

12034

VICE CLAMPING

Material

Steel, hardened (HRC 52-54).

Technical Notes

Typically used in conjunction with pitbull

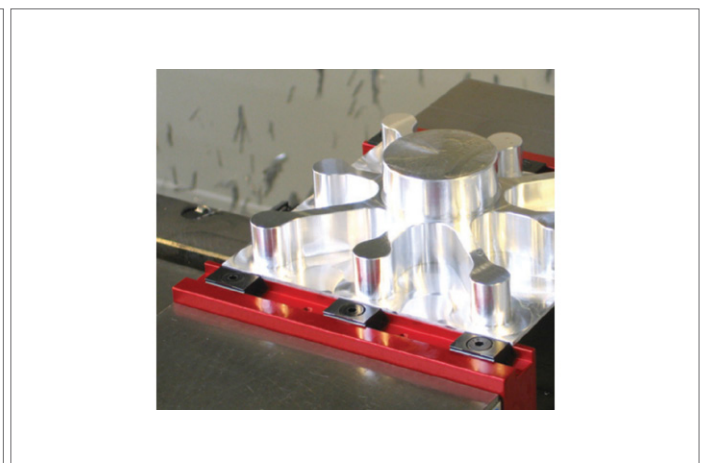
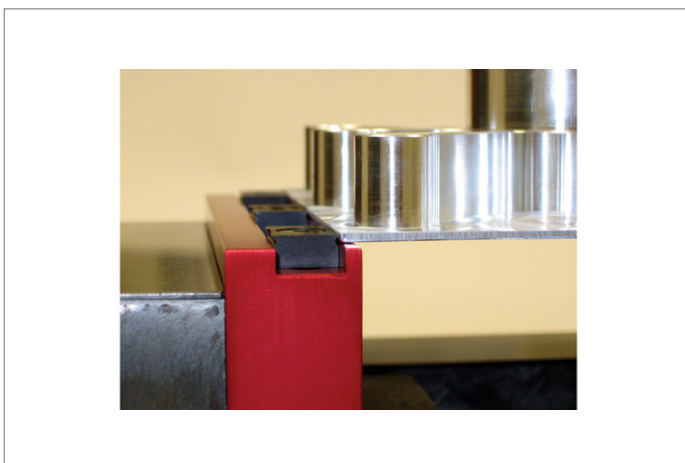
(part no. 12301) or Dynaforce (part no. 12010) clamps.

Allows aggressive clamping on as little as 1,5mm of material.

Tips

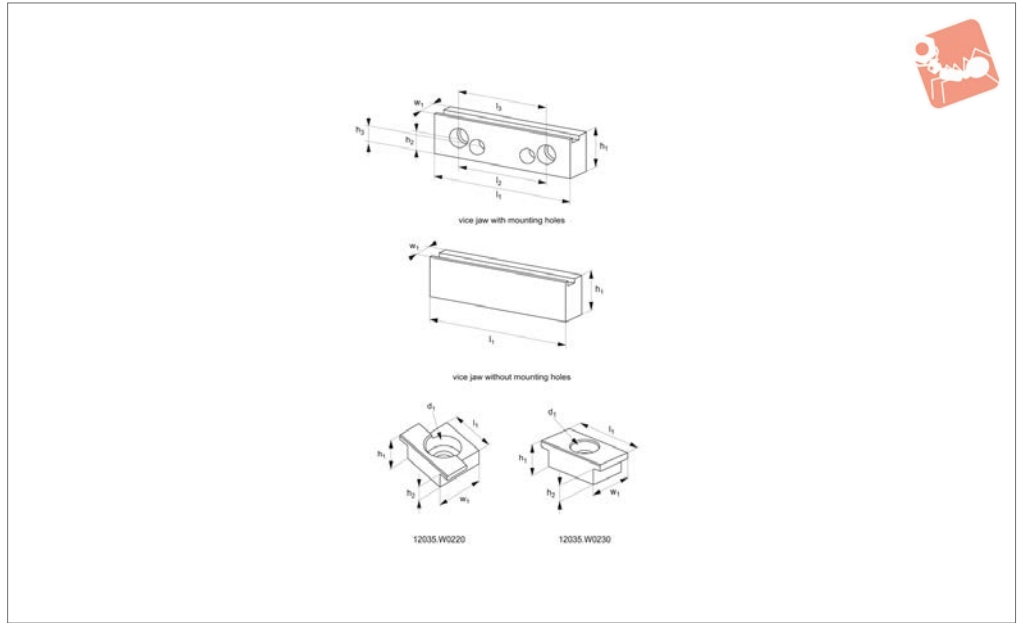
A further option includes an adaptor to suit 100mm and 150mm vices - see part no. 12035.

Order No.	d ₁	Grip height h ₂	h ₁	h ₃	l ₁	w ₁	A/F	Qty/pack	Weight g
12034.W0050	M 5	1,5 to 1,9	6.4	6.0	12.7	19.1	3	2	12
12034.W0075	M 5	1,5 to 3,0	7.9	8.1	19.1	19.1	3	2	22
12034.W0100	M 5	1,5 to 3,0	7.9	8.1	25.4	19.1	3	2	30
12034.W0150	M 8	1,5 to 5,6	12.7	6.0	25.4	25.4	5	1	37





12035



VICE CLAMPING

Material

Steel, heat-treated.

Technical Notes

The vice jaws for the Talongrip clamps increase the functionality of your 100 and 150mm vices (4" or 6").

This is a simple bolt-on system that allows

you to perform aggressive machining operations whilst clamping on as little as 1,5mm.

Ideal for small batch sizes or when building a fixture is not economical.

Tips

Supplied with one jawstop (either part no.

