

**TYPE ZXQKG PRECISION SINE  
TOOLING VISE**

**OPERATION INSTRUCTION**

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### I. Appliance and property

This type vise mainly applies to plane grinder, milling machine, EDM machine or wire cutting machine for setting angle surface, slot and slant hole, and also for measurement of workpiece. Simple structure, convenient operation, strong clamping force, high accuracy and wide range of adjustment make it a machinery accessory with high use value.

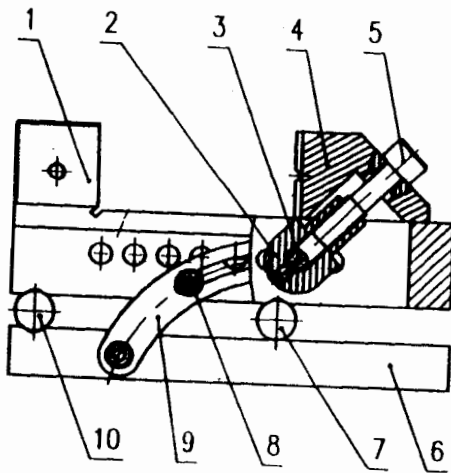
### II. Main specification:

| Code     | Jaw Width | Jaw Depth | Opening Width | Total Length | Adjusting Angle |
|----------|-----------|-----------|---------------|--------------|-----------------|
| ZXQKG50  | 50        | 25        | 65            | 140          | 0-45°           |
| ZXQKG63  | 63        | 32        | 85            | 175          |                 |
| ZXQKG73  | 73        | 35        | 100           | 190          |                 |
| ZXQKG80  | 80        | 40        | 100           | 200          |                 |
| ZXQKG88  | 88        | 40        | 125           | 235          |                 |
| ZXQKG100 | 100       | 45        | 125           | 245          |                 |
| ZXQKG125 | 125       | 50        | 160           | 285          |                 |

### III. Parts of name and quantity (with drawing)

| No. | Name      | quantity | No. | Name      | quantity |
|-----|-----------|----------|-----|-----------|----------|
| 1   | vise body | 1        | 2   | pivot pin | 1        |
| 3   | pin       | 1        | 4   | live jaw  | 1        |

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|--------------------------|---|--------------------------|---|
| 5. socket head cap screw | 1 | 6. base board            | 1 |
| 7. shaft                 | 1 | 8. socket head cap screw | 1 |
| 9. support rack          | 2 | 10. shaft                | 1 |



#### IV. Method and step

First adjust the required angle and choose proper gauge block. Loosen screw (8), Lift vise body (1) and put the gauge block under shaft (7). Then tighten screw (8), to the size of workpiece clamp the workpiece by adjusting the position of pin (3) in the holes of vise body (1). To get minor travel clamping, We can adjust screw (5), and move the live jaw (4).

#### V. Maintenance

Rotary parts, sliding parts should be lubricated periodically. For long term store, please clean, rinse and lubricate the parts and pack them in plastic bags.