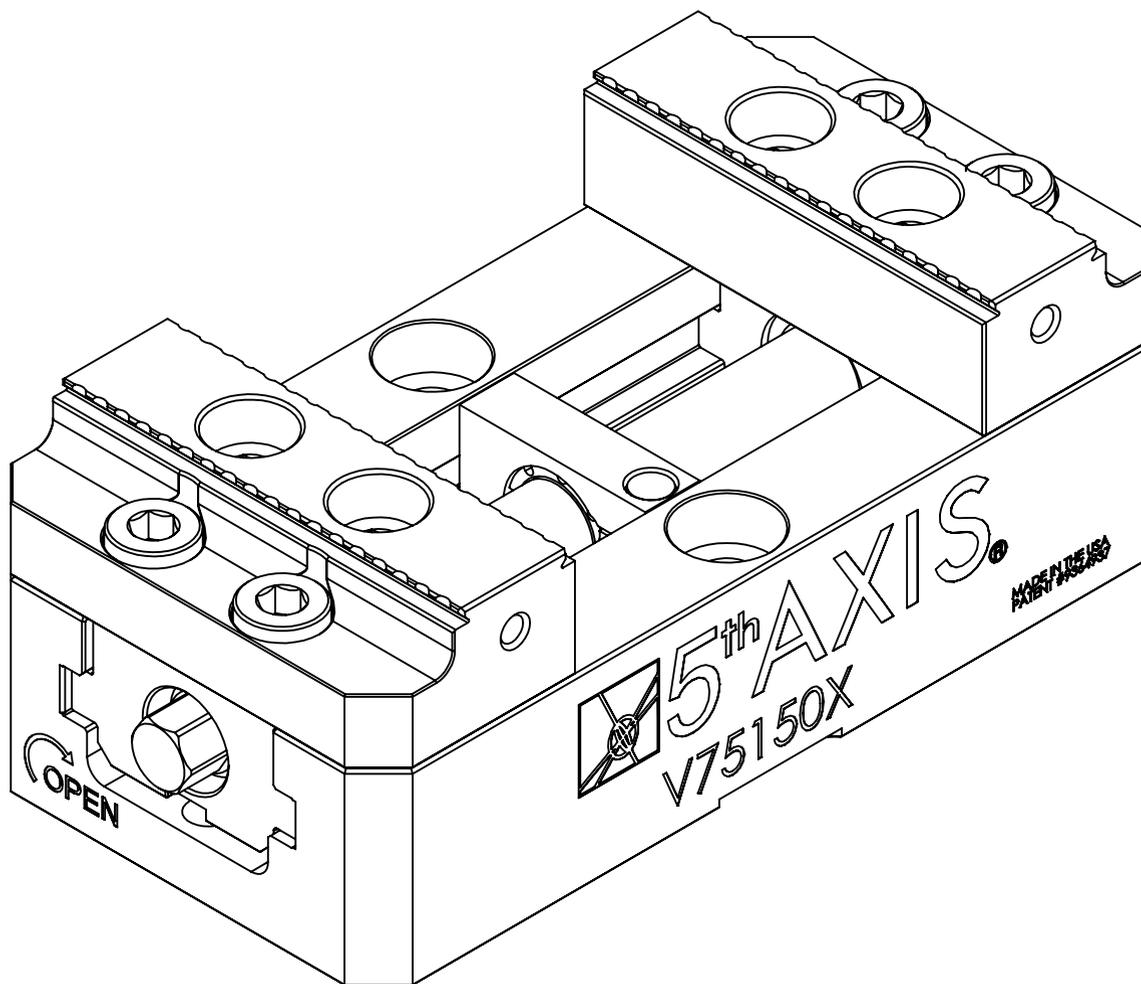
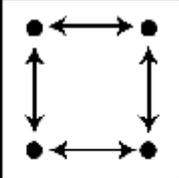


V75150X VISE OWNER'S MANUAL



			
0-90 MM [0"-3.5"]	40-127 MM [1.57"-5"]	52MM RockLock	Self-Centering

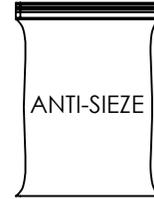
BILL OF MATERIAL

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	SB3V	SHOULDER BOLT	2
2	LP8	LOCATING PIN	2
3	M5X10.DP	DOWEL PIN 5x10MM	2
4	V75150X-4RK	LEADSCREW REPLACEMENT KIT	1
5	V75100X-2	TRUCK	2
6	V75150X-1	V75100X VISE BODY	1
7	V75100X-5	MASTER JAWS	2
8	76232	SHCS M8x16MM	8
9	TS10	THUMBSCREW	1
10	LB8008C5-A	ANTI-SIEZE PACKET	1
11	76252	BOLT M8x40MM	2

