

130MM & 75MM Self-Centering Vise Instruction Manual

For Part Numbers 5CV13041-IN, 5CV13045-IN, 5CV13049-IN, 5CV13051-IN

Usage and Maintenance

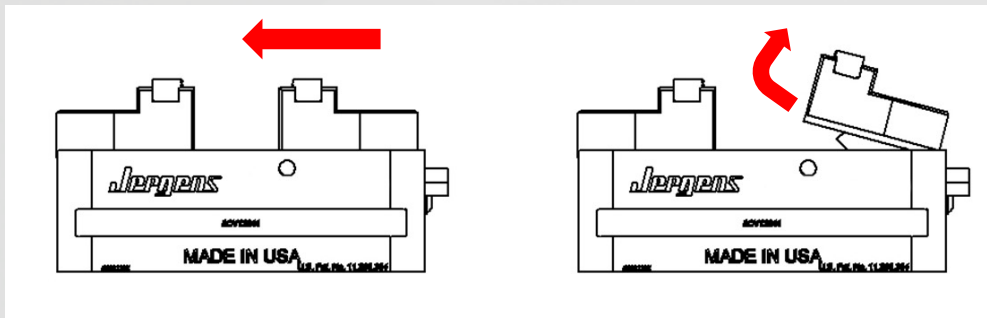
General Guidelines

- Keep the lead screw clean and clear of debris and chips. Use a nylon or soft wire brush to clean chips and debris off the leadscrew
- Do NOT over torque. Observe max torque marked on vise body
- Do NOT use impact guns or other power tools to operate vise
- Do NOT strike handle or vise with a mallet or hammer.
- When machining soft jaws, clamp on a small spacer block or shim with desired operating torque. This will stabilize the jaws during the modification process
- Keep lead screw well lubricated with anti-seize. Use Loctite LB C5-A or equivalent
- Use 6 point sockets on hex of lead screw, do NOT use 12 point sockets

Jaw Removal

Note: No tools are required to remove or install jaws.

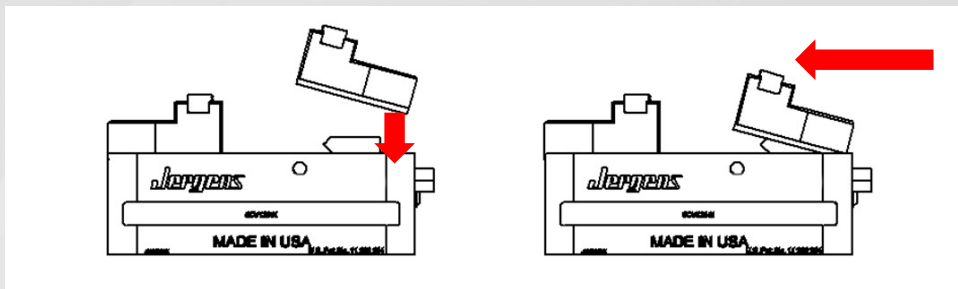
1. Turn lead screw to position jaws such that they are not overhanging vise body
2. Push jaw toward center of vise
3. Lift front of jaw off vise bed with a rotating motion



Jaw Installation

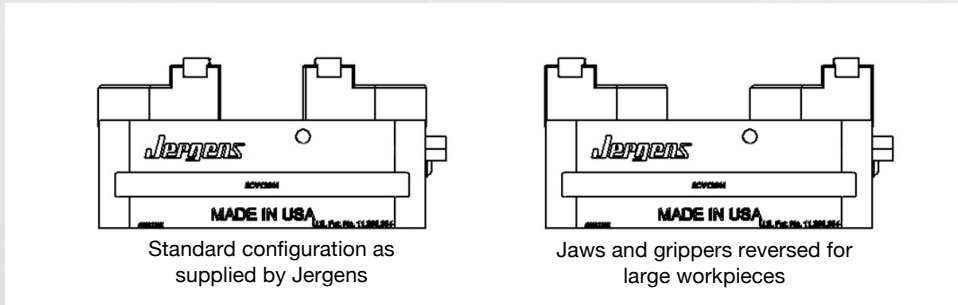
Note: All chips and debris must be cleaned from mating surfaces of jaw, truck, spring plunger and vise body prior to jaw installation.

