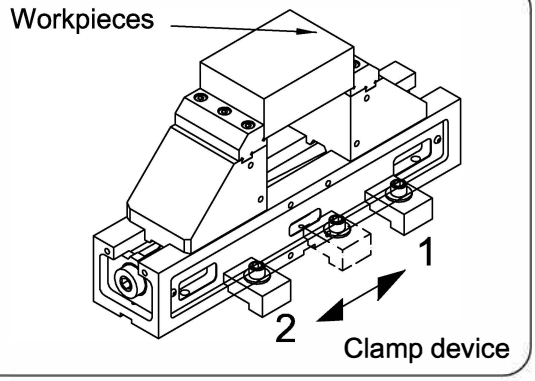
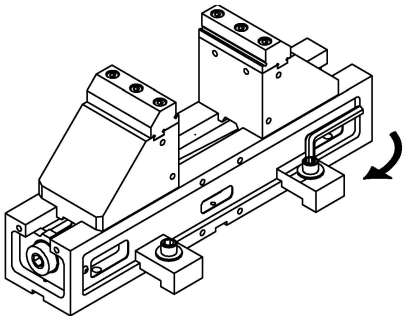


Installation to machine tool

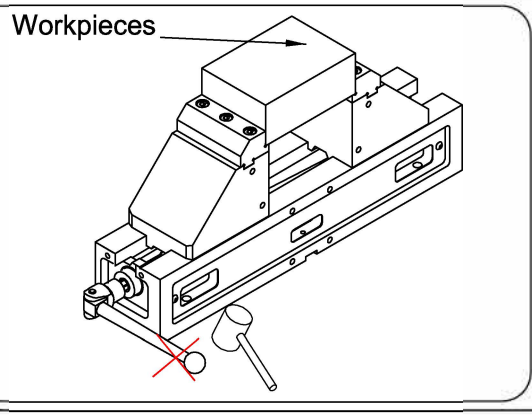
Set the clamp devices to optimum positions according to work size so as to minimize lifting of workpiece.



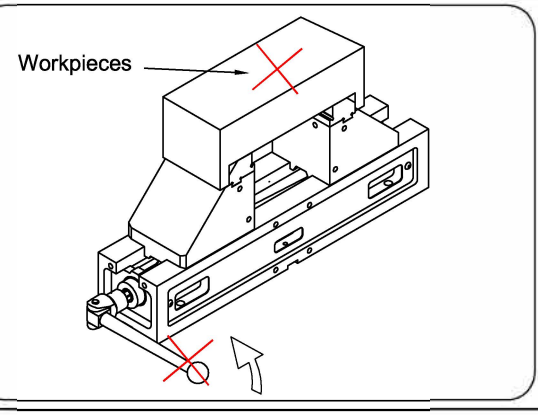
Securely tighten bolts

Tighten to recommended torque

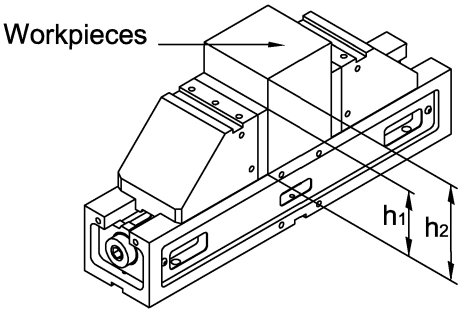
Bolt size M	M10	M12	M14	M16
Tighteening torque kg.m	600	1000	1500	1600



Caution when operaling ; The design of the vise with its active handle can create over one time of clamping force than general vise does. Do not hit the handle or its vicinity with a hammer ect., while fastening.



Usually turn handle clockwise when clamping work.

