

Milling instructions for movable jaws and stationary jaws

In order to achieve a highly precise clamping position, the following steps must be carried out:



General hazard

An unexpected start of the machine spindle increases the risk of accident.

General hazard

Observe the operating instructions for the clamping device, as well as the operating instructions for the machine!

1. Position the jaws in the forwardmost position on each base jaw.
2. Put a square piece of metal between the jaws and clamp it with clamping pressure [see Fig. 1].
3. Machine the red marked surfaces in order to produce a precise stop surface [see Fig. 2].
For a new jaw the machining allowance for hard machining is 0.1–0.15 mm. The jaw is case-hardened. It has a maximum hardness of 60 HRC and a maximum hardening depth of 0.6 mm.
4. Remove the square material after machining.

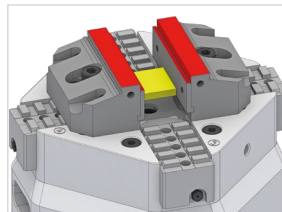


Fig. 1
clamped square material

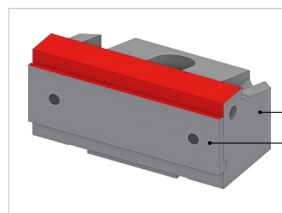


Fig. 2
movable jaw