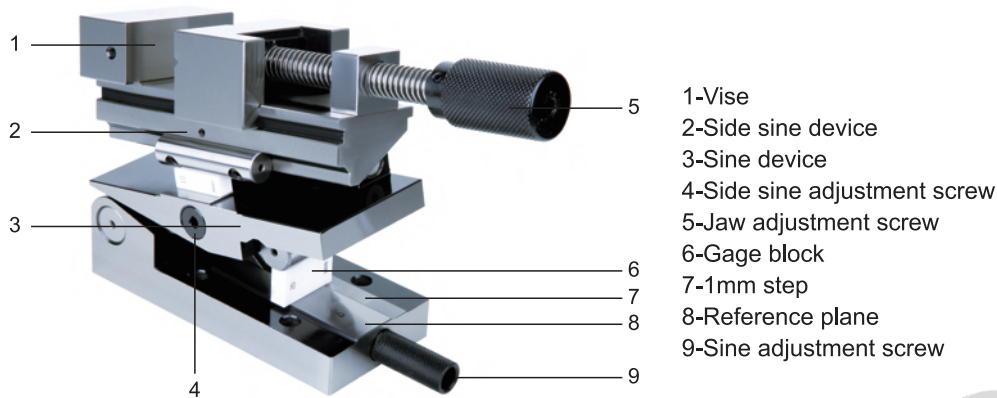


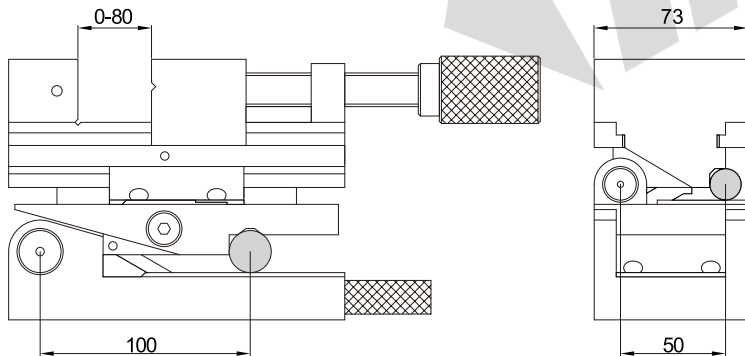
OPERATION INSTRUCTION

Precision Compound Sine Vise

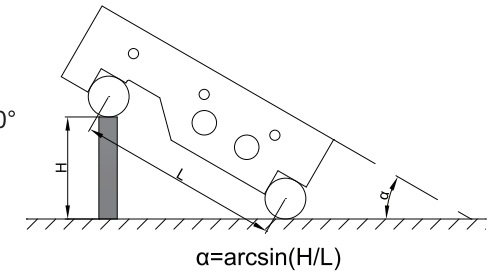


Code	Jaw Opening	Jaw width	Adjustable angle	Parallelism	Squareness	Accuracy of angle
6524-80	0-80mm	73mm	0-46°	3μm/100mm	5μm/100mm	±15"

- Vise is used to hold workpieces. Jaw opening is 0-80mm. Jaw width is 73mm.
- Sine and side sine device work with different gage blocks to build desired angles, according to sine principle. Adjustable angle is 0-46°.
- Axis center distance of sine device is 100mm. Axis center distance of side sine device is 50mm.
- Sine and side sine adjustment screws are used to lift sine and side sine device up and down.



- Sine principle, as right figure:
angle $\alpha = \arcsin(H/L)$
For example:
center distance (L) is 100mm,
height of gage block (H) is 50mm,
 $\alpha = \arcsin(H/L) = \arcsin(50/100) = \arcsin 0.5 = 30^\circ$



- 1mm step:
step size $1 \pm 0.002\text{mm}$, benefit for using when small size gage blocks are not available. If small gage blocks (smaller than 0.5mm) are needed (for example, 0.25mm), a gage block 1.25mm can be used on the step (fig. 1, 2) in order to make 0.25mm ($1.25 - 1 = 0.25\text{mm}$) (fig. 3)

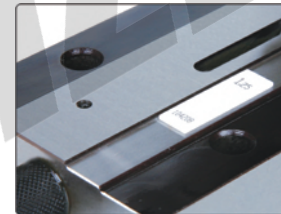


fig.1



fig.2

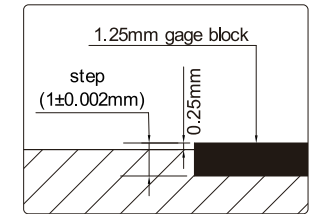


fig.3

- Notice:
 - 1) Protect each measuring surfaces. Be careful to take and put down vise slightly, avoid bumps or damage.
 - 2) Oil it after use, avoid rusting.