



## Maskinskruvstycke Precision vice



**50 mm 20951-0403**

**63 mm 20951-0502**

**88 mm 20951-0601**

**Luna**



## Table of contents

Application and property .....	2
Main technical specification .....	2
Name of parts.....	2
Operation methods and steps.....	3
Maintenance.....	3
Inspection list.....	3
Certificate of quality.....	4
Packing List .....	4

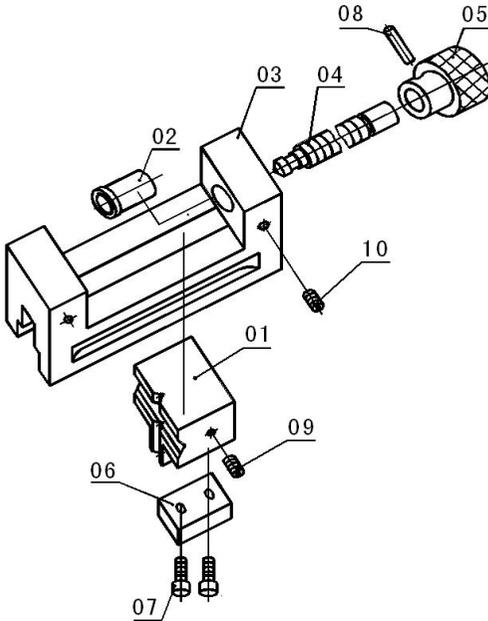
### 1. Application and property

It is an ideal and necessary tool for precision measurement and inspection, precision grinding and electricspark erosion, linear cutting machining etc. It's a kind of much actual valuable machinery accessory with simple structure, convenient operation, great clamping force, high accuracy, large adjustable scope.

### 2. Main technical specification

Type	Jaw Width (mm)	Jaw Depth (mm)	Jaw Open Length (mm)	Overall Length (mm)
20951-0403	50	25	65	155
20951-0502	63	32	85	190
20951-0601	88	40	125	250

### 3. Name of parts (with chart).



- |    |              |    |                       |
|----|--------------|----|-----------------------|
| 01 | Jaw          | 06 | Clamping board        |
| 02 | Brass-sleeve | 07 | Hex head socket screw |
| 03 | Body         | 08 | Cylindrical pin       |
| 04 | Lead screw   | 09 | Hex head socket screw |
| 05 | Handle       | 10 | Hex head socket screw |

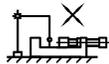
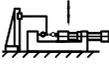
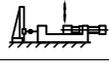
#### 4. Operation methods and steps

This unit can be easily operated with simple structure. Live jaw(01) are fixed on the body(03) by clamping board (06) and screw(07). Turn the handle (05), and the lead screw brings the live jaw(01) sliding on the body(03) for the purpose of clamping on diverse sizes workpiece. Additionally, this unit have different jaw open length, which is made to the user's option.

#### 5. Maintenance

Rotary parts and sliding parts should be often lubricated with oil. If long stored, they should be cleaned, coated with rust-proof oil, and packed in plastic bag.

#### INSPECTION LIST

No	Description	Item	Tolerance	Mea
1		Parallelism of upper surface of guide way to base surface	0.005/100	
2		Squareness of fixed jaw face and movable jaw face to base surface	0.005	
3		Parallelism of two jaw in width direction	0.005/100	
4		Squareness of end face of body to the base surface	0.008	
5		Squareness of two sides of the body to base surface	0.005	
6		Squareness of body end face to sides	0.008	
7		Parallelism of two sides of the body in length direction	0.005/100	

**TYPE 20951- PRECISION TOOL VISE**

**Certificate of Quality**

This unit has been tested and approved to be delivery.

**Packing List**

1. Vise	1
2. Technical documents	1
Operation instruction	1
Certificate of Quality	1
Packing List	1

Inspector:

Date:



