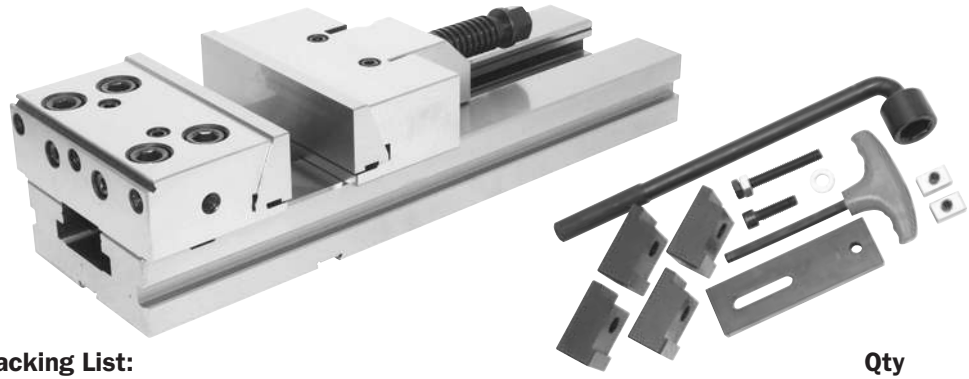


**Packing List:** **Qty**

| | | |
|---|---|---|
| 1. | INDEXA Modular Precision Vice | 1 |
| 2. | Box Wrench | 1 |
| 3. | 'T' Hex. Wrench | 1 |
| 4. | Vice Holding Clamps | 4 |
| 5. | Work Stop with Main Bolt | 1 |
| 6. | Positioning Key Nuts with Screws | 2 |
| 7. | Instructions/Quality Certificate/Packing List | 1 |

**INDEXA Machine Tools, Wigston, Leicester, England**

INDEXA™

## Certificate of Quality

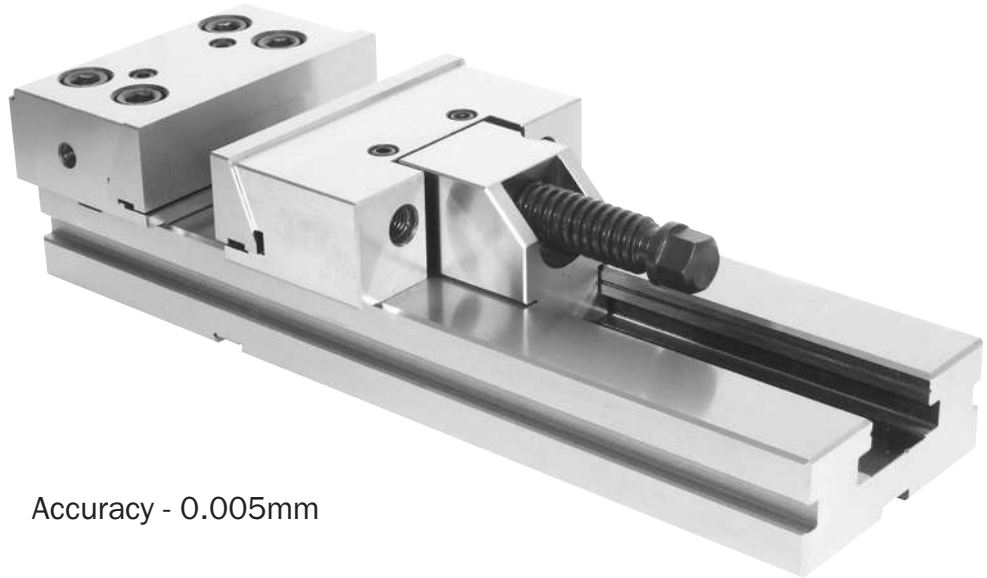
This Vice has been tested and approved for sale

Type PVM100 ☐
PVM125 ☐
PVM150 ☐
PVM150X ☐
PVM200X ☐

Inspector: Date:

INDEXA™

# Instructions for Modular Precision Machine Vices



Accuracy - 0.005mm

| MODEL | ORDER CODE |
|---|---|
| PVM100 | IND-445-0600K |
| PVM125 | IND-445-0620K |
| PVM150 | IND-445-0640K |
| PVM150X | IND-445-0660K |
| PVM200 | IND-445-0690K |

