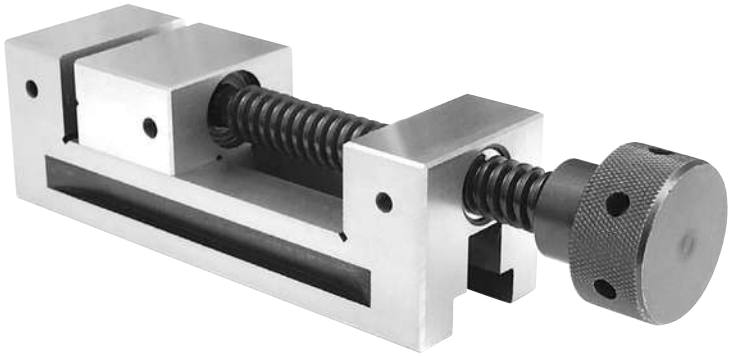
Packing List:	Qty
1. ATLAS Toolmaker's Vice Groove Jaw	1
2. Instructions/Quality Certificate/Packing List	1



ATLAS Works,
Wigston, Leicester, England

ATLAS WORKHOLDERS

Certificate of Quality

This Toomaker's Vice Type

PTV063 ☐

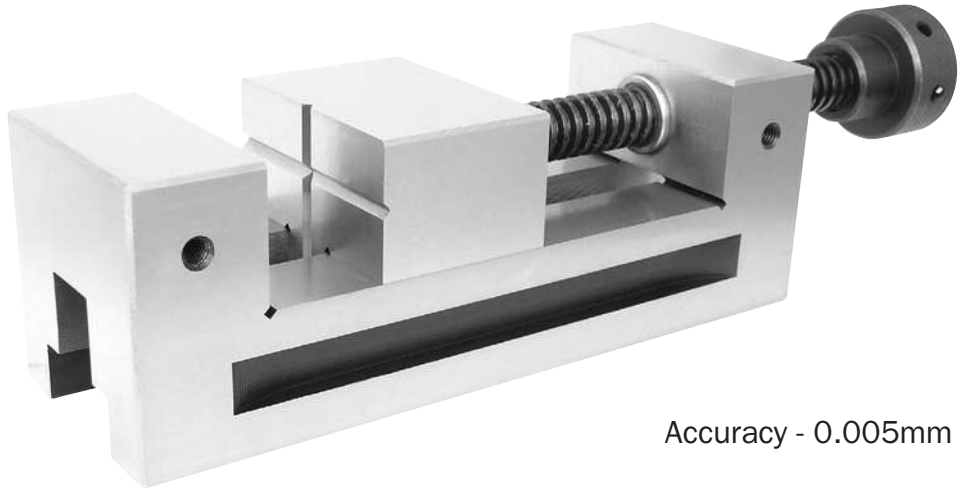
PTV100 ☐

has been tested and approved for sale by:

Inspector: Date:

ATLAS WORKHOLDERS

Instructions for TOOLMAKERS VICES



Accuracy - 0.005mm

Model	ORDER CODE
PTV063	ATL-445-2010K
PTV100	ATL-445-2050K

Always read instructions before use!
& retain for future reference

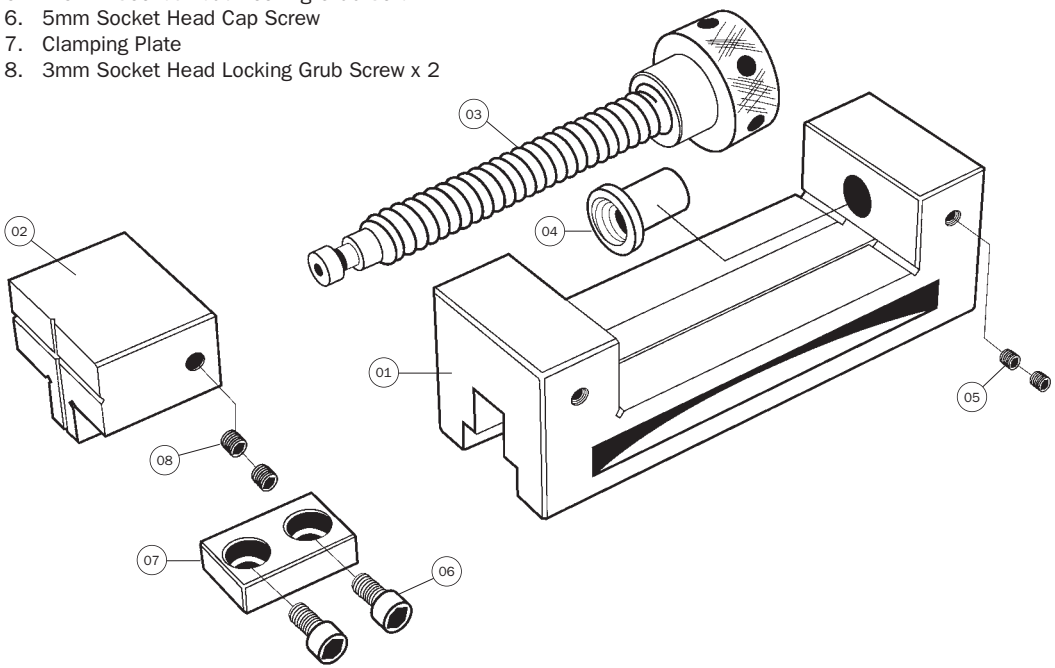
ATLAS Toolmaker's Vices are produced using the finest quality Alloy Steel, machined to give a smooth surface before hardening for durability.
The Vice has a quick release mechanism with a high clamping force making it ideal for measurement and inspection.

Main Technical Specifications

MODEL	Jaw width	Jaw Depth	Spread	Length	Weight
PTV063	63	32	85	190	4.15kg
PTV100	100	45	125	260	12.3kg

Components:

1. Body
2. Moveable Jaw
3. Lead Screw
4. Brass Sleeve
5. 2.5mm Socket Head Locking Grub Screw x 2
6. 5mm Socket Head Cap Screw
7. Clamping Plate
8. 3mm Socket Head Locking Grub Screw x 2



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

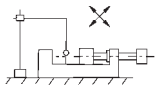
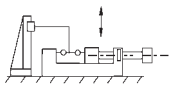
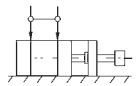
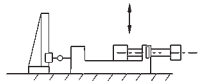
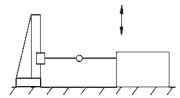
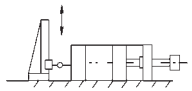
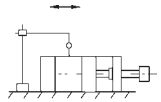
Instructions:

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 turning the Lead Screw 03 anti-clockwise.
3. Move Jaw 02 to the correct position for the size of work being undertaken and tighten by turning the Lead Screw 03 clockwise.

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 Checklist

	Check	Diagramatic	Tolerance (mm)	Result
1	Parallelism of the upper 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		0.008mm	
5	Squareness of the two sides of the body to the base surface		0.005/100mm	
6	Squareness of body end face to sides		0.008mm	
7	Parallelism of the two sides of the body in the length direction		0.005/100mm	