INCLUDED IN BOX

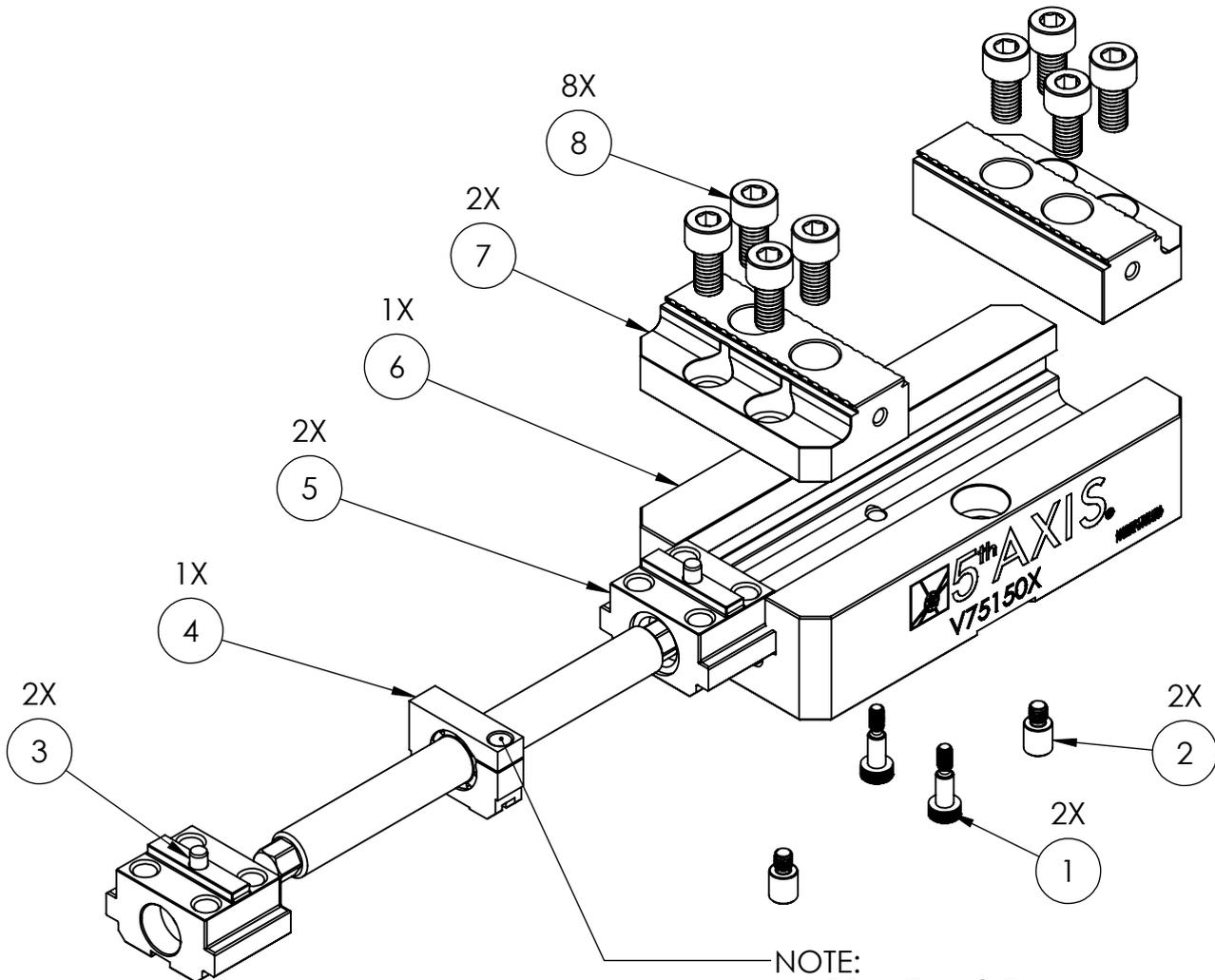


9: THUMBSCREW
P/N:TS10



10: ANTI SIEZE
PACKET
P/N: LB8008C5-A

11: MOUNTING BOLT X2
M8x40



NOTE:
WARRANTY VOID
IF REMOVED

Maintenance and Use

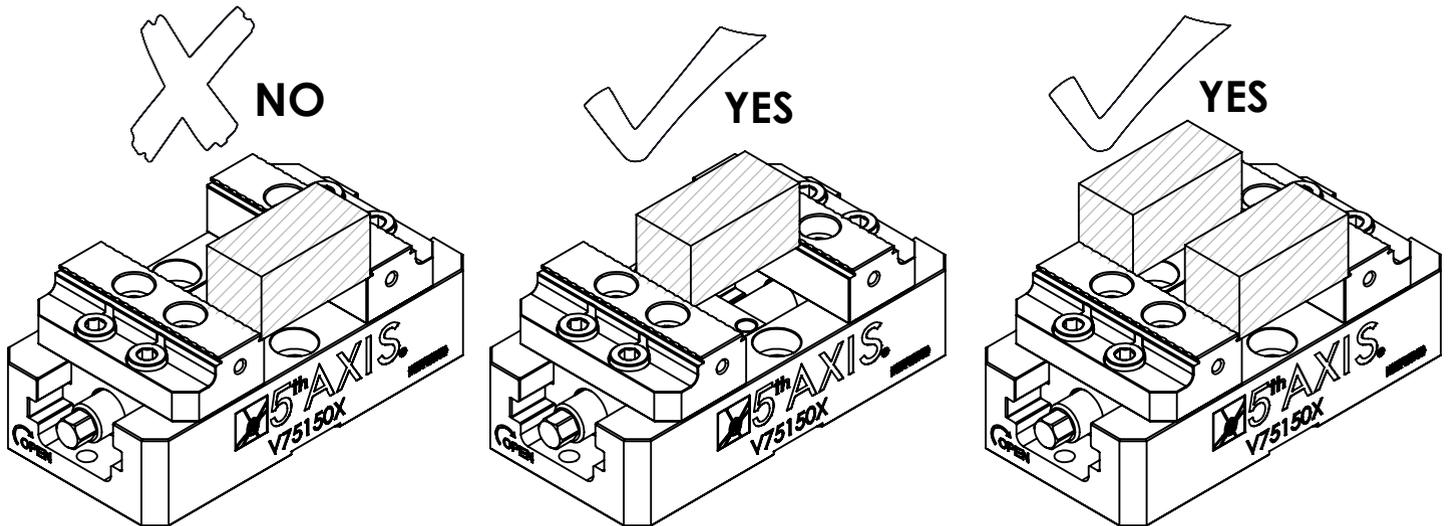
- Clean leadscrew with soft brush
- Use copper based anti-sieze on leadscrew (Loctite P/N: LB8008C5-A)
- Do not let chips build up during use
- Do not torque vise past 60 Nm [45 Ft LBS]
- Do not side load vise (see illustration below)
- Clamping Force at max torque with Master Jaws installed-22.2 kN [5000 lbf]
- Weight: 2.72 Kg [5.16 lbs]

Torque Values

- Jaw Bolts: 27 Nm [20 Ft LBS]-M8x16mm (P/N: 76232)
- Mounting Bolts: 34 Nm [25 Ft LBS]-M8x40mm (P/N: 76252)
- Lead Screw: 60 Nm [45 Ft LBS] Max

Special Notes

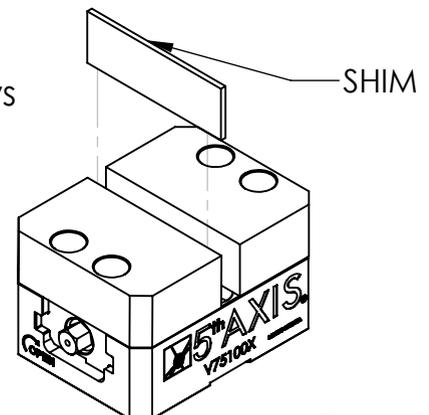
- Removing leadscrew assembly is not recommended and will void the warranty
- Failure to follow these instructions will cause self centering accuracy and/or repeatability to fail and may cause damage to the vise
- It is recommended to use only the two outside locating pin holes [LP8] labeled on page 4 as "A & B"



