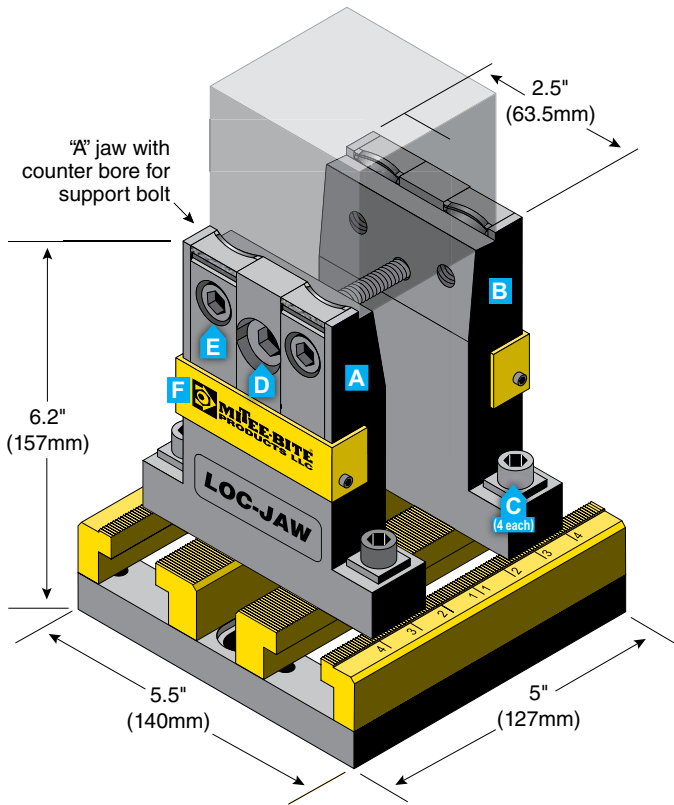


Congratulations on the purchase of your New Loc-Jaw® System!



The Loc-Jaw® system was designed to be a simple solution for 4th and 5th axis machining without having to perform a pre-op prior to running your parts. Two heavy duty hex T-handles are included for quick adjustments and tightening of workpieces ranging from .500" to 4". Extension Kit available for larger applications.

NOTE: A centering disk 1.5" (38.1mm) can be mounted to bottom of base unit for quick centerline location on faceplates having centering hole feature. Base plate is also configured with two drill bushings for use with diamond and tapered pins. This provides a quick change and precise mounting option. (Centering disk and pins included in accessory pack.)

1. Mount unit to faceplate/sub-plate using (2) 1/2-13 or M12 SHCS.

NOTE: Gripping Jaws can be adjusted to workpiece size by simply loosening jaw bolts **C** with support bolt **D** removed. Serrated rails have inch and metric indicators, which align with inboard face of jaws.

2. Loosen Jaw bolts and adjust to approximate width using workpiece. Tighten Jaw bolts; ensuring jaws are properly aligned in serrations and not pinching workpiece between hard stops. Tighten support bolt until desired load/unload clearance is achieved.

NOTE: An adjustable locator is provided if workpiece extends beyond jaw. Install on either jaw for precise lateral location of workpiece. Adjust and lock in place with provided locking nut. (Wrench and thumb screw in accessory pack)

NOTE: If precise location of workpiece is required a torque sequence on gripper bolts **E** is recommended and must be performed in same manner to achieve consistent results.

3. Secure workpiece by tightening both gripper bolts on one jaw then gripper bolts on opposite jaw. Combo-Edge Grippers are capable of producing over 6,000 pounds of force. The Knife Edge side penetrates up to .060" into the workpiece and the Blunt Edge side is coated with Tungsten Carbide for machining hard alloys.

Part is now ready to machine

GRIPPING ON WORKPIECES LESS THAN 1" WIDE:



1. Remove Jaw **A** (has counter bore for support bolt).
2. Remove chip cover **F** using 2.5mm hex key.
3. Remove gripper pivot pins, bolts and grommets (place grommets in accessory pack).
4. Place gripper plugs in counter bored holes of grippers and rotate grippers 180 degrees, reinstall pins.
5. Reinstall chip cover.
6. Place Jaw **A** back on base unit rotated 180 degrees from removed position.
7. Screw in gripper bolts and support bolt from back side of jaw.
8. Adjust jaws to desired location and tighten jaw bolts **C** and support bolt.
9. Part is ready to machine; tighten grippers on Jaw **A** first then grippers on opposite jaw.



Using Extension Kit

Torque (Ft/lbs)	Holding Force (lbs)
10	2,000
15	3,000
20	4,000
25	5,000
30	6,000

NOTE: Blunt Edge side is recommended for alloys above 35Rc



Knife Edge side

Blunt Edge side

Replacement Parts

Part No.	Description
14501	Loc-Jaw® Support Bolt #1 (M10 x 45mm)
14502	Loc-Jaw® Support Bolt #2 (M10 x 65mm)
14503	Loc-Jaw® Support Bolt #3 (M10 x 90mm)
14504	Loc-Jaw® Support Bolt #4 (M10 x 110mm)
14508	Loc-Jaw® Combo-Edge Grippers - 1 side knife edge, other side blunt edge with carbide coating (2 per pack)
14518	Loc-Jaw® Jaw Set - includes 2 Jaws, 4 Combo-Edge Grippers and Screws
14525	Loc-Jaw® Extension Kit - includes Base, 4 Rails, 1 meter of Rod & Hardware