

Operating Manual

80900 - 5 AXIS 100mm Manual Fixed Jaw Vise



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OPERATING MANUAL

5-Axis 100mm Vise-80900



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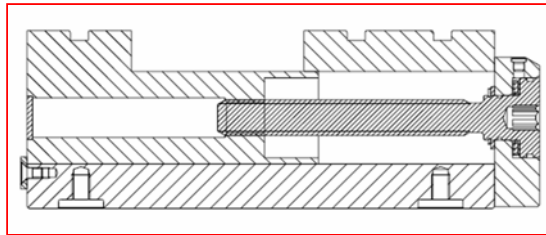
TABLE OF CONTENTS

			PAGE
1. General	1.1	Description	3
	1.2	Safety information	3
	1.3	Scope of supply	3
	1.4	Technical data	3
2. Operation	2.1	Fastening to the machine bed	4
	2.2	Adjusting the clamping range	4
	2.3	Clamping and unclamping	5
3. Appendix	3.1	Maintenance and care	6
	3.2	Service / Maintenance	6
	3.3	Spare parts	7

In order to ensure safe operation and appropriate operation, read this operating manual thoroughly prior to installation and commissioning !

5-Axis 100mm Vise-80900

1.1 Description



- Spindle drive
- Clamping force attained by using a torque wrench

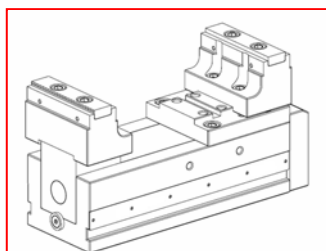
1.2 Safety information

- Before commissioning the system, take into account of the working area the machine to make sure that there is no possibility of collision.
- Fasten the machine vice firmly to the machine table using screws.
- The work piece clamping forces must be such as to ensure that there is no possibility of the work piece being moved by the machining forces.
- Use of a torque wrench for clamping manual vises is recommended. (for max. values, see 1.5).
- Regularly check the clamping force using a load cell.
- Remove the torque wrench after clamping.

1.3 Scope of supply

- Machine vice 80900 – 5 AXIS with jaws, grippers and handle. (torque wrench is not part of scope of supply)

1.4 Technical data



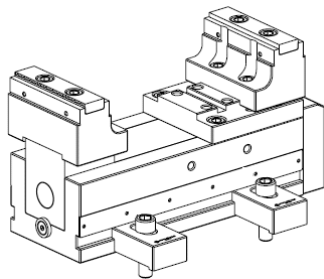
- Jaw width: 100 mm
- Max. clamping force: 25 kN
- Max. torque: 60 Nm

5-Axis 100mm Vise-80900

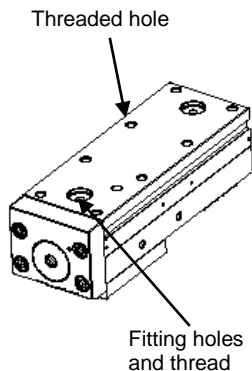
2.1 Fastening onto the machine bed

The machine vise must be fastened in such a way that it will not be moved by the machining forces.

- Before commissioning the system, take into account of the working area of the machine to make sure that there is no possibility of collision.
- Remove any unevenness and any debris which may be present between the locating surface and the base.



Fastening by means of clamping claws (available as accessories)

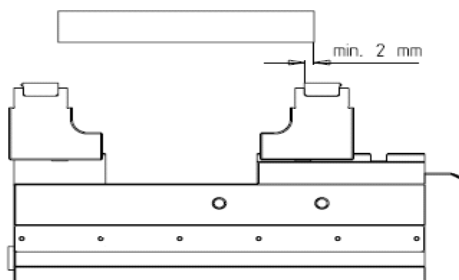


Fastening using threaded holes

Alignment using fitting holes in the base

Fastening and aligning by means of bolts (available as accessories)

2.2 Adjustment of the clamping range



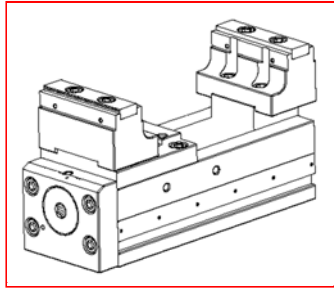
Adjust the insertion clearance for the work piece by turning the spindle.

