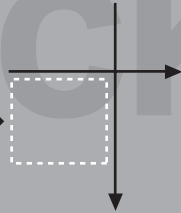


Revision january 2006

Fablock
www.fablock.com



Precision tool maker

USER HANDBOOK



FABLOCK

Precision tool maker

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Commitment

Every Fablock vise comes with a guarantee of exceptional performance, speed and precision that is second to none thanks to its vertical push-down jaws that ensure accurate reference points at all times.

Features and Benefits

- . High-quality alloyed steel.
- . Tempered at 58-60 HRC.
- . Accurate adjustments on all 4 sides.
- . Fit for upright, flat, or side mounting.
- . Fast mobile jaw.
- . Push-down movement occurs simultaneously on both jaws.
- . Reference points remain accurate at all times.
- . High-pressure grip.
- . Maximum opening can be over-sized on demand.
- . Modular.
- . Easy to clean.
- . 5-years limited warranty.



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Thank You

Thank you for choosing Fablock's precision vise.

Fablock vises are designed to significantly increase efficiency and productivity.

It is essential that users read the recommendations found in this handbook to ensure utmost precision and proper functioning for every component. With minimal maintenance, your Fablock vise is sure to give you complete satisfaction.

TECHNICAL ASSISTANCE

IF you have a problem with your FABLOCK vise, contact our office at (819) 694-7660 from 08:00 to 17:00 monday to friday.

Mounting recommendations

1- Fablock clamps are recommended, but standard clamps may also be used if care is given to ensuring the proper functioning of the vise's slide components.

2- Clamps must be mounted at a minimum distance of 3" from both extremities of the vise when clamping workpieces measuring 6" or less. See Figure A.

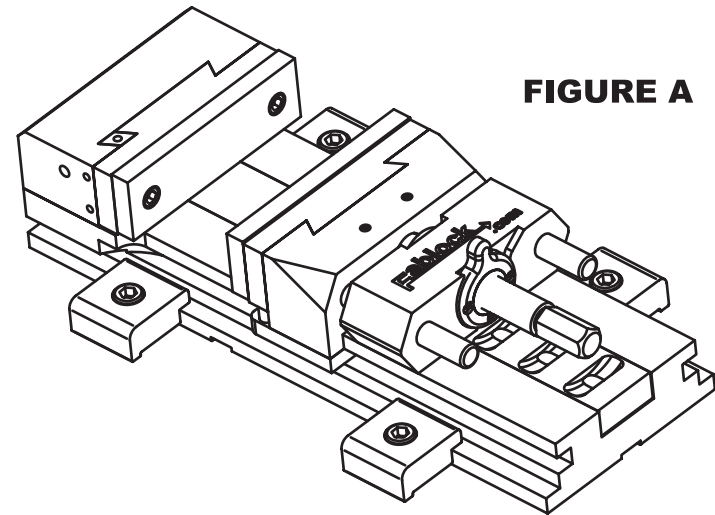
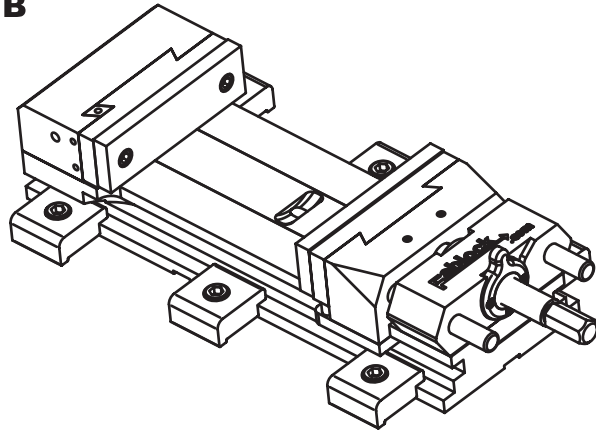


FIGURE A

3- For workpieces measuring 6" or more, it is recommended that clamps be added at the centre of the vise. This is especially recommended for pieces that are difficult to work, or when using over-sized tools. See Figure B.