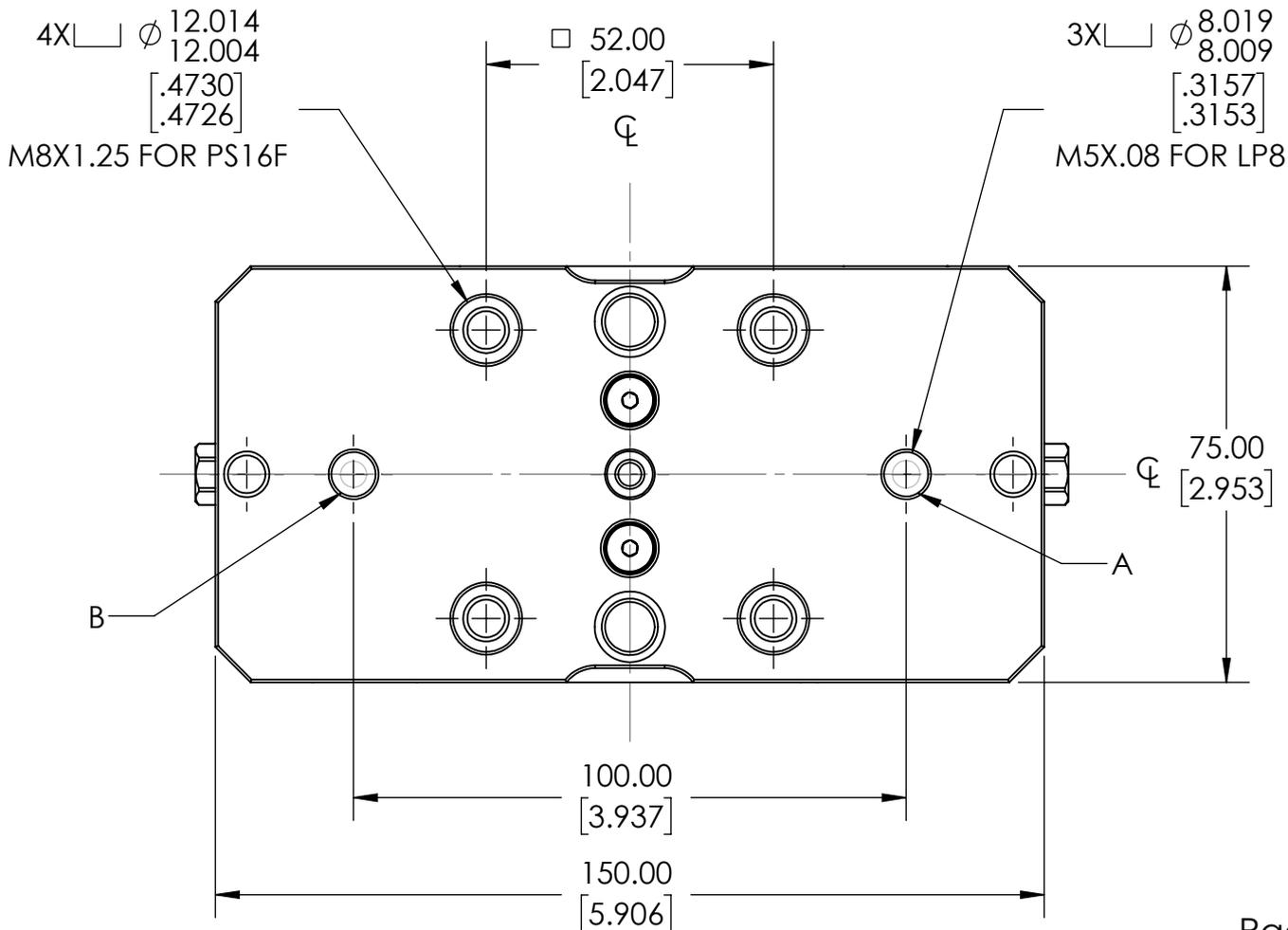
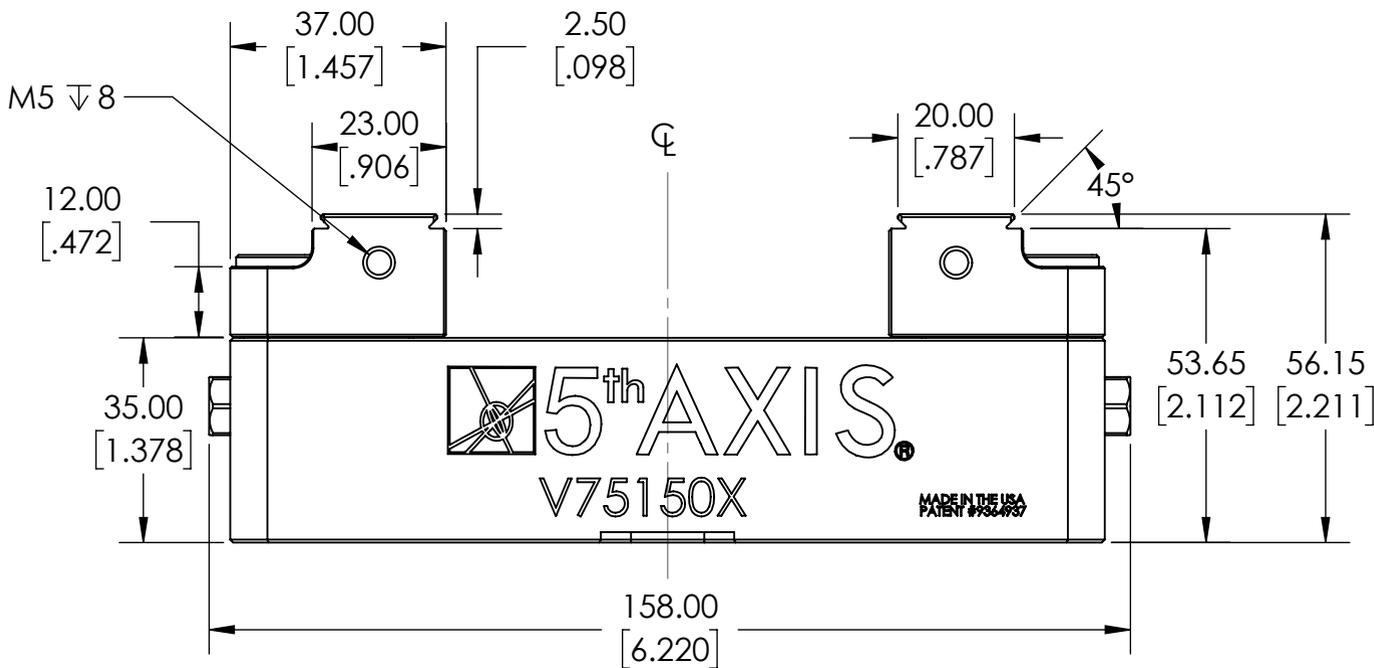
To Machine Profiles into Soft Jaws/Anti-Lift Soft Jaws:

- Insert an appropriately sized shim between the jaws
- Torque to operating torque value
- Machine profile of part
- Remove shim and place the part in vise
- Torque to same value as previous

Following these steps will ensure the highest accuracy and will compensate for any jaw deflection in the vise.



DIMENSIONS



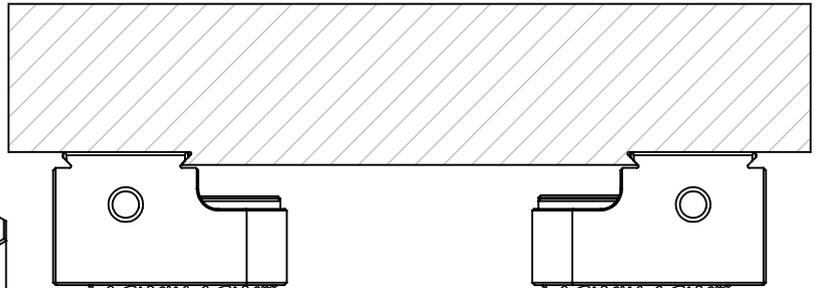
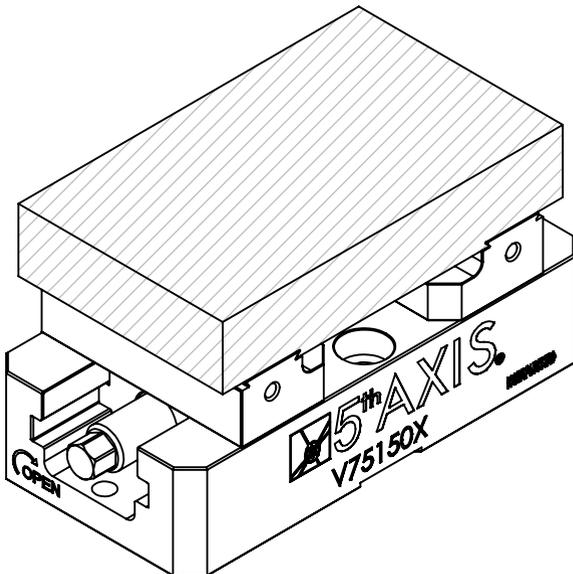
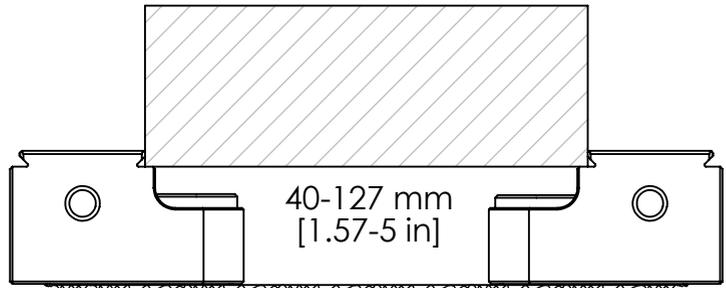
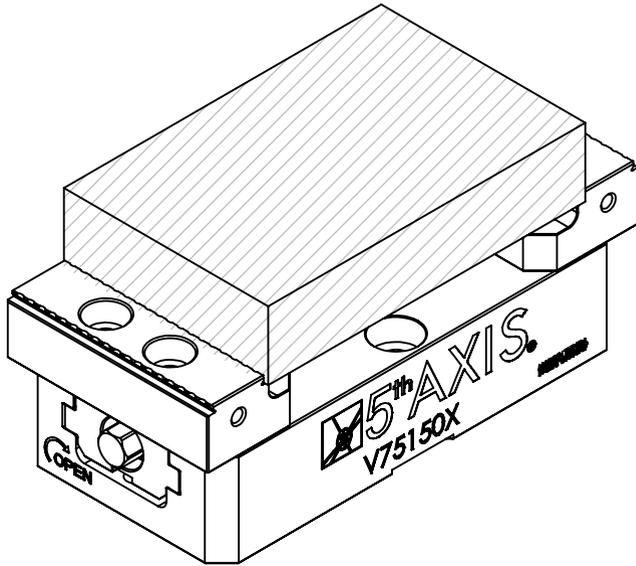
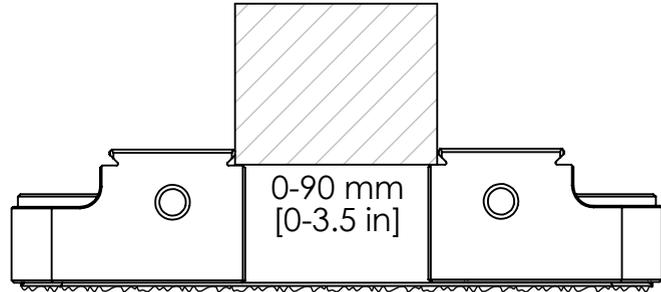
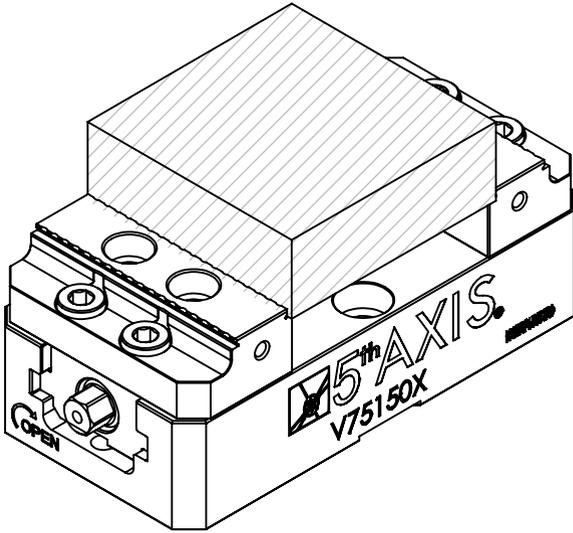
CONFIGURATIONS

