

INSTRUCTIONS MANUAL

High Precision Machine Vice SIMPLE AND RELIABLE



Manufactured by :

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Manufactured in India under Licence from
ALLMATIC - Jakob Spannsysteme GmbH, Germany



QUALITY CREATES TRUST

CLAMPING POWER

| | TORQUE | CLAMPING FORCE |
|----------|--------|----------------|
| Size 125 | 85 Nm | 35 kN |
| Size 160 | 120 Nm | 50 kN |

To ensure safe fixing of the workpiece, & to generate uniform repetitive clamping force we recommend using a torque wrench.



Never exceed the specified torque, because overloading the components will reduce their working life substantially.



Never use hammers or extensions or screwdrivers.

MAINTENANCE



In case where compressed air is used, distributed metal chips and coolant spray can pose the risk of injury.

Clean using a brush, chip extractor or chip removing hook.

After a long period of use, we recommend dismantling the basic vice and giving it a thorough cleaning. In doing so, check the flat point for wear and tear.

Replace where oblateness exceeds 4 mm in diameter, as the specified clamping force will otherwise not be reached.

After cleaning all the components, oil all the sliding surface.

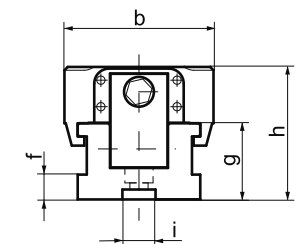
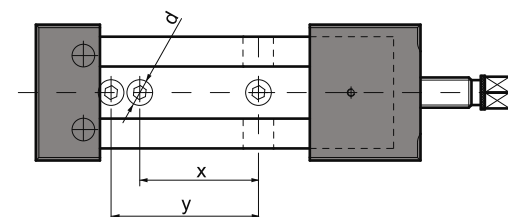
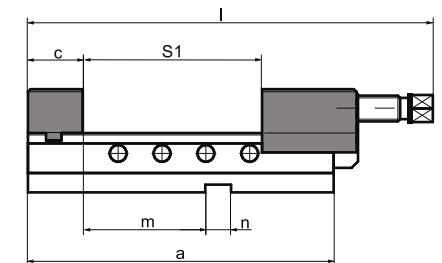
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TECHNICAL DATA

| TYPE | | 125 | 160 |
|-----------------------------------|-------|-------|-------|
| Dimensions Tolerances in mm | a | 310 | 405 |
| | b | 124 | 160 |
| | c | 50 | 66 |
| | d | 13 | 13 |
| | f | 15 | 15 |
| | g | 48 | 56 |
| | h | 87.5 | 105.5 |
| | i | 20 | 20 |
| | l max | 426 | 483 |
| | m | 120 | 128 |
| | n | 20 | 20 |
| | x | 100 | 100 |
| | y | 125.5 | 125.5 |

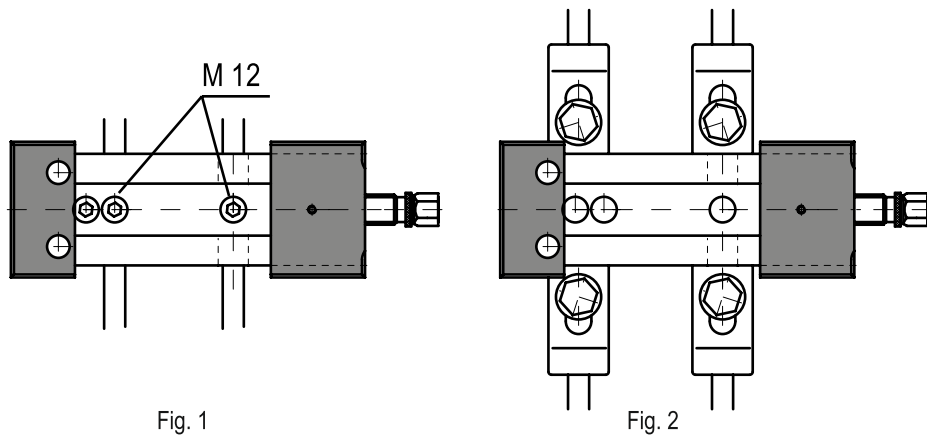
| TYPE | 125 | 160 |
|--------------------------|---------|---------|
| Clamping range S1 in mm | 0 - 208 | 0 - 283 |
| Torque in Nm | 85 | 120 |
| Max clamping force in kN | 35 | 50 |
| Weight in kg | 13.5 | 26 |



SAFETY AND PRECAUTIONS

- Persons using the amt-ALLMATIC high precision vice must read the operating instructions before commencing any work.
- Flexible workpieces only generate a low level of clamping power and represent a danger to persons and surrounding.
- Workpieces may fall off if little clamping pressure is applied.
- Please follow all accident prevention instructions applicable to this machine.
- Avoid all hazardous working practices.
- Only components that have been approved by the manufacturer may be used as replacement parts.
- The use of special jaws is necessary if the clamping face of the workpiece is not parallel.
- The same regulations apply to all accessories.

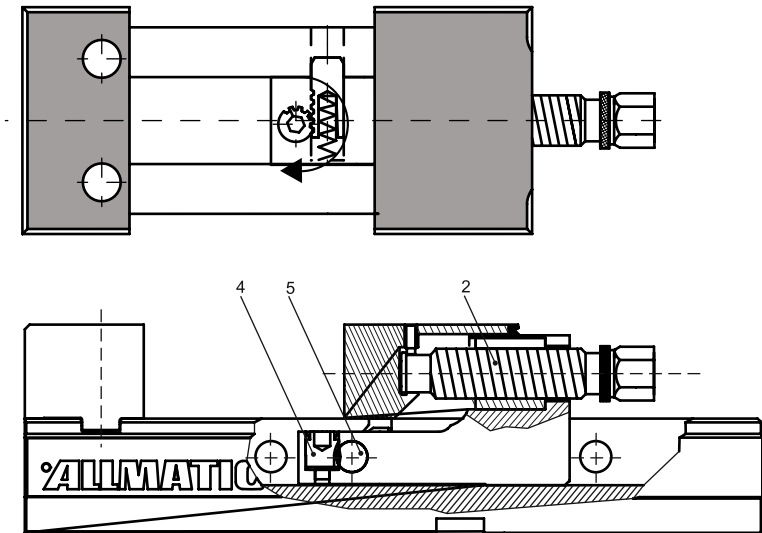
INSTALLATION



1. Direct fixing through the bottom of the vice.
2. Conventional fixing with side clamps.

(We recommend the use of 4 side clamps, as the stability of the machine table will improve the accuracy in positioning the workspace.)

OPERATION



In order to preset the clamping range, the mechanical locking mechanism must be released by turning the pinion (4) clockwise (right) against the spring force. Once the mobile clamping unit has been repositioned, it must be assured that the stop bolt is securely locked in place (5) The clamping force is generated by the spindle (2)

CLAMPING POSITION



Clamp the workpiece correctly (see diagram)