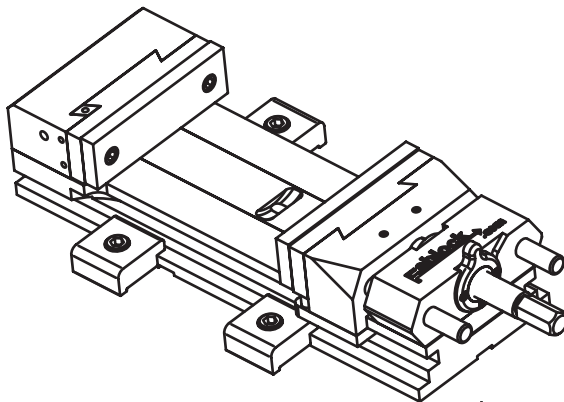
FIGURE B



4- It is recommended that clamps be moved closer to the centre of the vise, as seen in Figure C, for aluminium workpieces measuring 6" or more.

This should also be applied to finish-machining or to any cut requiring particular attention and precision.

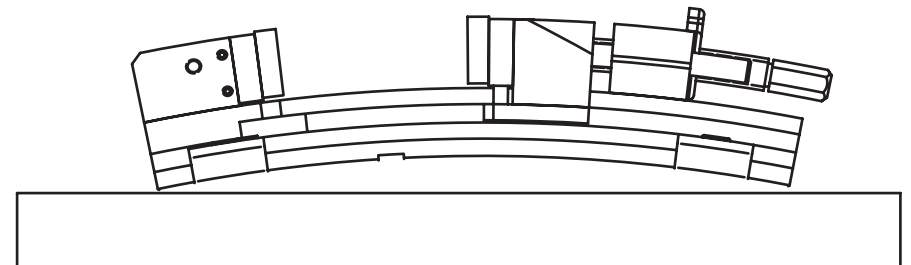
FIGURE C



It is essential that the user read these basic recommendations carefully, as a poorly clamped vise may result in distortion and prevent its proper functioning.

To sum up, clamps should be brought as close as possible to the workpiece for each and every mounting.

Inadequate clamping



Other recommendations

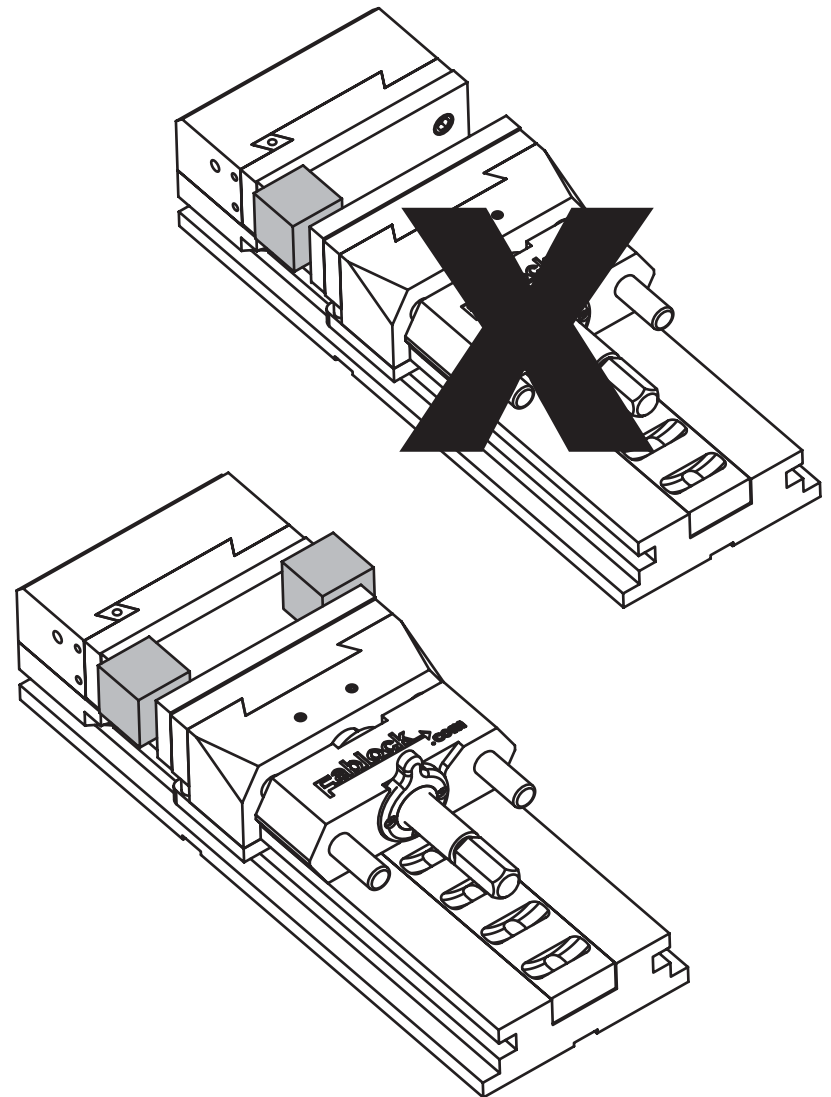
When using the Fablock vise under extreme conditions, when clamping large workpieces or for a rapid feed requiring a great deal of support strength, it is not recommended to use a hammer against the clamp arm. Instead, a longer force arm should be used. This will lead to the same result, without creating vibrations that can counter-act the vise's push-down mechanism and, consequently, disturb the reference points.

