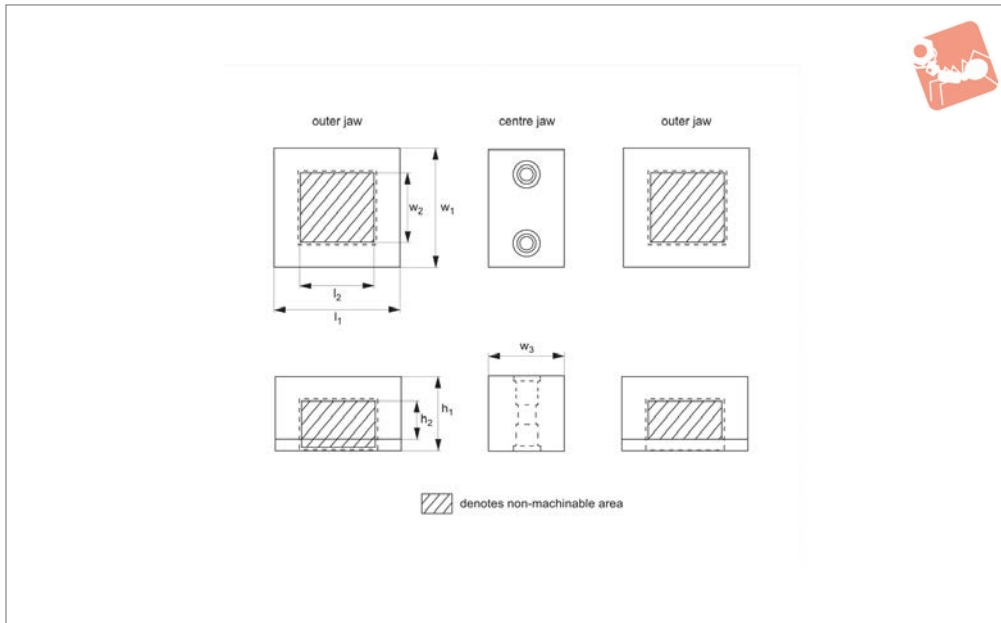




Machinable Vice Jaws - SnapLock for ReLock vices

Vice Clamping



19790

VICE CLAMPING

Material

Aluminium. Some sizes are available in steel (1018 or 4140), please call for details.

Technical Notes

Jaws are reversible for additional work-

piece setup.

For jaw capacity when used with vice, see technical pages.

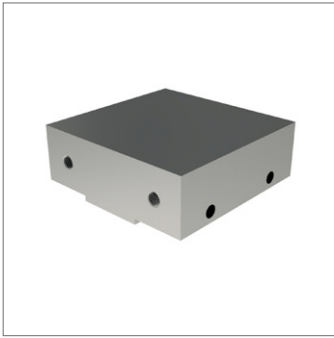
Tips

Only for use with our ReLock Vice system.

