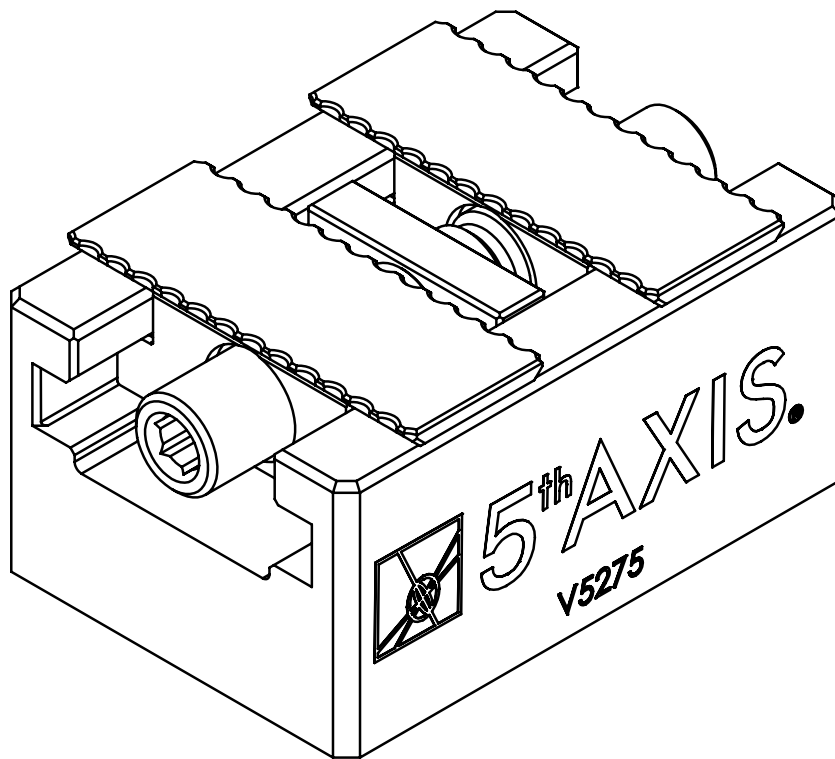
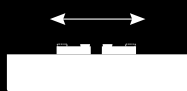


5th AXIS[®]