1. Turn lead screw to position trucks such that they are approximately half closed
2. Align jaw by inserting back end of locating tang into vise body just behind the spring plunger
3. Push jaw toward center of vise until it snaps down onto vise bed



Reversible Jaws

Jaws and gripping inserts are fully reversible to accommodate different workpiece sizes.

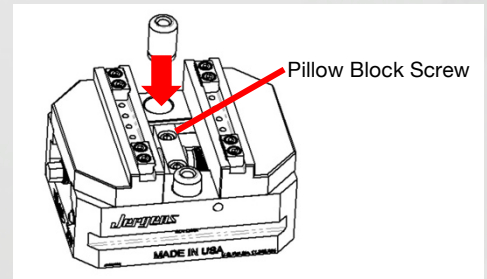


Centering

Vises come pre-centered from Jergens. In the event that the jaws need to be re-centered please use the following procedure:

1. Loosen both pillow block screws (DO NOT REMOVE) such that pillow block can freely move.
2. Insert (2) dowels in vise as shown. Dowel pins are supplied with vise. Refer to table for size.
3. Lightly clamp dowel pins.
4. Tighten pillow block screws to torque specified in table.
5. Loosen vise.
6. Remove dowel pins.

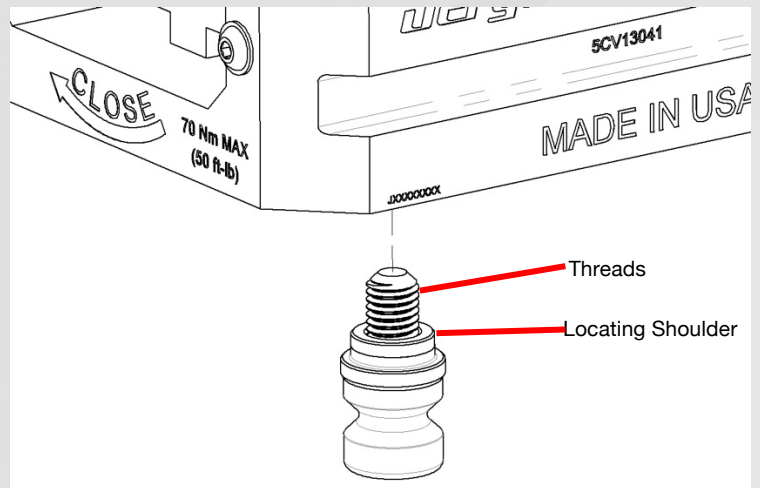
Vise Part Number	Dowel Pin Size	Pillow Block Screw Torque
5CV13041-IN	20mm	15 ft*lbs (20.3 Nm)
5CV13045-IN	20mm	15 ft*lbs (20.3 Nm)
5CV13049-IN	14mm	15 ft*lbs (20.3 Nm)
5CV13051-IN	14mm	15 ft*lbs (20.3 Nm)



