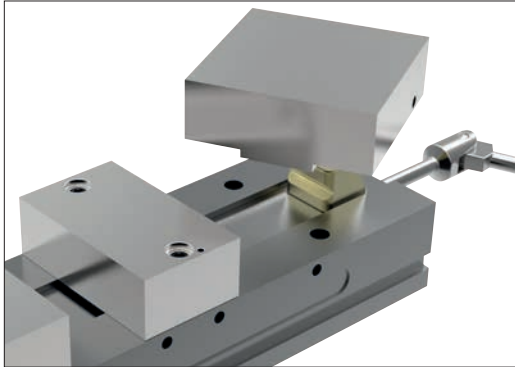


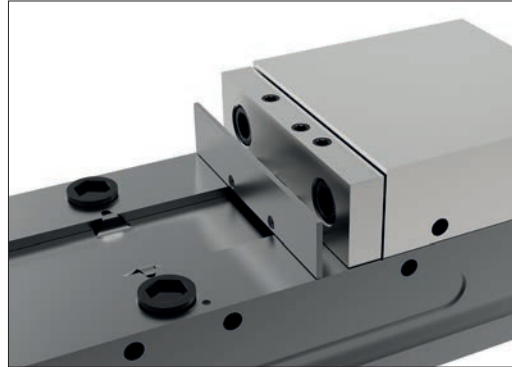


ReLock Accessories



SnapLock Machinable Fixture Jaws

Jaws can be attached, reversed, removed or indexed in a matter of seconds. The jaws are extremely versatile, allowing endless customising possibilities. Jaws are manufactured from steel and high quality aluminium.



SnapLock Carrier Jaws

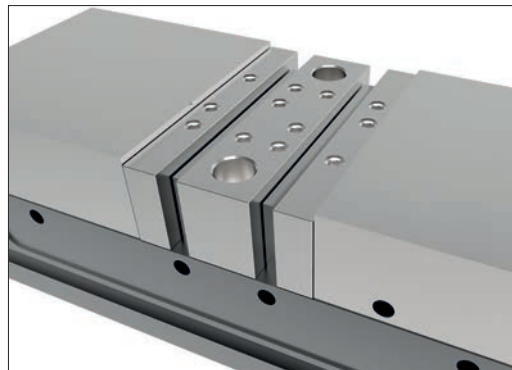
Carrier jaws allow mounting of AccuSnap and QuickChange master jaws or standard bolt-on jaws using an industry standard bolt pattern.

Both the AccuSnap and QuickChange vice jaw systems can be used in conjunction with most vice systems.



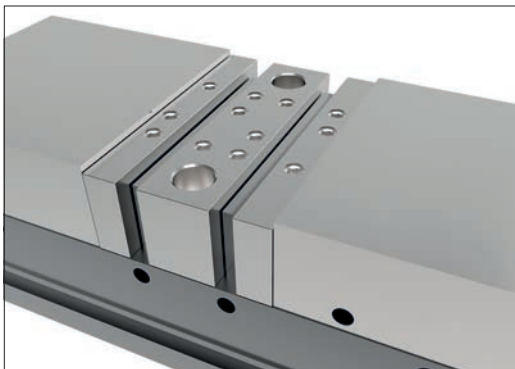
QuickChange Vice System

QuickChange jaws slide into position via a dovetail slot, as shown. The system includes master jaws, parallels, V-blocks, mill angles and machinable soft jaws. Adaptable to most vice systems.



AccuSnap Vice Jaw System

The AccuSnap vice jaw system (pictured), shows master jaws and parallels being used for workpiece set-up. The AccuSnap system allows setup change-over in seconds with extreme accuracy.



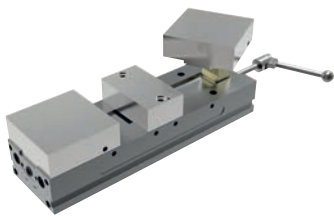
AccuSnap Machinable Fixture Jaws

Ideal for many workholding options of smaller workpieces. Jaws are offered in two thicknesses, from either aluminium or pre-hardened steel.



AccuSnap Workstops

Easily mount to AccuSnap parallels in a variety of configurations. Provides extreme workpiece location accuracy and repeatability. Can be used in conjunction with the AccuSnap presetting gauge to accurately reference your X, Y and Z machine datums.



The SnapLock system's allows simple, quick changeovers between machinable and carrier jaws.

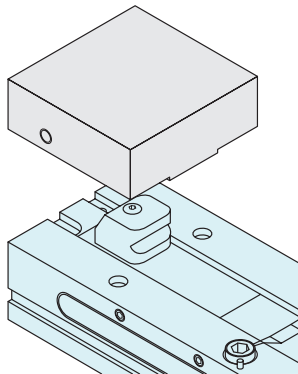
SnapLock Machinable Fixture Jaws

- Can be attached, reversed, removed or indexed in a matter of seconds.
- Extremely versatile, allowing endless customisation possibilities.
- Manufactured from high quality aluminium.

SnapLock Carrier Jaws

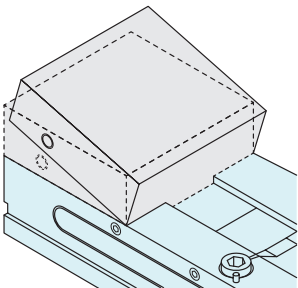
- Allows mounting of AccuSnap and QuickChange master jaws or standard bolt-on jaws using an industry standard bolt size and pattern.

Operation



Step 1

Align the SnapLock outer jaw over the appropriate ReLock vice knuckle

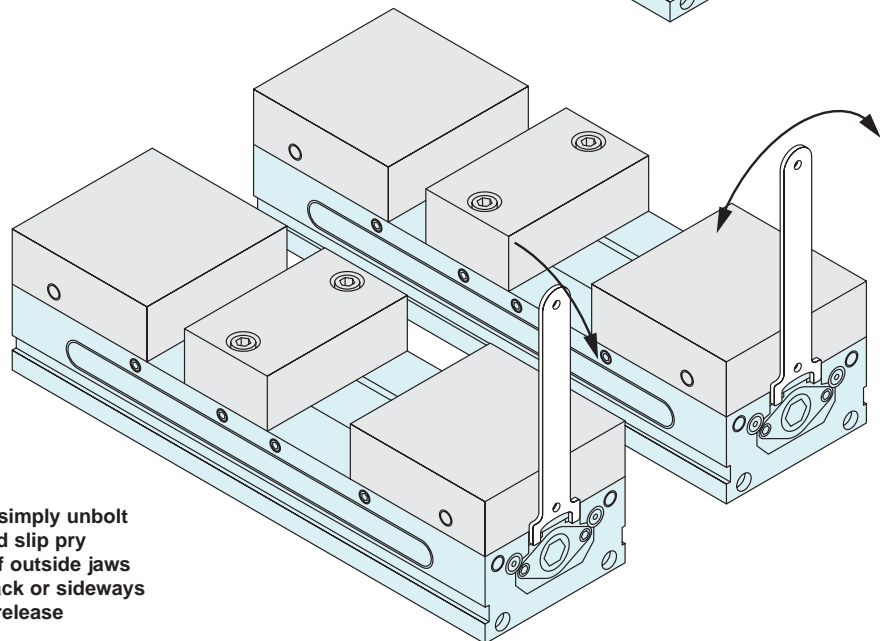
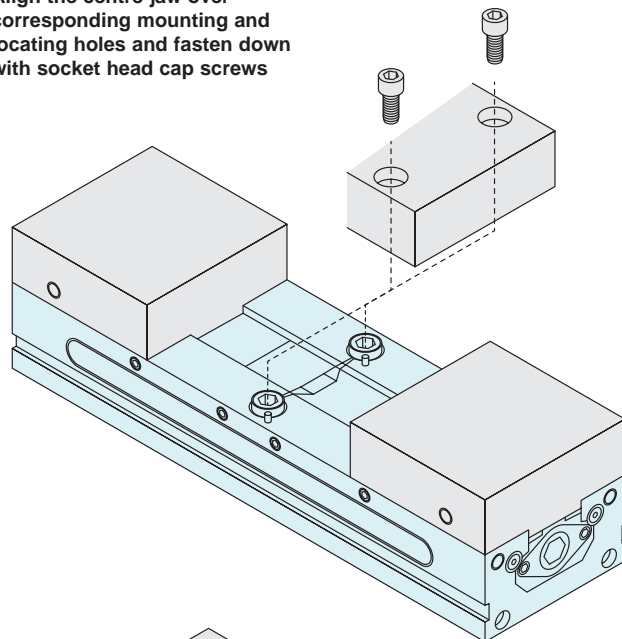


Step 2

Place the front edge of the jaw over the knuckle and press firmly down to "snap" into place

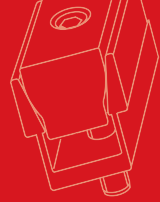
Step 3

Align the centre jaw over corresponding mounting and locating holes and fasten down with socket head cap screws



Step 4

For jaw removal, simply unbolt the centre jaw and slip pry wrench in slots of outside jaws as shown; pull back or sideways on the handle to release

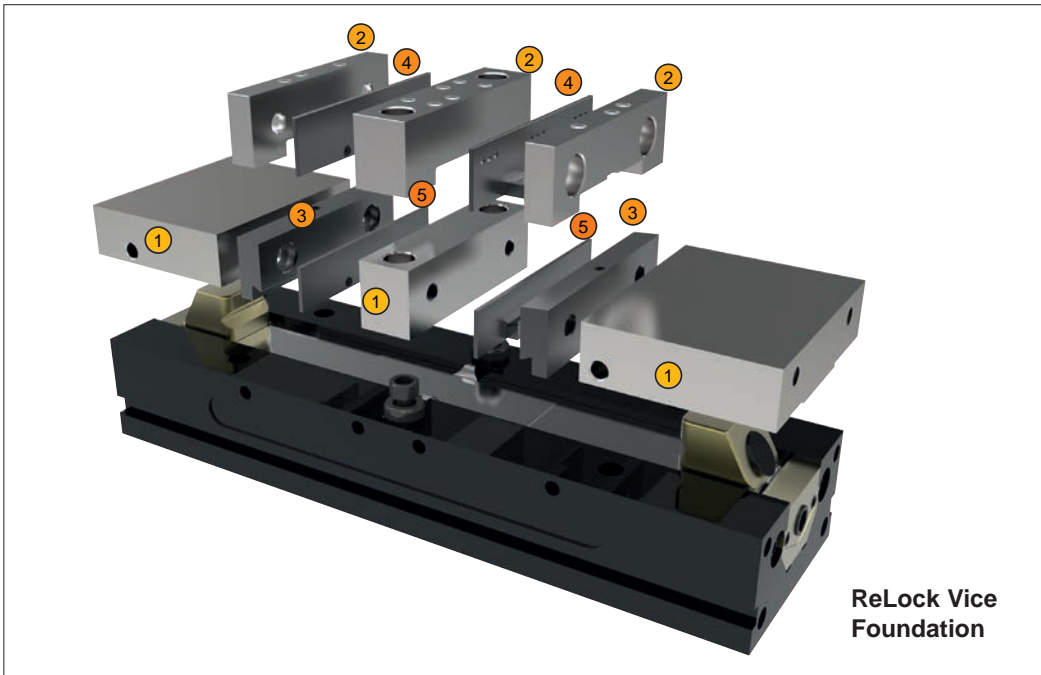


Foundation

The ReLock vice is the foundation for a fully flexible vice system, with a multitude of interchangeable jaws, parallels or mill angles to suit your application.

Base vice - ReLock 2 or ReLock 8.

- SnapLock® Carrier Jaws - accepts both AccuSnap® and QuickChange™ Jaw systems.
- AccuSnap or QuickChange Parallels and Mill Angles - select the approach best suited to your application.



Flexibility

1 SnapLock Carrier Jaws

SnapLock carrier jaws allow mounting of AccuSnap and QuickChange master jaws by using an industry standard bolt size and pattern. Carrier jaws snap on and off the SnapLock knuckles in seconds.

2 3 AccuSnap and QuickChange Master Jaws

AccuSnap QuickChange master jaws easily mount to the SnapLock carrier jaws by using an industry bolt size and pattern. AccuSnap master jaws patented locking receptacle accepts all AccuSnap accessories.

4 5 AccuSnap and QuickChange Parallels

AccuSnap and QuickChange parallels are designed for a range of set up variations when you need to position a workpiece between hardened jaws. AccuSnap parallels snap in and out of the AccuSnap master jaws in seconds. QuickChange parallels slide into position via a dovetail slot and gib.

Also available:

Machinable Fixture Jaws

AccuSnap and QuickChange machinable fixture jaws can be customised quickly to fixture a wide range of workpieces. The jaws snap or slide in and out of the master jaws in seconds. Available in either aluminium or hardened steel.

SnapLock Reversible Machinable Fixture Jaws

SnapLock reversible machinable fixture jaws are the most versatile method of fixturing on the ReLock System. Customising options are endless. Jaws can be machined on two faces for additional set up. Manufactured from high quality aluminium.

Fixture Plate

Ideal for a wide variety of fixturing applications, such as holding many small parts or parts with difficult clamping or locating requirements. Fixture plates can be attached or removed in seconds and are offered in two widths. Manufactured from high quality aluminium.

Modular Workstops

AccuSnap modular workstops quickly mount to parallels in many different positions. As many as three stops can be mounted to a single parallel to accommodate multi-piece set-ups.

Universal Workstop

The universal workstop easily mounts to the side of the ReLock in numerous positions. Optional extension is available for larger workpieces.

Workstop Presetting Gauge

The AccuSnap workstop presetting gauge, in combination with a standard micrometer, allows you to precisely preset your modular workstop positions in relation to the X, Y, and Z machine datums.

Single Station Conversion Plate

The single station conversion plate quickly converts the ReLock from double station to single station vice for larger workpieces.

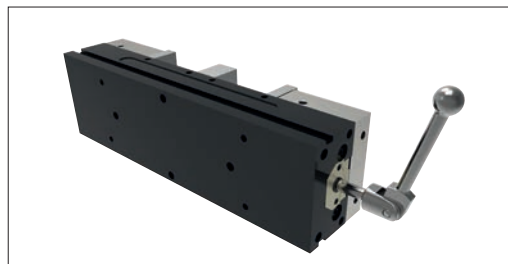


Features and Benefits



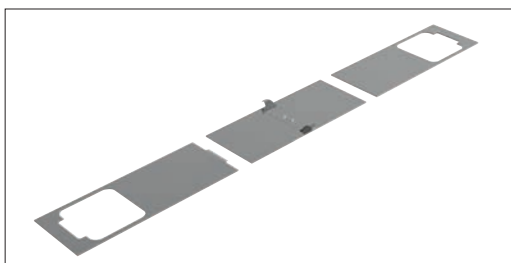
Optimised Table Space

Compact modular design allows a multitude of mounting configurations. Vices can be mounted close together without hindering the removal or attachment of jaws. The ReLock 8-station (shown) is ideal for horizontal machining centres, as well as for use with rotary indexers on vertical machining centres.



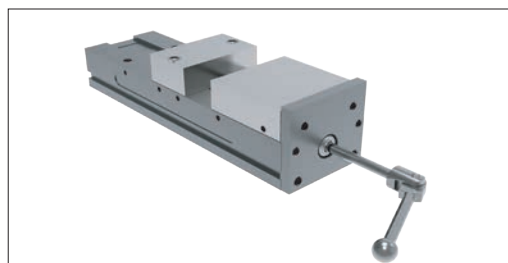
Locating and Mounting

Locating and mounting options are simple and accurate. The bottom surface of the system has four precision dowel pin holes for locating and four drilled and counterbored holes drilled through from the top surface for rugged mounting. Side clamp slots are also incorporated.



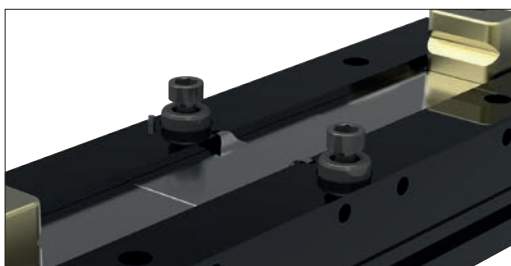
ReLock Chip Shields

ReLock's unique three piece telescopic chip shield wraps completely around the SnapLock knuckles, keeping swarf from getting into the vice's clamping mechanism. Shields can be quickly and easily removed for maintenance purposes.



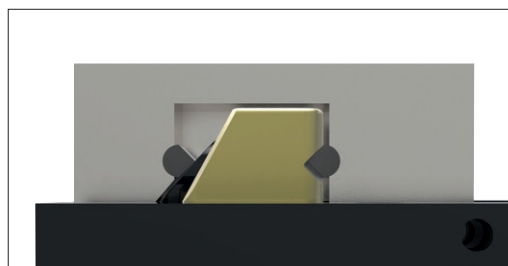
Single Station Conversion

Used in conjunction with SnapLock carrier jaws, the conversion plate allows the ReLock system to be converted from a double to a single station vice – ideal for larger workpieces.



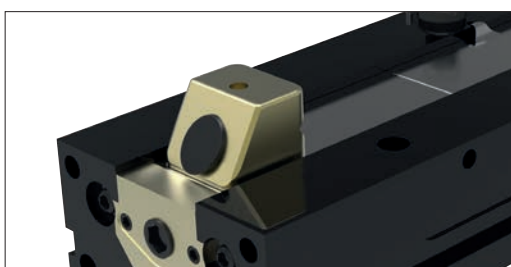
Centre Jaw Location

The ReLock's centre jaw locating studs allow quick jaw mounting and indexing to accuracies of $\pm 0.0005"$. Foolproof pin eliminates the possibility of the jaws being accidentally mounted in reverse.



SnapLock Knuckle

Exclusive SnapLock knuckle allows SnapLock soft jaws and SoftLock carrier to be attached and removed in seconds.



Auto Offset Mechanism

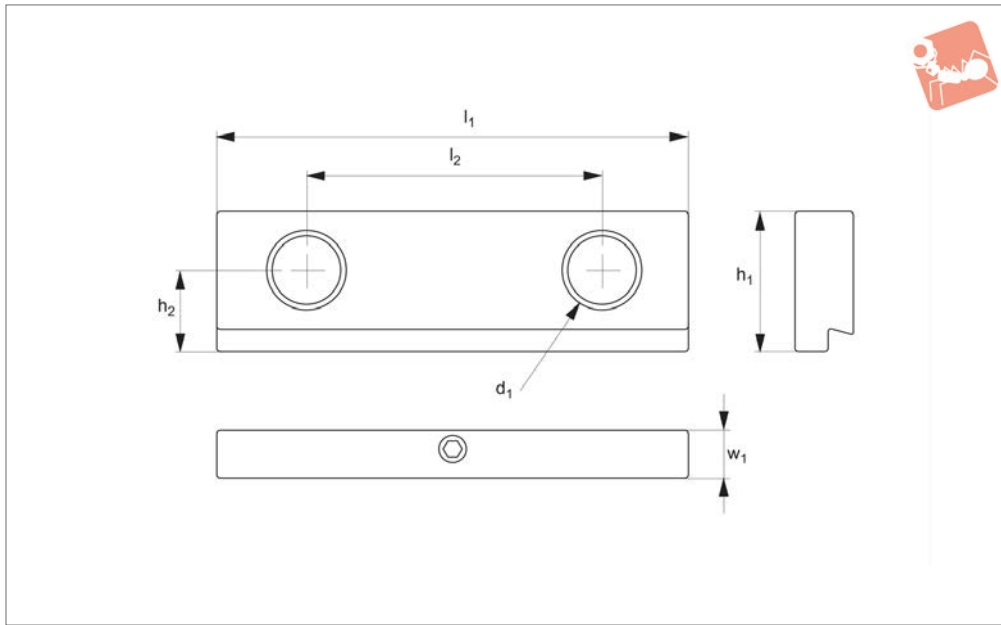
Exclusive automatic offset mechanism allows non-simultaneous workpiece clamping and unclamping to one of the three optional offset settings: 4" and 6": 0.030", 0.125", or 0.250"; 8": 0.125", 0.250", or 0.375". The offset setting is the distance the rear jaw backs away from the workpiece before the front jaw begins to back away from the workpiece.



Master Jaws - QuickChange

for use on SnapLock carrier jaws 19796

Vice Clamping



19850

VICE CLAMPING

Material

Body: 80000 psi ductile cast iron.

Technical Notes

These master jaws enable our ReLock vice snap lock carrier jaws to accept all

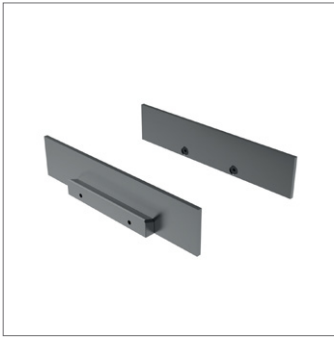
QuickChange jaw components, providing complete flexibility. Install QuickChange master jaws to SnapLock carrier jaws on vice for squareness. Prior to installation of master jaws remove any burrs, chips or dirt

from vice mounting surface.

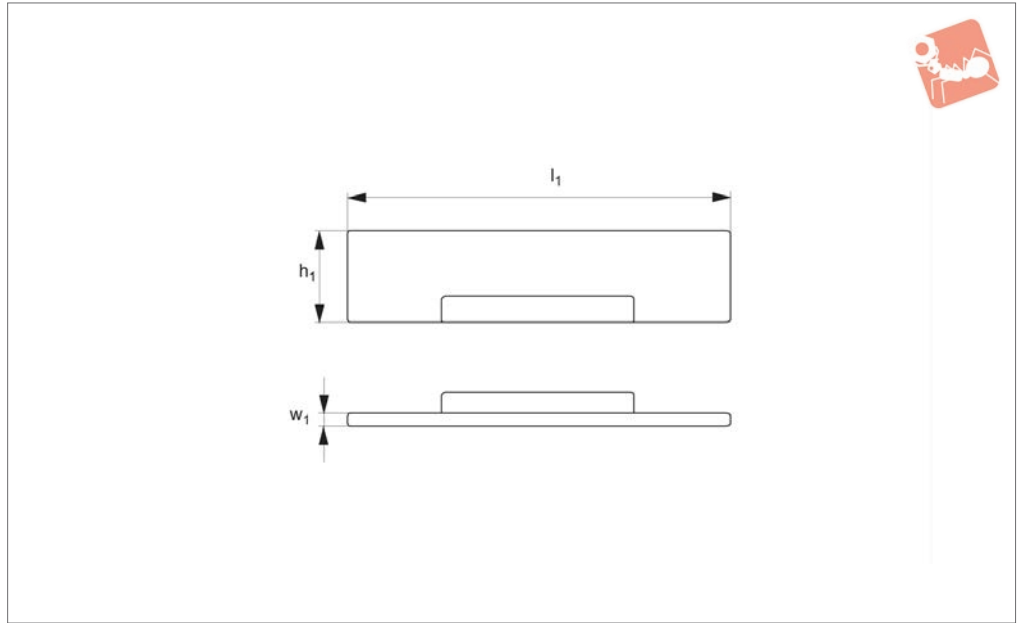
Important Notes

All dimensions are in inches.

Order No.	For vice size	l_1	l_2	h_1	h_2	w_1	d_1
19850.W0040	4"	4.06	2.500	1.235	0.687	0.560	3/8-16 S.H.C.S.
19850.W0060	6"	6.12	3.875	1.735	0.937	0.735	1/2-13 S.H.C.S.
19850.W0080	8"	8.12	4.750	2.230	1.128	1.105	5/8-11 S.H.C.S.



19852



Material

Body: 80000 psi ductile cast iron.

jaws no. 19850.

Technical Notes

Designed for use with QuickChange master

Important Notes

Supplied as a pair.

All dimensions are in inches.

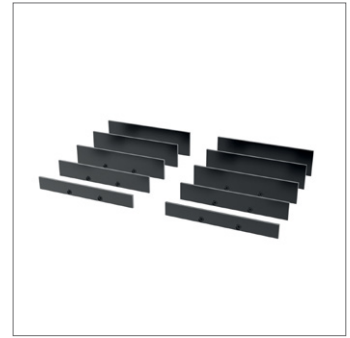
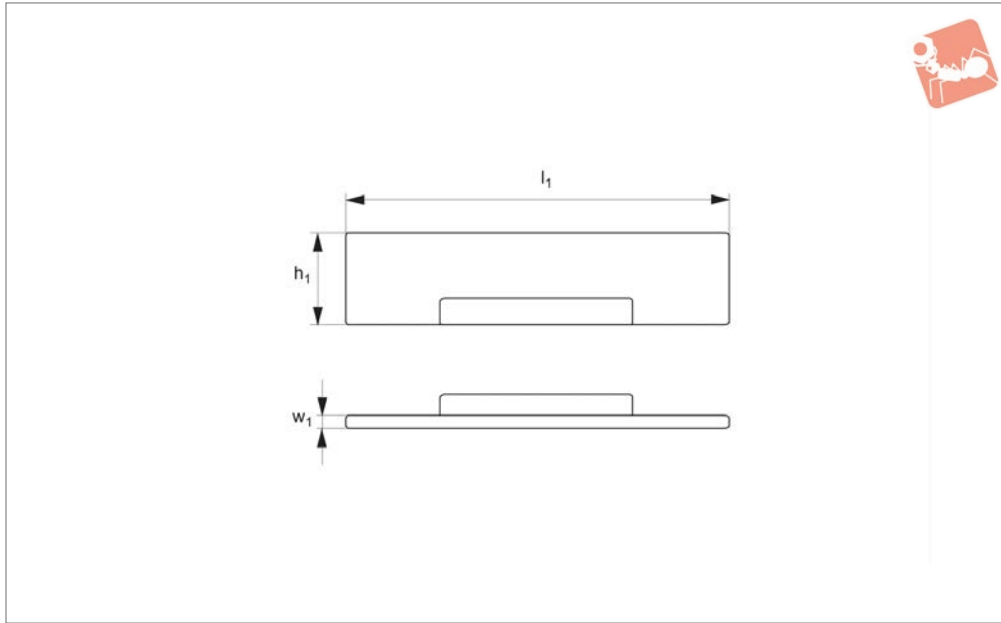
Order No.	For vice size	l_1	h_1 ± 0.0005	w_1
19852.W0041	4"	3.98	0.500	0.118
19852.W0042	4"	3.98	0.625	0.118
19852.W0043	4"	3.98	0.750	0.118
19852.W0044	4"	3.98	0.875	0.118
19852.W0045	4"	3.98	1.000	0.118
19852.W0046	4"	3.98	1.062	0.118
19852.W0047	4"	3.98	1.125	0.118
19852.W0048	4"	3.98	1.190	0.118
19852.W0061	6"	5.98	0.750	0.118
19852.W0062	6"	5.98	0.875	0.118
19852.W0063	6"	5.98	1.000	0.118
19852.W0064	6"	5.98	1.125	0.118
19852.W0065	6"	5.98	1.250	0.118
19852.W0066	6"	5.98	1.375	0.118
19852.W0067	6"	5.98	1.500	0.118
19852.W0068	6"	5.98	1.625	0.118
19852.W0069	6"	5.98	1.690	0.118
19852.W0081	8"	7.98	1.000	0.118
19852.W0082	8"	7.98	1.250	0.118
19852.W0083	8"	7.98	1.375	0.118
19852.W0084	8"	7.98	1.500	0.118
19852.W0085	8"	7.98	1.625	0.118
19852.W0086	8"	7.98	1.750	0.118
19852.W0087	8"	7.98	1.875	0.118
19852.W0088	8"	7.98	2.000	0.118
19852.W0089	8"	7.98	2.125	0.118



Vice Parallel Sets - QuickChange

for use with QuickChange master jaws 19850

Vice Clamping



19854

VICE CLAMPING

Material

Body: 80000 psi ductile cast iron.

jaws no. 19850.

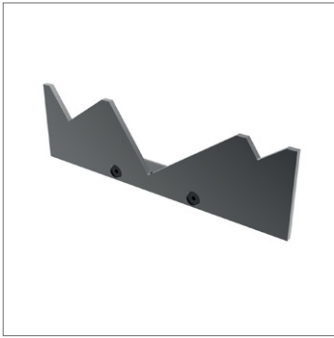
Important Notes

All dimensions are in inches.

