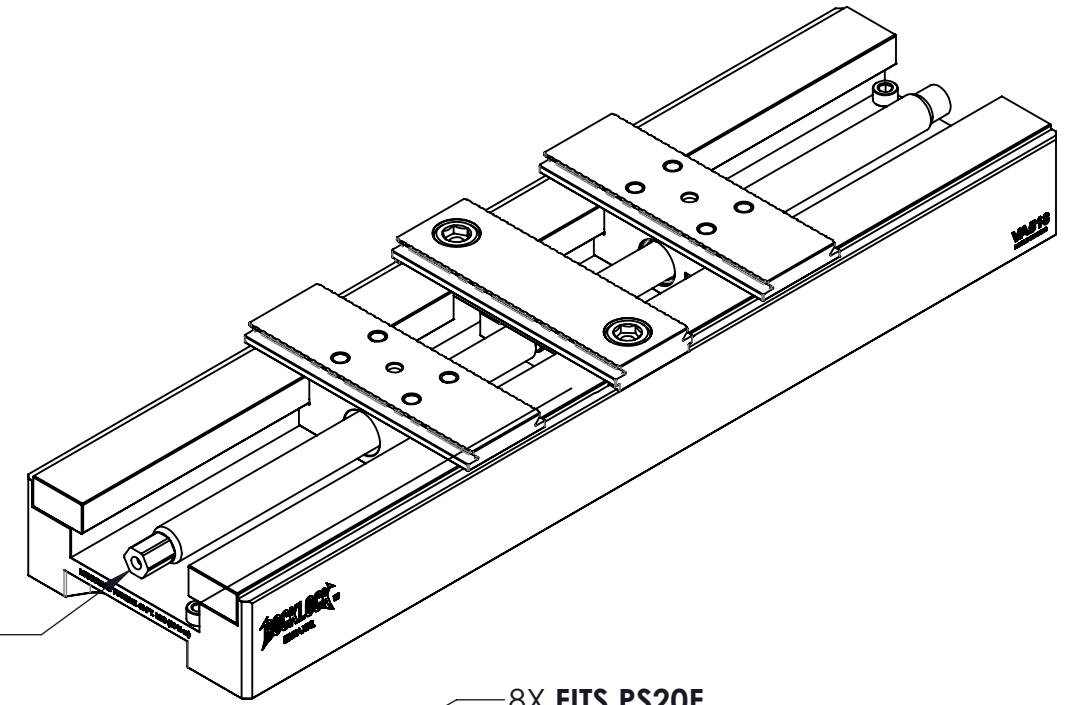


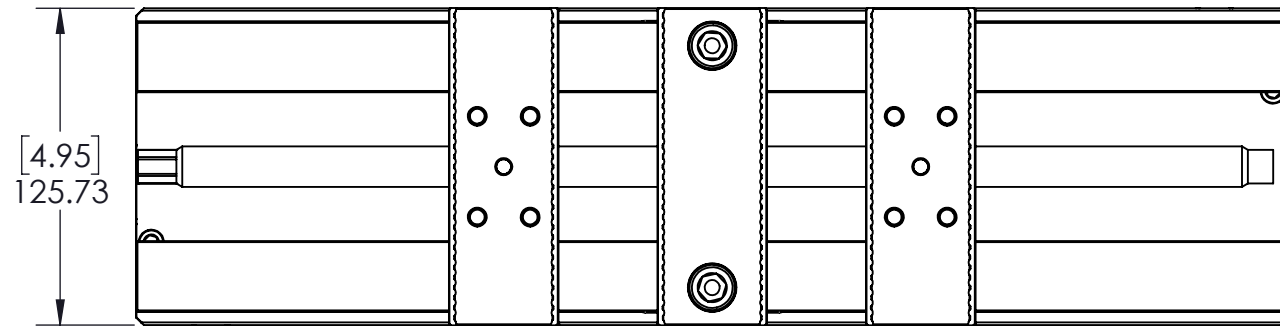
TECHNICAL DATA	VA518
JAW WIDTH	4.95" (125.73mm)
BASE LENGTH	18" (457.2mm)
CLAMPING FORCE	5000 lbf @ 45 ft-lb (22 kN @ 60 Nm)
MAXIMUM TORQUE (LEADSCREW)	45 ft-lb (60 Nm)

