



INSTRUCTIONS MANUAL RAIL VICE

Manufactured by :

AHIRE MACHINE TOOLS PVT. LTD.

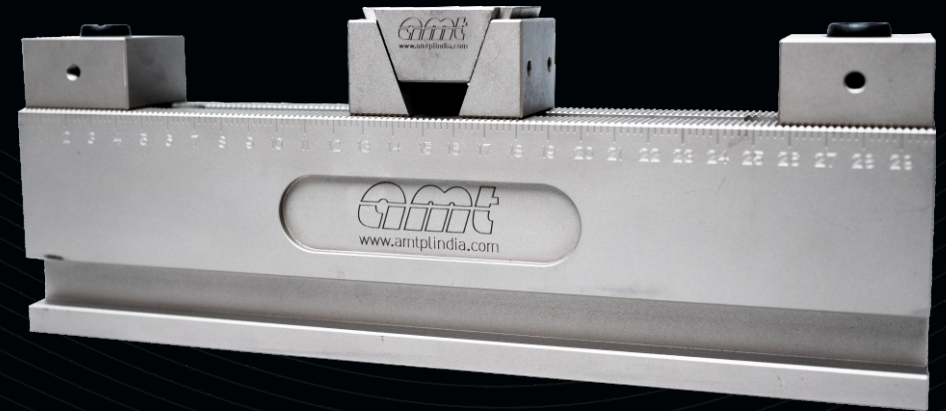
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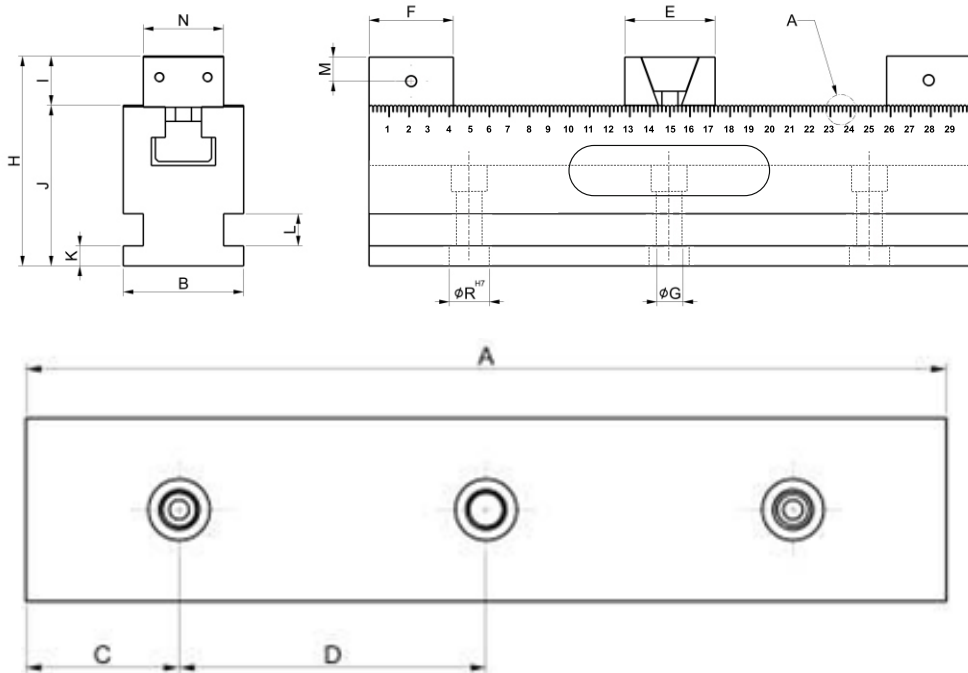
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QUALITY CREATES TRUST

TECHNICAL DATA

MODEL	A	B +/- 0.05	C	D +/- 0.01	E	F	G	H	I	J	K	L	M	N	R
KD-STJ-2 RL-300	300	60	50	100	42	42	13	105	24.5	80	10	16	12	40	20
KD-SJ-2 RL-300	300	60	50	100	42	42	13	105	24.5	80	10	16	12	40	20
KD-STJ-3 RL-500	500	60	50	200	60	42	13	105	24.5	80	10	16	12	40	20
KD-SJ-3 RL-500	500	60	50	200	60	42	13	105	24.5	80	10	16	12	40	20



SAFETY AND PRECAUTIONS

1. Persons using the amt high precision vice must read the operating instructions before commencing any work.
2. Flexible work pieces only generate a low level of clamping power and represent a danger to persons and surrounding.
3. Work pieces may fall off if little clamping pressure is applied.
4. Please follow all accident prevention instructions applicable to this machine.
5. Avoid all hazardous working practices.
6. Only components that have been approved by the manufacturer may be used as replacement parts
7. The same regulations apply to all accessories

1. Rail Body

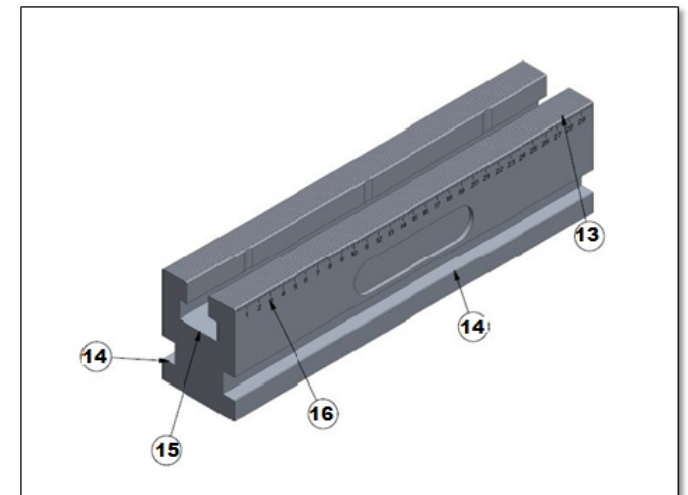
- The rail body is secured to the slots (14) using side clamps on machine table.
- The Fix jaws are guided in the T-slot (15) and are positively positioned and held on the precise rack teeth (13). The rail body with the scale (16) engraved on one side, serving as a visual aid for positioning the Fix jaws.

13) Precision rack teeth

14) Side Clamp Slot

15) T-Slot

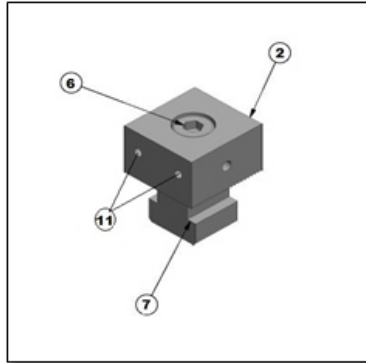
16) Scale



2. Fix Jaw RL

- The fixed jaw (2) is clamped onto the rail body (1) with the screw (9) and T-Nut (8).
- Threaded holes (16) are available for attaching accessories.

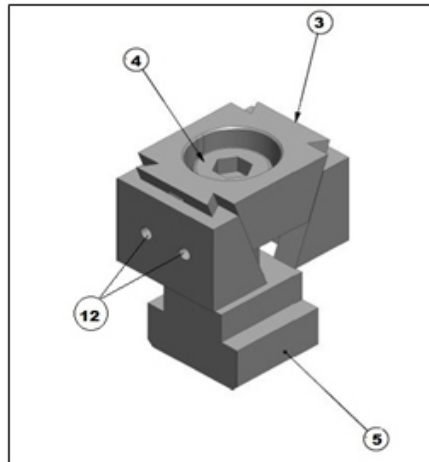
- 2) Fix Jaw RL
- 6) Allen Bolt
- 7) T-Nut
- 11) Threading Hole



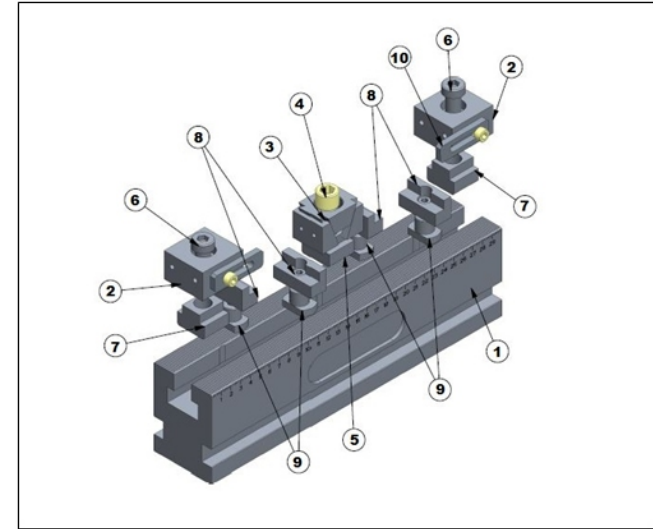
3. Wedge Clamp with Jaw

- Wedge clamp are fastened with the corresponding T-Nuts (5) and guided into the rail body (1) in its T-slot guide (13).
- Threaded holes (15) are available for attaching accessories.
- The wedge clamp (3) is vertically displaced with the screw (4), causing the jaw to exert unforced clamping force on the work piece.