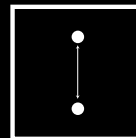
V5275 VISE OWNER'S MANUAL



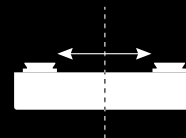
38.5 Max



3.5 Min



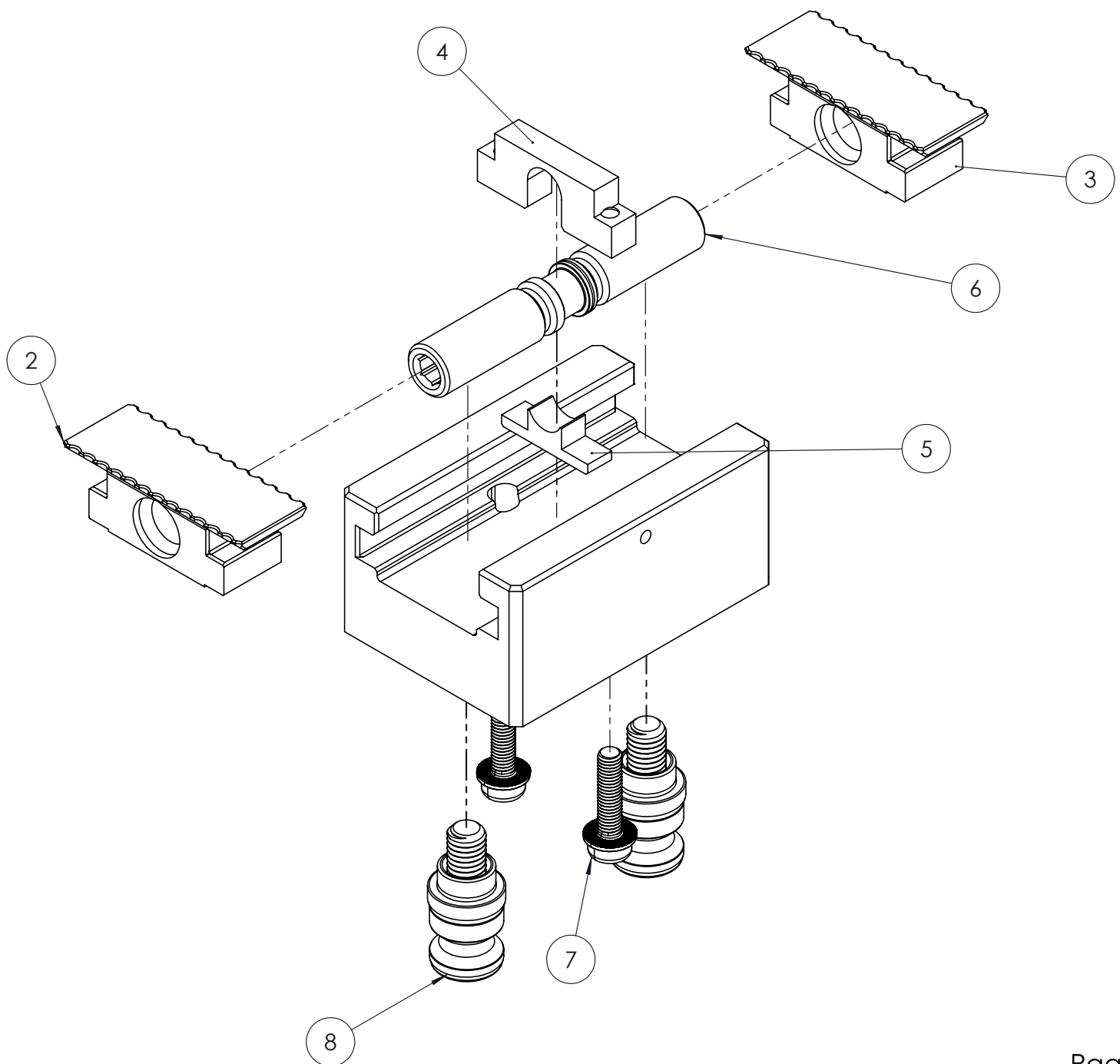
52MM 2X Pull
Stud Spacing



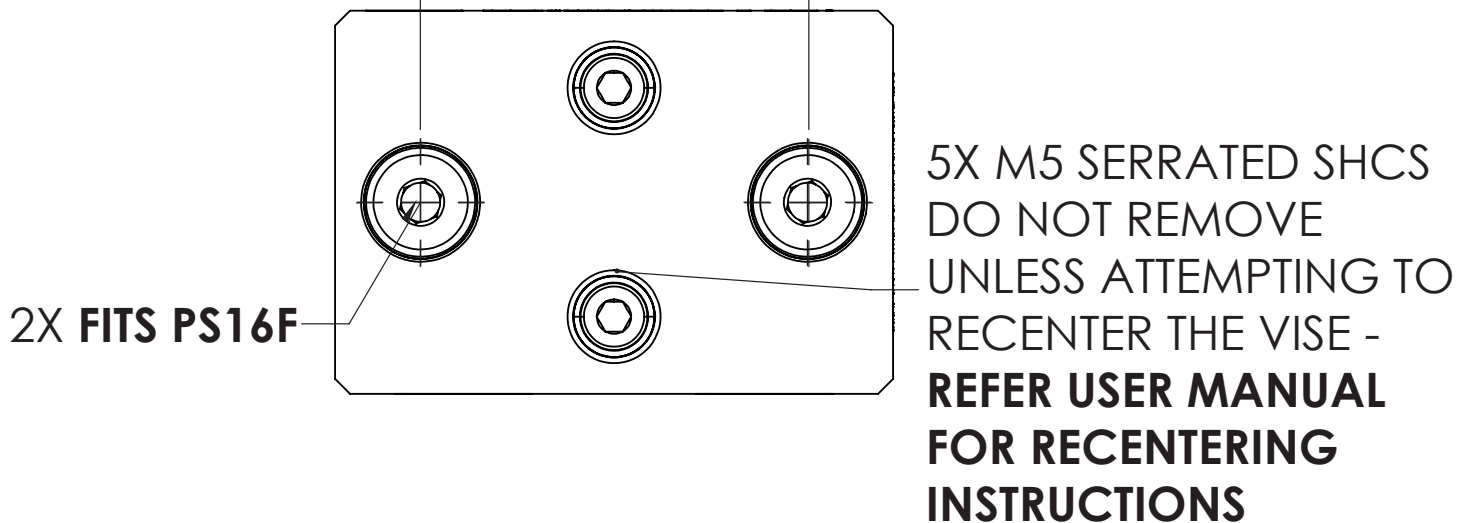
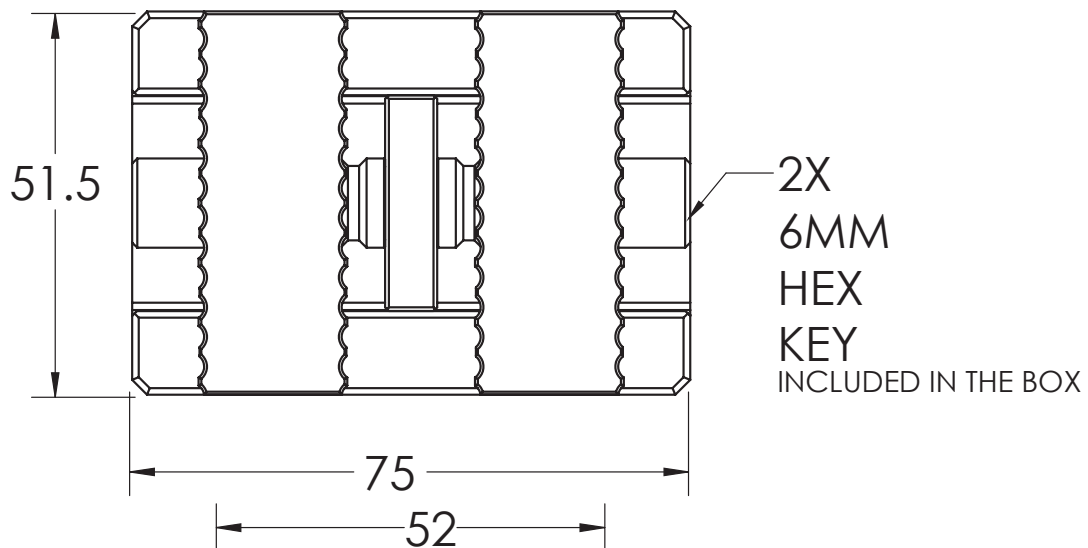
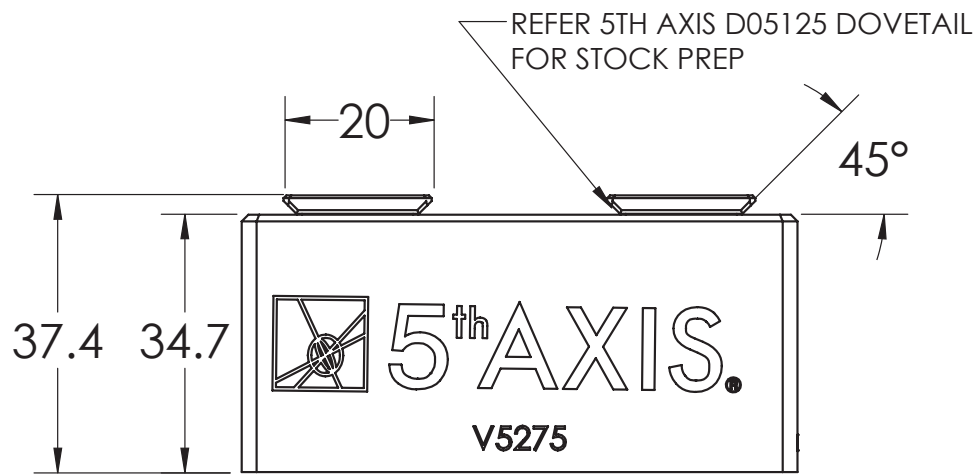
Self-Centering

INCLUDED IN THE BOX

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	V5275-1	BASE, 52 X 75MM, SELF CENTERING VISE	1
2	V5275-2L	75MM VISE, LEFT TRUCK-JAW	1
3	V5275-2R	75MM VISE, RIGHT TRUCK-JAW	1
4	V5275-3T	CENTERBLOCK, TOP	1
5	V5275-3B	CENTERBLOCK, BOTTOM	1
6	V5275-4	LEAD SCREW, 52 X75MM SELF CENTERING VISE	1
7	PS16F	52MM ROCKLOCK PULL STUD	2
8	M5X20.SF.SHCS.10.9.BL	(SERRATED-FLANGE SOCKET HEAD SCREW - M5X0.8 20MM LONG)	2
9	L-KEY-6MM-S	ALLEN-KEY 6MM	1