VA518

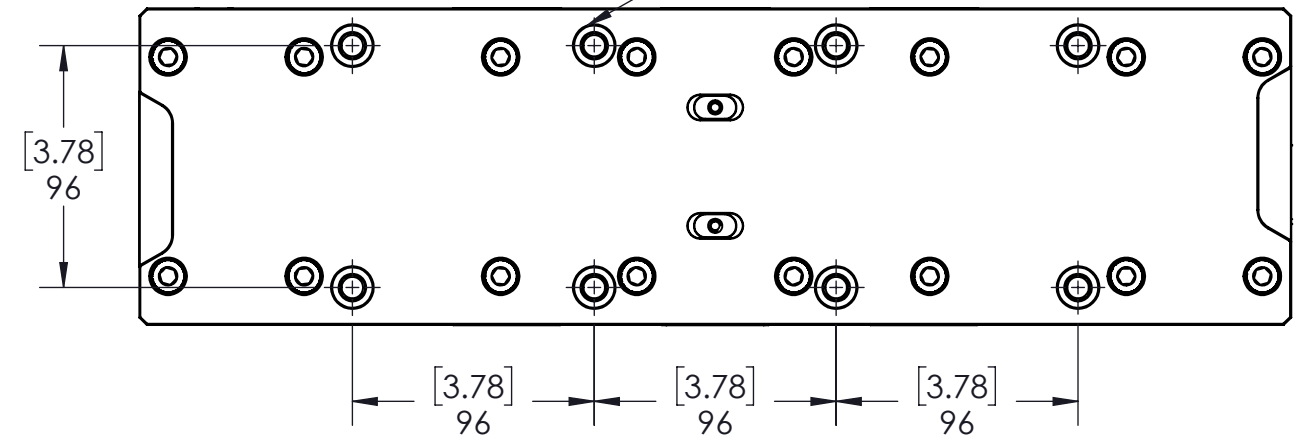


12mm HEX

8X FITS PS20F



[4.95]
125.73

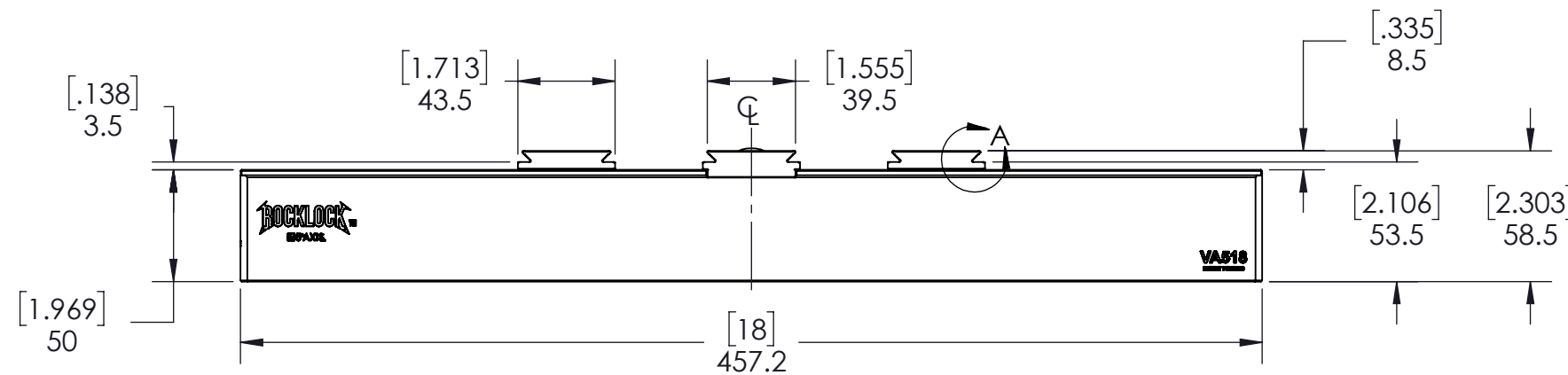


[3.78]
96

[3.78]
96

[3.78]
96

[3.78]
96



[.138]
3.5

[1.713]
43.5

[1.555]
39.5

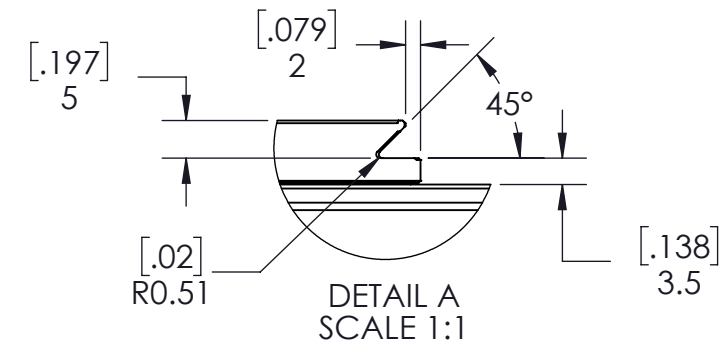
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8.5

[2.106]
53.5

[2.303]
58.5

[1.969]
50

[18]
457.2



[.197]
5

[.079]
2

45°

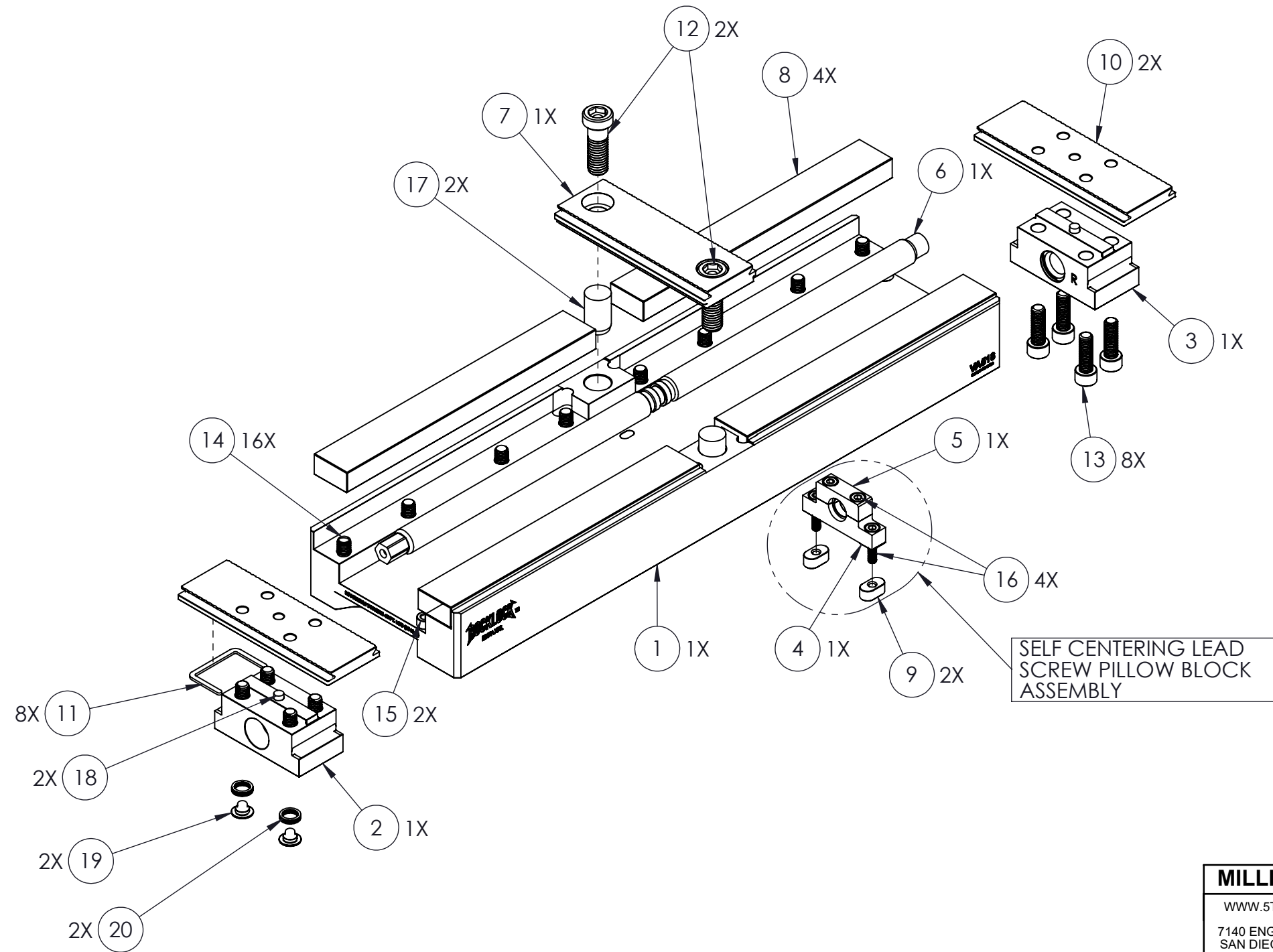
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R0.51

