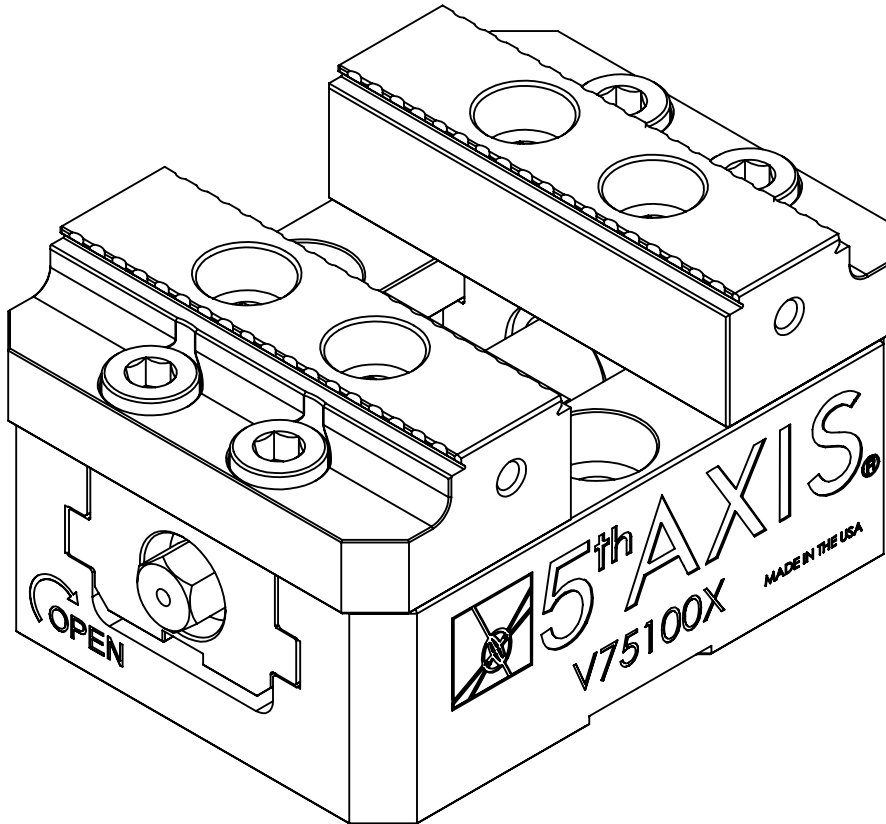


V75100X VISE OWNER'S MANUAL



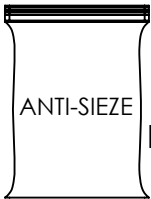
0-40 MM [0"-1.57"]	40-76 MM [1.57"-3"]	52MM RockLock	Self-Centering

BILL OF MATERIAL			
ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	SB3V	SHOULDER BOLT	2
2	LP8	LOCATING PIN	2
3	M5X10.DP	DOWEL PIN 5x10MM	2
4	V75100X-4RK	LEADSCREW REPLACEMENT KIT	1
5	V75100X-2	TRUCK	2
6	V75100X-1	V75100X VISE BODY	1
7	V75100X-5	MASTER JAWS	2
8	76232	SHCS M8x16MM	8
9	TS10	THUMBSCREW	1
10	LB8008C5-A	ANTI-SIEZE PACKET	1
11	76252	BOLT M8x40MM	2

