

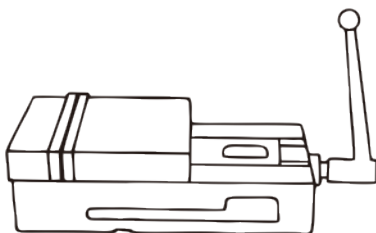
ACCU—LOCK PRECISION MACHINE VISE

TECHNOLOGY DOCUMENT

OPERATION INSTRUCTION

TEST CERTIFICATE

PACKING LIST



OPERATION INSTRUCTION

1. QM16N series of Precision machine vises with angle lock device are of high clamping rigidity and accuracy. Workpiece rising can be avoided during operation. Its hardened and fine ground guide surface have high accuracy and long service life. Thrust bearing assembly behind collar of screw shaft provides high clamping efficiency.

2. Changing jaw plate positions can enlarge clamping area. Both sides of the vise can be used as mounting base. Cross key slots, longitudinal key slots and standard clearance between fixed jaw clamping surface and cross key slots make it possible to set vises side by side on the machine table for machining a set of work pieces or gripping a large one. It can raise productivity and cut down machining cost.

3. The vise is not only ideal and necessary for N/C equipment but also useful for precision machine tools such as boring machine, milling machine and grinding machine etc.

4. During operation the vise is located by locating key and fixed with pressure bars on the machine table or directly on a magnetic chuck. Then has workpiece gripped firmly between the jaws.

5. During operation and transport, do not hit with a hammer so as to keep its original accuracy. Oil the vise through lubricating cup, Dismantle and clean the vise after a certain period of use so that the vise will keep its accuracy longer.

Main Specification

Model	QM16100N	QM16150U	QM16160N	QM16200N
Jaw width B	100	152	160	200
Jaw height H	32	45	45	56
Jaw opening L1 max	100	150	160	190
Jaw opening L2 max	150	210	210	275
Jaw opening L3 max	215	285	305	385
Cross key wide A1	265	350	375	470
Longitudinal key width A2	14	18	18	18
Hexagonal head of screw shaft S	14	18	18	18
Over dimensions(L×W×H)	14	19	19	19
Weight kg	305×100×86	410×150×115	438×160×122	517×200×135

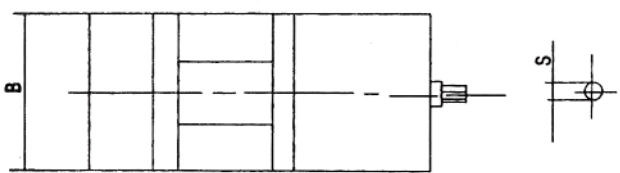
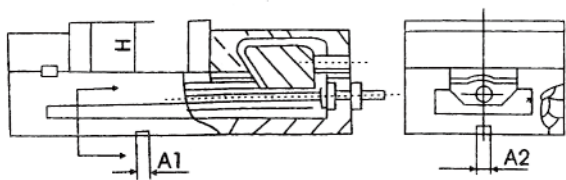


Fig.1

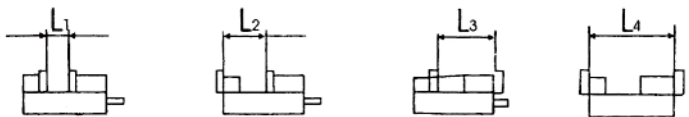


Fig.2

TEST CERTIFICATE

Model

Serial No.

This product has been tested and proved to be a qualified one. It is approved for **delivery**.

Director of works

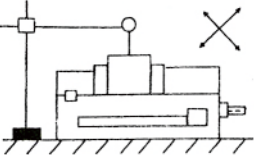
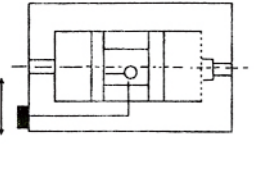
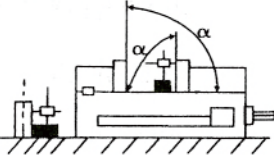
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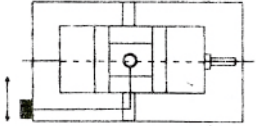
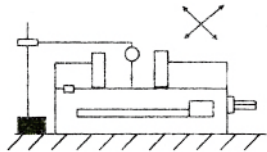
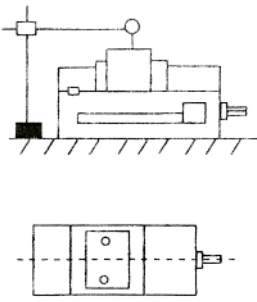
Inspector

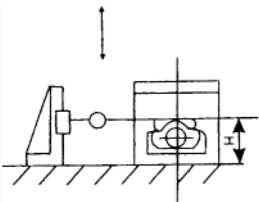
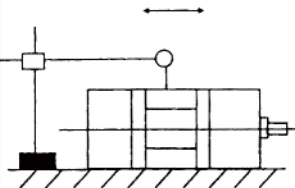
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Accuracy Test

As per to ZBJ52017--90

Item No.	Sketch	Inspection items	Accuracy	
			Permissible error	Actual
G1		parallelism of top guide surface to vise bottom	at a length of 100	
			0.010	
G2		perpendicularity of either fixed jaw or movable jaw to top guide surface	0.030/100 ($\alpha \leq 90^\circ$)	
G3		perpendicularity of fixed jaw to longitudinal key slot	0.015/100	

Item No.	Sketch	Inspection items	Accuracy	
			Permissible error	Actual
G4		Parallelism of fixal jaw to cross key slot of vise body	at a length of 100	
			0.015	
G5		parallelism of measuring block top surface to vise bottom	at a length of 100	
			0.020	
G6		Lifting of measuring block	0.015	

Item No.	Sketch	Inspection items	Accuracy	
			Permissible error	Actual
G7		perpendicularity of either side to vise bottom	at a length of 100	
			0.010	
G8		parallelism between two sides of the vise in longitudinal direction	at a length of 100	
			0.010	

PACKING LIST

Model	QM1680N	QM16100N	QM16125N	QM16150U	QM16160N	QM16200N		
QTY/Case	1/1	1/1	1/1	1/1	1/1	1/1	1/1	
Overall Dimensions (L×W×H)Cm								
Net weight kg								
Cross weight kg								
No	Name	Specification or Model						QTY
1	Angle lock precision vise	QM1680N	QM16100N	QM16125N	QM16150U	QM16160N	QM16200N	1
2	Hexa head dimension of handle	14	14	17	19	19	19	1
3	Locating keys	A12h8	A14h8	A14h8	A18h8	A18h8	A18h8	2
4	Cylindrical head screw	M5×12	M5×12	M5×12	M6×16	M6×16	M6×16	2
							GB65-85	
5	Technology document: Operation instruction. Test certificate. Packing list							

Inspector:

Date: