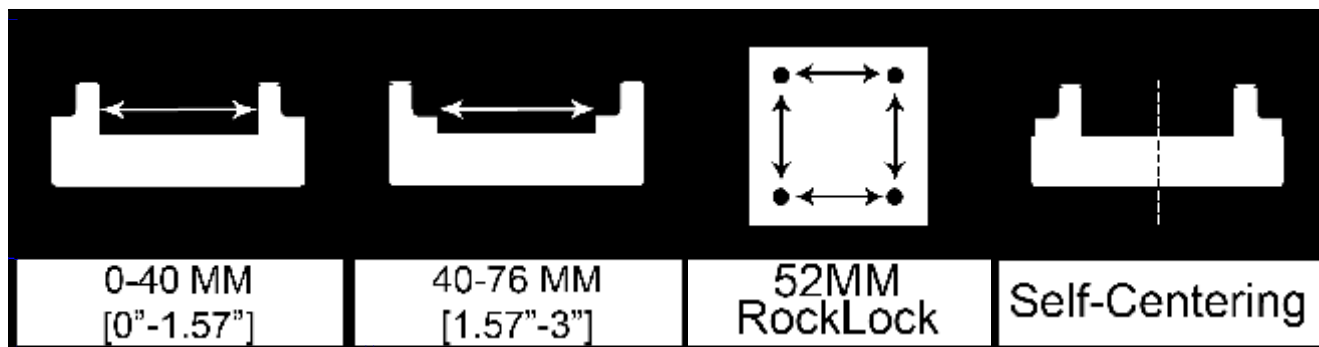
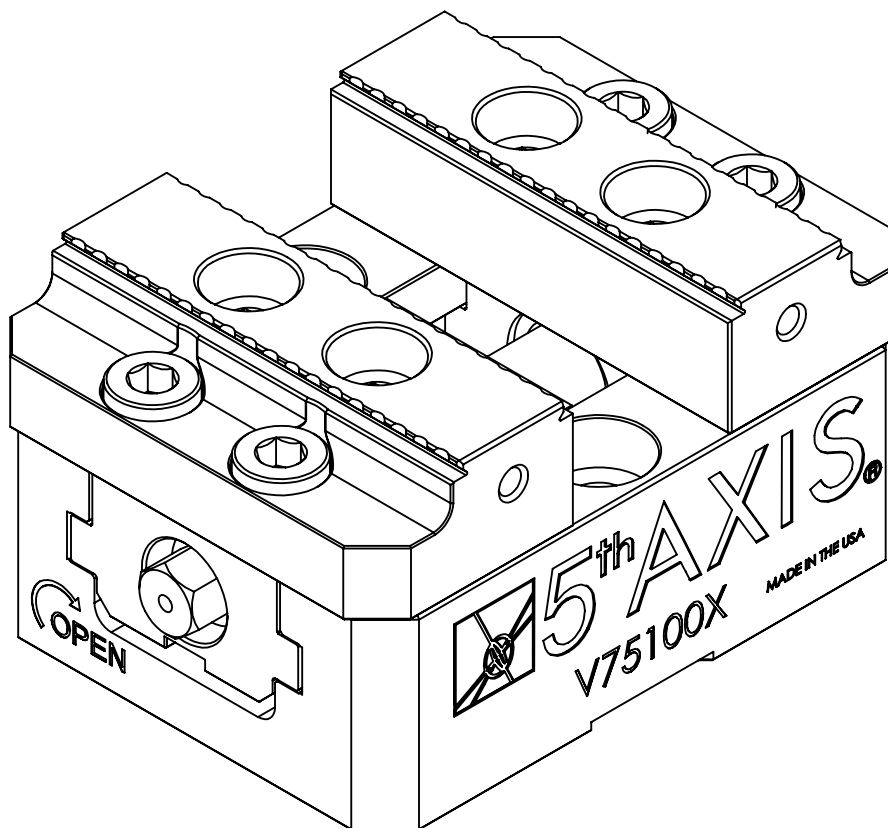