DIMENSIONS



MAINTENANCE AND USE

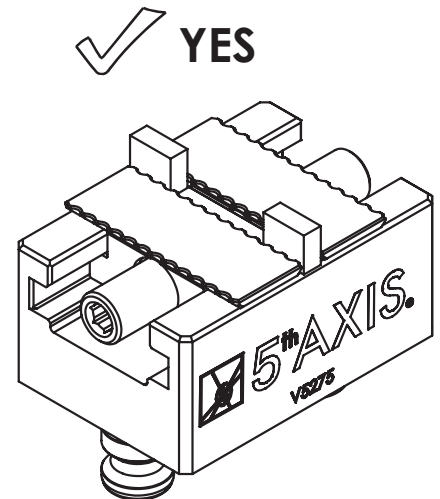
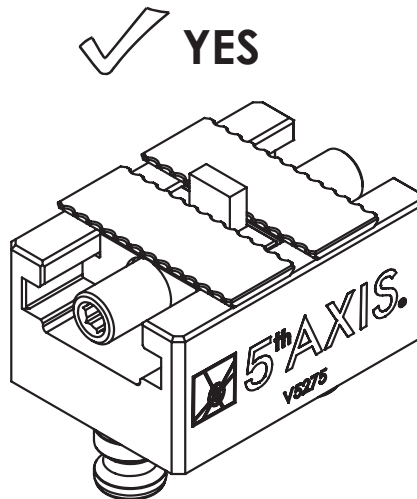
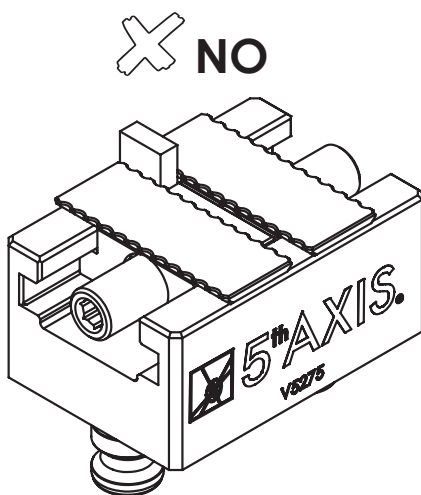
- Clean lead-screw with soft brush
- Use copper based anti-seize on lead-screw (Loctite P/N: LB8008C5-A)
- Do not let chips build up during use
- Do not torque vise past 30 Nm [22.12 Ft LBS]
- Do not side load vise (see illustration below)
- Clamping Force of max torque - 11.12 kN [2500 lbf]
- Weight: 0.8 Kg (1.76 lbs)