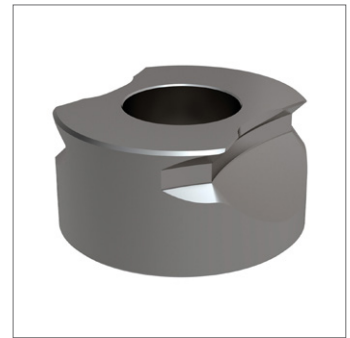
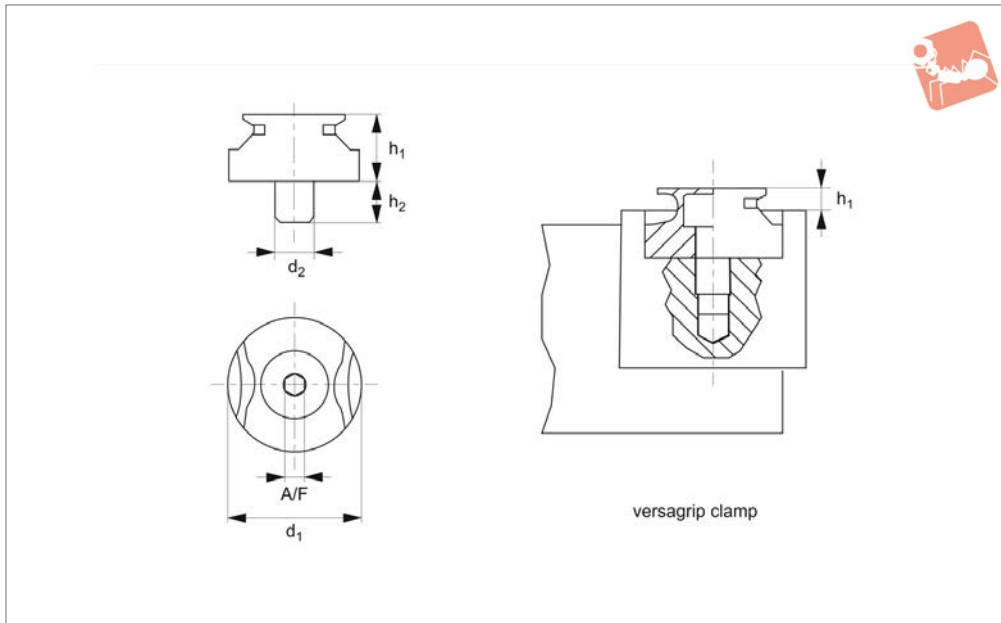
12035.W0220 or .W0230 - see table) and for individual Talongrips (either part no. 12034.W0050 or .W0075).

Important Notes

Set includes a pair of vice jaws, four talongrip clamps and one stop (part no.12035.W0220).

Order No.	For vice size	Type	Jaw type	Vice jaw	Vice jaw Stop	Talongrip clamps	Weight g
12035.W0010	4"	Vice jaw set	With holes	2 Off	1 pc 12035.W0220	4 pc 12034.W0050	1370
12035.W0015	4"/6"	Vice jaw set	With holes	2 Off	1 pc 12035.W0220	4 pc 12034.W0050	2290
12035.W0020	6"	Vice jaw set	With holes	2 Off	1 pc 12035.W0220	4 pc 12034.W0050	3220
12035.W0025	6"/8"	Vice jaw set	With holes	2 Off	1 pc 12035.W0230	4 pc 12034.W0075	5570
12035.W0110	-	Vice jaw set	W/o holes	2 Off	1 pc 12035.W0220	4 pc 12034.W0050	1490
12035.W0115	-	Vice jaw set	W/o holes	2 Off	1 pc 12035.W0220	4 pc 12034.W0050	2570
12035.W0120	-	Vice jaw set	W/o holes	2 Off	1 pc 12035.W0230	4 pc 12034.W0050	3420
12035.W0220	-	Jaw stop small	-	-	-	-	6
12035.W0230	-	Jaw stop large	-	-	-	-	10

Order No.	d ₁	h ₁	h ₂	h ₃	l ₁	l ₂	l ₃	w ₁
12035.W0010	-	37.6	-	17.5	100	-	63.5	25.4
12035.W0015	-	43.9	23.9	17.5	150	98.6	63.5	25.4
12035.W0020	-	43.9	-	23.9	200	-	98.6	25.4
12035.W0025	-	62.2	30.9	23.9	200	120.7	98.3	31.8
12035.W0110	-	37.6	-	-	100	-	-	25.4
12035.W0115	-	43.9	-	-	150	-	-	25.4
12035.W0120	-	43.9	-	-	200	-	-	25.4
12035.W0220	M 5	6.4	5.0	-	19	-	-	12.7
12035.W0230	M 5	7.9	5.7	-	19	-	-	12.7



12036.1

VICE CLAMPING

Material

Steel, hardened (HRC 52-54).

Technical Notes

The hardened grip has penetrating teeth designed to bite into the workpiece

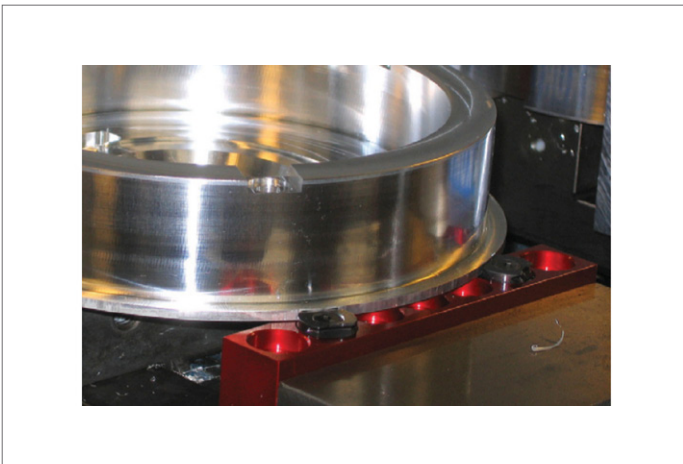
preventing lateral and its horizontal movement.

