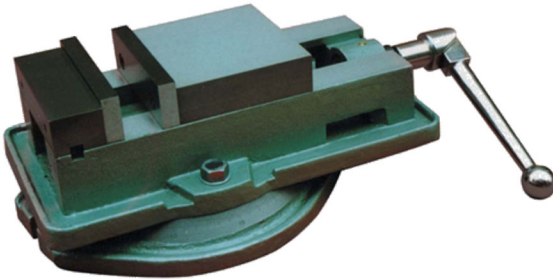


Precision Swivel Base Milling Vise



ITEM NO.	MODEL NO.
61-204-224	MH7241
61-204-225	MH7261
61-204-226	MH7267
61-204-228	MH7281

Version date: 05/20/2013

Please Read These Instructions Before Operating Your Machine
Contents Subject To Change Without Notice

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PACKING LIST

1. Vise, Handle, Keys and Bolts

GETTING STARTED

1. Unpack vise. Clean vise with a degreaser. Deburr the bottom of swivel base and bottom of vise to remove any burrs.
2. Check to make sure jaw bolts are tight.
3. Oil the vise on all surfaces.
4. If the moveable jaw ever gets hard to move you can adjust the clamping pressure. On the back of the moveable jaw it has a set screw you can use to adjust. Turn clockwise to tighten or counter clockwise to loosen.

MAIN USE AND PERFORMANCE

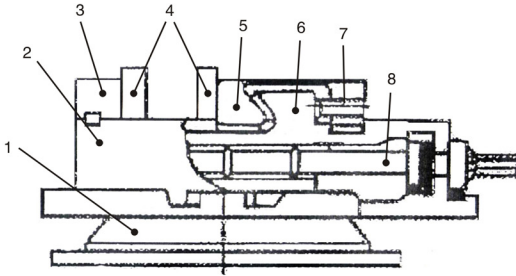
1. This product is for attachment to precision milling machines and grinders.
2. This vise uses a half sphere in the moveable jaw to apply downward pressure that keeps the material from moving up in the vise.
3. The jaws can be placed in four positions.

USES AND MAINTENANCE

1. The moveable jaw has an adjustment screw on the back of the jaw to maintain the correct pressure.
2. The vise must be oiled daily to maintain top performance.

MAIN STRUCTURE AND EXPLANATION

1. Main structure (See below figure)



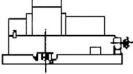
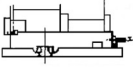
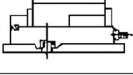
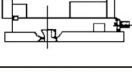
1	Base	5	Moveable Jaw
2	Body	6	Nut
3	Fixed Jaw	7	Adjust Screw
4	Hard Jaws	8	Screw

MAIN SPECIFICATION

MODEL #	MH7241	MH7261	MH7267	MH7281
Jaw Width	100	152	152	200
Jaw Height	34	45	45	60
Clamping Force	19KN	29KN	29KN	34KN
Location Width of Key	16	16	18	18
Bolt Width	14	18	18	18
Diameter of Bolt	M12	M16	M16	M16
Indexing Scale	1°	1°	1°	1°
Groove Center Distances	200	275	275	348
External Dimensions (L x W x H)	350 x 230 x 130	450 x 300 x 170	500 x 235 x 170	610 x 370 x 200
Weight (KGS)	18	33	35	55

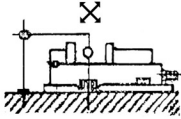
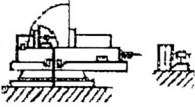
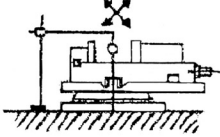
JAW OPENING

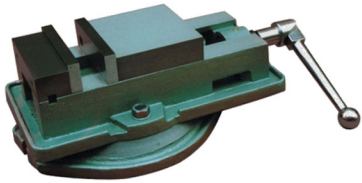
mm

MODEL #	MH7241	MH7261	MH7267	MH7281
	100	150	190	210
	150	215	255	290
	210	300	330	390
	260	370	400	470

ACCURACY TEST

mm

Testing item	Testing sketch	Accuracy
Parallelism of upper guide surface to support bottom of vise body		On a length of 100
		0.03
Perpendicularity of two jaws clamping surface to upper guide surface		0.050/100 ($\alpha < 90^\circ$)
Parallelism of upper guide surface to support bottom of base		On a length of 100
		0.05



TTC