Please note:
Check the clamping range overlap (min. 2 mm).

OPERATING MANUAL

5-Axis 100mm Vise-80900

2.3 Clamping and unclamping



- Clamping force achieved by turning the spindle in clockwise direction using a torque wrench until the set torque has been reached.
- Please observe the maximum values, see technical data.
- Release the clamping force by turning the spindle in counter-clockwise direction.

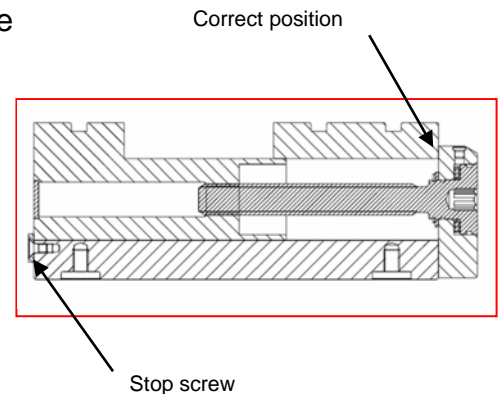
3.1 Maintenance and care

OPERATING MANUAL

5-Axis 100mm Vise-80900

Depending on the frequency of use, basic cleaning of the vise is required.

- Undo the stop screw
- Remove the slide by turning the spindle
- Remove the fixed jaw
- Clean the components
- Smooth the running surfaces, if necessary
- Oil the spindle and the running surfaces
- Ensure smooth running of the spindle and the slide
- When fastening the fixed jaw ensure the correct position



3.2 Service / Maintenance

SERVICE HOTLINE	877.426.2504
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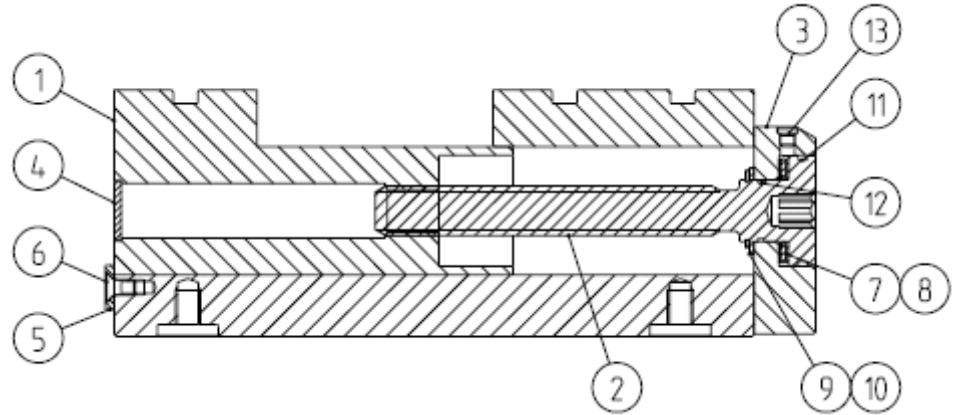
Customers abroad

- Please contact the JERGENS, INC. general importer or your local dealer

OPERATING MANUAL

5-Axis 100mm Vise-80900

3.3 Spare parts



Item	Designation	Qty.	Spare part no.
1	Slide	1	5.2040.0559
2	Spindle	1	5.2043.0259
3	Bearing cover	1	5.2041.0078
4	Covering cap	1	1.9606.0094
5	Disk	1	5.1022.0268
6	Countersunk screw	1	1.7991.0029
7	Axial disk	1	1.2065.0006
8	Axial needle cage	1	1.5405.0003
9	Circlip	1	1.0471.0025
10	Supporting ring	1	1.0988.0024
11	O ring	1	1.9500.0205
12	O ring	1	1.9505.0326
13	Lubricating nipple	1	1.3405.0006

Subject to modifications