INCLUDED IN BOX

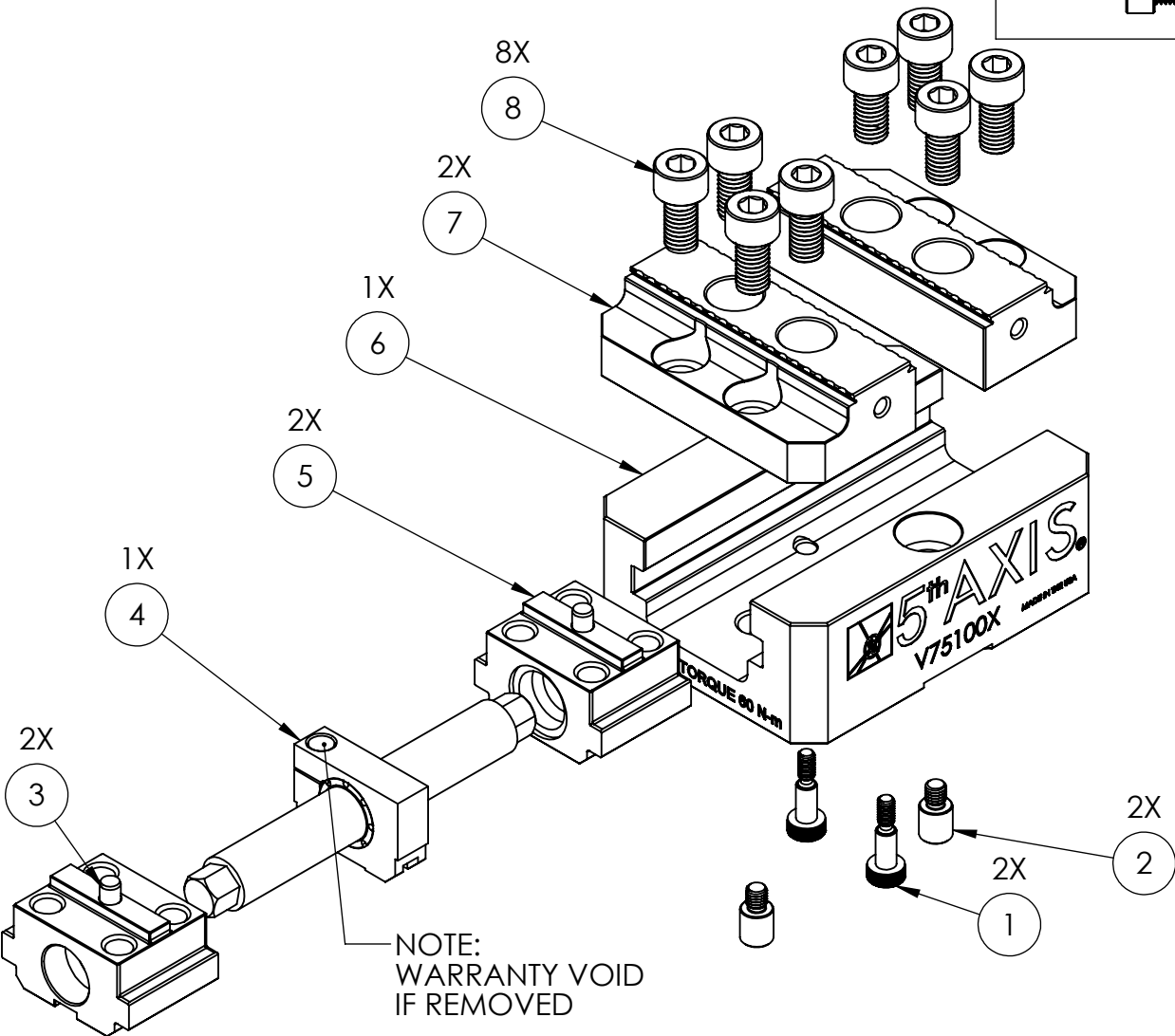


9: THUMBSCREW
P/N:TS10



10: ANTI SIEZE
PACKET
P/N: LB8008C5-A

11: MOUNTING BOLT X2
M8x40



Maintenance and Use

- Clean leadscrew with soft brush
- Use copper based anti-sieze on leadscrew (Loctite P/N: LB8008C5-A)
- Do not let chips build up during use
- Do not torque vise past 60 Nm [45 Ft LBS]
- Do not side load vise (see illustration below)
- Clamping Force at max torque with Master Jaws installed-22.2 kN [5000 lbf]
- Weight: 2.72 Kg [5.16 lbs]

Torque Values

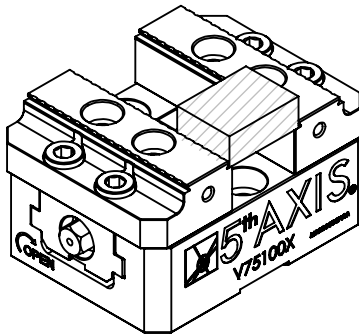
- Jaw Bolts: 27 Nm [20 Ft LBS]-M8x16mm (P/N: 76232)
- Mounting Bolts: 34 Nm [25 Ft LBS]-M8x40mm (P/N: 76252)
- Lead Screw: 60 Nm [45 Ft LBS] Max