Pull Stud Installation

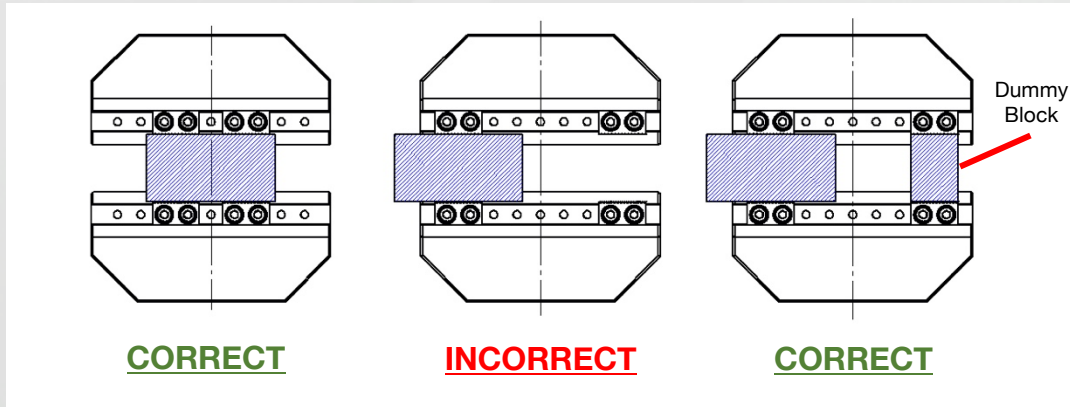
Vises can mount to Jergens Quick-Loc™ system on either a 52mm or 96mm pattern. 4 pull studs are required. Lubricate threads and locating shoulder with grease or anti-seize prior to installation. Ensure pull studs are fully seated against bottom surface of vise.

Pattern Spacing	Pull Stud Part Number	Installation Torque
52mm	QL-200800	13 ft*lbs (17.8 Nm)
96mm	QL-200805	25 ft*lbs (35 Nm)



Part Loading in Gripper Jaws

Proper part placement is critical to prevent unbalanced loading of the vise jaws. Excessive unbalanced loading of the jaws can adversely affect accuracy, clamp load and the lifespan of the vise. For best practice, place part for symmetric engagement of the grippers about the center line of the vise. If a part is needing to be clamped on only one side of the vise, use a dummy block of the same width to achieve symmetric gripper engagement.



