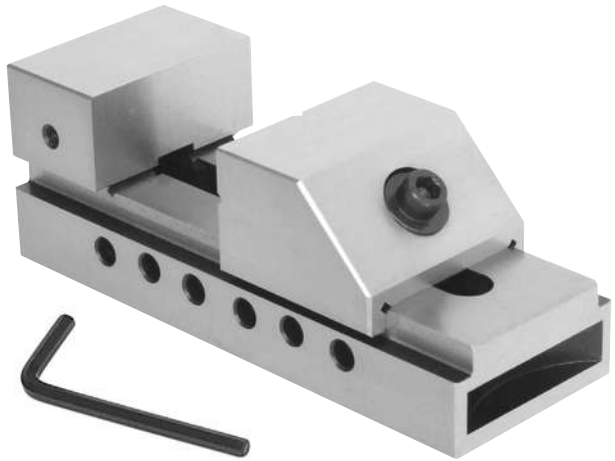
Packing List:	Qty
1. ATLAS Toolmaker's Vice Groove Jaw	1
2. Hex. Key. - 5mm	1
3. Instructions/Quality Certificate/Packing List	1



ATLAS Works,
Wigston, Leicester, England

ATLAS WORKHOLDERS

Certificate of Quality

This Toomaker's Vice Type TGJ050 has been tested and approved for sale by:

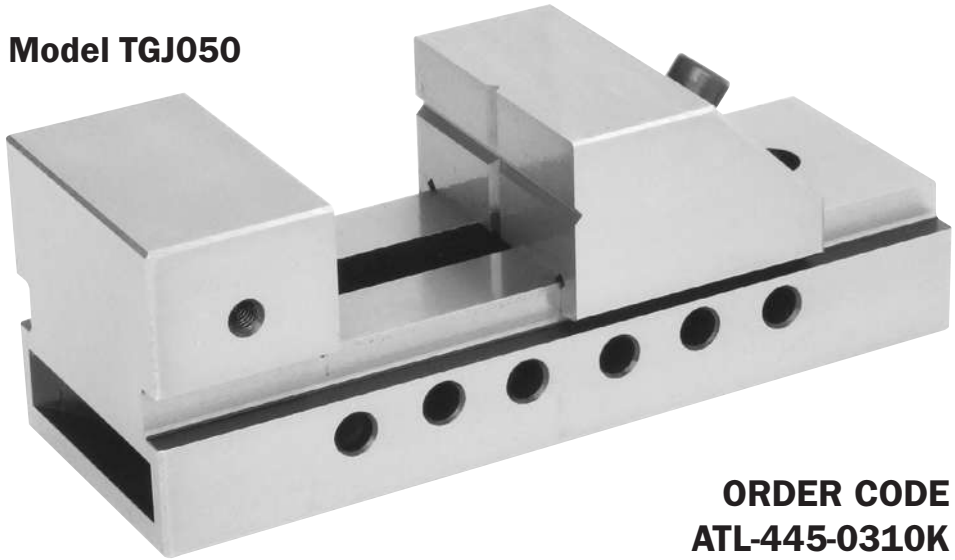
Inspector: Date:

ATLAS WORKHOLDERS

Instructions for PRECISION TOOLMAKERS VICE

50 x 65 x 25mm - Accuracy 0.005mm

Model TGJ050



ORDER CODE
ATL-445-0310K

Always read instructions before use!
& retain for future reference

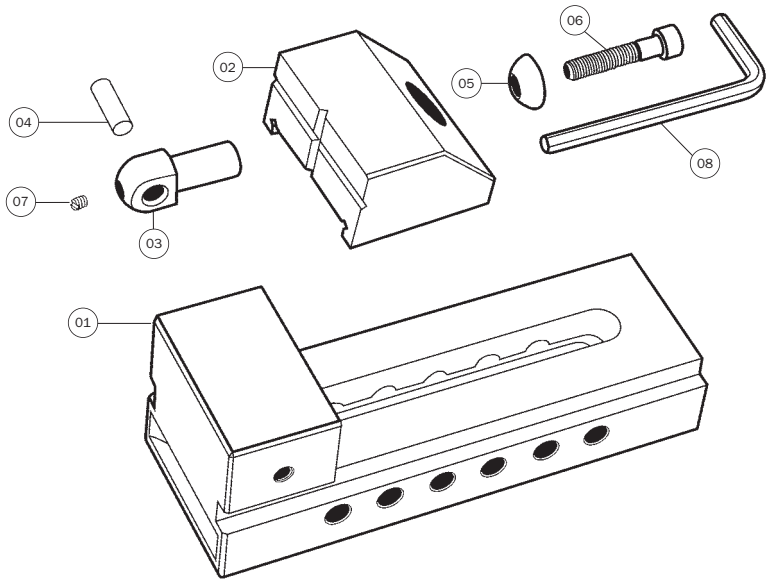
ATLAS Toolmaker's Vices are produced using the finest quality Alloy Steel, machined to give a smooth surface before hardening for durability.
The Vice has a quick release mechanism with a high clamping force making it ideal for measurement and inspection.

Main Technical Specifications

MODEL	Jaw width	Jaw Depth	Spread	Length	Weight
TGJ050	50	25	65	140	1.6kg

Components:

1. Body
2. MovEable Jaw
3. Jaw Adjusting Arm
4. Jaw Adjusting Pin
5. Clamping Ring
6. Socket Head Cap Screw 5mm
7. Slotted Grub Screw
8. Hex Key - 5mm



Note: This is a Precision Vice.
To ensure the best results, the work table accuracy should be within 0.005mm.

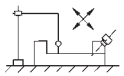
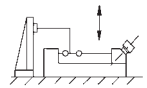
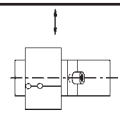
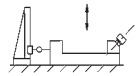
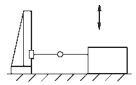
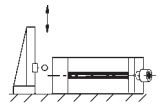
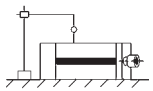
Instructions:

1. Choose the correct size vice for the intended workpiece and locate it on the table, fixing with clamping inserts.
2. Release the Jaw 02, by loosening Socket Head Cap Screw 06.
3. Move Jaw 02 to the correct position for the size of work being undertaken. (locating the Jaw Adjusting Pin 04 in the correct groove).
4. Tighten the Socket Head Cap Screw 06 onto the Clamping Ring 05 which tightens the Moveable Jaw 02, clamping the workpiece.

Maintenance

All parts should be lubricated regularly. If the Vice is to be stored for a long time, all parts must be cleaned, coated with oil and packed in plastic bags.

Inspection Check List

	Check	Diagramatic	Tolerance (mm)	Result
1	Parallelism of the upper body surface of the guide way to the base surface		0.005/100mm	
2	Squareness of the fixed jaw face and moveable jaw face to the base surface		0.005mm	
3	Parallelism of the two jaws in the width direction		0.005/100mm	
4	Squareness of the end face of the body to the base surface		0.012mm	
5	Squareness of the two sides of the body to the base surface		0.008mm	
6	Squareness of the body end face to the sides		0.008mm	
7	Parallelism of the two sides of the body in the length direction		0.005/100mm	