



# TILT TABLE MACHINE VICE

OPERATION      MANUAL

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## OPERATION MANUAL

Model QBK Tiltable Machine Vices are designed in rotary and tilting structure, featuring good rigidity, great clamping force, high stability and reliability as well as wide opening. They are good at strong cutting and ideal attachments for shaping machines. They can also be used as an accessory on other machine tools like milling machines, drilling machines and grinding machines etc.

With the same rotary and tilting structure as QHK, the Model QHK tiltable machine vices adapt closed lead screw to ensure good rigidity and high stability and reliability. Being easy in operation, they are the general-purpose attachments for miller and grinder as well as for other machining processes like milling, shaping, grinding and drilling etc.

The vice body can be indexed through 90 degrees in vertical direction along large arcshaped guide way of swivel disc which can be indexed through 360 degrees in horizontal direction on the base, through which any combination of angles can be obtained to suit the machining of various angles, faces, grooves and holes etc.

## Main Specification

During operation the machine vice should be located on the machine table with the locating key and tightened up.

After vicebody is indexed in the vertical, first screwdown the knurled screw, then tighten up the nuts of hold-down. Indexed in the horizontal, and tightened up the swivel plate.

When clamping and unclamping the workpiece, do not hit with a hammer, other wise the vice will be lost the original accuracy.

In order to ensure operation smart, all movable parts should be often lubricated.

Model	QHK 100	QHK 125	QBK 125	QHK 160
Width of jaw mm	100	125	125	160
Max. opening of jaw mm	80	100	140	125
Height of jaw mm	40	45	45	50
Width of locating key mm	14	14	14	18
Width of the square of the thread spindle mm	17	17	17	17
Diameter of fastening bolts mm	M12	M12	M12	M16
Graduations between vice body and base	1°	1°	1°	1°
Max. angle of front inclination of vice body	90°	90°	90°	90°
Overall dimensions (L × W × H) mm	319 × 182 × 148	372 × 230 × 152	418 × 230 × 162	434 × 250 × 196
Weight. kg	19	29	29	43

# TEST CERTIFICATE

Model

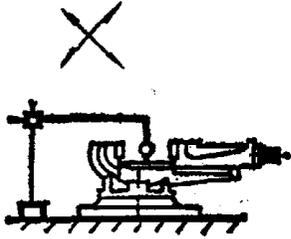
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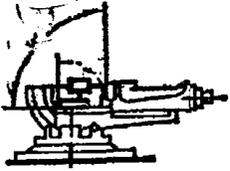
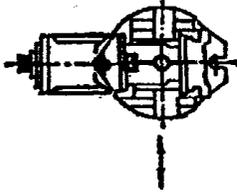
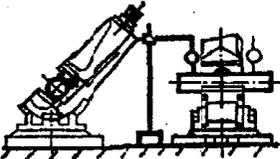
This product has been tested and found to be in conformity with our technical standard and approved for delivery.

Chief of Inspection Division    Work Manager

Date

## Accuracy Test

Item No.	Matters Tested	Testing Sketch	Accuracy mm	
			Allowable Error	Actual Error
1	Parallelism of upper guide surface to base		On a guide plane length of per100	
			0.060	qualified

Item	Matters Tested	Testing Sketch	Accuracy mm	
			Allowable Error	Actual Error
2	Perpendicularity of fixed jaw and movable jaw upper guide surface of vice body		On a length of 100	
			0.05	qualified
			$\alpha \leq 90^\circ$	
3	Parallelism between movable jaw & fixed jaw in the direction of width		On a length of 100	
			0.050	qualified
4	Parallelism of bar between jaws to the base in the direction of inclined vice body 30° & 60°		On a length of 100	
			0.080	qualified

## PACKING LIST

No.	Name	Specification or symbol				Quantity
1	Tiltable mach inevice	QHK 100	QHK 125	QBK 125	QHK 150	1 set.
2	Handle	17 × 17		17 × 17		1 pce.
3	T - slot bolts	M12 × 40		M16 × 55		2 pce.
4	Hexagon nuts	M12		M16		2 pce.
5	Washers	B12		B16		1 pce.
6	Technical Documents: Operation Manual, Test Certificate; packing List					1 copy.

Inspector

Date **0306**