**Always read instructions before use!**

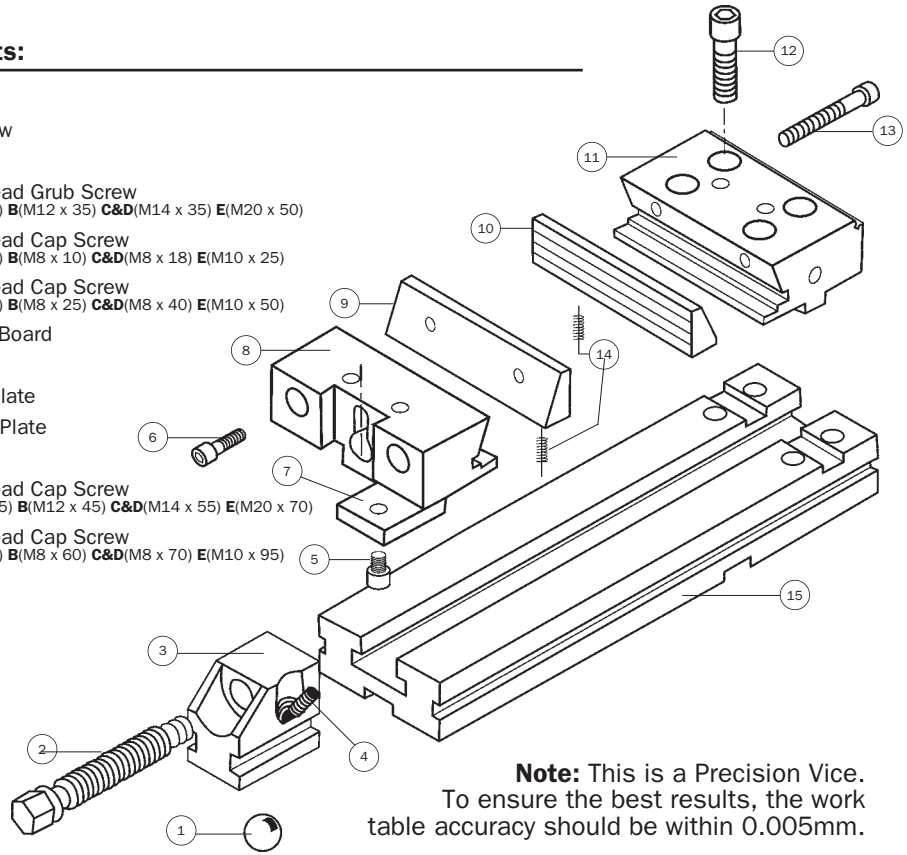
**INDEXA** Modular Precision Vices are produced using the finest quality Alloy Steel, machined to give a smooth surface before hardening for durability.
The adjustable base, fixed jaw and live jaw provide precision accuracy combined with the flexibility of fine adjustment. Ideal for use on CNC and other machines.

**Main Technical Specifications**

| * | MODEL | Jaw width | Jaw Depth | Spread | Length | Weight |
|---|---|---|---|---|---|---|
| **A** | PVM100 | 100 | 30 | 100 | 270 | 8.60kg |
| **B** | PVM125 | 125 | 40 | 150 | 345 | 15.10kg |
| **C** | PVM150 | 150 | 50 | 200 | 420 | 29.20kg |
| **D** | PVM150X | 150 | 50 | 300 | 520 | 32.90kg |
| **E** | PVM200X | 200 | 65 | 300 | 595 | 86.00kg |

**Components:**

1. Steel Ball
2. Lead Screw
3. Rack
4. Socket Head Grub Screw
   * **A**(M8 x 25) **B**(M12 x 35) **C&D**(M14 x 35) **E**(M20 x 50)
5. Socket Head Cap Screw
   * **A**(M6 x 20) **B**(M8 x 10) **C&D**(M8 x 18) **E**(M10 x 25)
6. Socket Head Cap Screw
   * **A**(M6 x 25) **B**(M8 x 25) **C&D**(M8 x 40) **E**(M10 x 50)
7. Clamping Board
8. Live Jaw
9. Live Jaw Plate
10. Fixed Jaw Plate
11. Fixed Jaw
12. Socket Head Cap Screw
    * **A**(M12 x 35) **B**(M12 x 45) **C&D**(M14 x 55) **E**(M20 x 70)
13. Socket Head Cap Screw
    * **A**(M6 x 65) **B**(M8 x 60) **C&D**(M8 x 70) **E**(M10 x 95)
14. Spring
15. Body




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

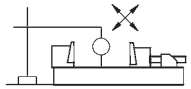
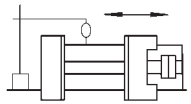
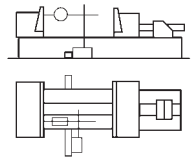
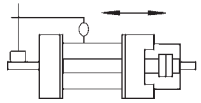
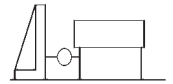
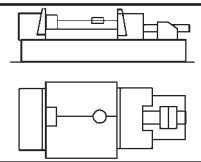
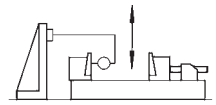
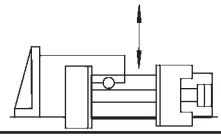
**Maintenance**

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.

**Instructions:**

1. Choose the correct size vice for the intended workpiece and locate it on the table, fixing with clamping inserts.
2. Release the Rack (3), by loosening Socket Head Grub Screw (4).
3. Move Rack (3) to the correct position for the size of work being undertaken. (listen for the Steel Ball (1) locating down in the set hole).
4. Tighten the Socket Head Grub Screw (4) onto the Steel Ball (1) which holds the Rack (3) in position.
5. Place the workpiece in position and turn Lead Screw (2) to move the Live Jaw, clamping the workpiece.

**Inspection Checklist**

| | Check | Diagramatic | Tolerance (mm) | Result |
|---|---|---|---|---|
| 1 | Parallelism of the upper body surface to the base surface |  | 0.005/100mm | |
| 2 | Parallelism of two sides in spread direction |  | 0.005/100mm | |
| 3 | Parallelism of the fixed jaw plate to the transverse slot on the bottom |  | 0.01/100mm | |
| 4 | Parallelism of the lengthwise slot's centre surface to the sides |  | 0.01/100mm | |
| 5 | Squareness to the two sides to the base surface |  | 0.008mm | |
| 6 | Parallelism error of jaw plates |  | 0.005/100mm | |
| 7 | Squareness of the two jaw plates to the base surface |  | 0.005mm | |
| 8 | Squareness of the fixed jaw plate to the sides |  | 0.02mm | |