# V75100X VISE OWNER'S MANUAL



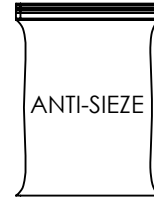
BILL OF MATERIAL

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

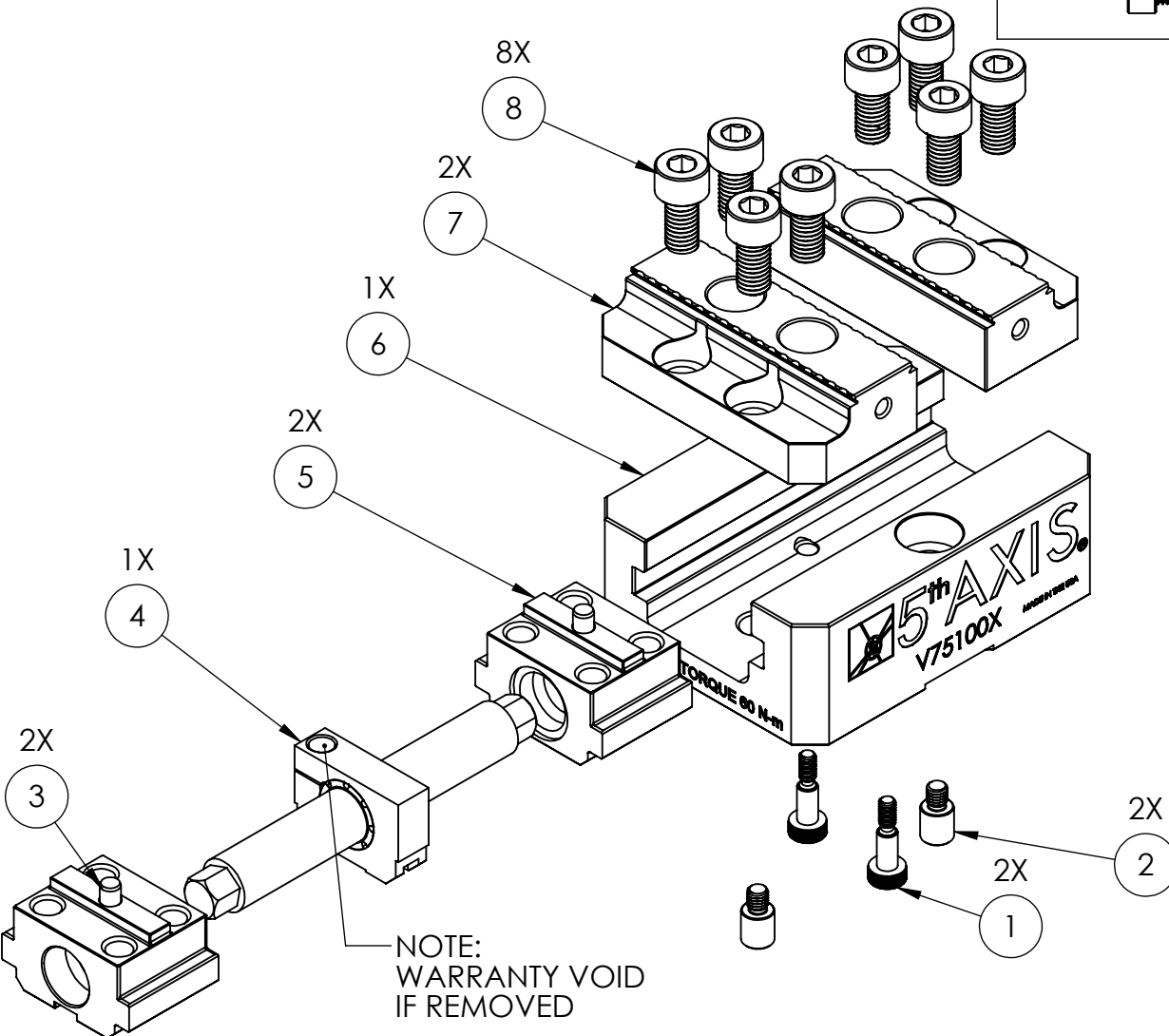


9: THUMBSCREW  
P/N:TS10



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

11: MOUNTING BOLT X2  
M8x40



## Maintenance and Use

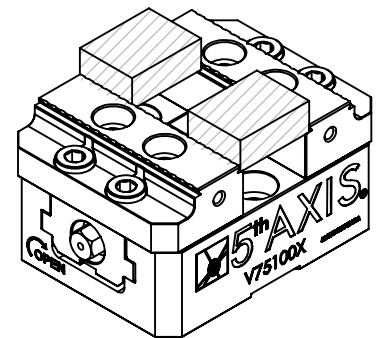
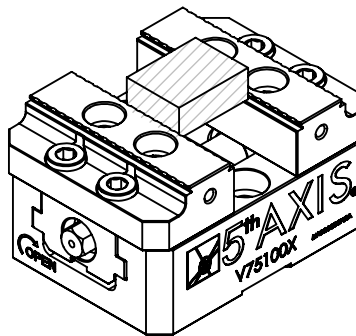
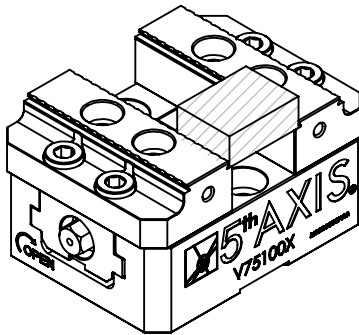
- Clean leadscrew with soft brush
- Use copper based anti-sieze on leadscrew (Loctite P/N: LB8008C5-A)
- Do not let chips build up during use
- Do not torque vise past 60 Nm [45 Ft LBS]
- Do not side load vise (see illustration below)
- Clamping Force at max torque with Master Jaws installed-22.2 kN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

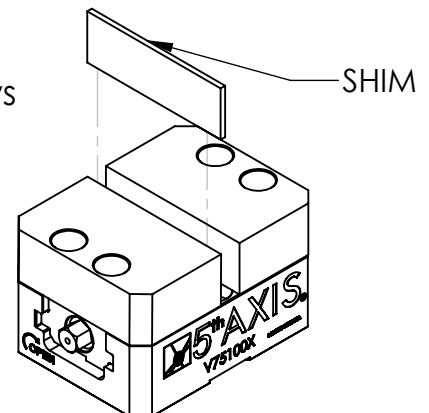
- Removing leadscrew assembly is not recommended and will void the warranty
- Failure to follow these instructions will cause self centering accuracy and/or repeatability to fail and may cause damage to the vise
- It is recommended to use only the two outside locating pin holes [LP8] labeled on page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



