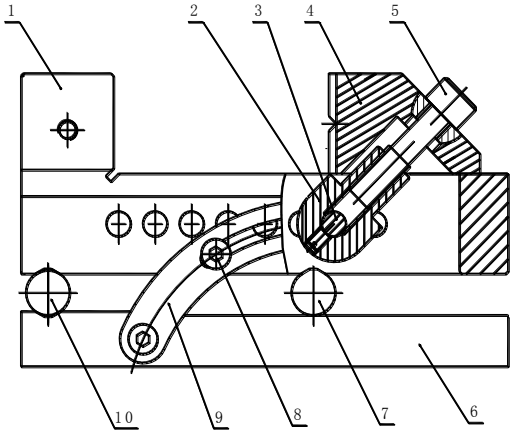
I. Main specification:

Center Distance between Rolls: 100mm (3.94”) within .015mm (.0006”)

Jaw Width:	73mm	(2.87”)
Jaw Depth:	35mm	(1.38”)
Jaw Opening:	95mm	(3.74”)
Overall Height:	103.5mm	(4.07”)
Overall Length:	190mm	(7.48”)

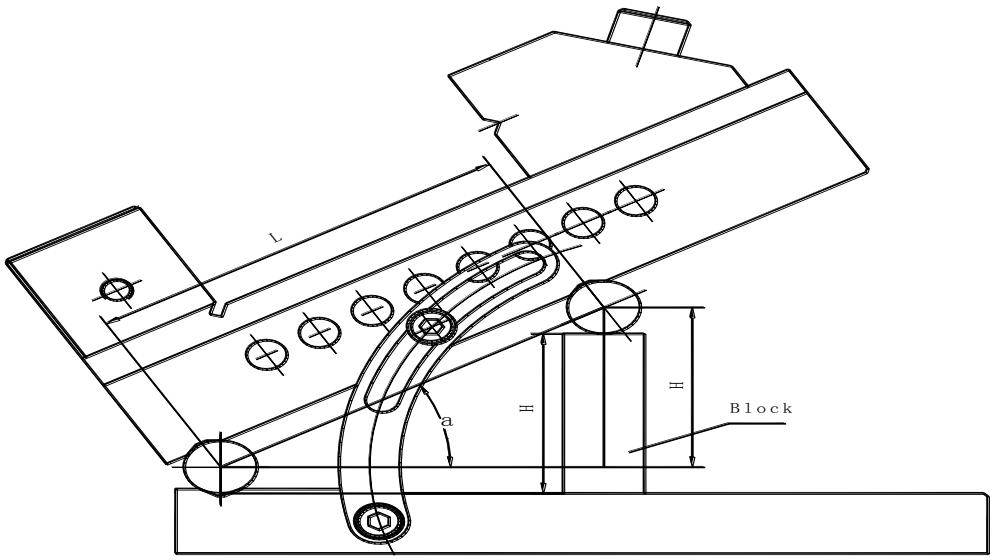
II. Parts of name and quantity (with drawing)



No.	Name	Quantity
1	vise body	1
2	pilot pin	1
3	pin	1
4	live jaw	1
5	socket head cap screw	1
6	base board	1
7	shaft	1
8	socket head cap screw	4
9	support rack	2
10	shaft	1

III. Method and step

First adjust the required angle and choose the proper gage block. Loosen screw (8), lift vise body (1) and put the gage block under the shaft (7). Then tighten the screw (8), to the size of workpiece clamp by adjusting the position of pin (3) in the holes of vise body (1). To get minor travel clamping, we can adjust the screw (5), and move the live jaw (4).



