece, clockwise rotate the handle to clamp the workpiece.
- (3). When machining angles, the following conversion formula must be used to select the gauge block and adjust the angle with the gauge block.
- (4). Place the gauge block between cylinder and the base plate, press the block firmly, and tighten the screws (2 on each side).
- (5). After use, in order to ensure the normal work and angle accuracy of the vise, please clean up the dirt, and then oil maintenance, so as not to rust, do not hit and damage during operation.

To set the sine angle, select the gauge block: first check the center distance E of the vise, then select the gauge block:  $h = E \cdot \sin \alpha$ .

If you are grinding a workpiece with a center distance of 30°20'. For example, if the center distance E = 100 mm, select the gauge block:  $h = 100 \times \sin(30^\circ 20') = 50.503$  mm.



### Cautions:

- Ensure that the machine tool magnet must be parallel and the bottom of the vise is even.
- The burrs of the workpiece must be treated before grinding, so as to ensure the angular accuracy of its grinding.
- The machined surface of the workpiece must be higher than the jaws. If this is not possible, it is recommended to raise the workpiece with parallel pads.
- To ensure firm clamping and prevent loosening of the clamp, try to clamp the workpiece on a flat surface.
- When clamping less rigid workpieces, the clamping area of the workpiece should be solidly padded and supported first to prevent deformation of the workpiece.