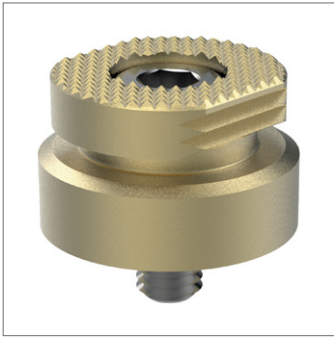
These grips will even hold flame cut parts and parts with negative drafts.

Tips

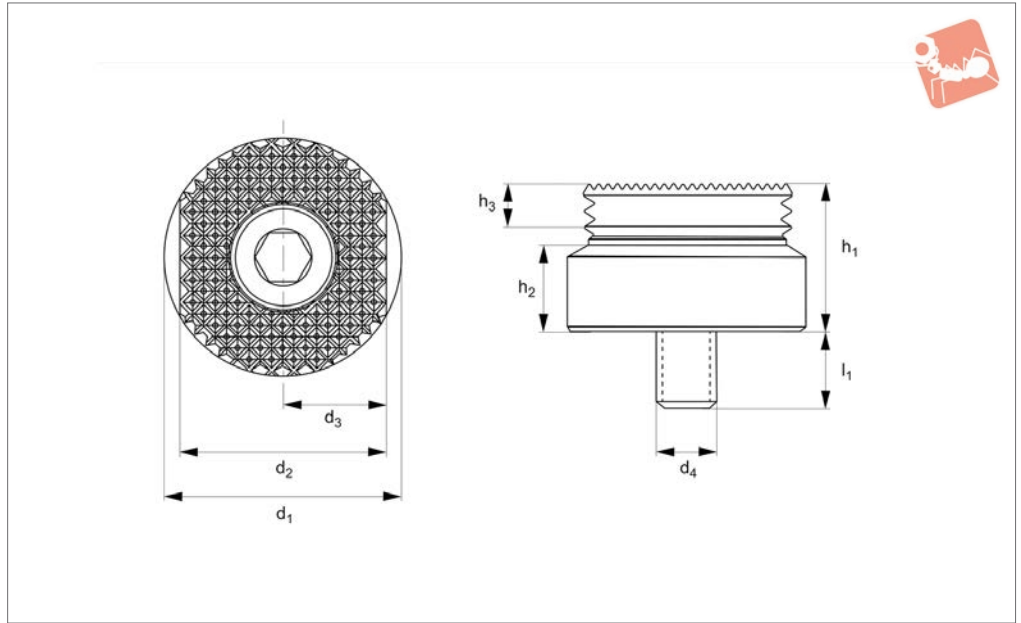
A further option includes an adaptor to suit 100mm and 150mm vices - see part no. 12037.

Order No.	h_1	h_2	d_1	d_2	Grip height h_1	A/F	Qty/pack	Weight g
12036.W0175	9.5	5.9	19.1	M5	1,5 to 3,0	4	2	18





12036.2



VICE CLAMPING

Technical Notes

Designed for those aggressive operations on harder materials while providing the versatility to hold just about any shape. Standard gripping height (.200") or

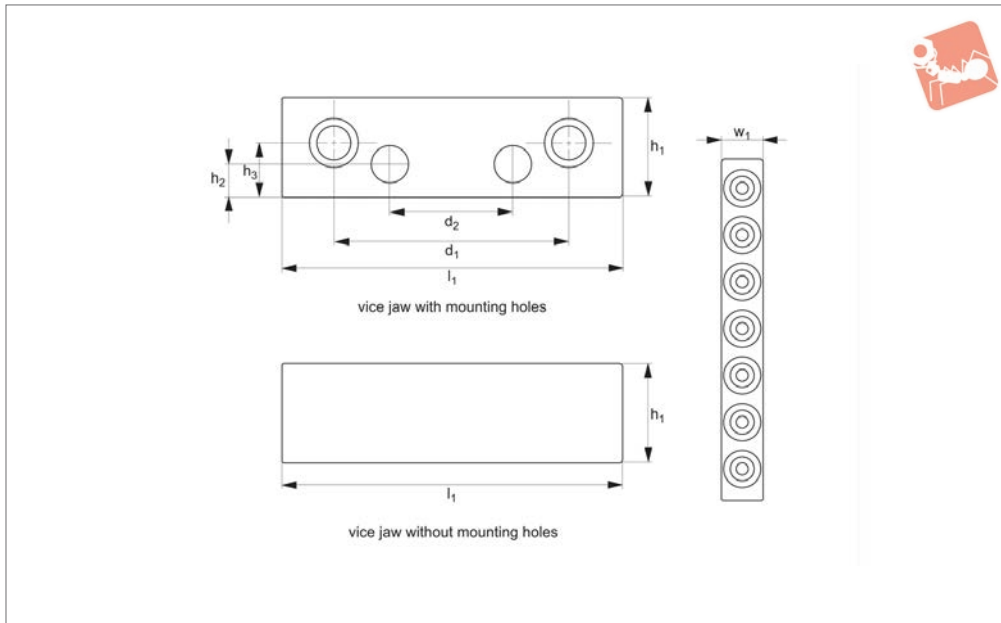
elevated workpiece for cutter clearance around jaws by resting part on the original Versagrip gripper or custom made pucks in the Versa pockets. Rotatable, flat, serrated top face for additional holding force in

horizontal pockets in jaws or hard stops.

Tips

Max. vice torque per pair of grips - 6" vice: 35-40 Lb/Fts (47,5-54,2 Nm.).

Order No.	h_1	h_2	h_3	d_1	d_2	d_3	d_4	l_1	Qty/pack	Weight g
12036.W0570	11.94	6.73	5.21	19,00-19,05	16.61	8.31	M 5	6.05	2	18



12037

VICE CLAMPING

Material

Steel, hardened (52-54 HRC).