Torque Values

- Lead Screw: 30 Nm [22 Ft LBS] Max

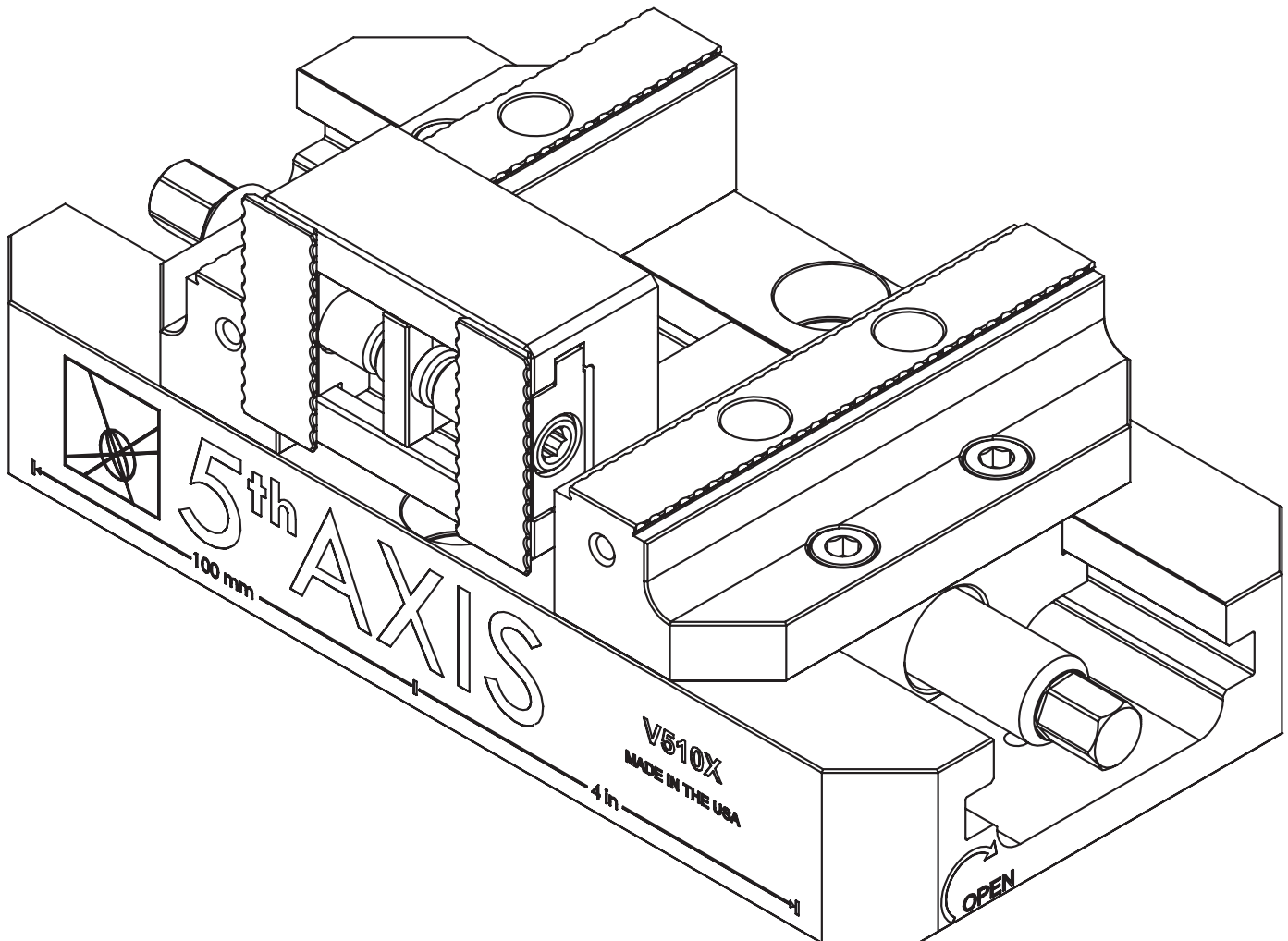
Special Notes

- Failure to follow these instructions will cause self-centering accuracy and/or repeatability to fail and may cause damage to the vise



CENTERING THE V5275

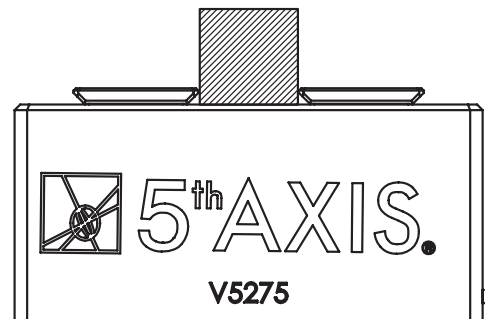
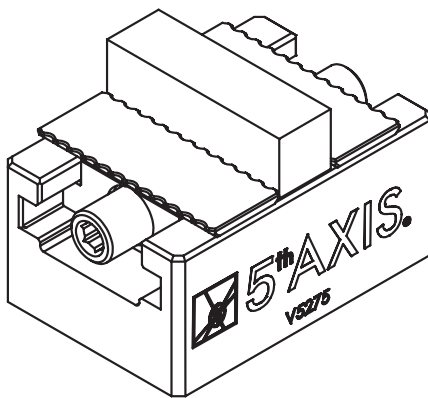
1. Loosen the Bottom Block M5 Bolts (x2, item 8 on BOM).
2. Lightly clamp the trucks (item 2) using a 6 mm hex key. Fully seat trucks against face. (As shown in diagram)
3. Tighten Bottom Block M5 Bolts (x2) to 15 in-lbs (1.69 N·m).
4. Verify jaw center by comparing a gauge block and zeroing at the top and outside of the vise body.
5. The vise should re-center to within .002".
 - Your vise is now re-centered.
 - If vise does not close on center, contact customer support.