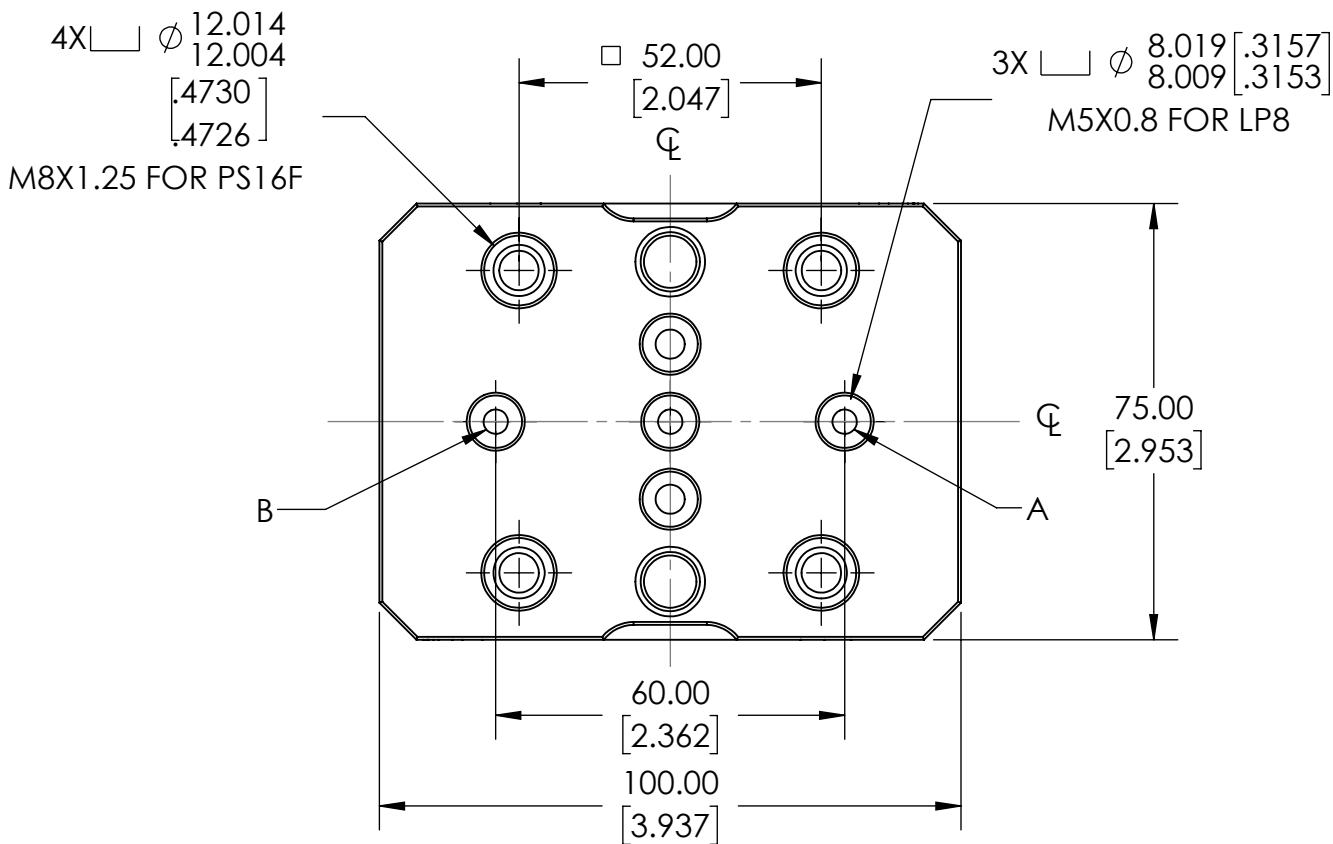
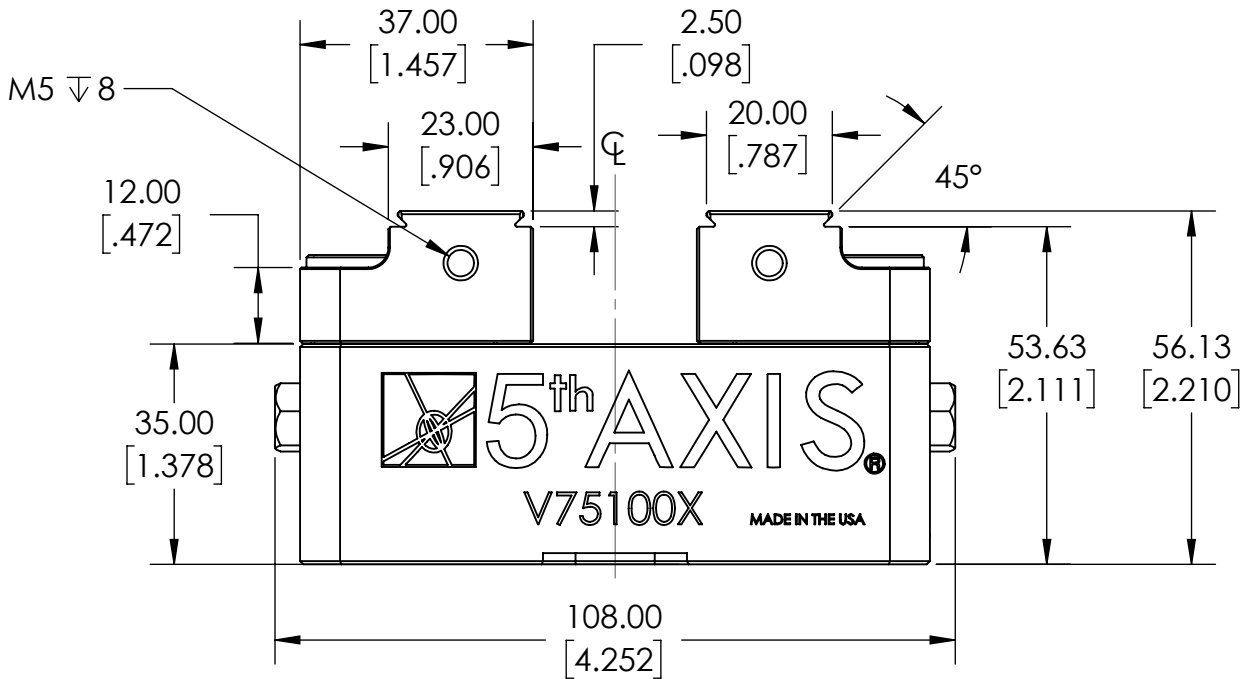
### To Machine Profiles into Soft Jaws/Anti-Lift Soft Jaws:

- 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.



# DIMENSIONS



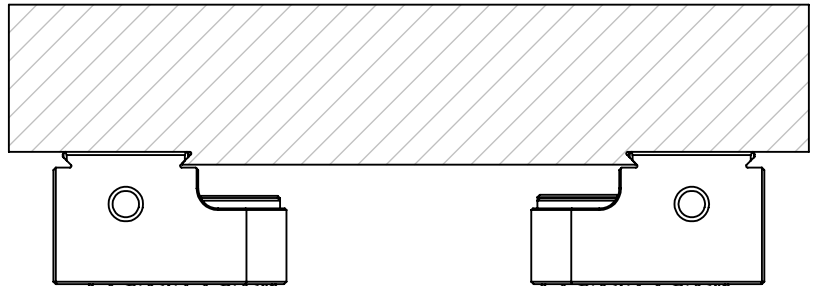
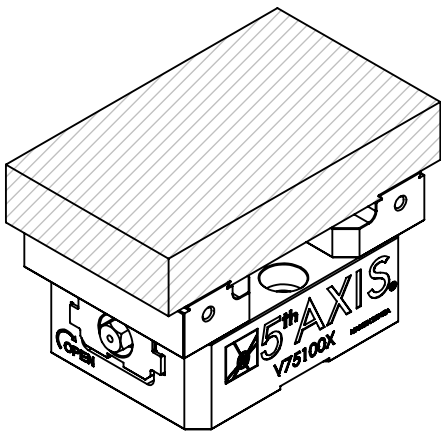
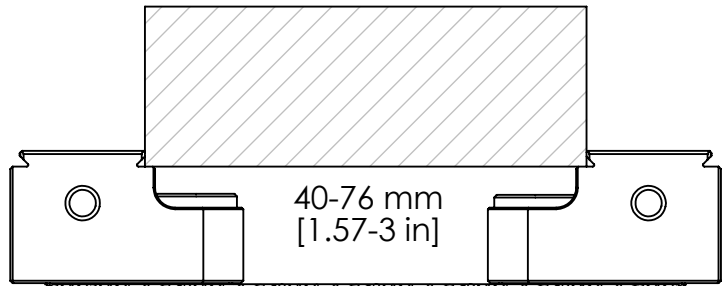
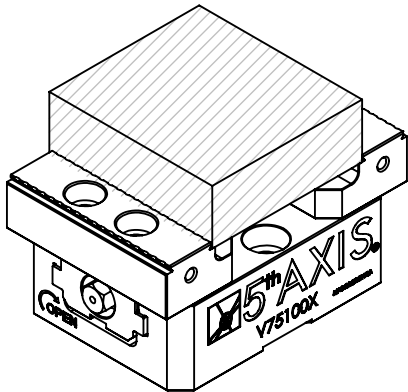
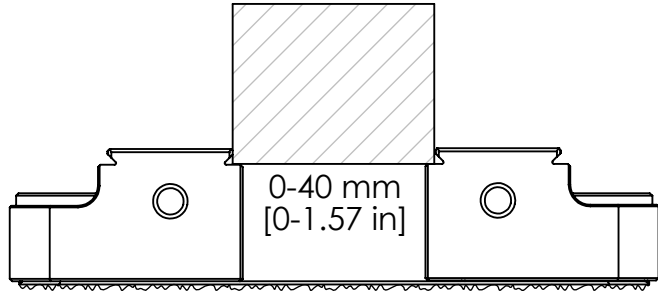
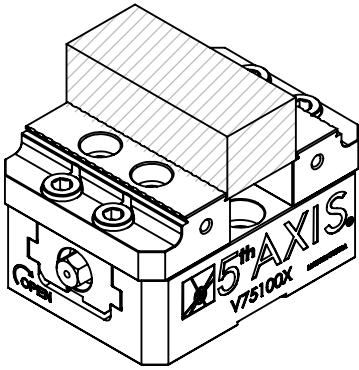
# CONFIGURATIONS