Technical Notes

The Versagrip jaws increase the functionality of your 100 and 150mm vices. This is a simple bolt-on system that allows you to perform aggressive machining operations

whilst clamping on as little as 1,5mm for irregular shaped parts.

Ideal for small batch sizes or when building a fixture is not economical.

Tips

Has penetrating teeth designed to bite into your workpiece to prevent lateral and horizontal movement.

They will hold flame cut parts, castings and even parts with negative draft.

Important Notes

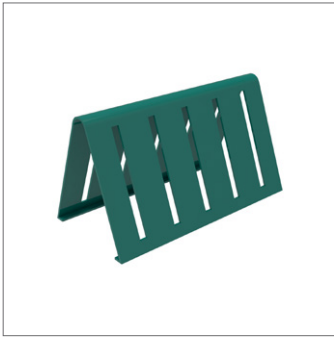
Set includes a pair of vice jaws, and four Versagrip clamps, part no. 12036.W0175.

Order No.	For vice size	Type	Jaw type	Vice jaw	Versagrip clamps	d ₁	d ₂	h ₁	h ₂	h ₃	l ₁	w ₁	Number of holes	Weight g
12037.W0015	4"/6"	Vice jaw set	With holes	2 off	4 pc 12036.W0175	98,55	63,5	47,75	23,87	17,47	150	25,4	7	2460
12037.W0020	6"	Vice jaw set	With holes	2 off	4 pc 12036.W0175	98,55		47,75	23,87		200	25,4	9	3470
12037.W0115		Vice jaw set	W/o holes	2 off	4 pc 12036.W0175			47,75			150	25,4	7	2780
12037.W0120		Vice jaw set	W/o holes	2 off	4 pc 12036.W0175			47,75			200	25,4	9	3640

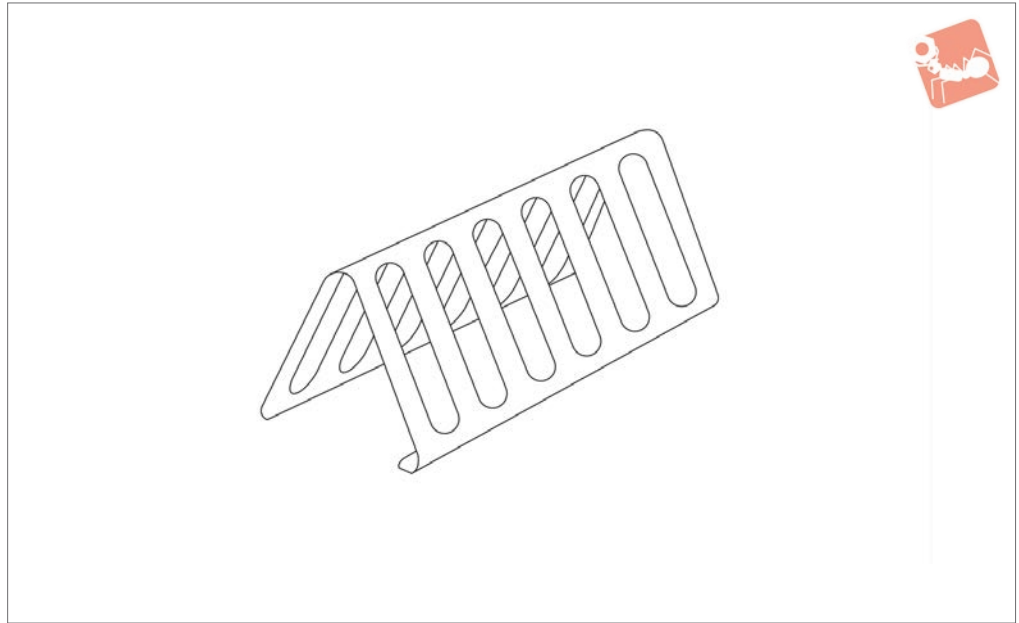




VICE CLAMPING



19838



Material

Steel.

Technical Notes

Provides convenient storage of parallel sets.

Order No.	For vice size	Suitable for parallel kits
19838.W0040	4"	19814.W0140
19838.W0041	4"	19814.W0040
19838.W0060	6"	19814.W0160
19838.W0061	6"	19814.W0060