This vise is designed to produce a maximum clamping force of 9,200 lbs.

Torque wrench setting: 115 lbs/ft.

These recommendations should be followed carefully as they will not only ensure the proper functioning of the vise but also help protect the vise's 5-year warranty.

What to do and what not to do

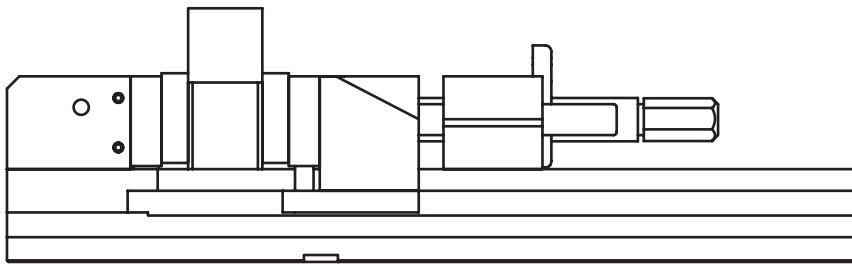


Exemption

The Fablock vise is designed to minimize the need for a hammer when holding workpieces against the back end of the vise or against liners.

A hammer may be necessary, however, when the workpiece is held against the upper portion of the jaws, or if the liners do not appear to be offering adequate support. Here, a light touch of the hammer will suffice.

See illustration below

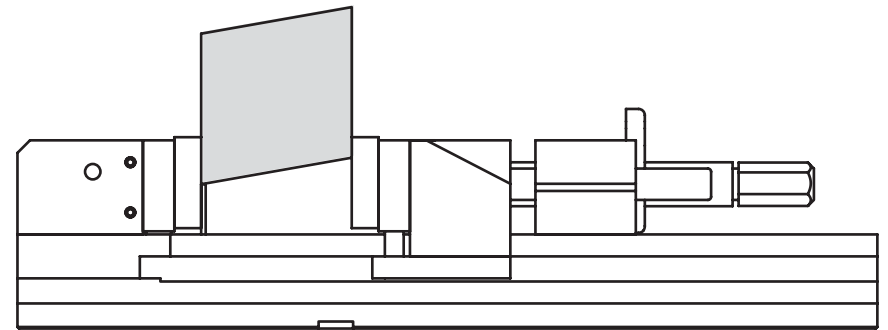


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Rough or misshapen workpieces

Clearly, workpieces that are rough or misshapen will not always find adequate vise support, with or without liners. In such cases, a single liner used on the fix-jaw side may become necessary. Here, the workpiece should be clamped at 90 degrees from both the fixed-jaw, which is extremely precise, and from the top part of the workpiece.

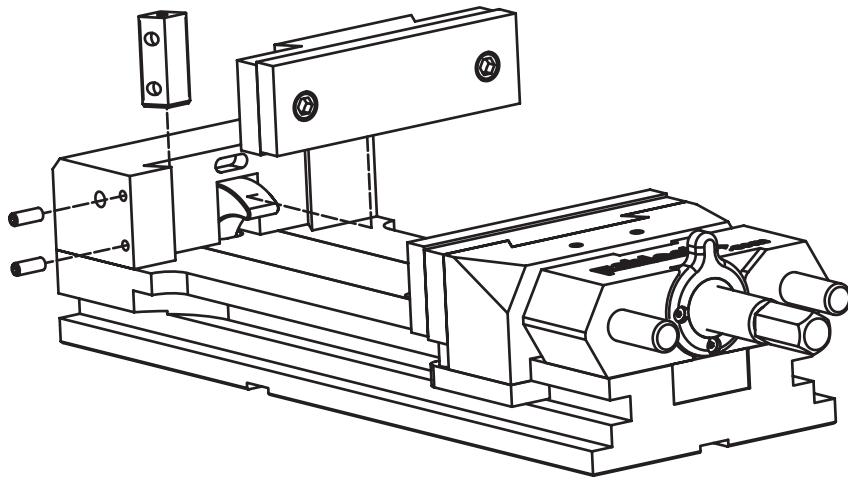
See illustration.



