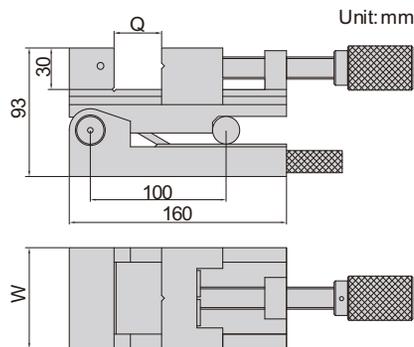
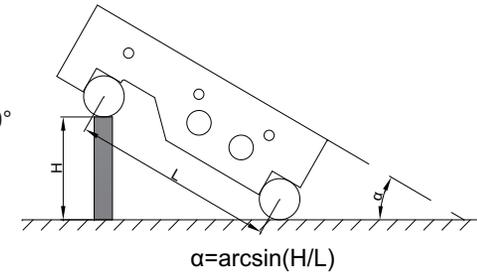


Code	Jaw Opening	Jaw width	Adjustable angle	Parallelism	Squareness	Accuracy of angle
6522-80	0-80mm	73mm	0-46°	3μm/100mm	5μm/100mm	±15"

1. --- Vise is used to hold workpieces. Jaw opening is 0-80mm. Jaw width is 73mm.
- Sine device work with different gage blocks to build desired angles, according to sine principle. Adjustable angle is 0-46°.
- Axis center distance of sine device is 100mm.
- Sine adjustment screw is used to lift sine device up and down.



2. Sine principle, as right figure:  
 $\alpha = \arcsin(H/L)$   
 For example:  
 center distance (L) is 100mm,  
 height of gage block (H) is 50mm,  
 $\alpha = \arcsin(H/L) = \arcsin(50/100) = \arcsin 0.5 = 30^\circ$



3. 1mm step:  
 step size  $1 \pm 0.002\text{mm}$ , benefit for using when small size gage blocks are not available.  
 If small gage blocks (smaller than 0.5mm) are needed (for example, 0.25mm), a gage block 1.25mm can be used on the step (fig. 1, 2) in order to make 0.25mm ( $1.25 - 1 = 0.25\text{mm}$ ) (fig. 3)



fig.1



fig.2

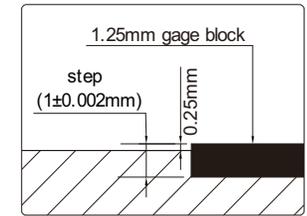


fig.3

4. Notice:
  - 1) Protect each measuring surfaces. Be careful to take and put down vise slightly, avoid bumps or damage.
  - 2) Oil it after use, avoid rusting.