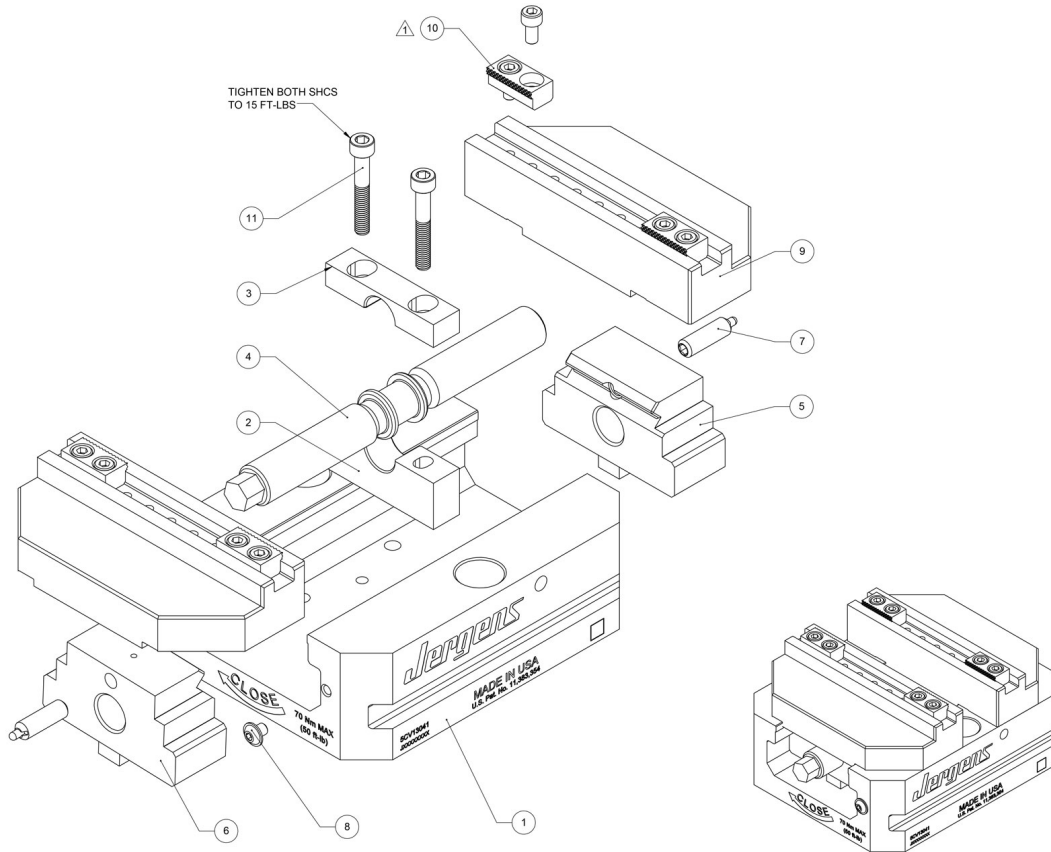
Storage

If a vise is to be unused for an extended amount of time, please follow these storage guidelines:

- Clean off all chips, debris and fluids (coolant)
- Lubricate all internal components with grease
- Spray or coat all external surfaces with rust preventative
- Store in dry/climate controlled environment
- Re-use original packaging if available