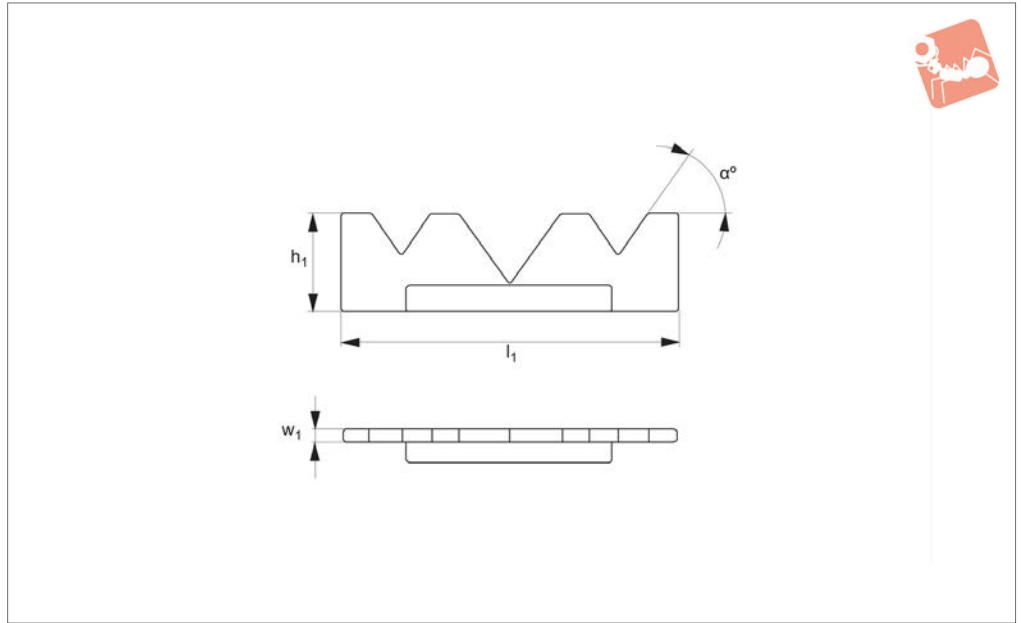
Technical Notes

Designed for use with QuickChange master

Order No.	For vice size	Type	l ₁	w ₁	Set contents 1 pair per size h ₁										
					±0.0005										
19854.W0040	4"	Basic	3.98	0.118	0,500	0,750	1,000	1,125	1,190						
19854.W0060	6"	Basic	5.98	0.118	0,750	1,000	1,250	1,500	1,625						
19854.W0080	8"	Basic	7.98	0.118	1,000	1,250	1,500	1,750	2,000						
19854.W0140	4"	Advanced	3.98	0.118	0,500	0,625	0,750	0,875	1,000	1,125	1,062	1,190			
19854.W0160	6"	Advanced	5.98	0.118	0,750	0,875	1,000	1,125	1,250	1,375	1,500	1,625	1,690		
19854.W0180	8"	Advanced	7.98	0.118	1,000	1,250	1,375	1,500	1,625	1,750	1,875	2,000	2,125		



19856



VICE CLAMPING

Material

Body: 80000 psi ductile cast iron.

19850.

All dimensions are in inches.

Technical Notes

For use with QuickChange master jaw

Important Notes

Sold individually, for a pair please order quantity of 2.

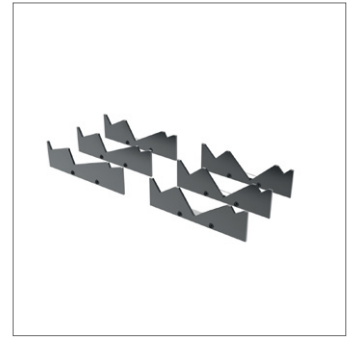
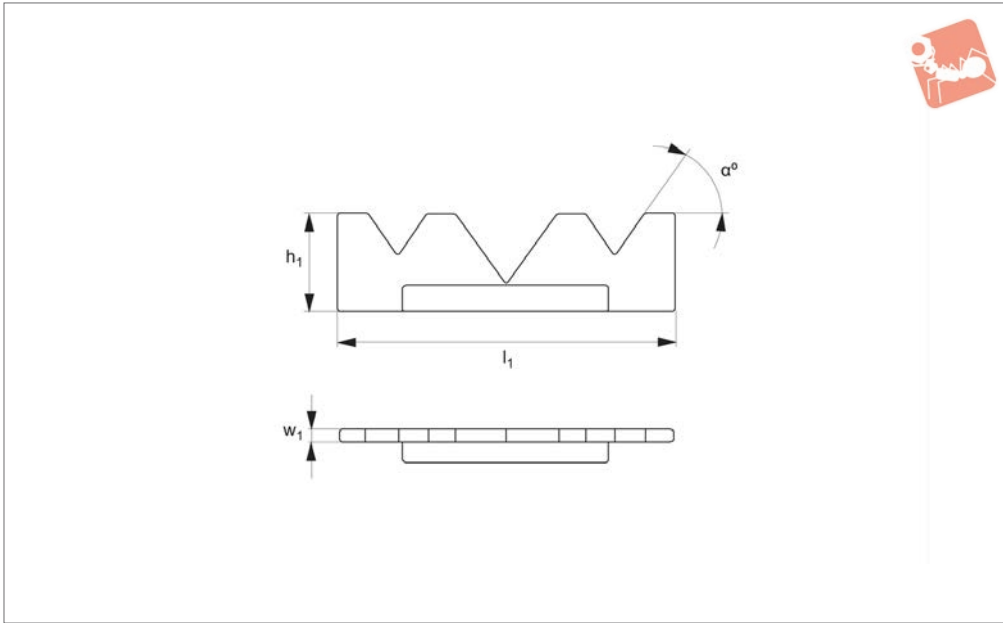
Order No.	For vice size	l_1	h_1	w_1	α
19856.W0040	4"	4	1.24	0.118	20
19856.W0041	4"	4	1.24	0.118	25
19856.W0042	4"	4	1.24	0.118	30
19856.W0043	4"	4	1.24	0.118	35
19856.W0044	4"	4	1.24	0.118	40
19856.W0045	4"	4	1.24	0.118	45
19856.W0060	6"	6	1.74	0.118	20
19856.W0061	6"	6	1.74	0.118	25
19856.W0062	6"	6	1.74	0.118	30
19856.W0063	6"	6	1.74	0.118	35
19856.W0064	6"	6	1.74	0.118	40
19856.W0065	6"	6	1.74	0.118	45
19856.W0080	8"	8	2.23	0.118	20
19856.W0081	8"	8	2.23	0.118	25
19856.W0082	8"	8	2.23	0.118	30
19856.W0083	8"	8	2.23	0.118	35
19856.W0084	8"	8	2.23	0.118	40
19856.W0085	8"	8	2.23	0.118	45



Vice Mill Angle Sets - QuickChange

for use with QuickChange master jaws 19850

Vice Clamping



19858

VICE CLAMPING

Material

Body: 80000 psi ductile cast iron.

19850.