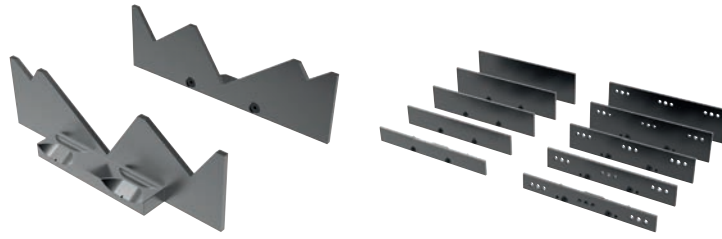


AccuSnap Jaws and Parallels

for use on SnapLock Jaw System for ReLock Vices

19810 - 19838
Clamping & Height Setting

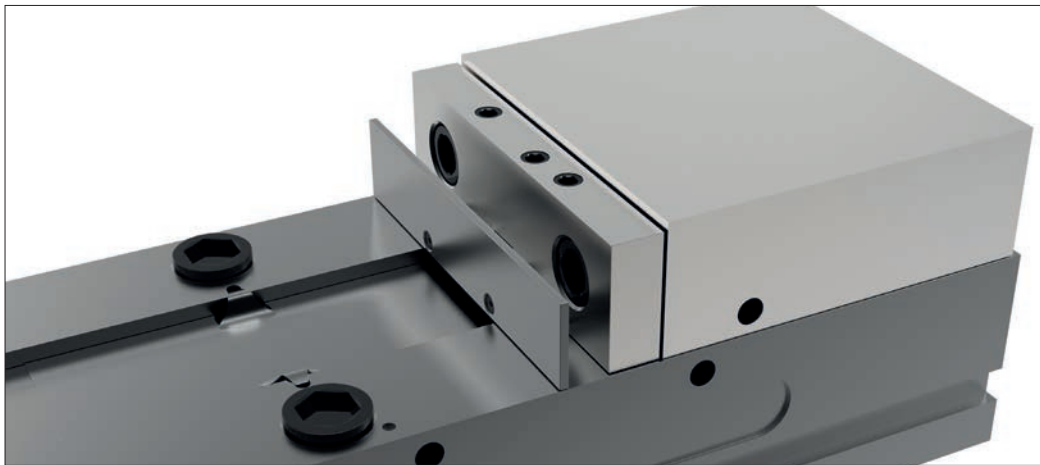
- Fast, accurate and versatile.
- Reduces setup time drastically.
- $\pm 0,0002''$ repeatability.
- Adaptable to most vice systems.



Step 1:

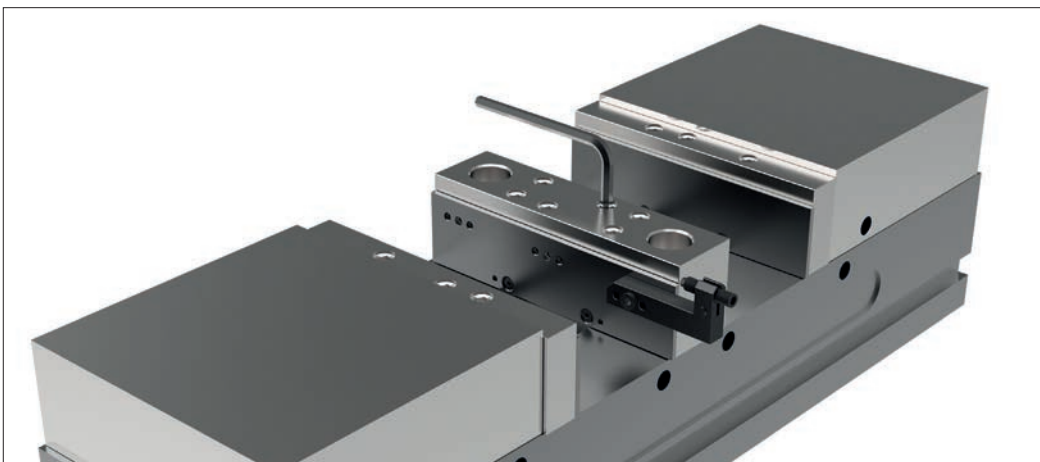
Before mounting AccuSnap master jaws, thoroughly inspect, clean and remove any burrs or chips from the mounting surface.

Simply attach the AccuSnap master jaws to the carrier jaw system using the industry standard bolt system.



Step 2:

Snap in the parallels or soft jaws that you require for your set-up and begin machining. Two lock screws are provided for extra holding assurance, but are not necessary to hold parallels in place. Do not overtighten lock screws.



Step 3:

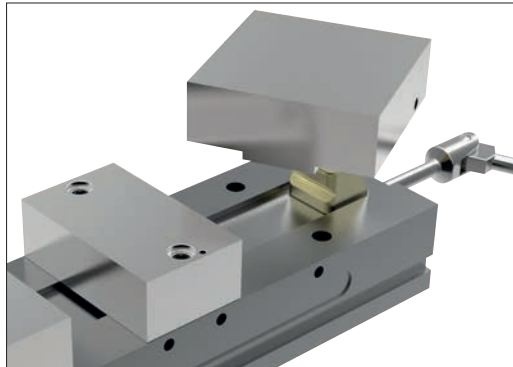
When finished with your job, unlock parallels (if needed) and turn the kick out screw to eject the jaw or parallel.

You are ready to repeat the process for your next job.



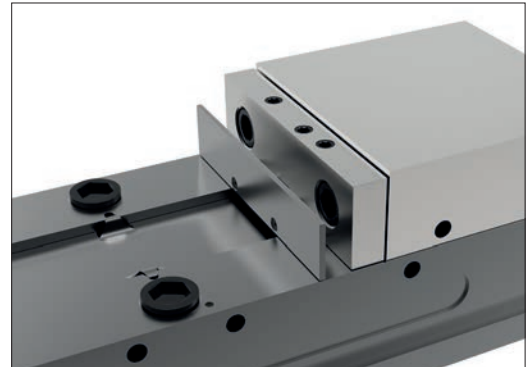
ReLock Accessories

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



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.



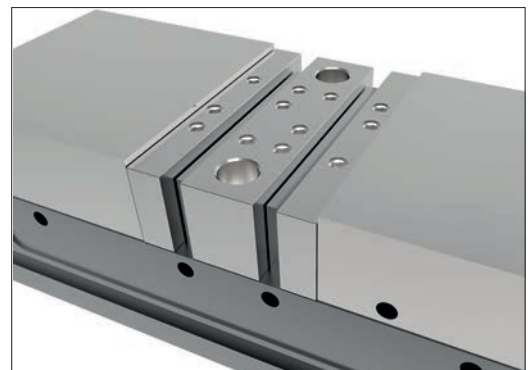
SnapLock Carrier Jaws

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



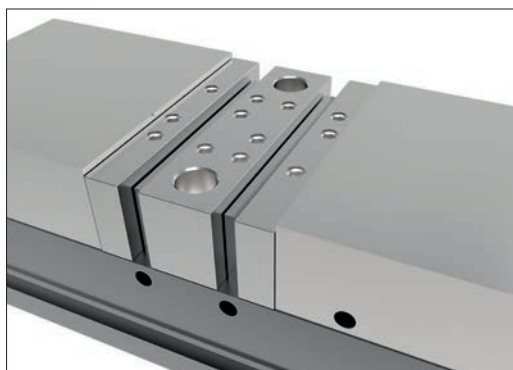
QuickChange Vice System

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.