CONFIGURATIONS

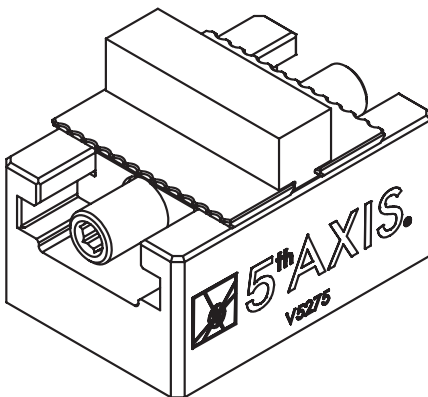
Use Serrations For:

- Softer Materials (Aluminum and soft steels) <25HRC
- Less Aggressive Machining

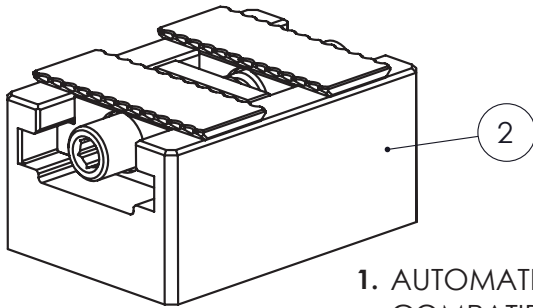


Use Dovetail for:

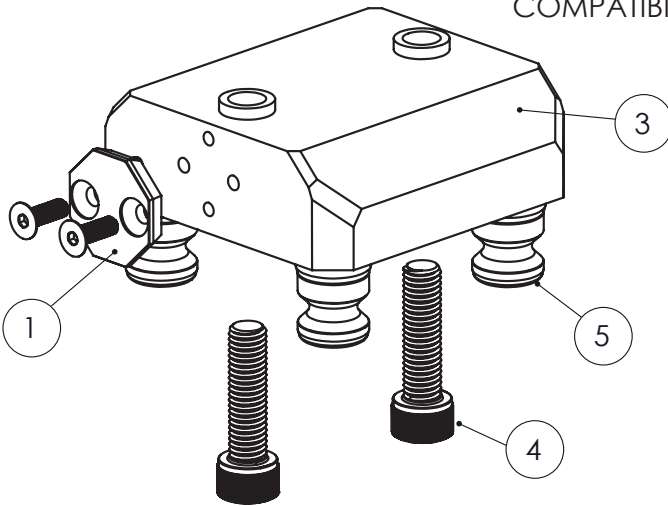
- Harder Materials
- Heavier Machining
- Parts Larger than the Vise