DETAIL A
SCALE 1:1


[.138]
3.5

MILLIMETER			
WWW.5THAXIS.COM 7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432			
THIRD ANGLE PROJECTION		DESCRIPTION	
		LITE VISE - 5X18	
SIZE	PART NO.	REV	
B	VA518	C	
DO NOT SCALE DRAWING		SCALE 1:3	WEIGHT: 11.3 KG
		SHEET 1 OF 6	

VA518



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VA518-1	BASE, 5X18	1
2	VA56-2L	TRUCK, LEFT	1
3	VA56-2R	TRUCK, RIGHT	1
4	VA56-3B	BLOCK, BOTTOM	1
5	VA56-3T	BLOCK, TOP	1
6	VA518-4	SCREW, VA18, 16MM	1
7	VA513-5	LOW PROFILE STACKABLE CENTER BASE	1
8	VA518-6	LOCATING BLOCK	4
9	VA56-8	NUT	2
10	VA56-9	LOW PROFILE STACKABLE JAW BASE	2
11	VA56-10	WIPER SEAL	8
12	M12X35MM.LHSCS	LOW HEAD SOCKET CAP SCREW, M12X1.75X35MM	2
13	M8X025.SHCS	SOCKET HEAD CAP SCREW M8X1.25X25MM	8
14	M8X35MM.SHCS	SOCKET HEAD CAP SCREW M8X1.25X35MM	16
15	M6X6MM.SHCS	SOCKET HEAD CAP SCREW, M6X1X10MM	2
16	M5X20MM.SHCS	SOCKET HEAD CAP SCREW M5X.8X20MM	4
17	M16X30MM.DP	DOWEL PIN, M16X30MM	2
18	M6X10.DP	DOWEL PIN M6X10MM	2
19	HW.0520.FP	PIN, FRICTION, .520 STEPPED, BRASS	2
20	CS050-H2-S17	WAVE SPRING 17-4 W/SHIMS	2

MILLIMETER WWW.5THAXIS.COM 7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432			
	DESCRIPTION LITE VISE - 5X18		
THIRD ANGLE PROJECTION	SIZE B	PART NO. VA518	REV C
DO NOT SCALE DRAWING		SCALE 1:3	WEIGHT: SHEET 2 OF 6

8

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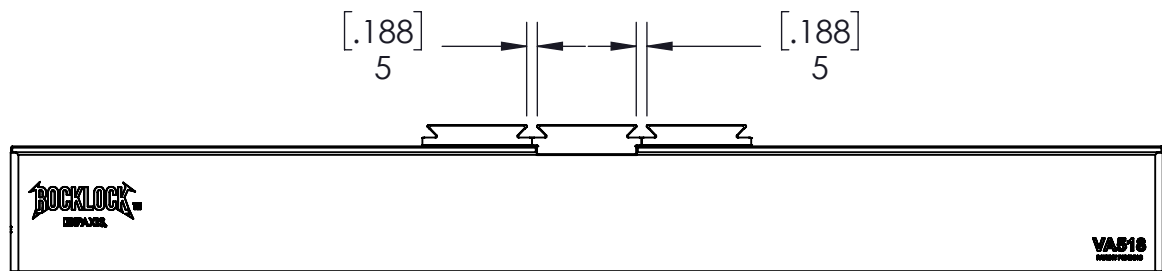
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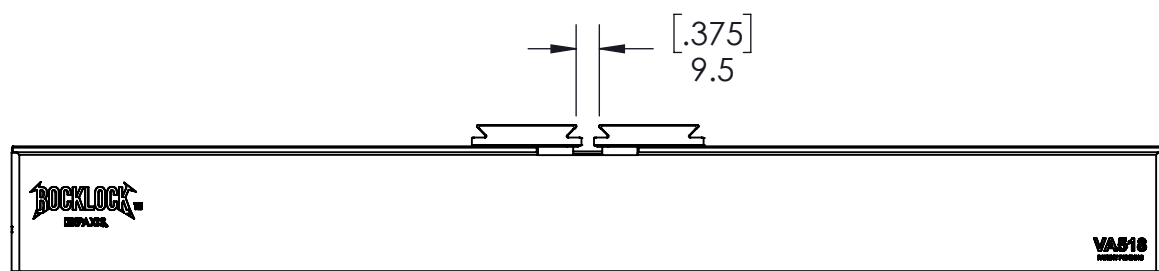
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NOTES: USING DOVETAIL ALLOWS VISE TO CLAMP LARGER PART.
 BELOW CLAMPING RANGE ONLY SHOWS THE CAPABILITY OF THE GRIPPER TEETH.

