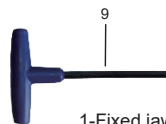
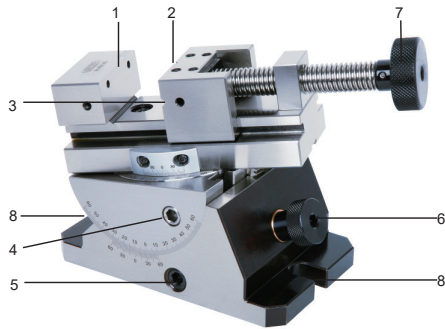
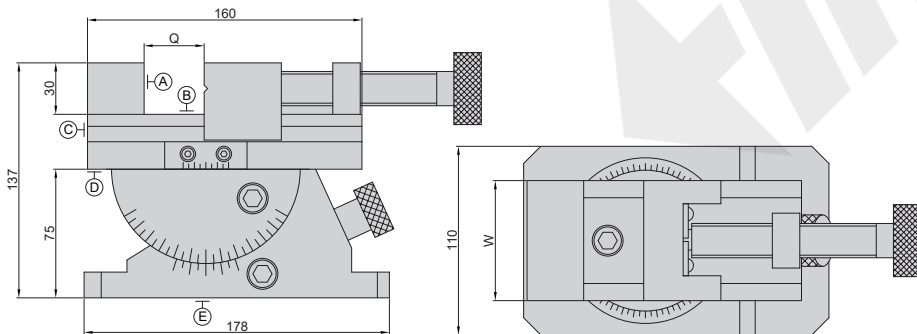


Code	Jaw opening (Q)	Jaw width (W)
6521-80	0-80mm	70mm

- Horizontal rotary: range 360°, graduation 0.05°
- Vertical incline: range 45°, graduation 0.05°
- With incline adjust knob
- Parallelism and squareness between A, B, C and D: 5μm/100mm, parallelism between D and E at 0°: 10μm/100mm
- Made of tool steel
- Hardness HRC56-58



- 1-Fixed jaws
- 2-Movable jaws
- 3-V-groove
- 4-Horizontal rotary locking screw
- 5-Vertical Tilt Lock Screw
- 6-Vertical tilt adjusting knob
- 7-Jaw adjusting handle
- 8-Base mounting slot
- 9-Hexagon wrench M8



1. Suitable for precision flat milling, milling machine, electrical discharge machining, etc., clamping workpiece for machining of flat or inclined surfaces and angular oblique holes.

2. Usage.

---Clean the bottom surface of the vise and the working surface of the machine tool, place the vise in the proper position on the machine tool workbench, and fix it with a pressure plate, bolts and nuts.

---Parallelism Adjustment

When the parallelism of the workpiece is not strictly required, simply loosen the locking screws on both sides of the base, turn the tilt adjustment knob, and adjust the scale to zero; When the parallelism of the workpiece is strictly required, the dial gauge can be used to measure the guide rail surface of the clamp body to obtain the parallelism that meets the specified requirements.

---Angle adjustment

- a. Horizontal plate angle adjustment: Loosen the horizontal rotary locking screw on the front side of the arc block, rotate the vise to the desired angle position, and then tighten the locking screw.
- b. Tilt Angle Adjustment: Loosen the tilt locking screws on both sides of the base and turn the tilt knob. Tighten the locking screws on both sides when the desired angle is reached.

----Workpiece clamping

Turn the jaw adjusting handle counterclockwise to move the movable jaws outward to the proper position, put in the cleaned workpiece, and turn the jaw adjusting handle clockwise to clamp the workpiece.

Note: V-groove is suitable for clamping cylindrical workpieces.

3. Note:

- The machined surface of the workpiece must be higher than the jaws, if not, it is recommended to raise the workpiece with parallel pads.
- To ensure firm clamping and prevent loosening of the clamp, try to clamp the flat side of the workpiece as much as possible.
- When clamping less rigid workpiece, the clamping area of the workpiece should be solidly padded and supported first to prevent deformation of the workpiece.