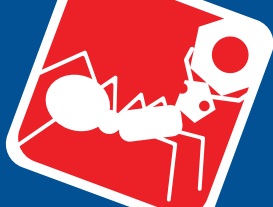


AccuSnap Workstops

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.

How to use the SnapLock Jaw System

19790-19862
Clamping & Height Setting



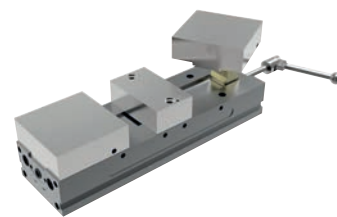
The SnapLock system's allows simple, quick changeovers between machinable and carrier jaws.

SnapLock Machinable Fixture Jaws

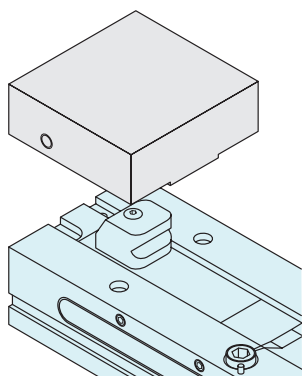
- Can be attached, reversed, removed or indexed in a matter of seconds.
- Extremely versatile, allowing endless customisation possibilities.
- Manufactured from high quality aluminium.

SnapLock Carrier Jaws

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

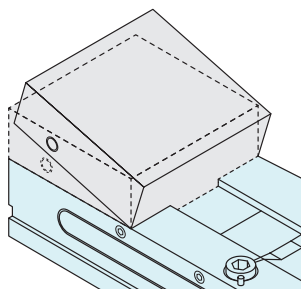


Operation



Step 1

Align the SnapLock outer jaw over the appropriate ReLock vice knuckle

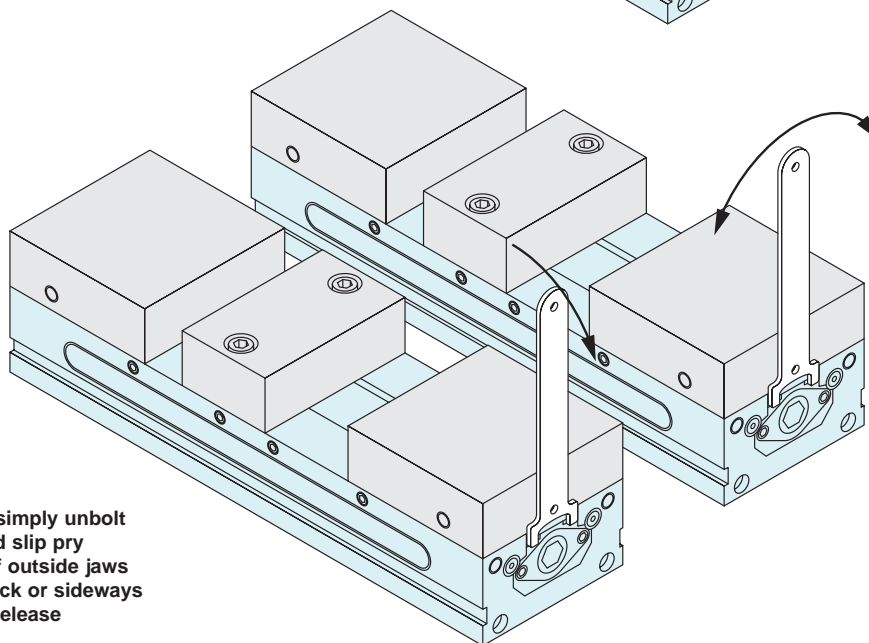
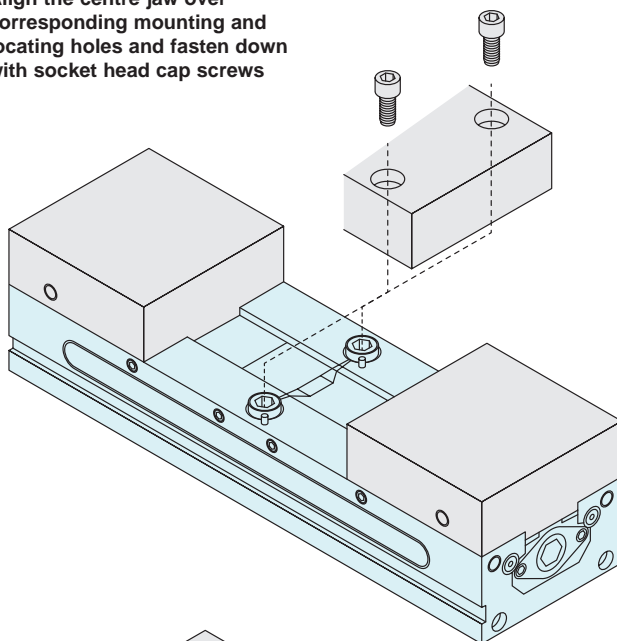