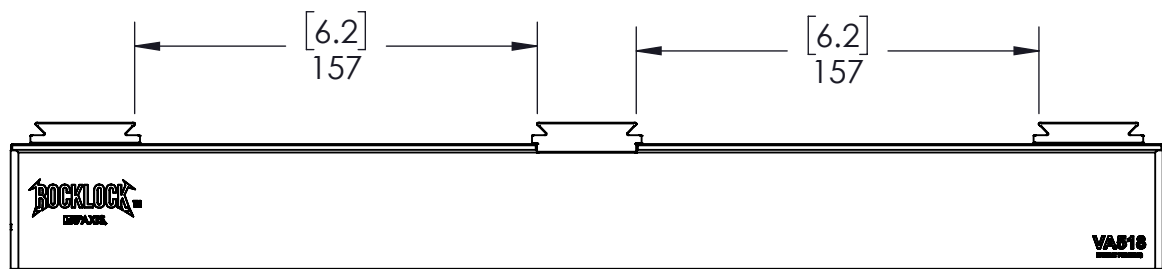
VA518



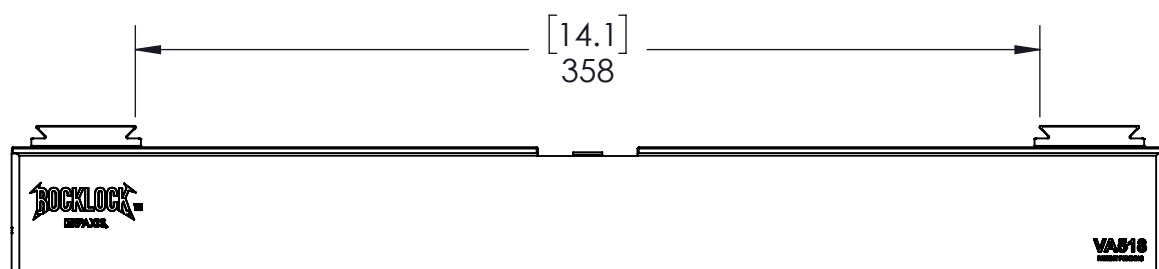
DOUBLE STATION (MINIMUM CLAMPING RANGE)




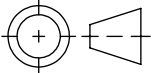
SELF CENTERING (MINIMUM CLAMPING RANGE)



DOUBLE STATION (MAXIMUM CLAMPING RANGE)



SELF CENTERING (MAXIMUM CLAMPING RANGE)

MILLIMETER			
WWW.5THAXIS.COM 7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432			
THIRD ANGLE PROJECTION		DESCRIPTION	
		LITE VISE - 5X18	
SIZE	PART NO.	REV	
B	VA518	C	
DO NOT SCALE DRAWING		SCALE 1:3	WEIGHT:
		SHEET 3 OF 6	

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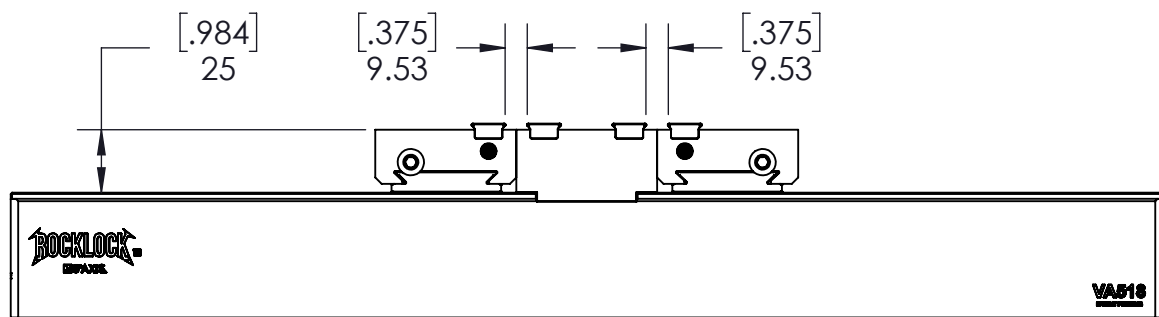
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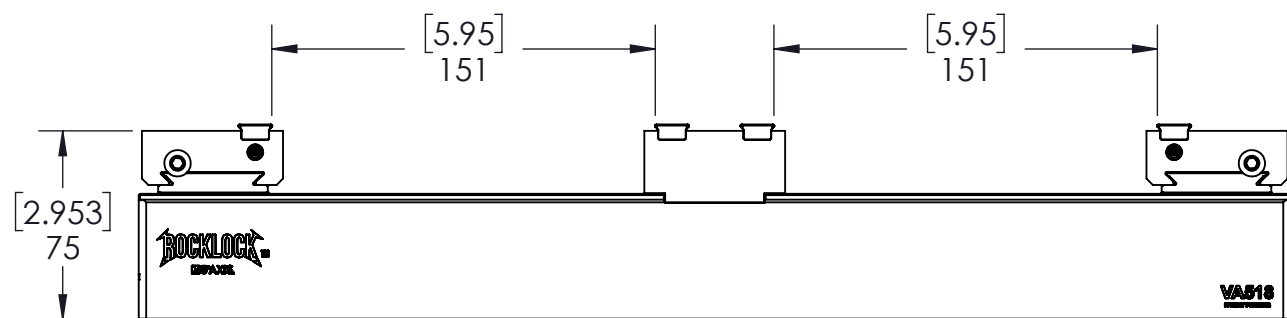
1

NOTES: USING DOVETAIL ALLOWS VISE TO CLAMP LARGER PART.
BELOW CLAMPING RANGE ONLY SHOWS THE CAPABILITY OF THE GRIPPER TEETH.