Note: If the workpiece includes sides that are not perpendicular, and whether or not it is held by smaller, secondary liners, the vise will not correctly push the piece toward the back end, as it is held only by a single liner. In such cases, a hammer becomes useless in pushing back the workpiece due to its non-perpendicularity and will have no effect, as the workpiece is held by only a single liner.

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Stationary dovetail jaw maintenance

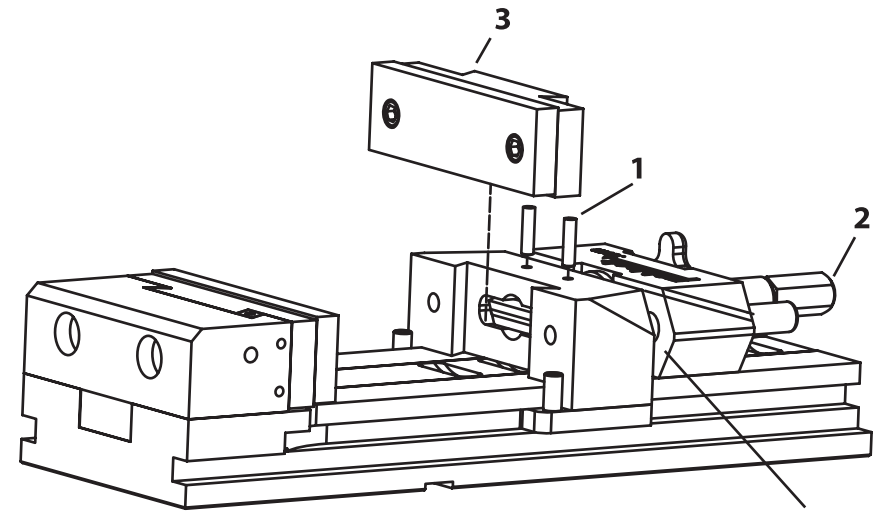


This vise is designed to allow the dismantling of the stationary dovetail jaw for maintenance purposes without having to remove the vise from the machine, and without altering reference points for the workpiece. This eliminates the loss of time associated with removing the vise, re-installing it, and resetting reference points.

Removing the stationary jaw:

Simply remove the screws (1) that secure the gib; remove the adjustment gib (2) with a 1/4-20 bolt by lifting it upwards; remove the stationary dovetail jaw (3) by gently sliding it to the side. For peak performance, the stationary jaw's slides must be thoroughly cleaned and lubricated with high-quality grease before reassembling the vise by following these instructions in reverse order.

Moveable jaw maintenance



See Note *

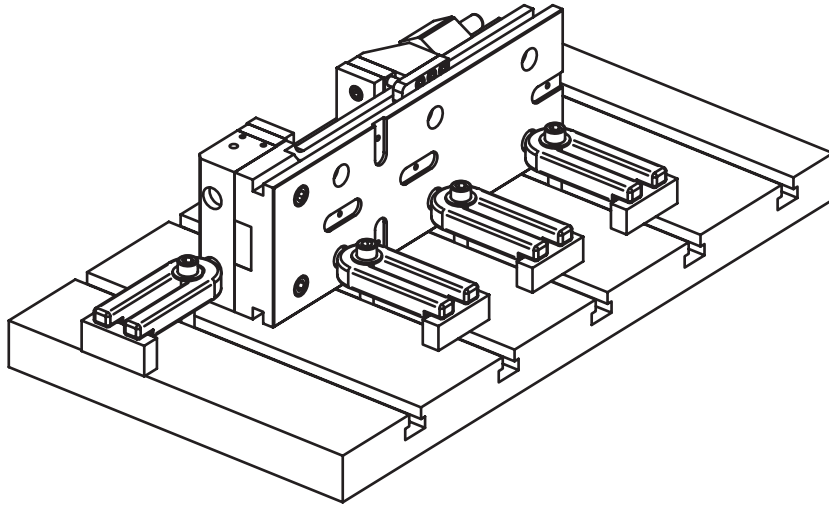
Removing the moveable jaw:

Simply remove the BLOCK ANGLE screws (1); firmly hold down the moveable dovetail jaw (3) while loosening and removing the tightening screw by hand (2) until it reaches its limit; release the moveable dovetail jaw (3) and removed it from the top (**be careful not to loose the springs found in both cavities underneath the moveable dovetail jaw (3)**). These springs are normally held in place with grease. For peak performance, the moveable jaw's slides must be thoroughly cleaned and lubricated with high-quality grease before reassembling the vise by following these instructions in reverse order.

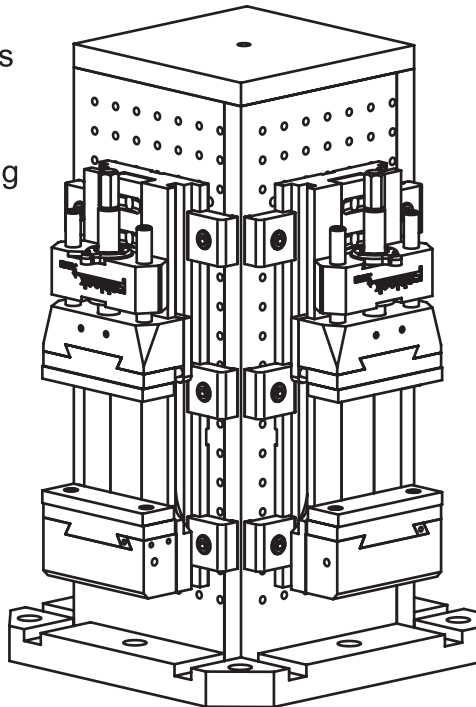
*Note:

An approximate distance of 0.5" must be kept between the positioning block and the moveable jaw at all times to allow the free movement of the tightening screw (2).

Side and upright mounting.



All Fablock vises can be mounted sideways or upright using the appropriate clamps or specially designed bracing components, especially when mounting the vise upright.



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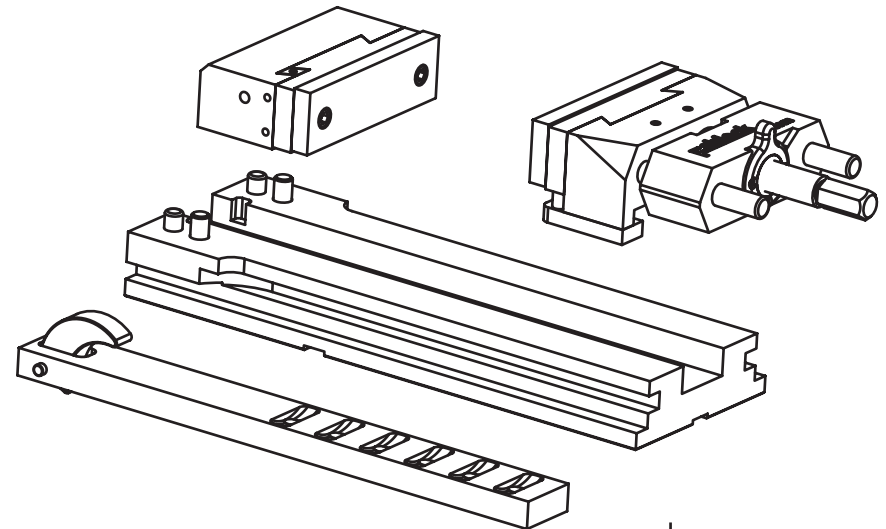
Modular and why

Firstly, all Fablock vise components are designed for use with other Fablock vise models without the need for special adjustments.

Example: In case of accidental breakage, you need only return the damaged component for replacement, not the entire vise.

Secondly, and given the flexibility of a modular vise, the base can be over-sized on request to offer a maximum opening.

Example: A standard 6" vise can accommodate an 8¼" work-piece. Should this prove insufficient for your needs, you may request an over-sized base that can handle larger pieces (optional). Fablock will send you a submission for the new base without changing any other component.



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