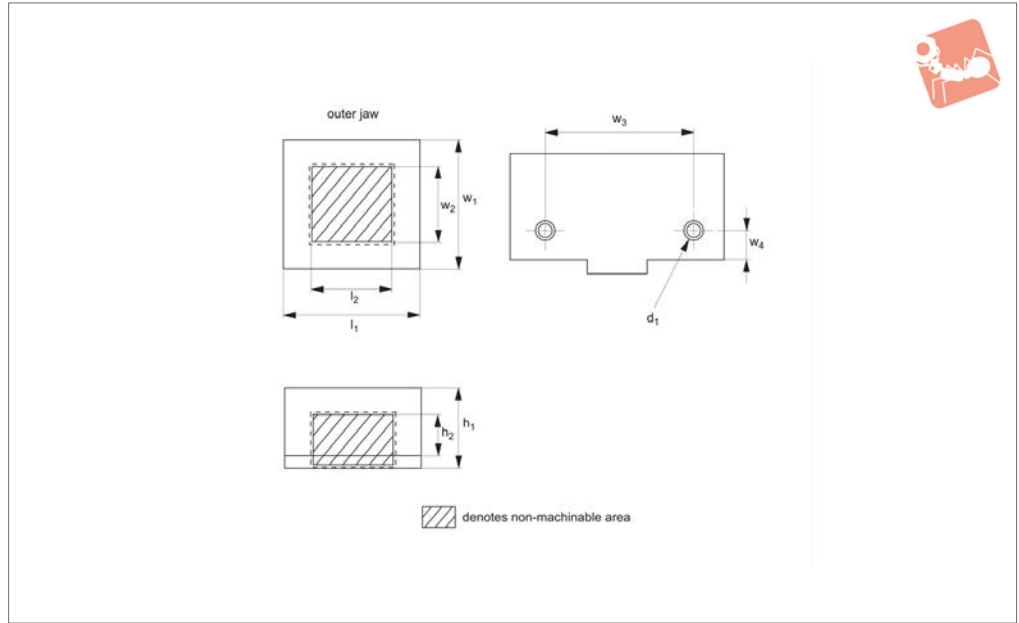
Important Notes

All dimensions are in inches.

Order No.	For vice size	Contents	Type	l_1	l_2	w_1	w_2	w_3	h_1	h_2
19790.W0401	4"	2 x Outer, 1 x Centre	Std.	4.250	2.250	3.94	2.060	2.5	1.50	1.06
19790.W0402	4"	1 x Centre	Std.	-	-	3.94	-	2.5	1.50	-
19790.W0403	4"	1 x Outer	Std.	4.250	2.250	3.94	2.060	-	1.50	1.06
19790.W0411	4"	2 x Outer, 1 x Centre	Tall	4.250	2.250	3.94	2.060	2.5	2.75	1.06
19790.W0412	4"	1 x Centre	Tall	-	-	3.94	-	2.5	2.75	-
19790.W0413	4"	1 x Outer	Tall	4.250	2.250	3.94	2.060	-	2.75	1.06
19790.W0421	4"	2 x Outer, 1 x Centre	Wide	4.250	-	5.94	-	2.5	1.50	-
19790.W0422	4"	1 x Centre	Wide	-	-	5.94	-	2.5	1.50	-
19790.W0423	4"	1 x Outer	Wide	4.250	2.250	5.94	2.060	-	1.50	1.06
19790.W0601	6"	2 x Outer, 1 x Centre	Std.	5.812	3.063	5.94	2.810	3.5	2.00	1.28
19790.W0602	6"	1 x Centre	Std.	-	-	5.94	-	3.5	2.00	-
19790.W0603	6"	1 x Outer	Std.	5.812	3.063	5.94	2.810	-	2.00	1.28
19790.W0611	6"	2 x Outer, 1 x Centre	Tall	5.812	3.063	5.94	2.810	3.5	3.25	1.28
19790.W0612	6"	1 x Centre	Tall	-	-	5.94	-	3.5	3.25	-
19790.W0613	6"	1 x Outer	Tall	5.812	3.063	5.94	2.810	-	3.25	1.28
19790.W0621	6"	2 x Outer, 1 x Centre	Wide	5.812	3.063	7.94	2.810	3.5	2.00	1.28
19790.W0622	6"	1 x Centre	Wide	-	-	7.94	-	3.5	2.00	-
19790.W0623	6"	1 x Outer	Wide	5.812	3.063	7.94	2.810	-	2.00	1.28
19790.W0801	8"	2 x Outer, 1 x Centre	Std.	7.500	3.125	7.94	2.625	4.5	2.50	1.50
19790.W0802	8"	1 x Centre	Std.	-	-	7.94	-	4.5	2.50	-
19790.W0803	8"	1 x Outer	Std.	7.500	3.125	7.94	2.625	-	2.50	1.50
19790.W0811	8"	2 x Outer, 1 x Centre	Tall	7.500	3.125	7.94	2.625	4.5	3.75	1.50
19790.W0812	8"	1 x Centre	Tall	-	-	7.94	-	4.5	3.75	-
19790.W0813	8"	1 x Outer	Tall	7.500	3.125	7.94	2.625	-	3.75	1.50
19790.W0821	8"	2 x Outer, 1 x Centre	Wide	7.500	3.125	9.94	2.625	4.5	2.50	1.50
19790.W0822	8"	1 x Centre	Wide	-	-	9.94	-	4.5	2.50	-
19790.W0823	8"	1 x Outer	Wide	7.500	3.125	9.94	2.625	-	2.50	1.50



19792



VICE CLAMPING

Material

Aluminium. Some sizes are available in steel (1018 or 4140), please call for details.

