

10290

STANDARD MANUAL CLAMPING

Material

Steel, heat-treated and blackened.

Technical Notes

Supplied in pairs.

Tips

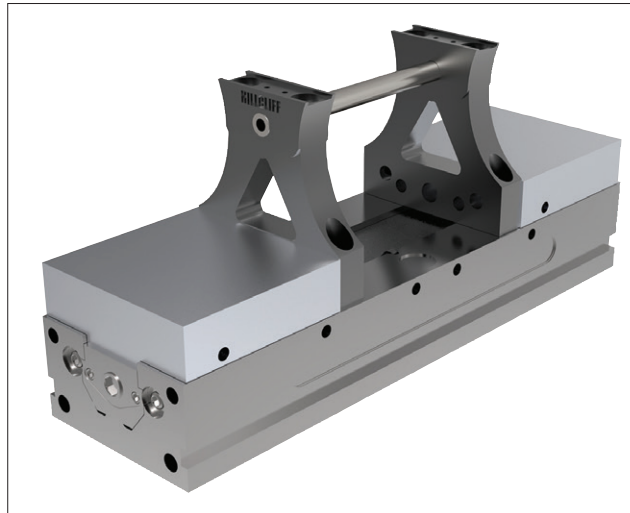
Used with:
21000 T-slot bolt, 21120 T-stud, 24400 collar nut, 25000 plain washer.

Order No.	For bolt	For vice jaw width	h_1	h_2	$h_3 \times l_2$	l_1	l_3	l_4	w_1	w_2	Weight g
10290.W0015	M12- M16	100	22.5	15	10x6,5	78	40	10.5	40	16.5	660
10290.W0020	M12- M16	125/160	27.5	20	10x6,5	78	40	10.5	40	16.5	705



Vice Application

- Mount jaws to either 4 or 6 inch vice with logo facing outwards, keeping the mounting bolts loose.
- Determine which grippers will be used, install and hand-tighten the grippers. If VersaGrips are being used to grip round stock, place in outboard bores. Do not tighten screws at this point. Tighten vice lightly onto workpiece allowing jaws to centre themselves, adjust VersaGrips, and tighten gripper screws and mounting bolts for both jaws.
- Loosen vice jaw for load/unload clearance of workpiece. Install support/pivot bolt.
- Setup is complete. Tighten support bolt allowing grippers to penetrate 0.25-1.52mm on material < 40 HRC.
- For additional holding force, loosen vice handle which will eliminate any jaw lift that may have occurred and depending on amount of torque can increase pressure to over 4000 kg.



T-slot and Grid Table Application

- Using vertical counterbores on outboard edges of jaws, install mounting bolts into t-nuts or grid plate and adjust accordingly. Do not tighten at this time.
- Select appropriate support bolts and install in upper horizontal counterbore and thread into opposite tower.
- Place workpiece between jaws and lightly tighten upper support bolt until all grippers contact workpiece. Tighten vertical mounting bolts.
- Loosen upper support bolt one full turn or until adequate workpiece clearance is obtained.
- Upper support bolt is now the “drive bolt” for securing and releasing workpiece.
- Any size T-nuts can be utilised. We provide 16mm T-nuts.