Technical Notes

For use with QuickChange master jaw

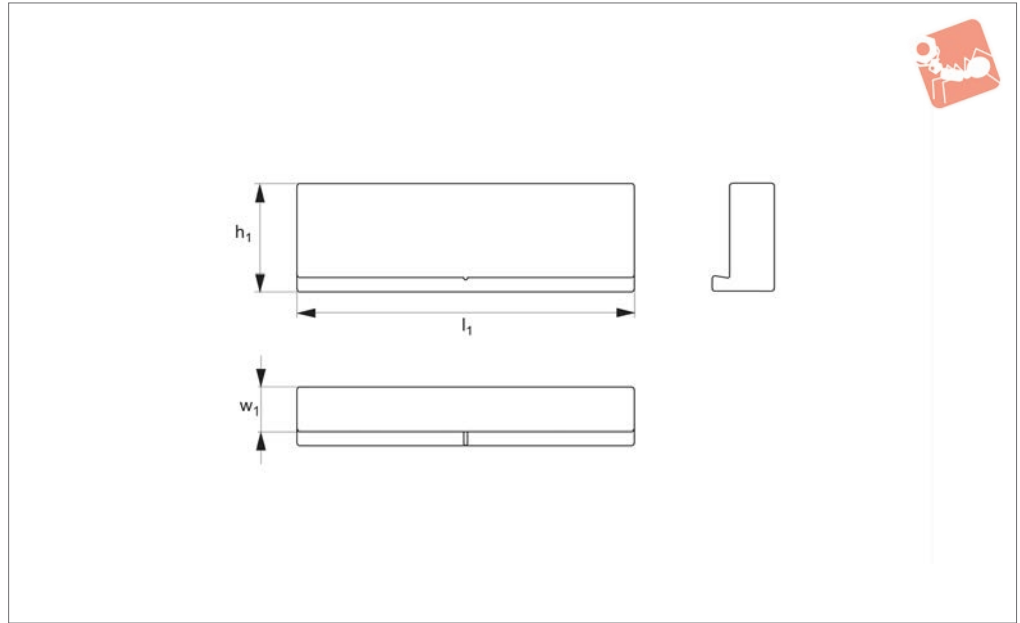
Important Notes

All dimensions are in inches.

Order No.	For vice size	l_1	h_1	w_1	Set contents 1 pair each of α°
19858.W0040	4"	4	1.24	0.118	20° 25° 30° 35° 40° 45°
19858.W0060	6"	6	1.74	0.118	20° 25° 30° 35° 40° 45°
19858.W0080	8"	8	2.23	0.118	20° 25° 30° 35° 40° 45°



19862



Material

Aluminium or steel.

19850.

All dimensions are in inches.

Technical Notes

For use with QuickChange master jaw

Important Notes

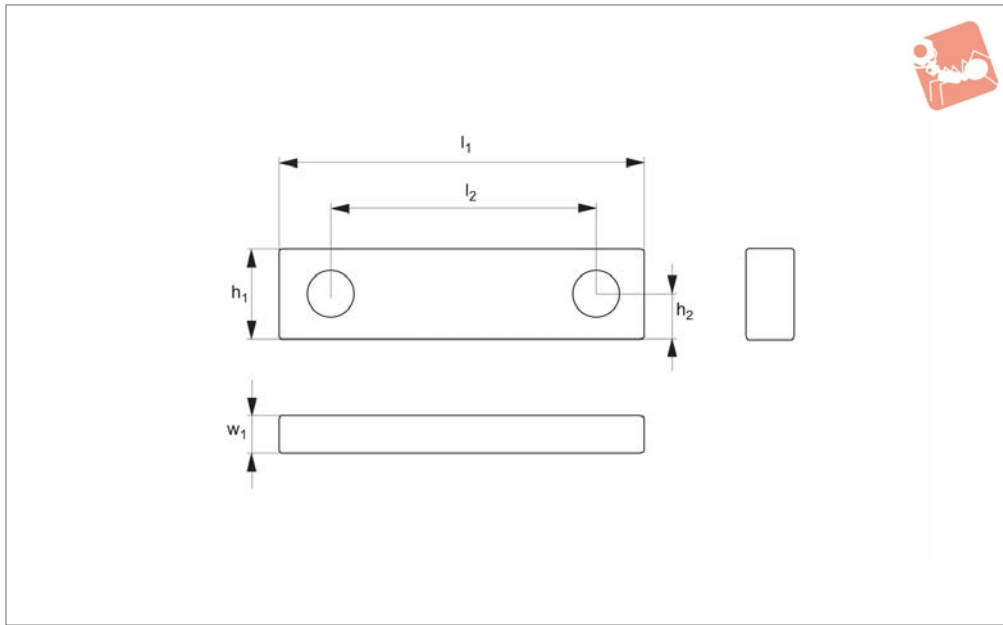
Sold as individually, for a pair please order quantity of 2.

Order No.	For vice size	Material	l_1	h_1	w_1
19862.W0040	4"	Aluminium	4	1.5	0.69
19862.W0041	4"	Aluminium	4	1.5	1.38
19862.W0060	6"	Aluminium	6	2.0	0.75
19862.W0061	6"	Aluminium	6	2.0	1.50
19862.W0080	8"	Aluminium	8	2.5	1.25
19862.W0081	8"	Aluminium	8	2.5	2.50
19862.W0140	4"	Steel	4	1.5	0.69
19862.W0141	4"	Steel	4	1.5	1.38
19862.W0160	6"	Steel	6	2.0	0.75
19862.W0161	6"	Steel	6	2.0	1.50
19862.W0180	8"	Steel	8	2.5	1.25
19862.W0181	8"	Steel	8	2.5	2.50



Soft Vice Jaws - Universal bolt-on

Vice Clamping



19890

VICE CLAMPING

Material

Aluminium.

Important Notes

All dimensions are in inches.

