

VICE MAINTENANCE GUIDE

Daily Vise Maintenance

1. Clear all free standing chips
2. Visually inspect the leadscrew
3. Clean leadscrew with soft brush
4. Air-dry / brush off all remaining machined chips



Quarterly Maintenance

1. Do not let chips build up during use
2. Do not over torque vise
3. Do not side load vise (see page 2)
4. Apply copper based anti-seize to leadscrew
5. Re-torque jaw bolts - please refer to 2D drawings for torque specifications

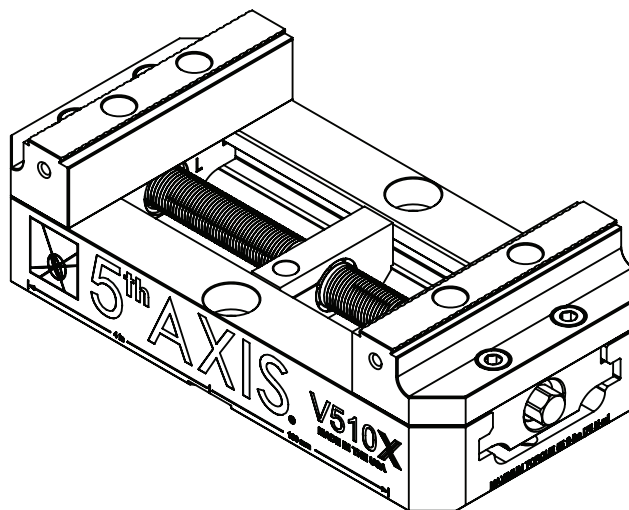
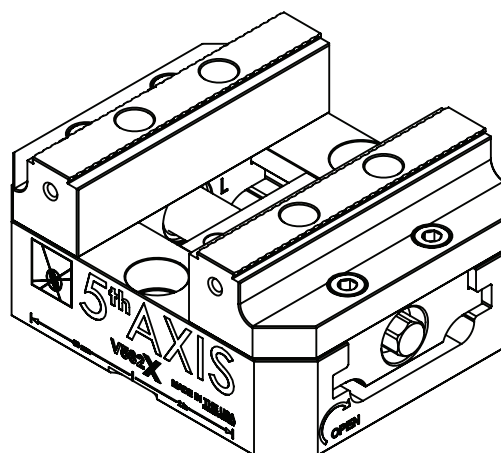
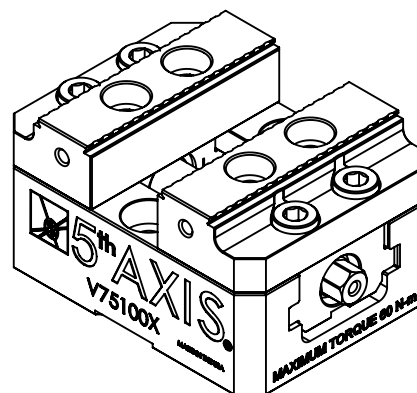
Looking for 2D Drawings and 3D Models?

<https://5thaxis.com/downloads/>



Questions? Visit the FAQ Page.

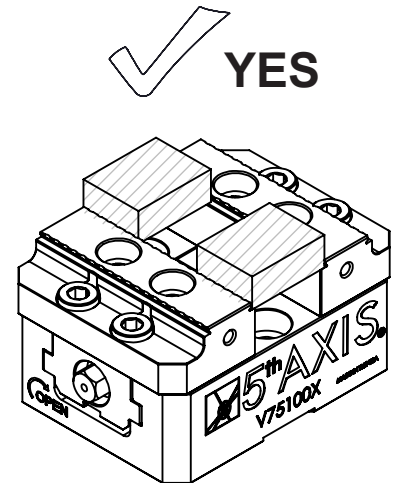
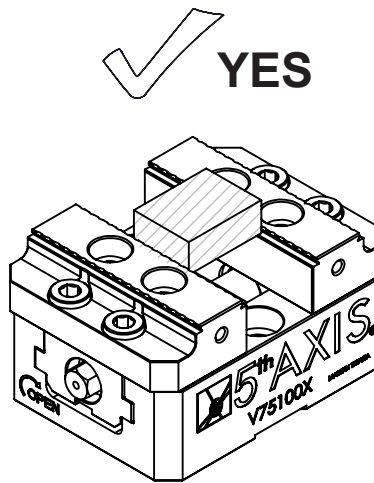
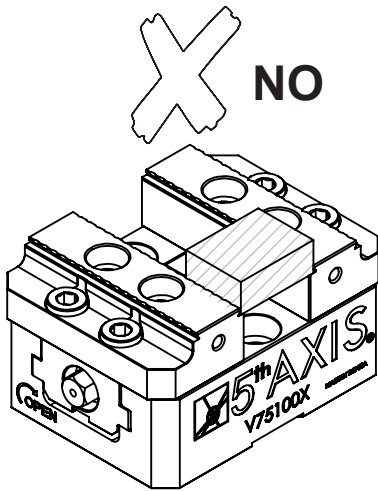
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WISE DO'S AND DON'TS

Proper Material Clamping for Roughing Operations

1. Do not side load vise (see illustration below)
2. Master jaws are 55 HRC / Built to clamp material under ~35 HRC
3. For material harder than 35 HRC we recommend using the 45° dovetail feature
 - a. The requirement is lower for Lite Vise Master Jaws: they are limited to HRC 25 for clamping directly. (applies to VA56, VA513 and VA518)
4. For finishing operations utilize soft jaws (see next section)



Machine Profile into Soft Jaws for Finishing Operations

1. Insert shim between soft jaws
2. Tighten vise to operating torque
3. Machine profile of the part
4. Remove shim and place component in the vise
5. Tighten vise to same operating torque