Use Serrations For:

- Softer Materials (Aluminum and soft steels)
- Less Aggressive Machining

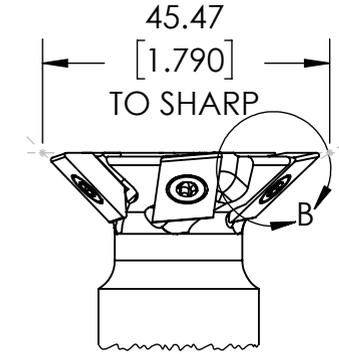
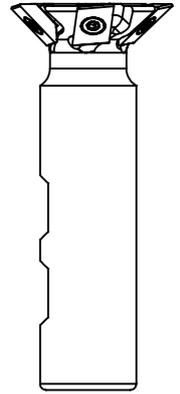
Use Dovetail for:

- Harder Materials
- Heavier Machining
- Parts Larger than the Vise

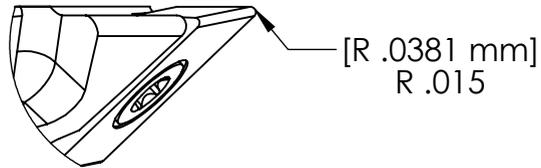


(See next page for dovetail stock prep)

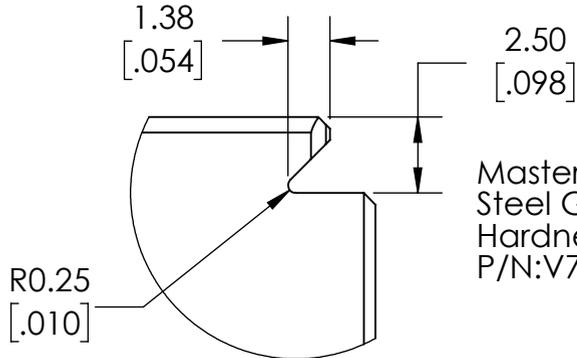
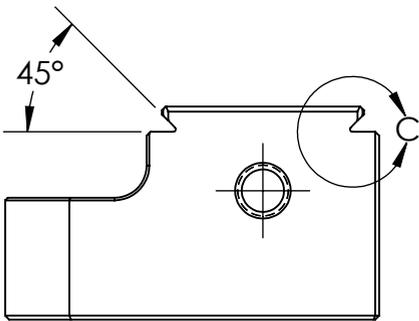
Dovetail Stock Prep



