QM16

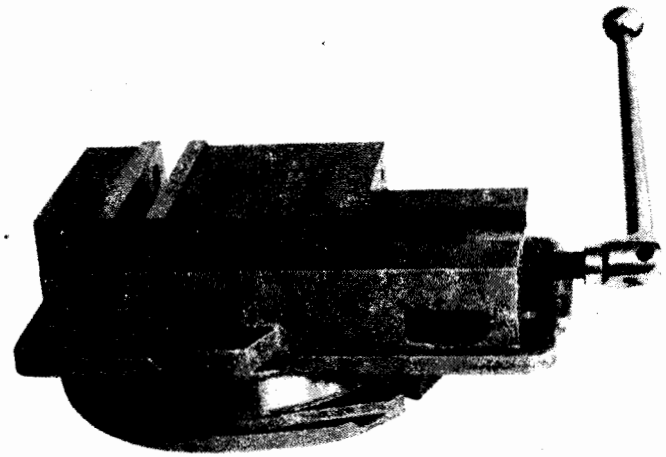
ACCU－LOCK PRECISION MACHINE VISE

TECHNICAL DOCUMENT

OPERATION MANUAL

TEST CERTIFICATE

PACKING LIST



OPERATION MANUAL

Ⅰ. MAIN USES AND FEATURES

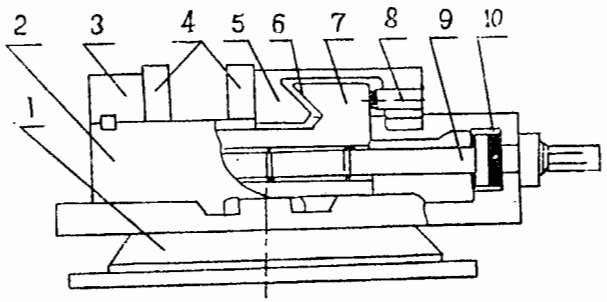
1. This product is main attchments to precision millings grinders Nc machines, it is particulary suitable for the finishing of precision parts.
2. The spherical segment in the movable jaw forces the vertical pressure downward when the horzontal pressure works, so that this jaw does not lift the workpiece.
3. Four positions allow extra capacity to change opening of jaw.
4. As the thrust component of the screw is equipped with thrust needle bearing it can be easily operated.

Ⅱ. OPERATION AND MAINTENANCE

1. Be sure to adjust the set screw at the middle of the movable jaw black so as to eliminate the clearance between the nut and the body and bring them in prt oper contact. If the contact is too tight, difficult – moment of the movable jaw block will take place, too loose, the screw will not be coaxial with the nut hole and this will result in crushed thread. Therefore don't force the screw.
2. Both in operation and transport, hommering or impacting are absolutely impermissible so that the accuracy so required is mainlained.
3. In order to ensure operation smart all movable parts should be often lubricated.

Ⅲ. MAIN STRUCTURE AND SPECIFICATIONS

1. Main structure(see figure below)



1—Base　　2—Body

3.—Fixed jaw　　4—jaw

5—Movable jaw　　6— spherical segment

7— Nut　　8— Adjust screw

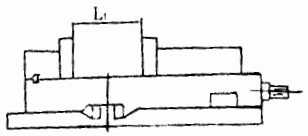
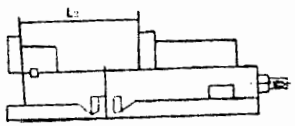
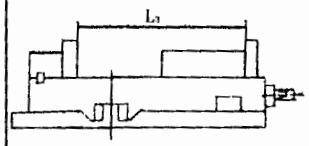
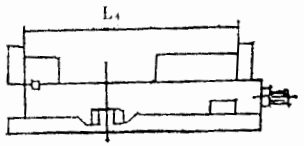
9— Screw　　10— Thrust needle bearing

Main specification

model / Denomination	80	100	125	160	200	250
jaw width	80	100	125	160	200	250
jaw height	25	32	40	45	55	75
stop－key width	12	14 (12)	14	18 (16)	18 (20)	22 (20)
Bolt diameter	M10	M12	M12	M16	M16	M20
overall diameter (L×W×H)	267× 186× 108	237× 228× 124	377× 248× 139	450× 298× 157	571× 410× 198	715× 514× 232
Weight	14	17	26	46	91	161

Opening of jaw

mm

model / Position	80	100	125	160	200	250
	75	100	110	140	190	245
	110	150	165	200	275	355
	170	215	245	305	385	500
	210	265	305	365	470	615

TEST CERTIFICATE

Model QM16 Serial No.

This product has been tested and found to be in conformity our technical standard and approved for delivery.

Inspector

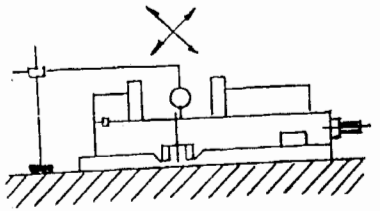
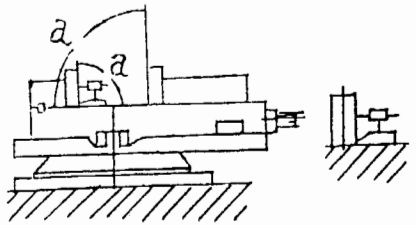
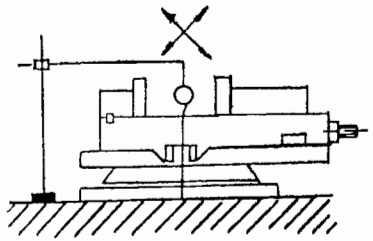
Chief – inspector

Director

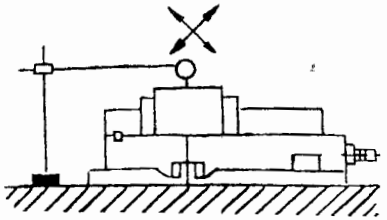
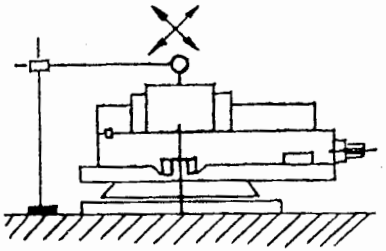
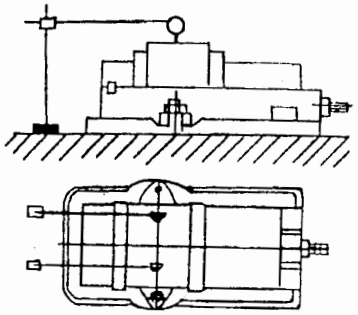
Date

Accuracy test

mm

Test item	Test iluslustration	Accuracy
parallelism of upper guide surface to support bottom of vise body		on a length of 100 0.015
perpendjcularity of two jaws clamping surface to upper guide surface		0.050/100(α ⩽90°)
parallelism of upper guide surface to support bottom of base		on a length of 100 0.020

mm

Test item	Test iluslustration	Accuracy
parallelism surface of clamping test block to support bottom of vise body		on a length of 100 0.030
parallelism surface of clamping test block to support bottom of base		on a length of 100 0.040
Tilt of clamping test block surface		0.040

PACKING LIST

NO.	Item	Quantity
1	Augle tight Precision machine vise	1 set
2	Handle	1 pce
3	Technical document	1 set

Packing inspector

Date