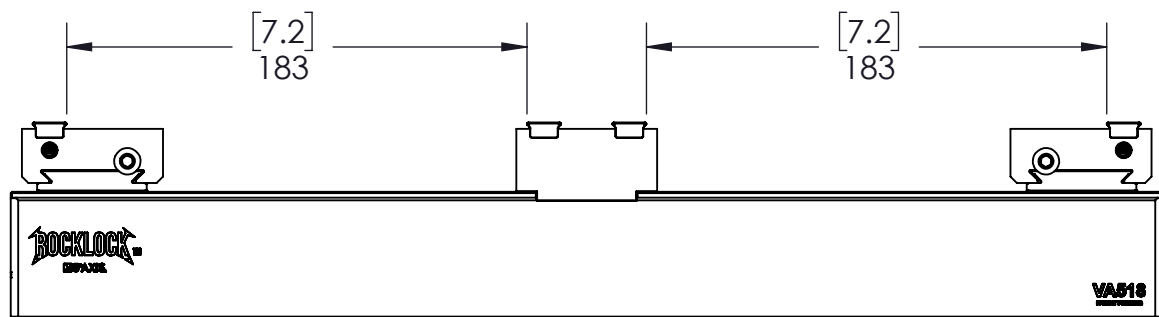
VA518 SHOWN W/ OPTIONAL VA513-GJ-A



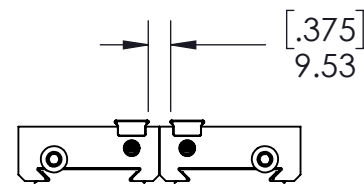
DOUBLE STATION (MINIMUM CLAMPING RANGE)



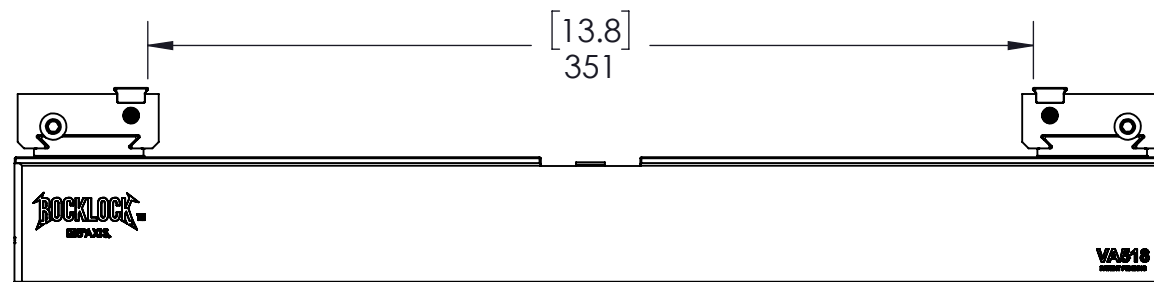
DOUBLE STATION (MAXIMUM CLAMPING RANGE)



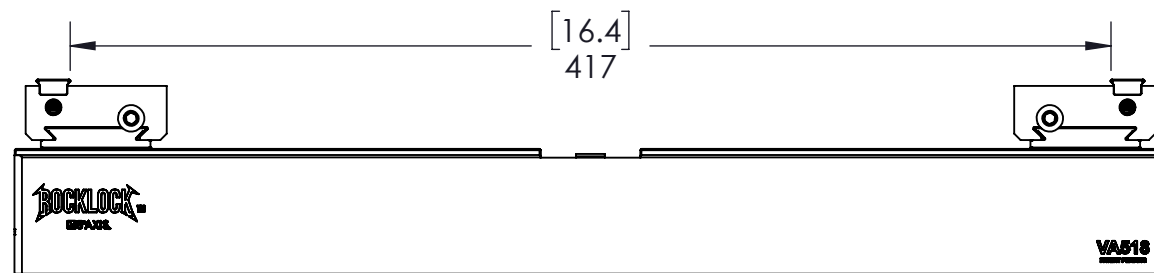
DOUBLE STATION W/JAWS REVERSED (MAXIMUM CLAMPING RANGE)




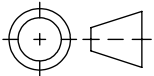
SELF CENTERING (MINIMUM CLAMPING RANGE)



SELF CENTERING (MAXIMUM CLAMPING RANGE)



SELF CENTERING W/JAWS REVERSED (MAXIMUM CLAMPING RANGE)

MILLIMETER			
WWW.5THAXIS.COM			
7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432		DESCRIPTION LITE VISE - 5X18	
THIRD ANGLE PROJECTION 	SIZE B	PART NO. VA518	REV C
DO NOT SCALE DRAWING		SCALE 1:3	WEIGHT:
		SHEET 4 OF 6	