Technical Notes

For use with single station conversion

plate no. 19759 to convert 2 station ReLock vice into a single station vice. For jaw capacity when used with vice, see technical pages.

Tips

Only for use with our ReLock Vice system.

Important Notes

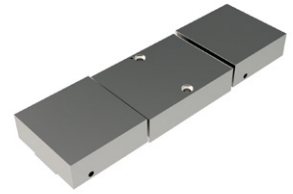
All dimensions are in inches.

Order No.	For vice size	Contents	Type	l_1	l_2	w_1	w_2	w_3	w_4	h_1	h_2	d_1
19792.W0040	4"	1 x Outer	Std.	4.250	2.250	3.94	2.060	2.500	0.687	1.50	1.06	3/8-16x0,63
19792.W0041	4"	1 x Outer	Tall	4.250	2.250	3.94	2.060	2.500	0.687	2.75	1.06	3/8-16x0,63
19792.W0060	6"	1 x Outer	Std.	5.812	3.063	5.94	2.810	3.875	0.937	2.00	1.28	1/2-13x0,75
19792.W0061	6"	1 x Outer	Tall	5.812	3.063	5.94	2.810	3.875	0.937	3.25	1.28	1/2-13x0,75
19792.W0080	8"	1 x Outer	Std.	7.500	3.125	7.94	2.625	4.750	1.218	2.00	1.50	5/8-11x1,30
19792.W0081	8"	1 x Outer	Tall	7.500	3.125	7.94	2.625	4.750	1.218	3.75	1.50	5/8-11x1,30



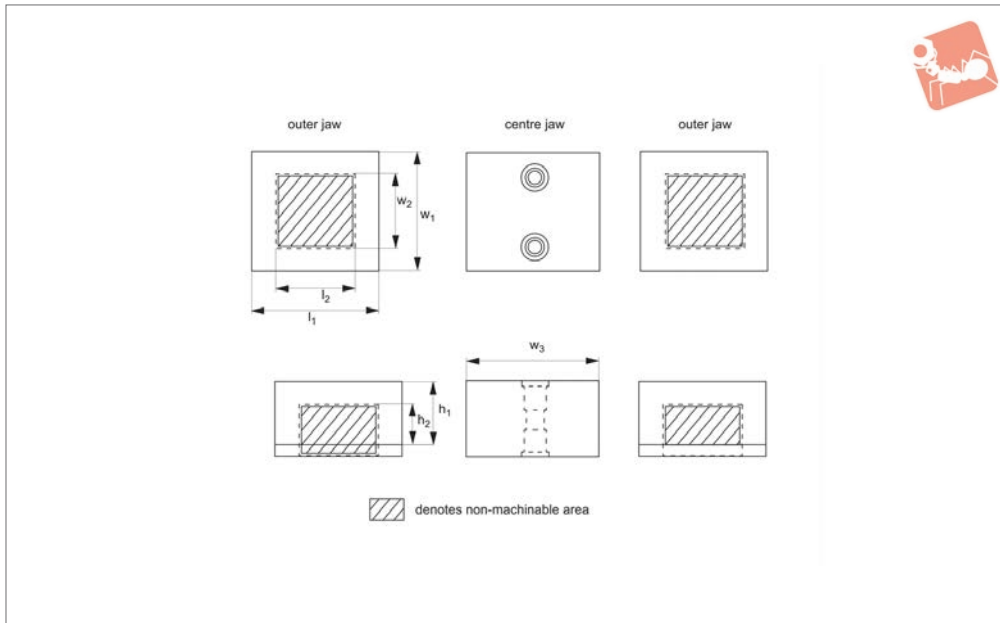
Machinable Vice Jaws - SnapLock for ReLock vices - full coverage

Vice Clamping



19794

VICE CLAMPING



Material

Aluminium.

For jaw capacity when used with vice, see technical pages.

Important Notes

All dimensions are in inches.