Special Notes

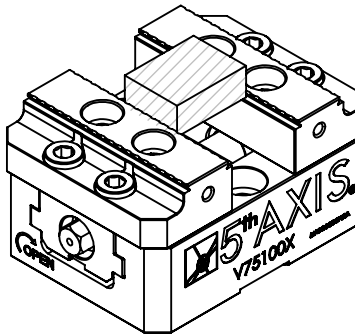
- Removing leadscrew assembly is not recommended and will void the warranty
- Failure to follow these instructions will cause self centering accuracy and/or repeatability to fail and may cause damage to the vise
- It is recommended to use only the two outside locating pin holes [LP8] labeled on page 4 as "A & B"



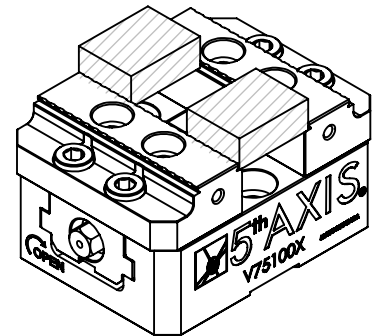
NO



YES



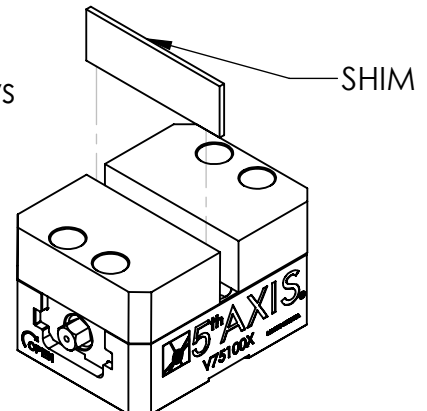
YES



To Machine Profiles into Soft Jaws/Anti-Lift Soft Jaws:

- Insert an appropriately sized shim between the jaws
- Torque to operating torque value
- Machine profile of part
- Remove shim and place the part in vise
- Torque to same value as previous

Following these steps will ensure the highest accuracy and will compensate for any jaw deflection in the vise.



Technical drawing of the V75100X 5th Axis head assembly. The drawing shows the front view of the assembly with dimensions in inches and millimeters.

Dimensions:

- Overall width: 108.00 [4.252]
- Overall height: 56.13 [2.210]
- Height of the main body: 53.63 [2.111]
- Height of the top flange: 12.00 [.472]
- Width of the top flange: 37.00 [1.457]
- Width of the central cutout: 23.00 [.906]
- Width of the right side flange: 20.00 [.787]
- Radius of the top flange: R2.50 [.098]
- Angle of the top flange: 45°
- Thread specification: M5 ∇ 8

Text on the assembly:

- 5th AXIS
- V75100X
- MADE IN THE USA



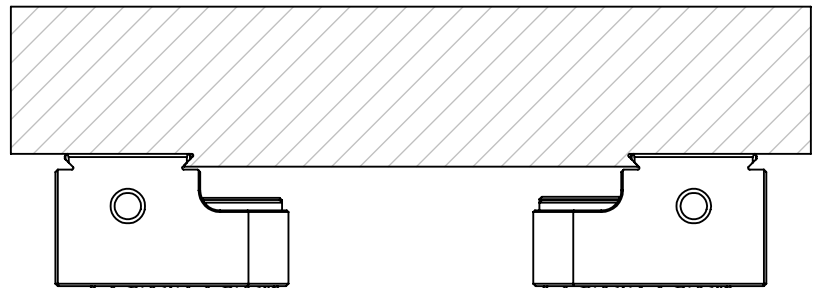
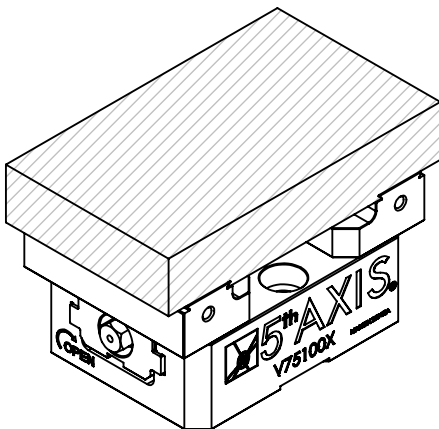
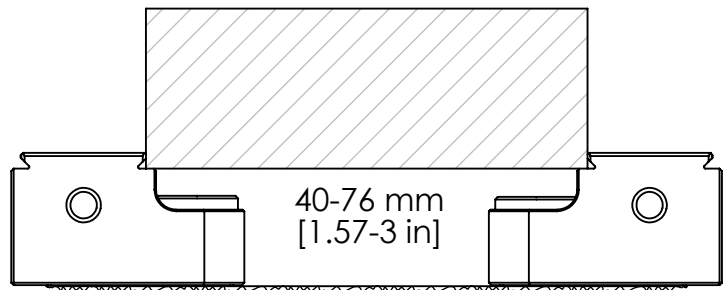
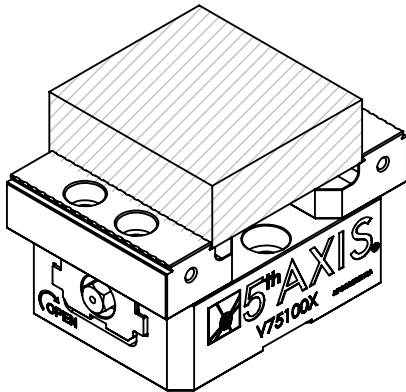
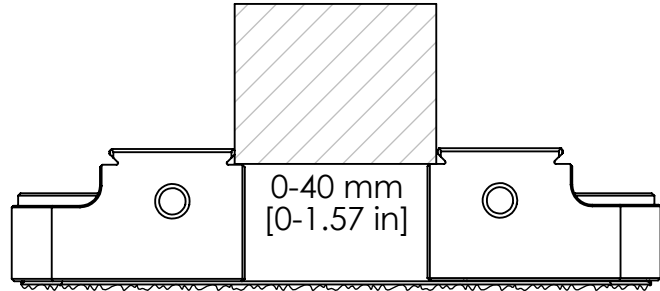
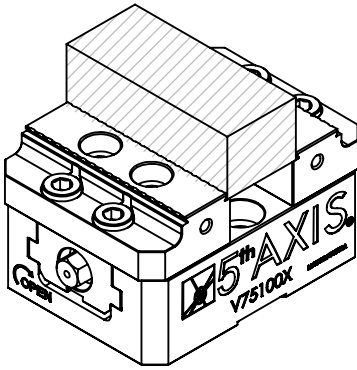
CONFIGURATIONS

Use Serrations For:

- Softer Materials (Aluminum and soft steels)
- Less Aggressive Machining

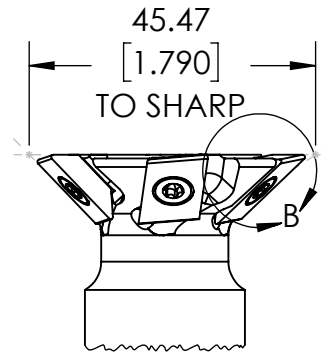
Use Dovetail for:

- Harder Materials
- Heavier Machining
- Parts Larger than the Vise

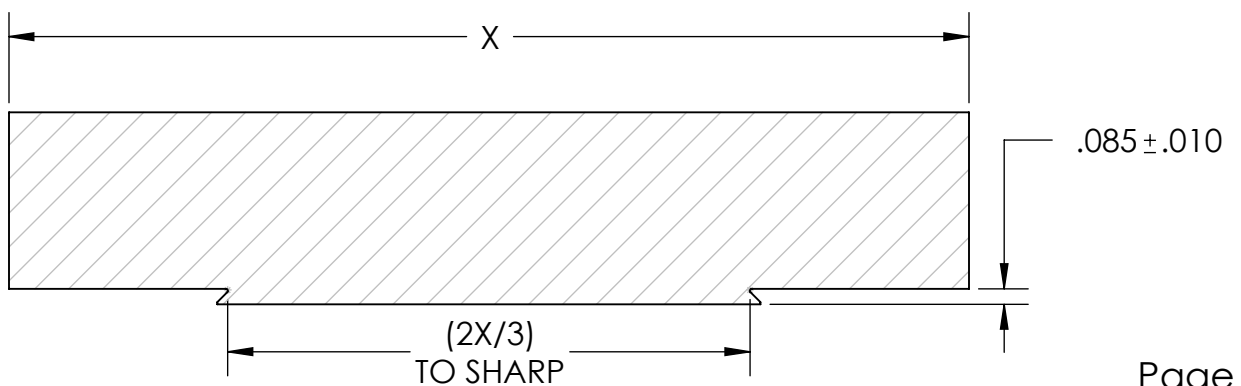
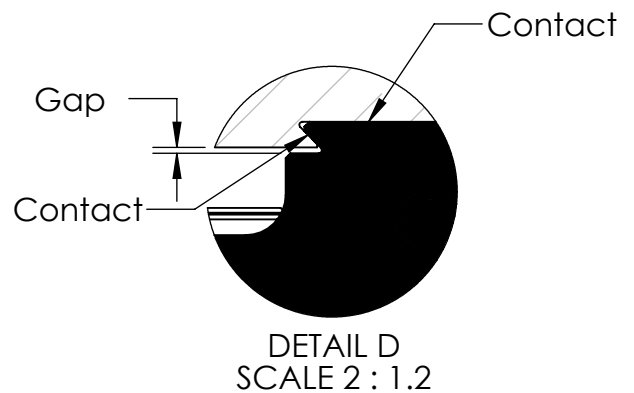
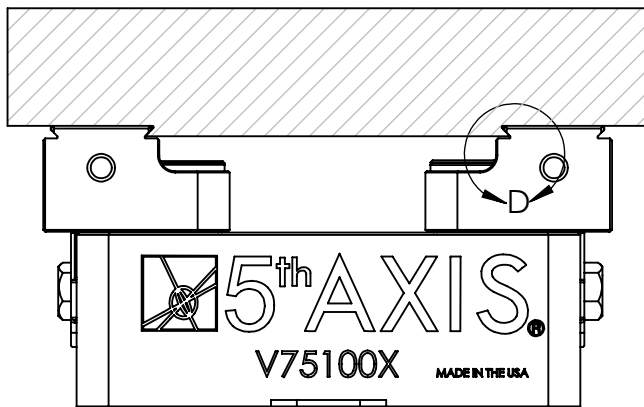
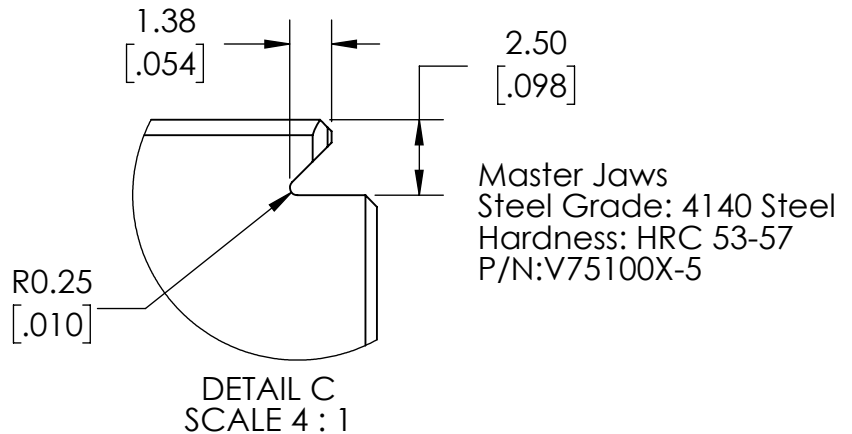
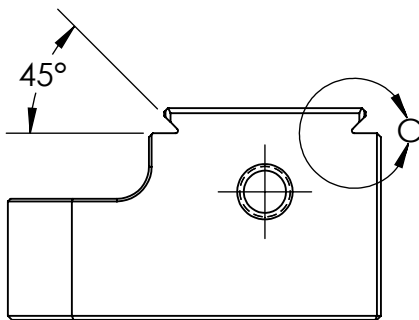
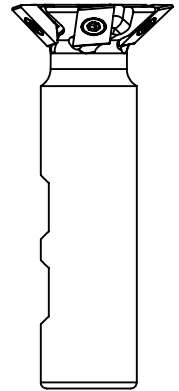
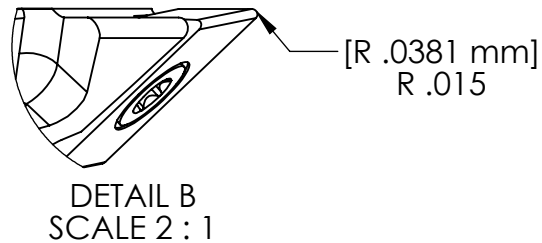