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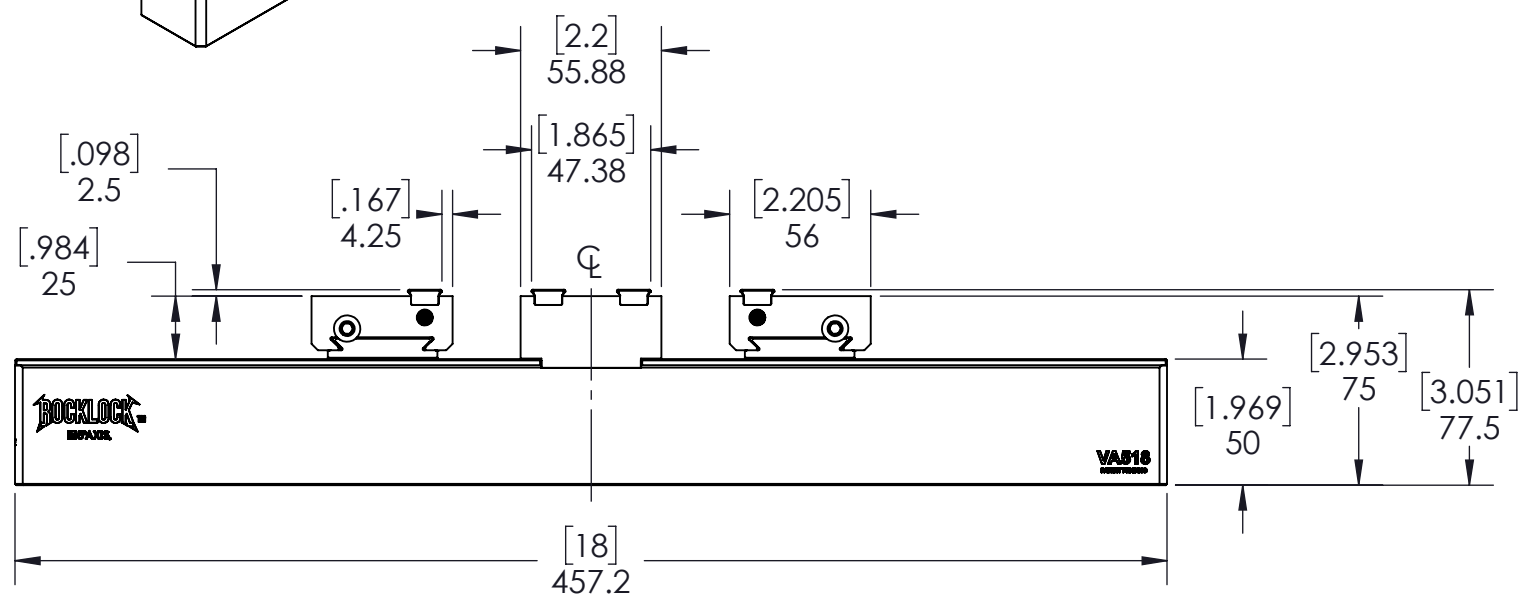
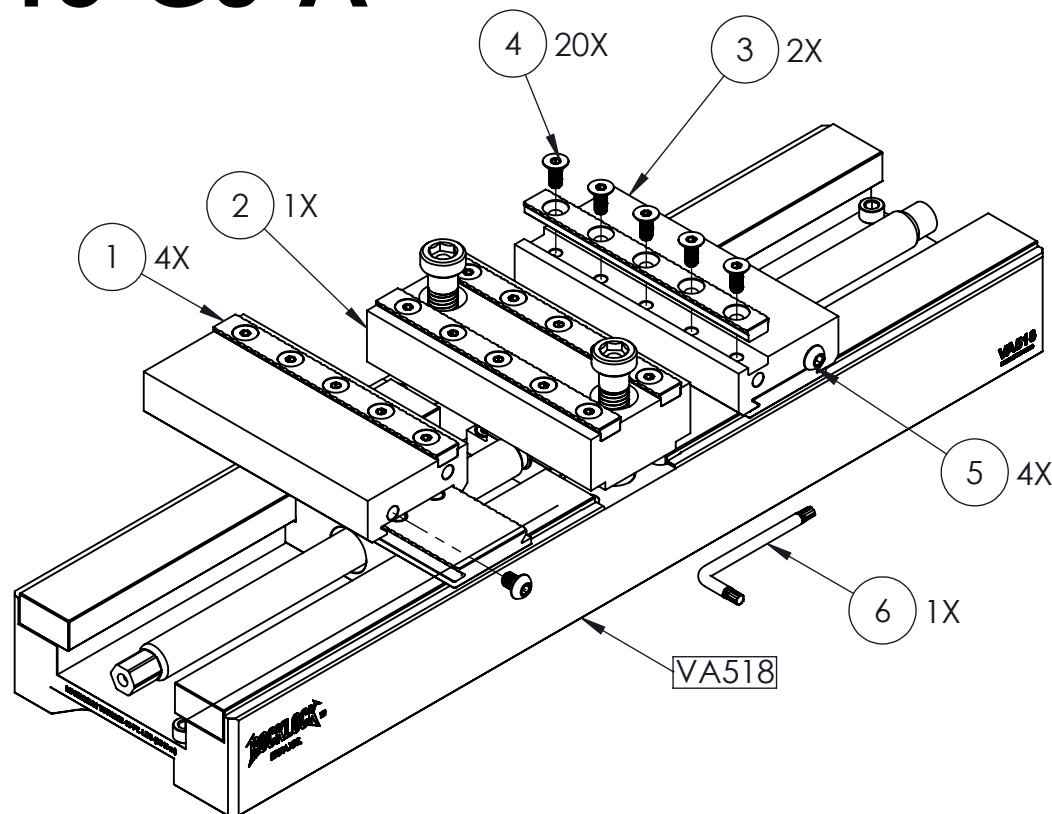
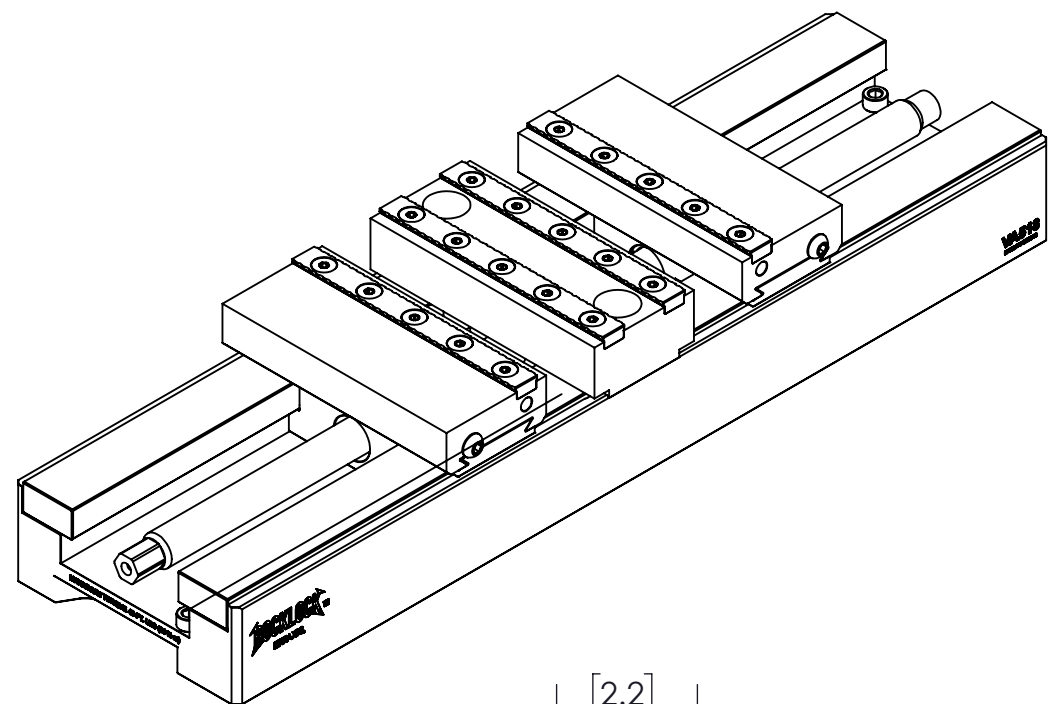
3