- 3) Wedge Clamp with Jaw
- 4) Allen Bolt
- 5) T-Nut
- 12) Threading Hole



OPERATION

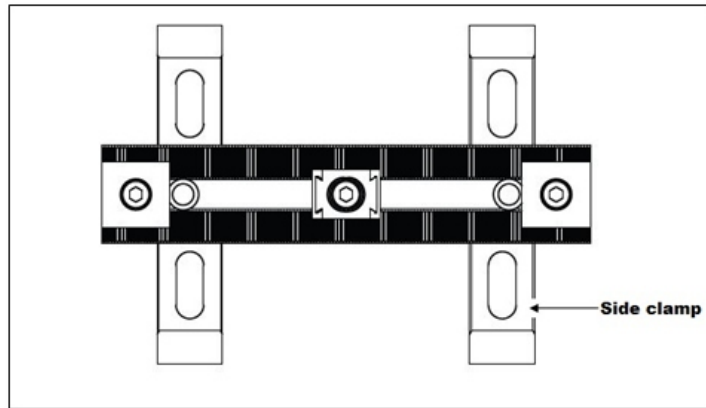


- 1) Rail Body
- 2) Fix Jaw RL
- 3) Wedge Clamp with Jaw
- 4) Allen Bolt
- 5) T-Nut M16
- 6) Allen Bolt
- 7) T-Nut M12
- 8) Step Jaw RL
- 9) T-Nut M6
- 10) Work Piece Stopper RL

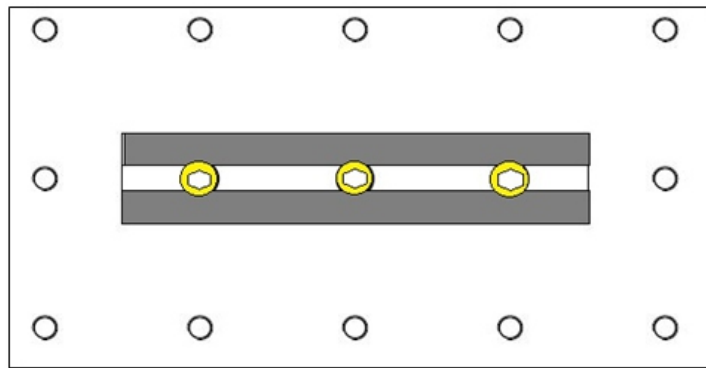
INSTRUCTION

- Choose the correct size of vice for the intended work piece and locate it on the table, fixing with side clamps.
- Move fix jaw RL (2) and wedge clamp (3) to the correct position considering the size of work piece. (set the t-nut from t-slot in rail body (1))
- The Rail Vice consists of the rail body (1), which is clamped onto a machine table. the rail body (1) has a T-slot (15) guide in the middle for the wedge clamp (3) and precise rack teeth on the top for precise positioning of the Fix jaws (2).
- Place the work piece in position and turn Allen bolt (4) to move the wedge clamp (3) for clamping the work piece.

INSTALLATION



Mounting on a Machine Table



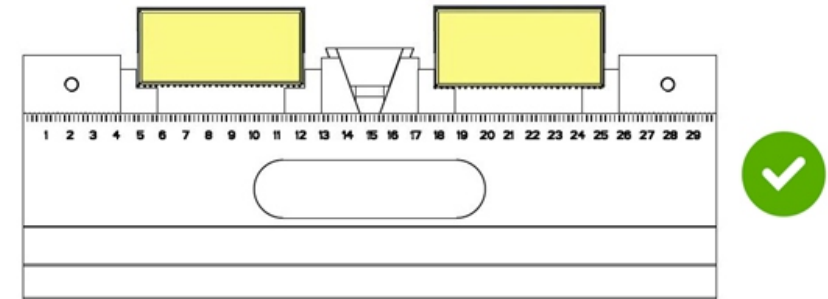
Mounting on a Machine Table for Centre Bolting

1. Conventional fixing with side clamps.
2. Vice fixed to centre hole clamping.

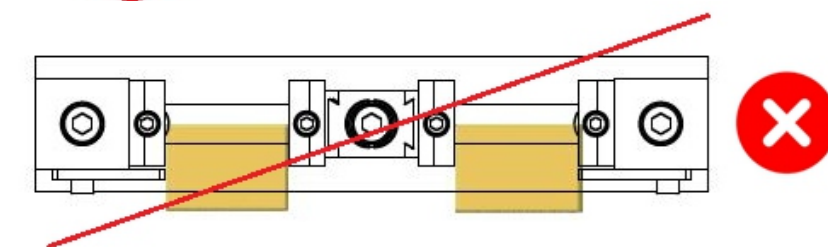
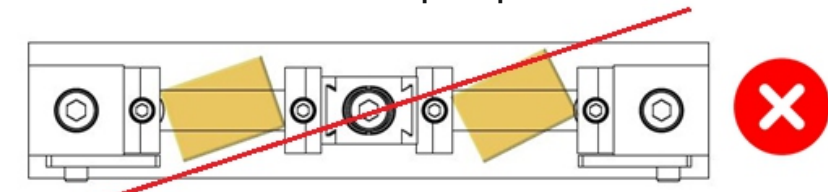
(We recommend the use 4 Nos of side clamps for rail vice-300 and 6 Nos of side clamps for rail vice-500, as the stability of the machine table will improve the accuracy in positioning the workspace)

CLAMPING POSITION

Clamp the work piece correctly (see diagram)



Correct work piece position



Incorrect work piece position

MINTENANCE



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 rail vice and giving it a thorough cleaning. In doing so, check the flat point for wear and tear.

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