## Use Serrations For:

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

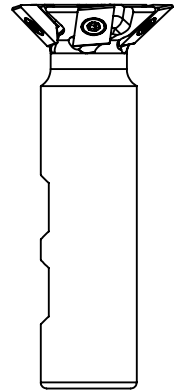
## Use Dovetail for:

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

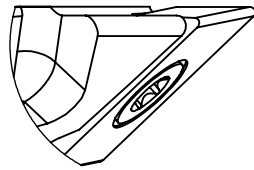


(See next page for dovetail stock prep)

# Dovetail Stock Prep

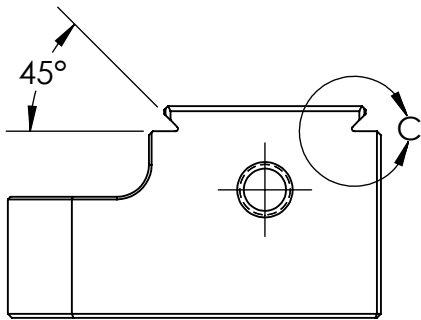
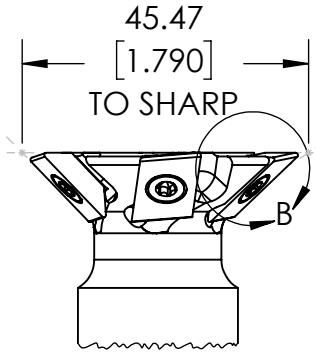


## Dovetail Cutter



[R .0381 mm]  
R .015

DETAIL B  
SCALE 2 : 1



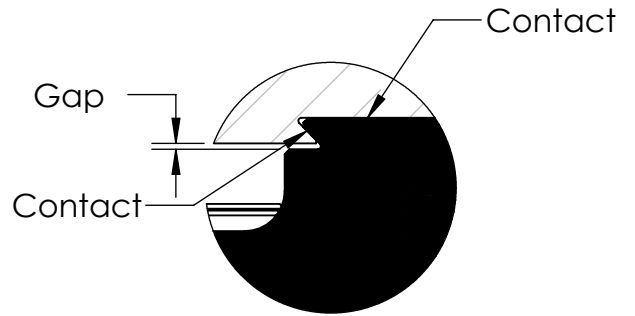
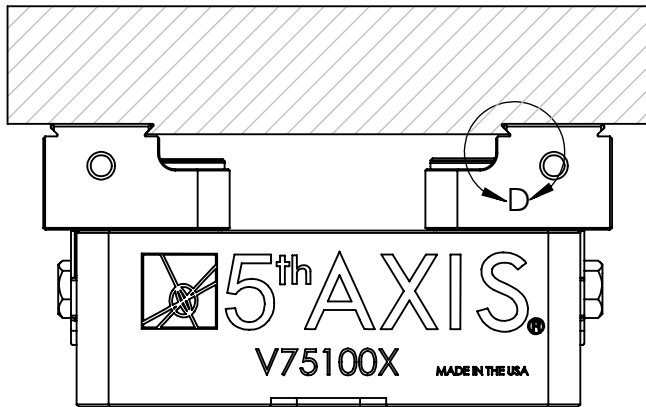
1.38  
[.054]

2.50  
[.098]

