

**TYPE ZXQKG PRECISION SINE
TOOLING VISE**

OPERATION INSTRUCTION



I. Appliance and property

This type vise mainly applies to plane grinder, milling machine, EDM machine or wire cutting machine for setting angle surface, slot and slant hole, and also for measurement of workpiece. Simple structure, convenient operation, strong clamping force, high accuracy and wide range of adjustment make it a machinery accessory with high use value.

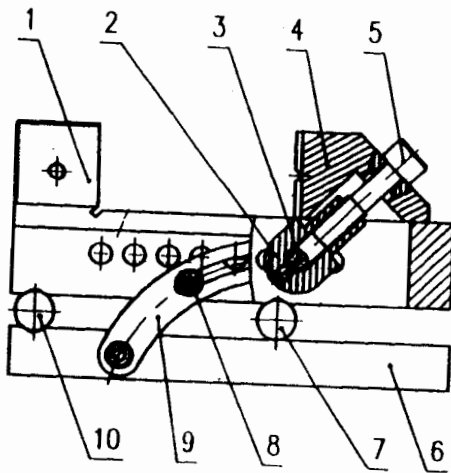
II. Main specification:

Code	Jaw Width	Jaw Depth	Opening Width	Total Length	Adjusting Angle
ZXQKG50	50	25	65	140	0-45°
ZXQKG63	63	32	85	175	
ZXQKG73	73	35	100	190	
ZXQKG80	80	40	100	200	
ZXQKG88	88	40	125	235	
ZXQKG100	100	45	125	245	
ZXQKG125	125	50	160	285	

III. Parts of name and quantity (with drawing)

No.	Name	quantity	No.	Name	quantity
1	vise body	1	2	pivot pin	1
3	pin	1	4	live jaw	1

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|--------------------------|---|--------------------------|---|
| 5. socket head cap screw | 1 | 6. base board | 1 |
| 7. shaft | 1 | 8. socket head cap screw | 1 |
| 9. support rack | 2 | 10. shaft | 1 |



IV. Method and step

First adjust the required angle and choose proper gauge block. Loosen screw (8), Lift vise body (1) and put the gauge block under shaft (7). Then tighten screw (8), to the size of workpiece clamp the workpiece by adjusting the position of pin (3) in the holes of vise body (1). To get minor travel clamping, We can adjust screw (5), and move the live jaw (4).

V. Maintenance

Rotary parts, sliding parts should be lubricated periodically. For long term store, please clean, rinse and lubricate the parts and pack them in plastic bags.