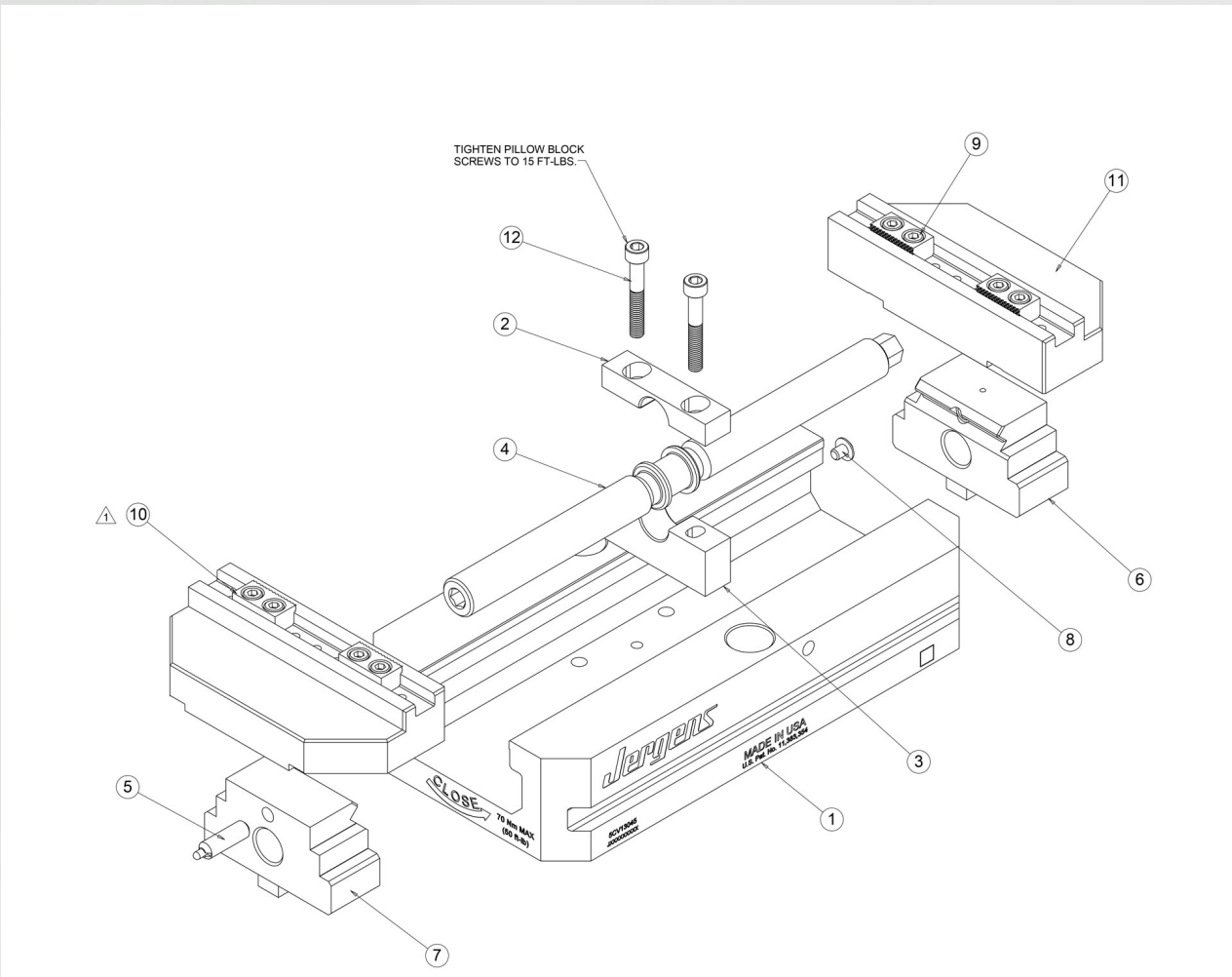
Replacement Parts 5CV13041-IN

ITEM NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	774077	VICE BASE, 130MM X 160MM, QL 96/52
2	1	774079	PILLOW BLOCK, M18, LOWER
3	1	774078	PILLOW BLOCK, M18, UPPER
4	1	774080	LEAD SCREW, TR M18X2
5	1	774082	TRUCK, TR M18x2, RH
6	1	774081	TRUCK, TR M18x2, LH
7	2	26853	SPRING PLUNGER, M8 X 1.25, HF
8	1	770149	M5 X 0.8 X 6MM LG, FBHCS
9	2	774085	JAW, INSERT, 130mm
10	4	5JISER1.0	JAW, INSERT, SERRATED 1.0 LG
11	2	771338	M6 X 1.0 X 40MM, SHCS



