Operating manual

Including installation and assembly instructions

81600  5-Axis 40mm Self Centering Vise

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

- Spindle drive with right-handed or left-handed thread
- Build-up of the clamping force using a torque wrench
- The clamping force is built up proportionally to the torque

1.2 Safety information

- Before commission the system, make sure that there is no possibility of collision taking account of the working area of the machine.
- Fasten the machine vice firmly to the machine bed using screws
- The workpiece clamping forces must be such as to ensure that there is no possibility of the workpiece being moved by machining forces.
- Mechanical versions are clamped using a torque wrench. (observe max. values, see 1.5)
- Check the Clamping force at regular intervals using a load cell.
- Remove the torque wrench after the clamping process is complete

1.3 Scope of supply

- Machine vice 81600 with an operating manual / spare parts list (clamping jaws and torque wrench are not part of the supply).

1.4 Technical Data

- Jaw width: 40 mm
- Max. clamping force: 7.5 kN with a torque of 20 Nm
- Max. torque: 23 Nm
- Clamping stroke: 20 mm
- Weight: 1.6 kg
2.1 Fastening to the machine bed

The machine vise must be fastened in such a way that the work pieces cannot be moved by the machining forces.

- Before commissioning the system, take into account the work 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.

- Fasten with threaded holes in the base
- Alignment with dowel holes in the base

2.2 Adjusting the clamping range

Turn hex spindle to adjust clamping range.

2.3 Clamping and unclamping

- By turning the spindle clockwise using a torque wrench, clamping force is applied based on selected torque.
- Observe maximum values, see technical data
- For unclamping, turn the spindle counter-clockwise.

3.1 Maintenance and care

Concentric clamps should not be disassembled. Maintenance and cleaning should be confined to surfaces and components accessible from the outside of the vise.
3.2 Service / Maintenance

| SERVICE – HOTLINE | 877-426-2504 |

**Note:**

Repair of the 5 – Axis Vise must be carried out by the manufacturer.