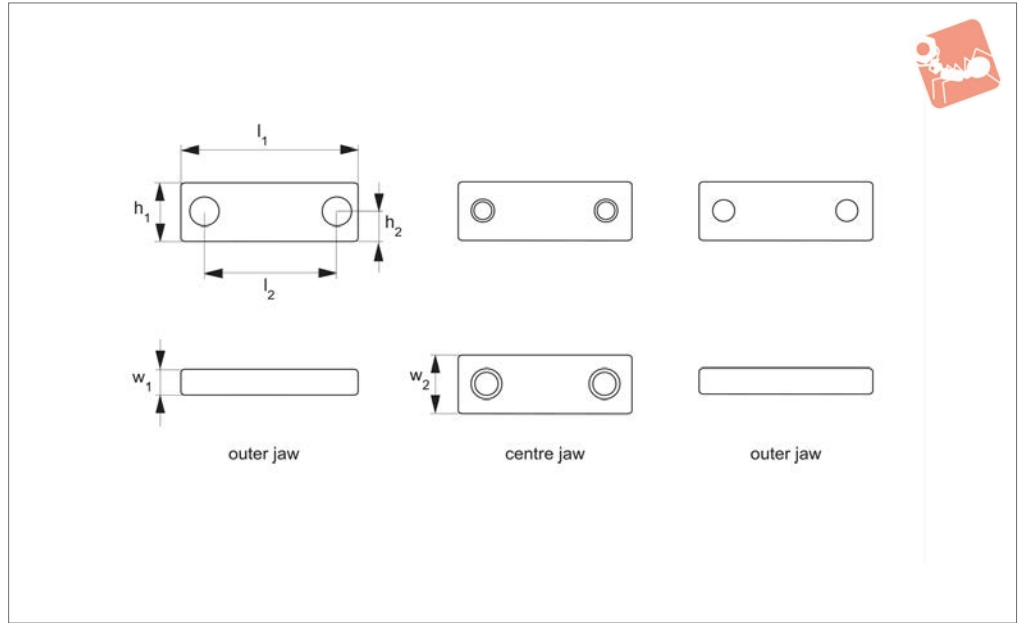
Technical Notes

For use with most industry standard vices.

Order No.	For vice size	l_1	l_2	h_1	h_2	w_1
19890.W0040	4"	5	2.500	1.5	0.687	1.00
19890.W0060	6"	7	3.875	2.0	0.937	1.25
19890.W0080	8"	9	4.750	2.5	1.128	2.00



19892



VICE CLAMPING

Material

Steel.

Technical Notes

Centre jaw only for use with ReLock vice

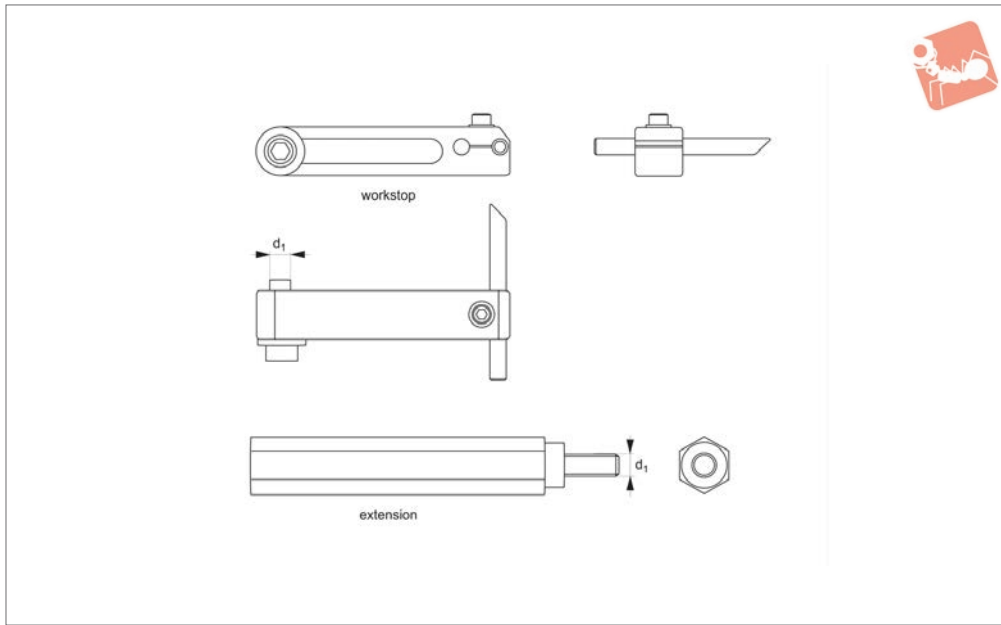
system. Outside jaws fit most standard vice bolt hold patterns.

Install these hard jaws on SnapLock carrier jaws on vice for squareness.

Important Notes

All dimensions are in inches.

Order No.	For vice size	l_1	l_2	h_1	h_2	w_1	w_2	Set contents
19892.W0401	4"	3.98	2.500	1.35	0.687	0.560	1.25	2 x Outer, 1 x Centre
19892.W0402	4"	3.98	-	1.35	-	-	1.25	1 x Centre
19892.W0403	4"	3.98	2.500	1.35	0.687	0.560	-	2 x Outer
19892.W0601	6"	5.98	3.875	1.85	0.937	0.750	1.50	2 x Outer, 1 x Centre
19892.W0602	6"	5.98	-	1.85	-	-	1.50	1 x Centre
19892.W0603	6"	5.98	3.875	1.85	0.937	0.750	-	2 x Outer
19892.W0801	8"	7.98	4.750	2.35	1.218	1.125	1.98	2 x Outer, 1 x Centre
19892.W0802	8"	7.98	-	2.35	-	-	1.98	1 x Centre
19892.W0803	8"	7.98	4.750	2.35	1.218	1.125	-	2 x Outer



19894

VICE CLAMPING

Material

Steel.

Technical Notes

Multiple extension pieces can be used to create longer offset.

Important Notes

***Design change was made to the 19752.W... vice:** 3/8-16 tapped hole was modified to a 5/16-18 tapped hole. Check your vice to verify the size you need before

ordering.

All dimensions are in inches.

Order No.	For vice size	Type	Extension length	Thread size d_1
19894.W0401	4"	Workstop	-	5/16-18
19894.W0402	4"	Extension	4	5/16-18
19894.W0601	6"	Workstop	-	5/16-18*
19894.W0602	6"	Extension	6	5/16-18*
19894.W0611	6"	Workstop	-	3/8-16*
19894.W0612	6"	Extension	6	3/8-16*
19894.W0801	8"	Workstop	-	1/2-13
19894.W0802	8"	Extension	8	1/2-13