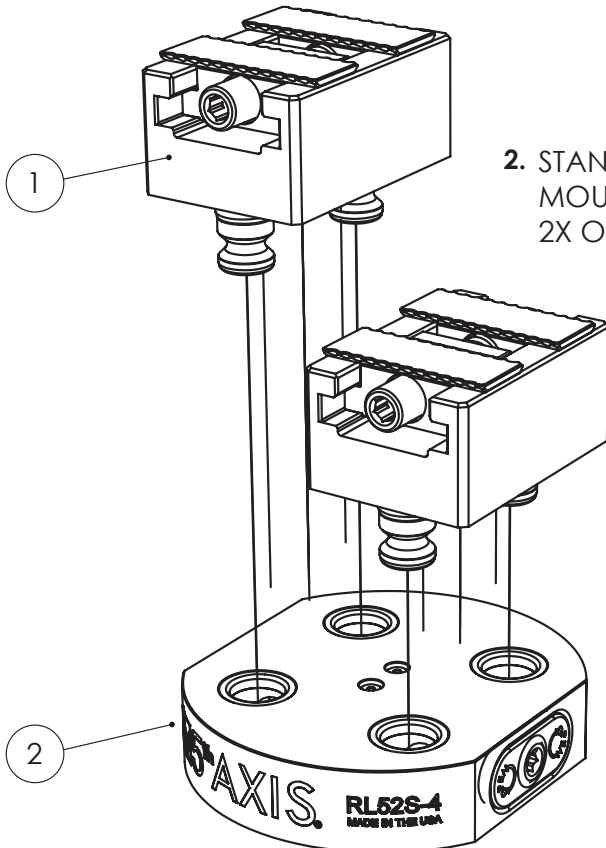
MOUNTING OPTIONS



1. AUTOMATION
COMPATIBILITY



2. STANDARD
MOUNTING
2X ON 52 BASE



ITEM NO.	DESCRIPTION	QTY
1	AGC-52	1*
2	V5275	1
3	A52-V5275-1	1**
4	M8X30.SHCS.12.9.BL	2**
5	PS-16F	4***

* CLEAT SOLD SEPARATELY

** AUTOMATION TOP TOOLING
SOLD SEPARATELY

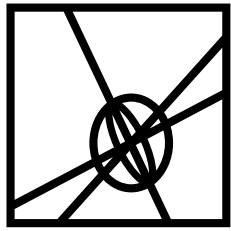
*** VISE COMES WITH 2X PS16F;
ADDITIONAL SOLD SEPARATELY

NO	DESCRIPTION	QTY
1	V5275	2
2	RL52S-4*	1

* ANY 52MM ROCKLOCK BASE WILL BE
COMPATIBLE.

RL52S-4 SHOWN FOR REFERENCE.

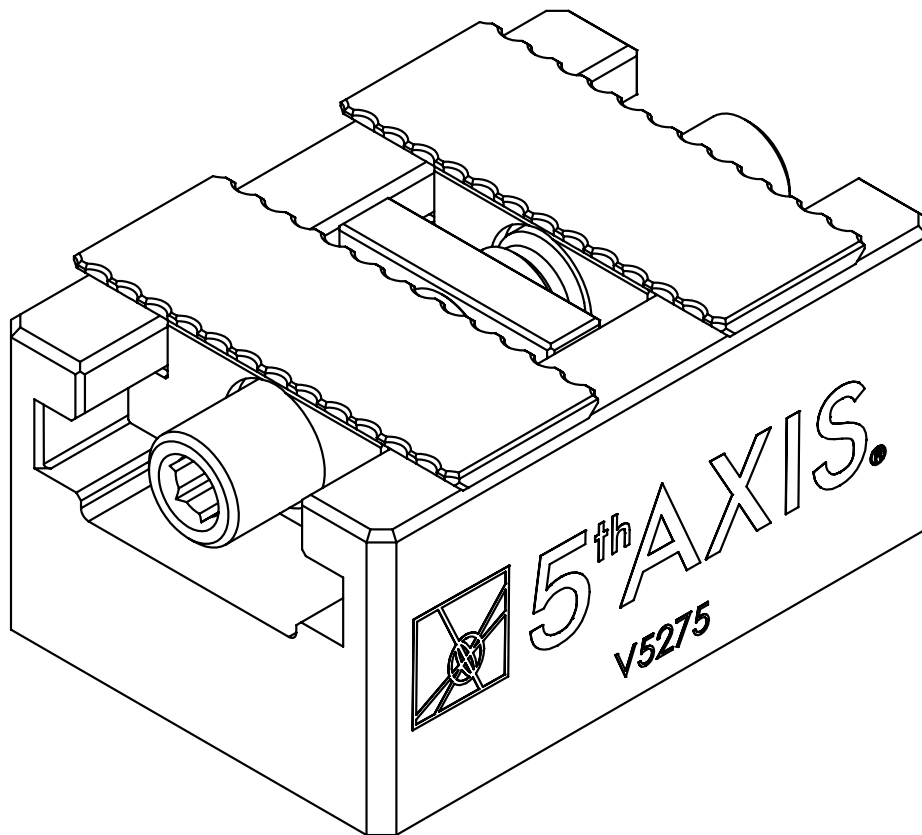
REFER 5TH AXIS WEBSITE OR REACH OUT TO
US AS AT WWW.5THAXIS.COM
TO FIND SUITABLE BASE PER APPLICATION



5th AXIS[®]

V5275 OWNER'S MANUAL

Self Centering



**AVAILABLE FOR DOWNLOAD AT:
5THAXIS.COM**

PHONE: 858-505-0432