Step 2

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

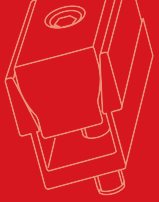
Step 3

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



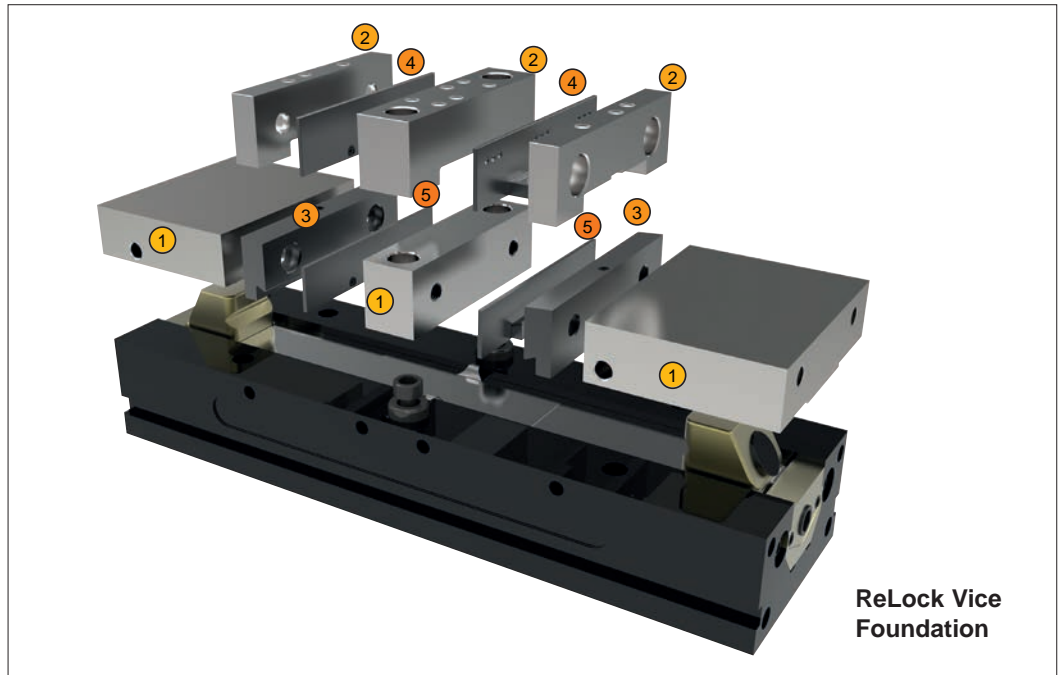
Foundation

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

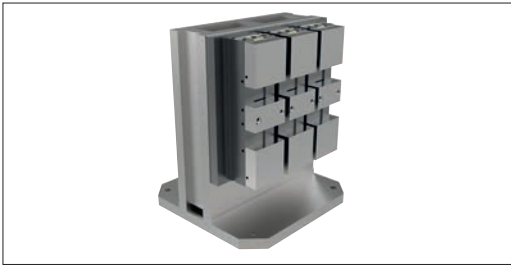
The AccuSnap workstop presetting gauge, in combination with a standard micrometer, allows you to precisely preset your modular workstop positions in relation to the X, Y, and Z machine datums.

Single Station Conversion Plate

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

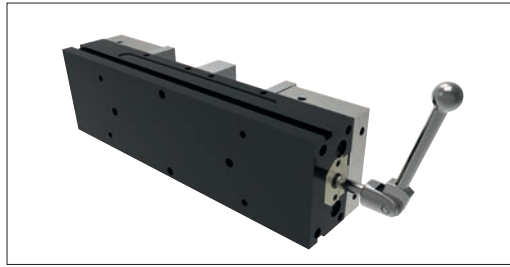


Features and Benefits



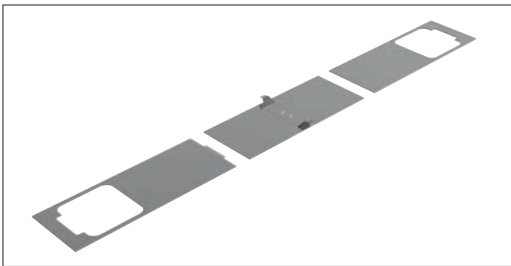
Optimised Table Space

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.



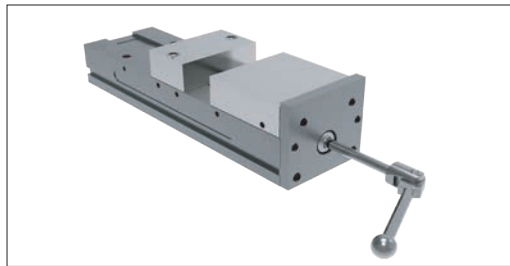
Locating and Mounting

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.



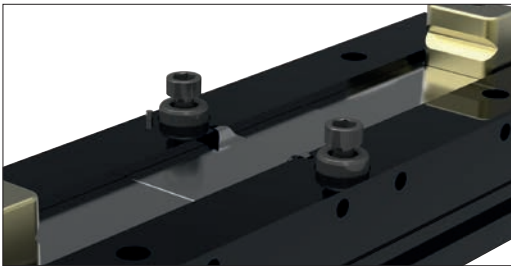
ReLock Chip Shields

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.



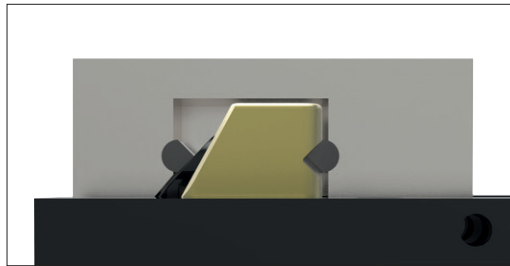
Single Station Conversion

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.



