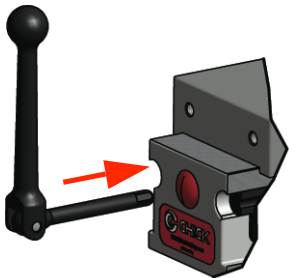


One-Lok™ Single Station CNC Vise User Guide: Workpiece Clamping

STEP 1:

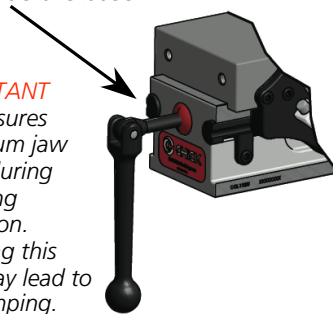
Insert the One-Lok swivel wrench into base.



STEP 2:

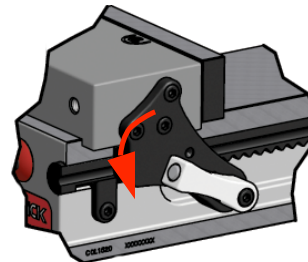
Open the movable jaw to its maximum open position with the drive racks extended slightly outside the base.

IMPORTANT
This ensures maximum jaw travel during clamping operation. Omitting this step may lead to misclamping.



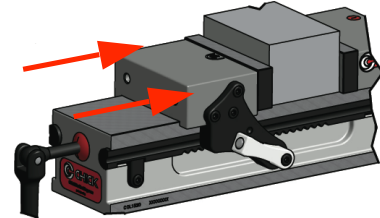
STEP 3:

Depress the buttons on the quick-release toggles and rotate the toggles down to their unlocked position.



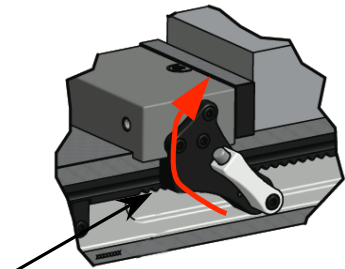
STEP 4:

Slide the movable jaw to meet your workpiece – now that's fast!



STEP 5:

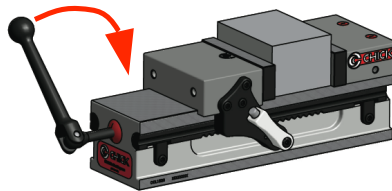
Rotate the toggles back up to their locked position.



When the toggles are locked, the movable jaw will move back slightly to engage the drive racks.

STEP 6:

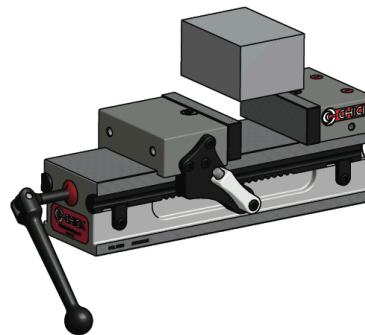
Clamp your workpiece down – up to 10,000 lbs! – by turning the swivel wrench only several turns clockwise.



Note: The drive racks have 20mm (.75") of travel. The pitch of the drive rack teeth is 10mm (.375).

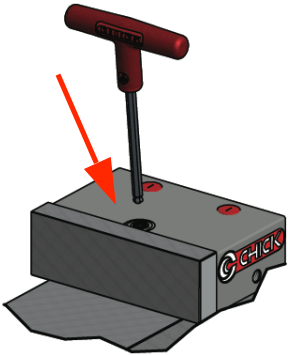
STEP 7:

Now you can quickly unclamp and clamp successive workpieces using just the swivel wrench.

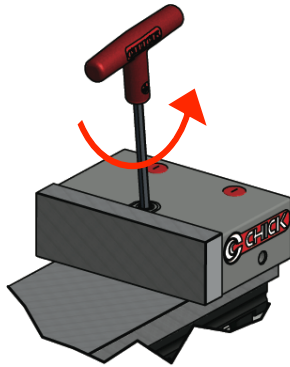


One-Lok™ Single Station CNC Vise User Guide: Removal and Installation of BoltFast™ Jaws

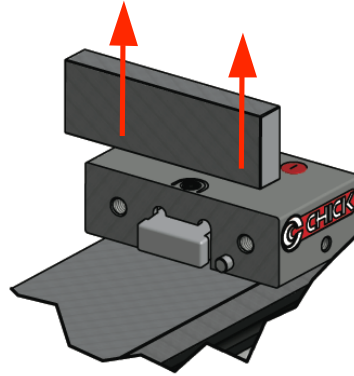
STEP 1:
Insert the One-Lok T-wrench
into the locking screw.



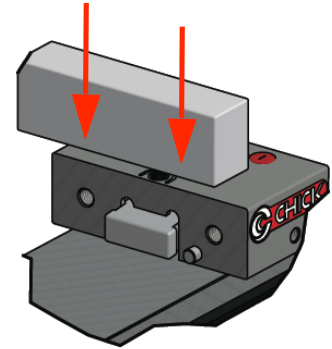
STEP 2:
Turn counterclockwise to loosen
the BoltFast locking slider.



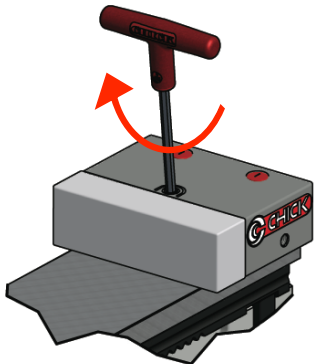
STEP 3:
Remove the BoltFast jaw by
sliding it upward.



STEP 4:
Place the new BoltFast jaw by
sliding it downward onto the
locking slider.



STEP 5:
Using the T-wrench, tighten
the locking screw hand-tight.



STEP 6:
Your BoltFast jaws are now
ready for clamping.