2

1

TECHNICAL DATA	VA518 WITH VA513-GJ-A INSTALLED
JAW WIDTH	4.95" (125 mm)
BASE LENGTH	18" (457 mm)
CLAMPING FORCE	5000 lbf @ 45 ft-lb (22 kN @ 60 Nm)
MAXIMUM TORQUE (LEADSCREW)	45 ft-lb (60 Nm)
MAXIMUM TORQUE (M5 FHCS)	55 in-lb (6 Nm)
MAXIMUM TORQUE (M6 BHCS)	65 in-lb (7.5 Nm)

VA518 SHOWN W/ OPTIONAL VA513-GJ-A



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VA56-7	GRIPPER BAR	4
2	VGD-VA5-F	DUAL VISE FIXED GRIPPER JAW, ALUMINUM	1
3	VGD-VA5-M	DUAL VISE MOVEABLE GRIPPER JAW, ALUMINUM	2
4	M5X12MM.TPFHS	TORX PLUS FLAT HEAD SCREW, M5X.8X12MM	20
5	M6X8MM.BHCS	BUTTON HEAD CAP SCREW, M6X1X8MM	4
6	IP25.L-KEY	TORX PLUS L-KEY, IP25	1

FOR REFERENCE ONLY - NOT FOR RESALE

MILLIMETER

WWW.5THAXIS.COM
 7140 ENGINEER ROAD
 SAN DIEGO, CA 92111
 P (858) 505-0432



DESCRIPTION
**LITE VISE - 5X18
 W/ STACKABLE ALUMINUM GRIPPER JAW**

THIRD ANGLE PROJECTION

SIZE
B

PART NO.

VA518 WITH VA513-GJ-A

REV
C

DO NOT SCALE DRAWING

SCALE 1:3

WEIGHT:

SHEET 5 OF 6

8

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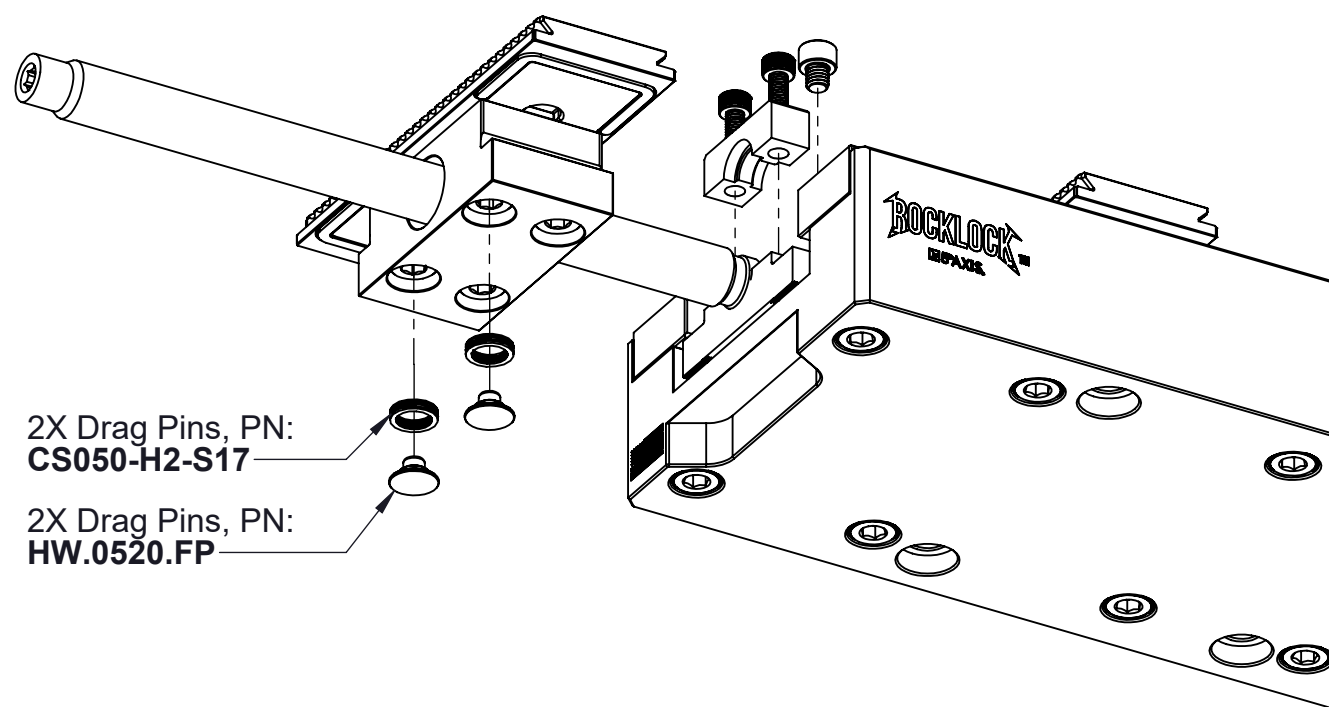
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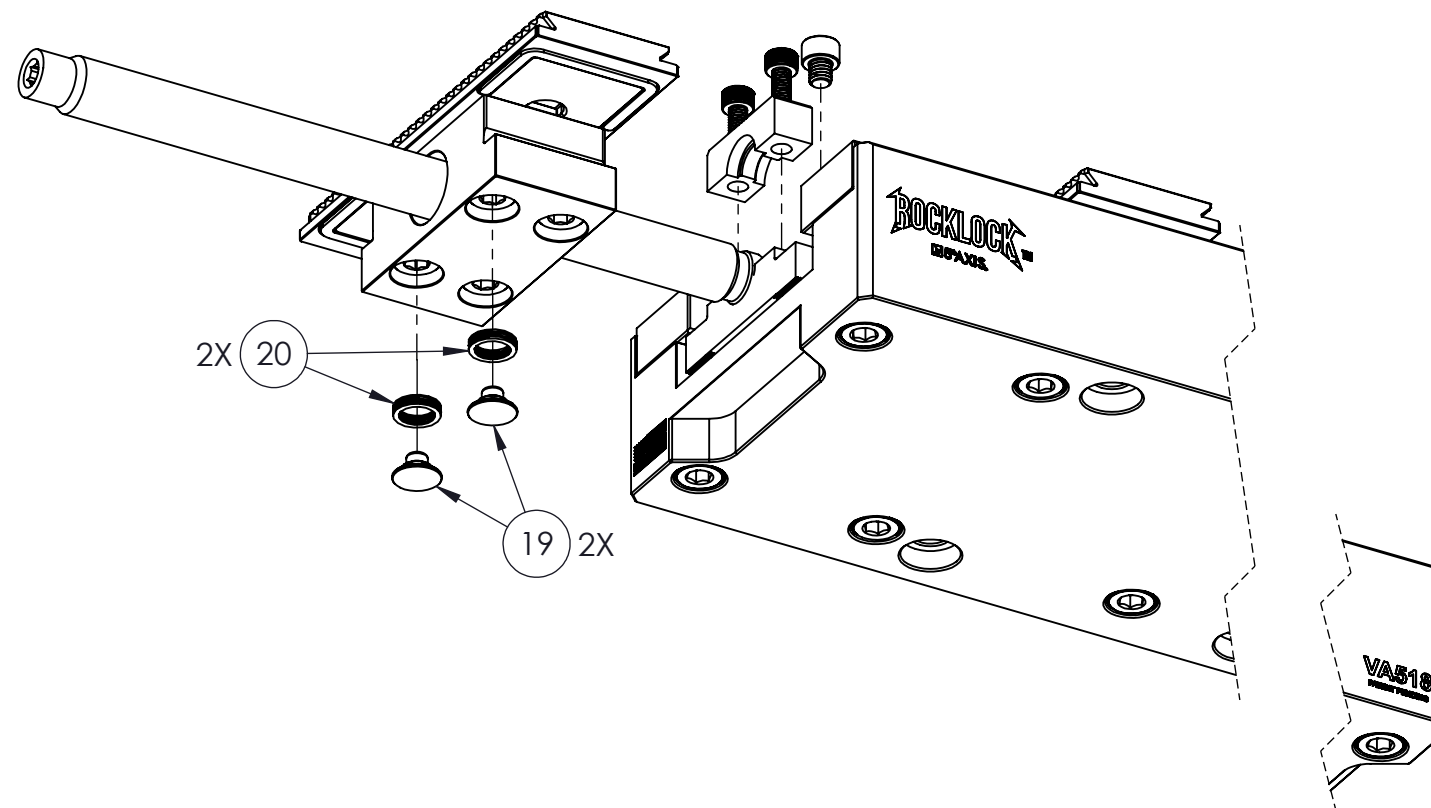
1

VA518 DRAG PIN & SPRING DETAIL



2X Drag Pins, PN:
CS050-H2-S17

2X Drag Pins, PN:
HW.0520.FP




2X (20)

(19) 2X

The latest revision of VA513 and VA518 include 2x Drag Pins and Compression Springs (shown above) to provide friction when vise is used in a vertical orientation, so the trucks do not slide freely (in dual station configuration only).

Use caution when sliding truck and jaw assembly partially out of base during maintenance or conversion between dual station and self-centering configurations, as these components will eject themselves. Upon re-installation of the truck and lead screw assembly, the pins and springs must be assembled as shown, and compressed as the truck is slid into the base. Pins and springs can be installed in any or all of the jaw bolt counterbores on the underside of the trucks for more or less friction. Replacement pins and springs are available to purchase separately.

MILLIMETER				
WWW.5THAXIS.COM 7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432				
THIRD ANGLE PROJECTION		DESCRIPTION	LITE VISE - 5X18 - DRAG PIN DETAIL	
SIZE	PART NO.	VA518		REV
B				C
DO NOT SCALE DRAWING		SCALE 1:2	WEIGHT:	SHEET 6 OF 6