Dovetail Cutter

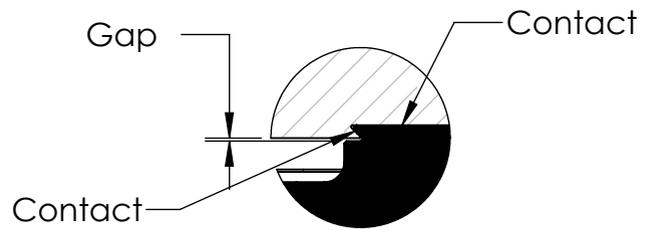
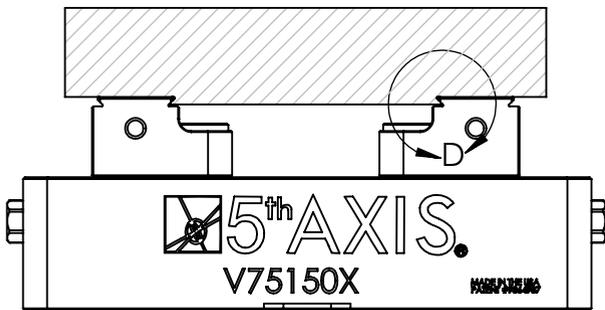


DETAIL B
SCALE 2 : 1

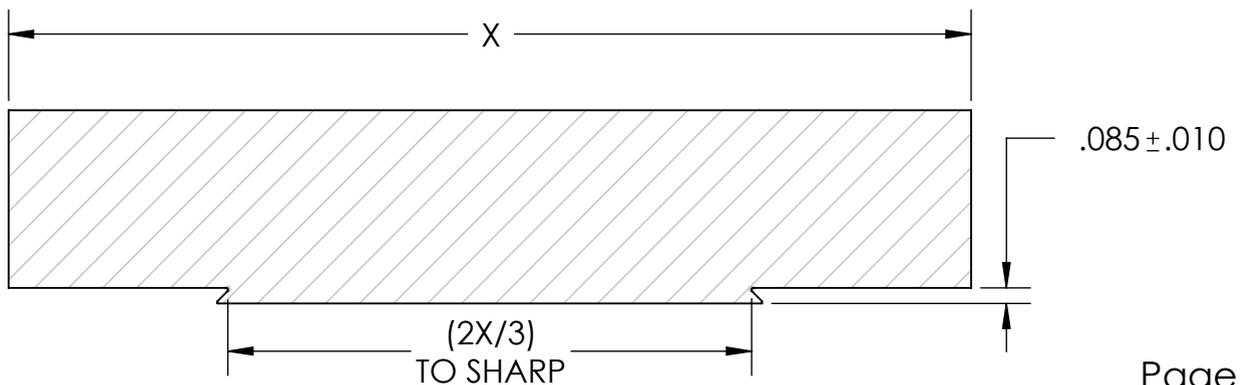


DETAIL C
SCALE 4 : 1

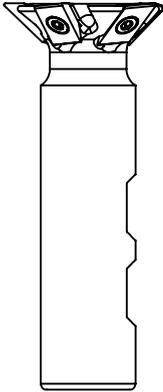
Master Jaws
Steel Grade: 4140 Steel
Hardness: HRC 53-57
P/N:V75100X-5



DETAIL D
SCALE 1 : 1.2



ACCESSORIES



Cutter Details

- Shank Diameter (in) 1" (P/N: DC1750-45)
- Shank Diameter (mm) 25mm (P/N: DC1750-M)
- Insert Part Number: DC1750-B
- 45 Degrees
- Material H13 Tool Steel
- 5 Flute Cutter
- Cutting Diameter: 45.5mm [1.79in]



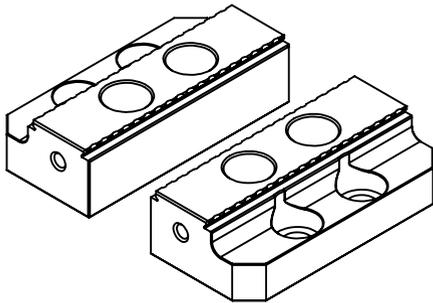
52mm Pull Studs

P/N: PS16-F

- For 52mm Rocklock
- Hardened S7 Tool Steel
- M8 Threads

Installing Pull Studs

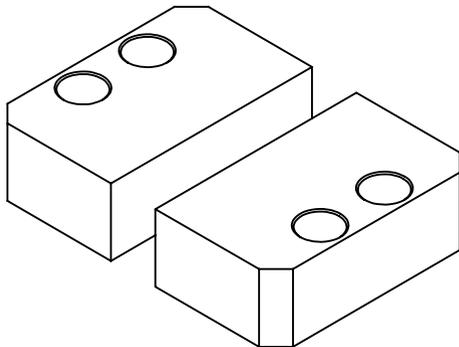
- Secure threaded stud finger tight only
- Grease precision surfaces
- Torque to 10 Ft-lbs via bottom hex head