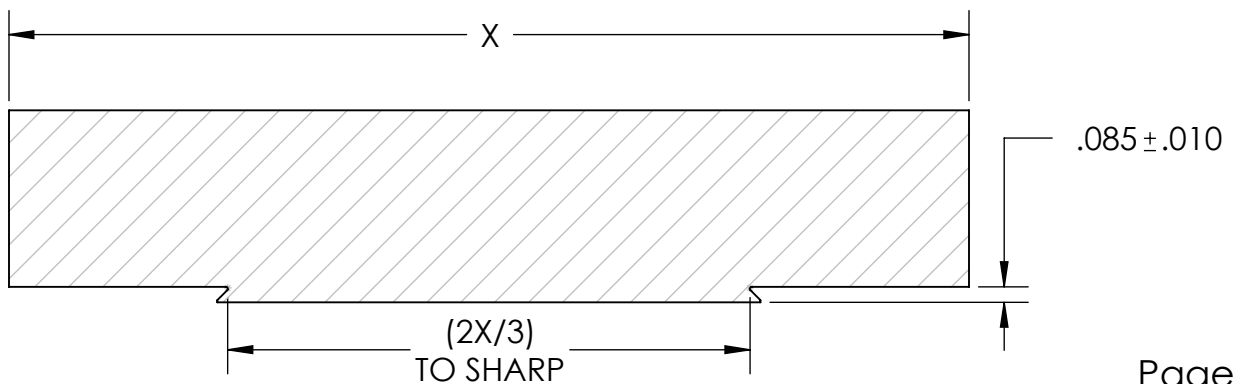
R0.25  
[.010]

Master Jaws  
Steel Grade: 4140 Steel  
Hardness: HRC 53-57  
P/N:V75100X-5

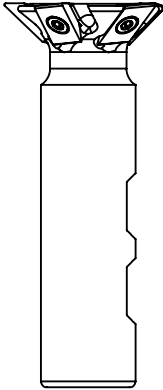
DETAIL C  
SCALE 4 : 1



DETAIL D  
SCALE 2 : 1.2



# 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]



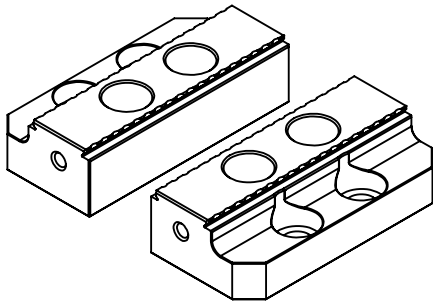
## 52mm Pull Studs

**P/N: PS16-F**

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

## Installing Pull Studs

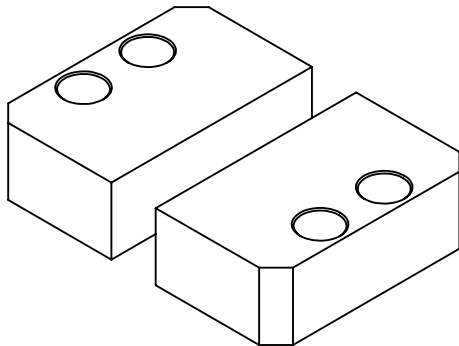
- Secure threaded stud finger tight only
- Grease precision surfaces
- Torque to 10 Ft-lbs via bottom hex head



## Replacement Master Jaws

**P/N: V75100X-5**

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



## Soft Jaws

**VAJ75X- Aluminium**

**P/N: VAJ75X**

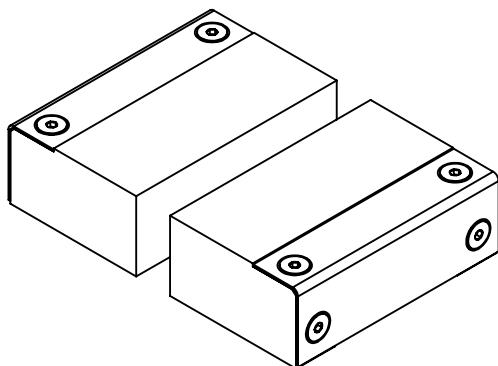
- 6061-T6
- Compatible with V75100 and V75100X
- 75mm x 45mm x 25mm

**VSJ75X-Steel**

**P/N: VSJ75X**

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

DOWNLOAD DRAWINGS AT: [FIFTHAXIS.COM/DOWNLOADS](http://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](http://fifthaxis.com/downloads)