H=L x sin a

L=100mm

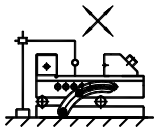
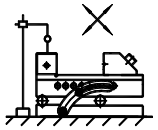
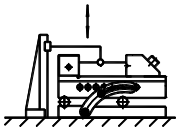
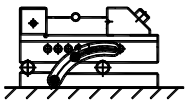
a	H(mm)	H(Inch)	a	H(mm)	H(Inch)	a	H(mm)	H(Inch)	a	H(mm)	H(Inch)
1°	1.745	.0687	**12.5°**	21.644	.8521	**24°**	40.674	1.6013	**35.5°**	58.070	2.2862
1.5°	2.618	.1031	**13°**	22.495	.8856	**24.5°**	41.469	1.6326	**36°**	58.779	2.3141
2°	3.490	.1374	**13.5°**	23.345	.9191	**25°**	42.262	1.6639	**36.5°**	59.482	2.3418
2.5°	4.362	.1717	**14°**	24.192	.9524	**25.5°**	43.051	1.6949	**37°**	60.182	2.3694
3°	5.233	.2060	**14.5°**	25.038	.9857	**26°**	43.837	1.7259	**37.5°**	60.876	2.3967
3.5°	6.105	.2404	**15°**	25.882	1.0190	**26.5°**	44.620	1.7567	**38°**	61.566	2.4239
4°	6.976	.2746	**15.5°**	26.724	1.0521	**27°**	45.399	1.7874	**38.5°**	62.251	2.4508
4.5°	7.846	.3089	**16°**	27.564	1.0852	**27.5°**	46.175	1.8179	**39°**	62.932	2.4776
5°	8.716	.3431	**16.5°**	28.402	1.1182	**28°**	46.947	1.8483	**39.5°**	63.608	2.5043
5.5°	9.585	.3774	**17°**	29.237	1.1511	**28.5°**	47.716	1.8786	**40°**	64.279	2.5307
6°	10.453	.4115	**17.5°**	30.071	1.1839	**29°**	48.481	1.9087	**40.5°**	64.945	2.5569
6.5°	11.320	.4457	**18°**	30.902	1.2166	**29.5°**	49.242	1.9387	**41°**	65.606	2.5829
7°	12.187	.4798	**18.5°**	31.730	1.2492	**30°**	50.000	1.9685	**41.5°**	66.262	2.6087
7.5°	13.053	.5139	**19°**	32.557	1.2818	**30.5°**	50.754	1.9982	**42°**	66.913	2.6344
8°	13.917	.5479	**19.5°**	33.381	1.3142	**31°**	51.504	2.0277	**42.5°**	67.559	2.6598
8.5°	14.781	.5819	**20°**	34.202	1.3465	**31.5°**	52.250	2.0571	**43°**	68.200	2.6850
9°	15.643	.6159	**20.5°**	35.021	1.3788	**32°**	52.992	2.0863	**43.5°**	68.835	2.7100
9.5°	16.505	.6498	**21°**	35.837	1.4109	**32.5°**	53.730	2.1154	**44°**	69.466	2.7349
10°	17.365	.6837	**21.5°**	36.650	1.4429	**33°**	54.464	2.1443	**44.5°**	70.091	2.7595
10.5°	18.224	.7175	**22°**	37.461	1.4748	**33.5°**	55.194	2.1730	**45°**	70.711	2.7839
11°	19.081	.7512	**22.5°**	38.268	1.5066	**34°**	55.920	2.2016			
11.5°	19.937	.7849	**23°**	39.073	1.5383	**34.5°**	56.641	2.2300			
12°	20.791	.8185	**23.5°**	39.875	1.5699	**35°**	57.358	2.2582			

IV. Maintenance

Rotary parts, sliding parts should be lubricated periodically. For long term storage, clean, rinse and

lubricate the parts and pack them in plastic bags.

Inspection List

No	Item	Description	Tolerance	Meas.
1	Parallelism of upper surface of guide way to bottom surface		0.005/100	
2	Parallelism of upper surface of vise body to bottom surface		0.005	
3	Squareness of fixedjaw face and movable jaw face to base surface		0.005	
4	Paraiielism of two jaw faces in width direc-tion		0.005	