Replacement Master Jaws

P/N: V75100X-5

- P/N: V75100X-5
- 75mm x 37mm x 21mm



Soft Jaws

VAJ75X- Aluminium

P/N: VAJ75X

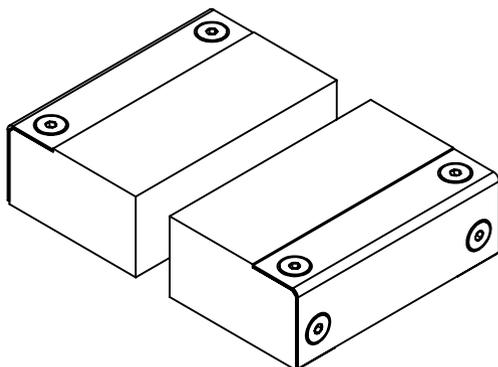
- 6061-T6
- Compatible with V75100 and V75100X
- 75mm x 45mm x 25mm

VSJ75X-Steel

P/N: VSJ75X

- 1018 Annealed
- Compatible with V75100 and V75100X
- 75mm x 45mm x 25mm

DOWNLOAD DRAWINGS AT: FIFTHAXIS.COM/DOWNLOADS



Anti-Lift Soft Jaws

P/N: AL75XA (ALUMINUM), AL75XS (STEEL)

REPLACEMENT JAW P/N: AL75-2A (ALUMINUM), AL75-2S (STEEL)

WHAT IS INCLUDED

- Anti-Lift Cleats
- AL75 Anti-Lift Soft Jaws
- Jaw Covers
- Jaw Cover Hardware

BENEFITS

- High Precision Op 2
- Reduced Jaw Lift <.025mm (<.001 in)
- Patent Pending
- Available in Aluminum and 1018 Steel

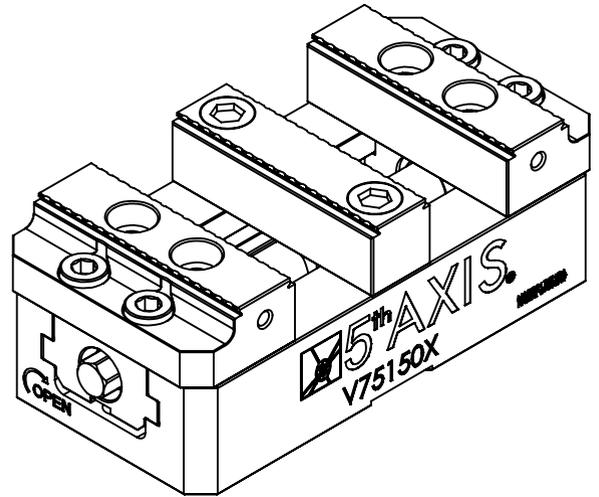


V75150X OWNER'S MANUAL

REV A
APPROVED 5/15/2019

Available for download
at: fifthaxis.com/downloads

CONVERT YOUR CENTERING VISE TO A DOUBLE STATION VISE

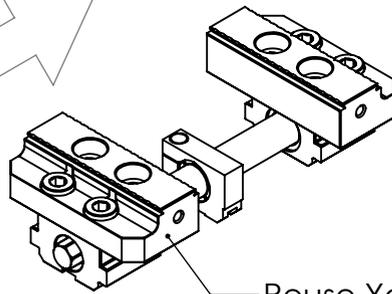


Ask your distributor about how to upgrade your system to a double station

PARTS SOLD SEPERATELY

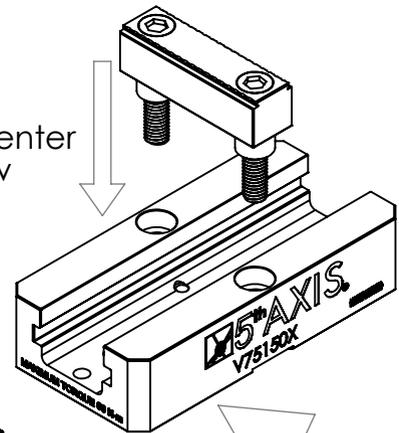
CONVERTING YOUR SELF CENTERING VISE

Remove Self-Centering Assembly

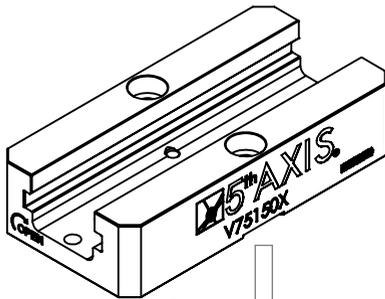


Reuse Your Jaw Set

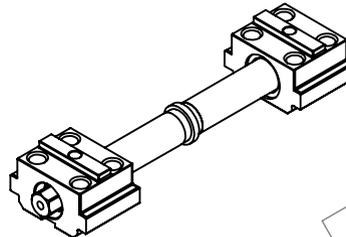
Install Center Jaw



Remove Shoulder Bolts



Install Double Station Assembly



Soft Jaw and Master Jaw Compatible
Ask your distributor about how to upgrade your system to a double station

PARTS SOLD SEPERATELY