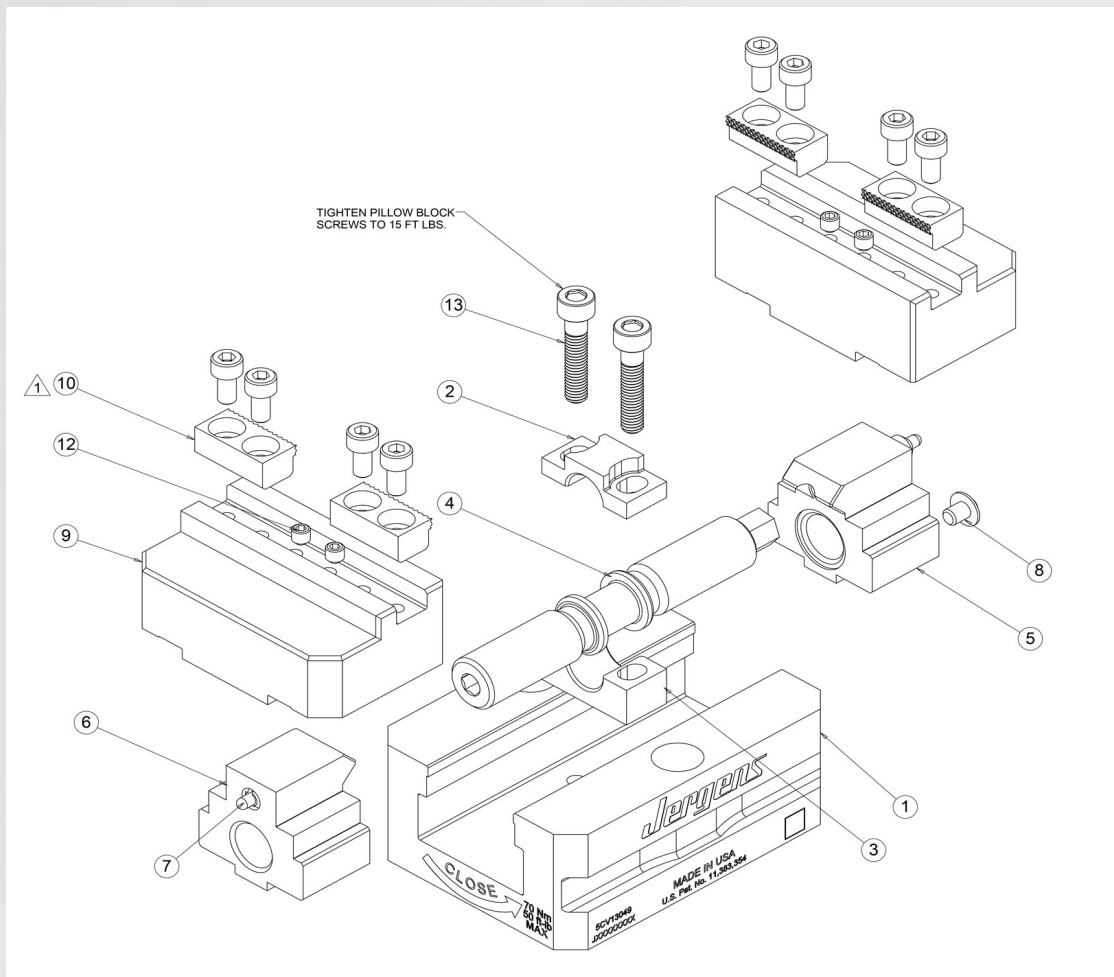
Replacement Parts 5CV13045-IN

ITEM NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	774092	WISE BASE, 130MM X 250MM, QL 96/52
2	1	774078	PILLOW BLOCK, M18, UPPER
3	1	774079	PILLOW BLOCK, M18, LOWER
4	1	774086	LEAD SCREW, TR M18X2
5	2	26853	SPRING PLUNGER, M8 X 1.25, HF
6	1	774081	TRUCK, TR M18X2, LH
7	1	774082	TRUCK, TR M18X2, RH
8	1	770149	M5 X 0.8 X 6MM LG, FBHCS
9	8	771954	M5 X 0.8 X 10MM LG SHCS
10	4	5JISER1.0	JAW INSERT, SERRATED 1.0 LG
11	2	774085	JAW, INSERT- 130MM
12	2	771338	M6 X 1.0 X 40MM, SHCS



Replacement Parts 5CV13049-IN

ITEM NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	774094	WISE BASE, 75MM X 100MM, QL 52
2	1	774096	PILLOW BLOCK, UPPER
3	1	774097	PILLOW BLOCK, LOWER
4	1	774098	LEAD SCREW, TR M16X2
5	1	774099	TRUCK, Tr M16X2, LH
6	1	774100	TRUCK, Tr M16X2, RH
7	2	26853	SPRING PLUNGER, M8 X 1.25, HF
8	1	770149	M5 X 0.8 X 6MM LG, FBHS
9	2	774108	JAW, INSERT, 75mm
10	4	5JISER1.0	JAW INSERT, SERRATED 1.0 LG
12	4	774113	M5 X 0.8 X 5MM X LG CPSS
13	2	770244	M6 X 1.0 X 30MM, SHCS



Replacement Parts 5CV13051-IN

ITEM NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	774120	WISE BASE, 75MM X 160MM, QL 52
2	1	774096	PILLOW BLOCK, UPPER
3	1	774097	PILLOW BLOCK, LOWER
4	2	774095	M6 X 1.0 X 30MM, SHCS
5	1	774119	LEAD SCREW, TR M16X2
6	1	774100	TRUCK, TR M16X2, RH
7	1	774099	TRUCK, TR M16X2, LH
8	2	26853	SPRING PLUNGER, M8 X 1.25, HF
9	1	770149	M5 X 0.8 X 6MM LG, FBHCS
10	2	774108	JAW, INSERT, 75MM
11	4	5JISER1.0	JAW INSERT, SERRATED 1.0 LG
12	4	774113	M5 X 0.8 X 5MM LG CPSS