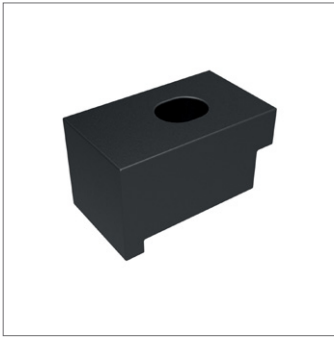
SnapLock Knuckle

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

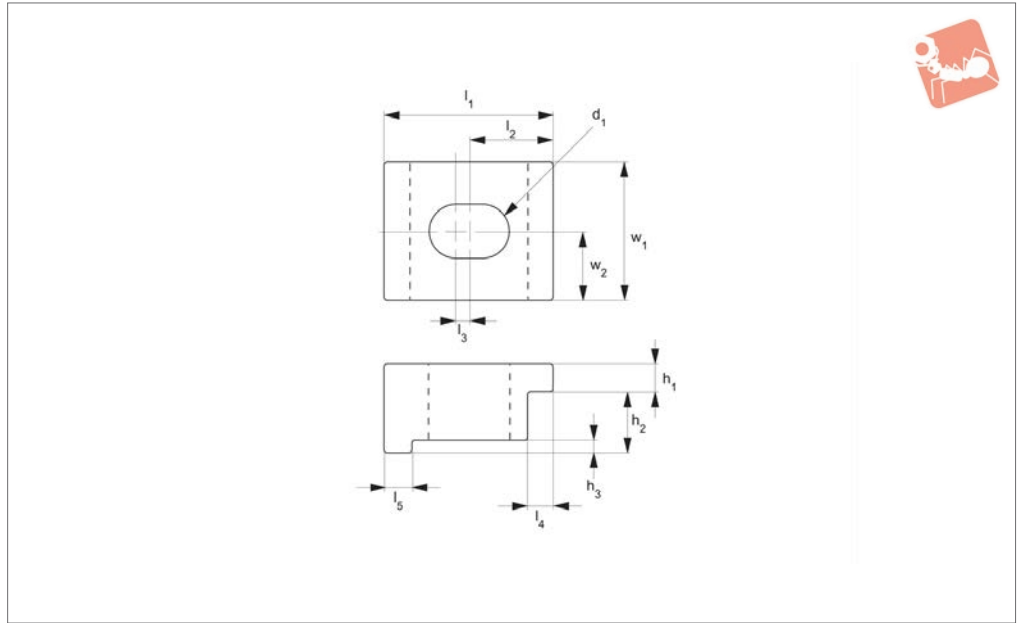


Auto Offset Mechanism

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.



19896



VICE CLAMPING

Material

Steel (1018), case hardened, black oxide finish.

table. Fits into side groove on side of clamp - suitable for most industry standard vices.

Technical Notes

Used to secure vice to fixture of machine

Important Notes

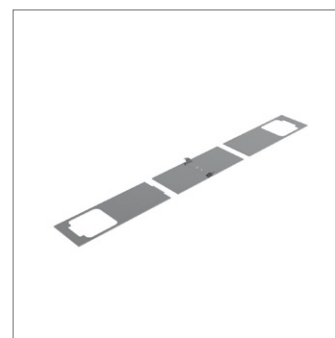
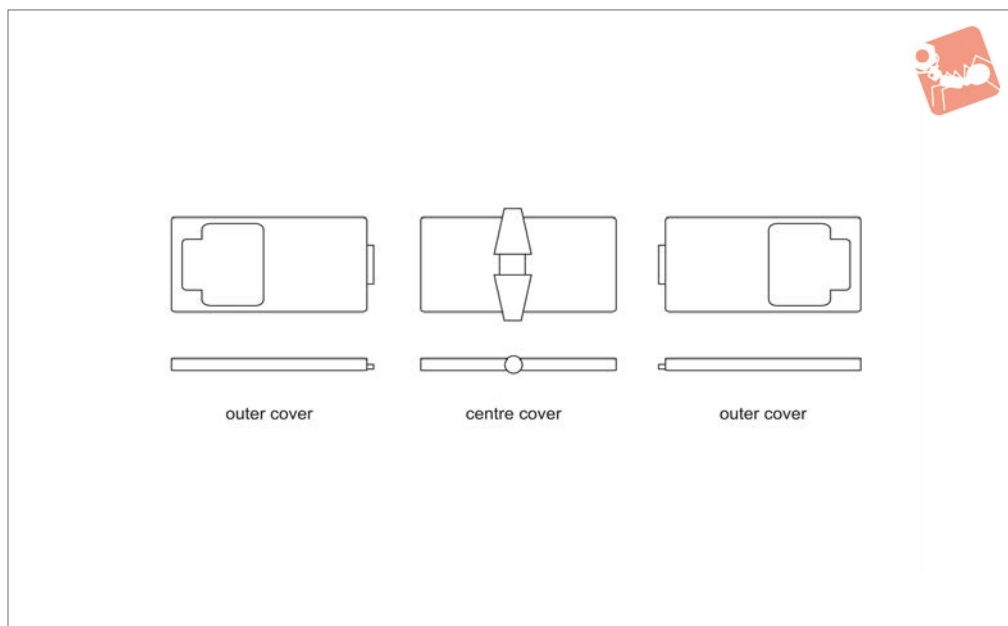
All dimensions are in inches.

Order No.	For thread d_1	For vice size	h_1	h_2	h_3	l_1	l_2	l_3	l_4	l_5	w_1	w_2
19896.W0040	3/8	4"	0.25	0.50	0.13	1.50	0.63	0.13	0.19	0.25	1.25	0.625
19896.W0041	1/2	4"	0.25	0.50	0.13	1.50	0.63	0.13	0.19	0.25	1.25	0.625
19896.W0060	3/8	6"	0.50	0.75	0.19	2.12	0.85	0.13	0.25	0.25	1.25	0.625
19896.W0061	1/2	6"	0.50	0.75	0.19	2.12	0.85	0.13	0.25	0.25	1.25	0.625
19896.W0062	3/8	6"	0.50	0.75	0.19	2.12	0.85	0.13	0.25	0.25	1.25	0.625



Chip Shield Covers for double and eight station vices

Vice Clamping



19899

VICE CLAMPING

Technical Notes

Fits double station and eight station vices.
Shield covers protects vice screw and

mechanism from swarf and other debris.

Important Notes

All dimensions are in inches.

Order No.	For vice size	Set contents
19899.W0040	4"	2 x Outer, 1 x Centre
19899.W0060	6"	2 x Outer, 1 x Centre
19899.W0080	8"	2 x Outer, 1 x Centre