(See next page for dovetail stock prep)

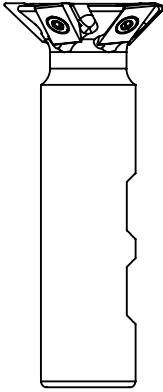
Dovetail Stock Prep



Dovetail Cutter



ACCESSORIES



Cutter Details

- Shank Diameter (in) 1" (P/N: DC1750-45)
- Shank Diameter (mm) 25mm (P/N: DC1750-M)
- Insert Part Number: DC1750-B
- 45 Degrees
- Material H13 Tool Steel
- 5 Flute Cutter
- Cutting Diameter: 45.5mm [1.79in]



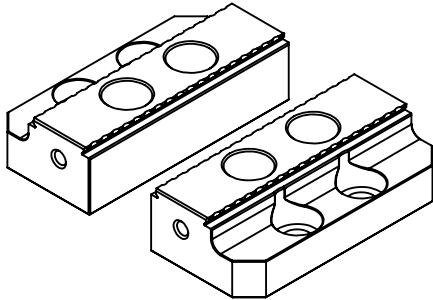
52mm Pull Studs

P/N: PS16-F

- For 52mm Rocklock
- Hardened S7 Tool Steel
- M8 Threads

Installing Pull Studs

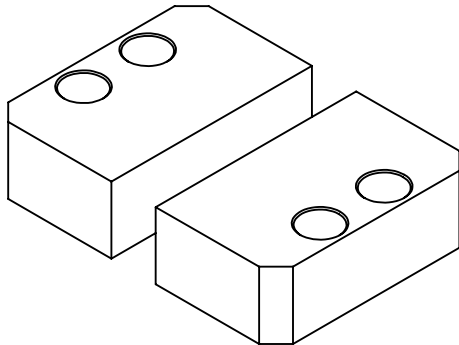
- Secure threaded stud finger tight only
- Grease precision surfaces
- Torque to 10 Ft-lbs via bottom hex head



Replacement Master Jaws

P/N: V75100X-5

- P/N: V75100X-5
- 75mm x 37mm x 21mm



Soft Jaws

VAJ75X- Aluminium

P/N: VAJ75X

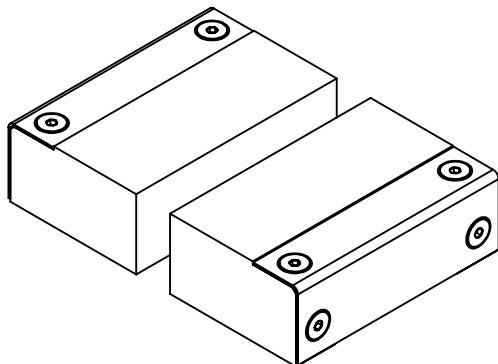
- 6061-T6
- Compatible with V75100 and V75100X
- 75mm x 45mm x 25mm

VSJ75X-Steel

P/N: VSJ75X

- 1018 Annealed
- Compatible with V75100 and V75100X
- 75mm x 45mm x 25mm

DOWNLOAD DRAWINGS AT: FIFTHAXIS.COM/DOWNLOADS



Anti-Lift Soft Jaws

P/N: AL75XA (ALUMINUM), AL75XS (STEEL)

REPLACEMENT JAW P/N: AL75-2A (ALUMINUM), AL75-2S (STEEL)

WHAT IS INCLUDED

Anti-Lift Cleats
AL75 Anti-Lift Soft Jaws
Jaw Covers
Jaw Cover Hardware

BENEFITS

- High Precision Op 2
- Reduced Jaw Lift <.025mm (<.001 in)
- Patent Pending
- Available in Aluminum and 1018 Steel



V75100X OWNER'S MANUAL

REV A
APPROVED 5/1/2019

Available for download
at: fifthaxis.com/downloads