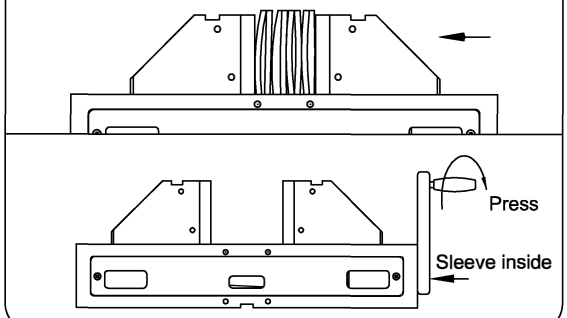


Work height should be lower than twice height of jaws(depend on cutting force)

Don't cut extremely tall work in comparison with jaw height.

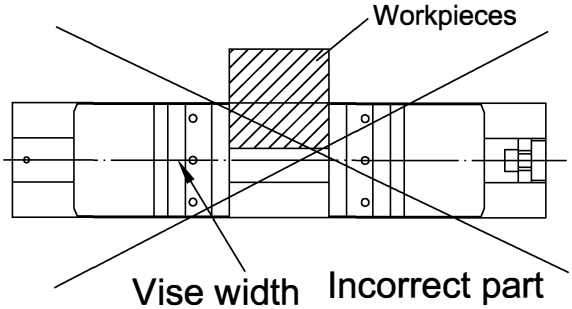
Reduce cutting force when cutting direction is ↑as shown.

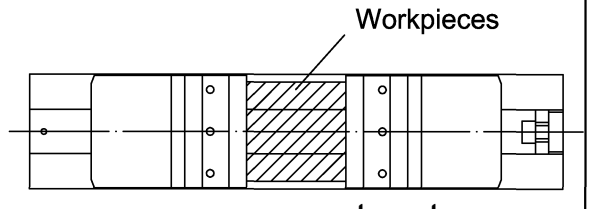
{$h_2 < h_1 \times 2$} is reference formula.

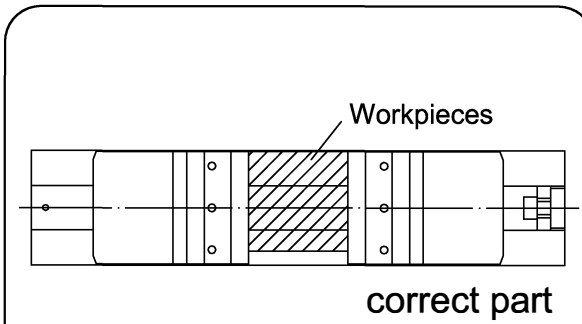


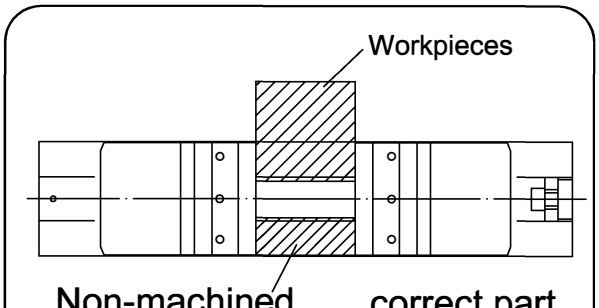
In order to avoid distortion, in the case of thin walled, hollow or lower rigidity workpieces, set the desired clamping rage before performing the suffcient preliminary clamping by turning the handle clockwise, pushing the sleeve forward as shown in the firure.

Release sleeve mechanism and turn the handle clockwise for the final clamp adjustment. The handle operation for this priliminary clamping must be done by hand without using a hammer.



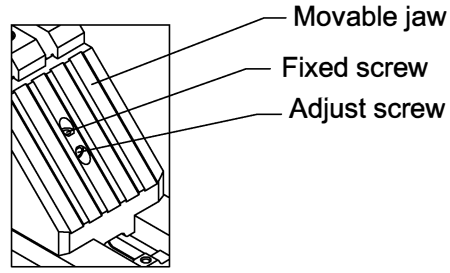






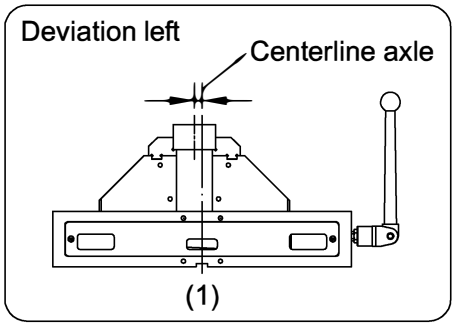
Adjust the interval of the Movable jaw:

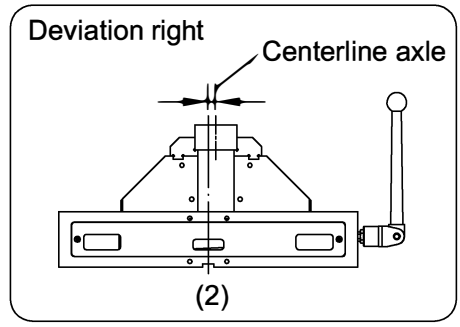
Don't tie the adjust screw when you setting.It will cause the movable jaw can't move smooth.



The step of the revise the center:

How to setting the center?Please see the diagram.
Please check the centerline is deviation right or left first.





The step of the sequence:

1.Please unlock the fixed nut first and unlock the stop screw.

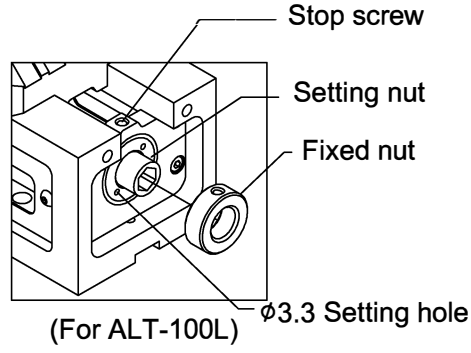
2.If the situation like (1), Please in clockwise the setting nut. One circle is about 1.5mm distance.

3.If the situation like (2), Please in opposite clockwise the setting nut. One circle is about 1.5mm distance.

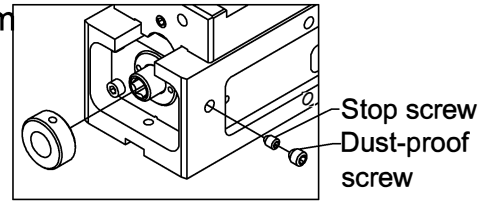
4.Finaly,tight the stop screw first and tight the fixed nut for smooth turning.

5.After setting, please check the center is correct.
If not, please do the step 2 or step 3 again.
If yes, it finish the setting.

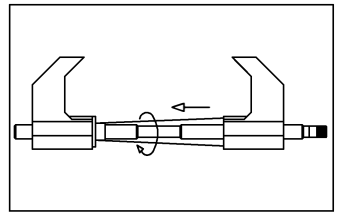
6.Please clean the vise and inside the vise ever 3 month. And please use the antirust oil on the spindle.



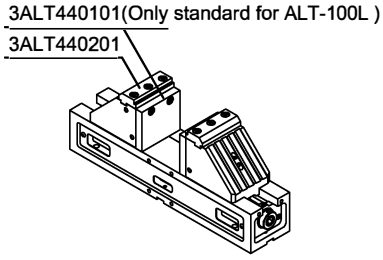
(For ALT-100L)



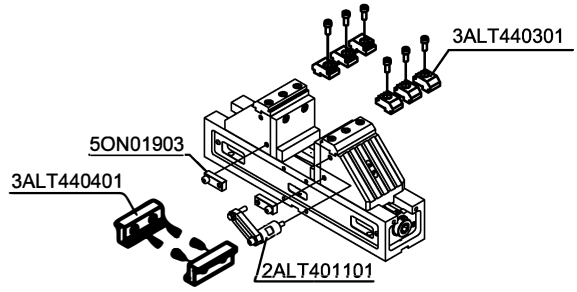
(For ALT-75)



Model: ALT-75 & ALT-100



(Standard attached jaws)



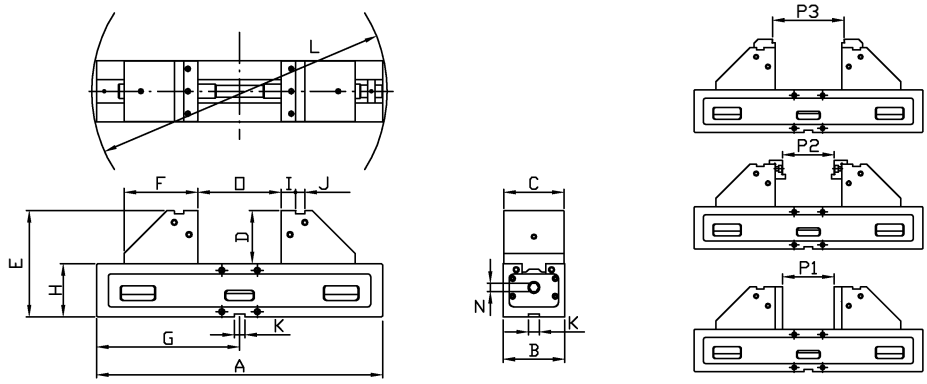
(Option parts and jaws)

Part list for jaws and parts

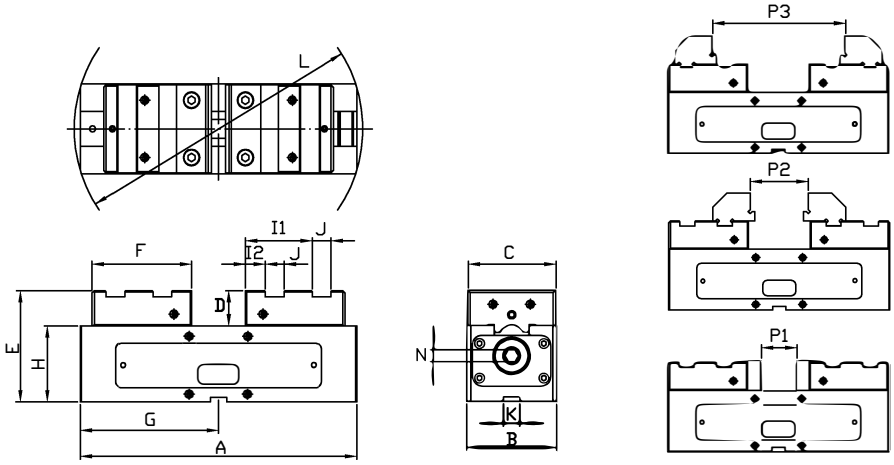
1. 3ALT440101 Standard Jaws X 2pcs
2. 3ALT440201 Step jaws X 2pcs
3. 3ALT440301 V type jaws X 6pcs
4. 3ALT440401 Z type jaws X 2pcs
5. 5ON01903 Workstop1 X 2pcs
6. 2ALT401101 Workstop2 X 2pcs

Dimensions:

3 Different clamping positions



MODLE	A	B	C	D	E	F	G	H	I	J	K	L	N	O	P1	P2	P3	Clamping Force	Weight
ALT-100S	280	104	102	90	180	125	140	90	24	16	14	300	14	30	–	–	40	20KN	17Kg
ALT-100M	324	104	102	90	180	125	162	90	24	16	18	350	13	74	44	42	84	20KN	20Kg
ALT-100L	484	104	102	90	180	125	242	90	24	16	18	500	13	184	102	200	240	20KN	30Kg



MODLE	A	B	C	D	E	F	G	H	I1	I2	J	K	L	N	O	P1	P2	P3	Clamping Force	Weight
ALT-75S	196	77	75	30	95	85	98	65	17	57	16	14	210	10	30	–	26	106	20KN	8Kg
ALT-75M	236	77	75	30	95	85	118	65	17	57	16	14	210	10	70	42	66	146	20KN	10Kg

Model:ALT-100