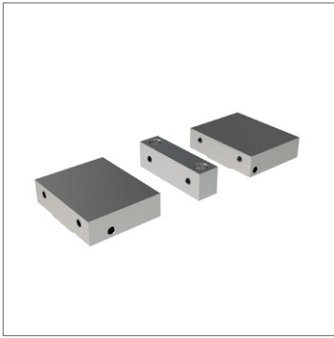
Technical Notes

Jaws are reversible for additional work-piece setup.

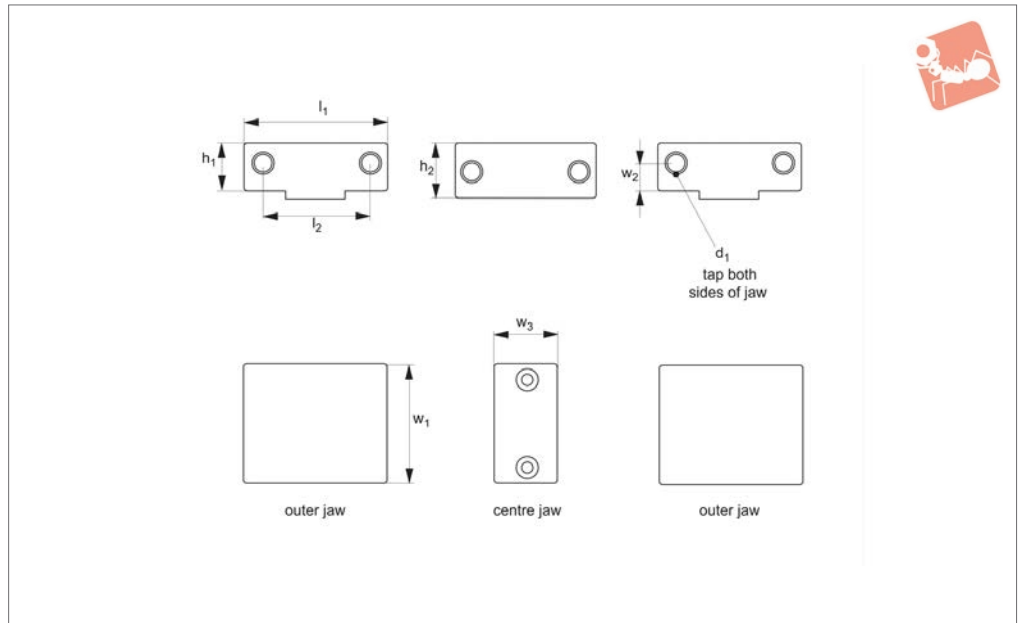
Tips

Only for use with our ReLock Vice system.

Order No.	For vice size	Contents	Type	l ₁	l ₂	w ₁	w ₂	w ₃	h ₁	h ₂
19794.W0041	4"	Outer Jaw - 2 x 19790.W0403, Centre Jaw - 1 x 19794.W0042	Std.	4.250	2.250	3.94	2.060	6.500	1.50	1.06
19794.W0042	4"	1 x Centre Jaw	Std.	4.250	2.250	3.94	2.060	6.500	1.50	1.06
19794.W0043	4"	Outer Jaw - 2 x 19790.W0413, Centre Jaw - 1 x 19794.W0044	Tall	4.250	2.250	3.94	2.060	6.500	2.75	1.06
19794.W0044	4"	1 x Centre Jaw	Tall	4.250	2.250	3.94	2.060	6.500	2.75	1.06
19794.W0045	4"	Outer Jaw - 2 x 19790.W0423, Centre Jaw - 1 x 19794.W0046	Wide	4.250	2.250	5.94	2.060	6.500	1.50	1.06
19794.W0046	4"	1 x Centre Jaw	Wide	4.250	2.250	5.94	2.060	6.500	1.50	1.06
19794.W0061	6"	Outer Jaw - 2 x 19790.W0603, Centre Jaw - 1 x 19794.W0062	Std.	5.812	3.063	5.94	2.810	7.875	2.00	1.28
19794.W0062	6"	1 x Centre Jaw	Std.	5.812	3.063	5.94	2.810	7.875	2.00	1.28
19794.W0063	6"	Outer Jaw - 2 x 19790.W0613, Centre Jaw - 1 x 19794.W0064	Tall	5.812	3.063	5.94	2.810	7.875	3.25	1.28
19794.W0064	6"	1 x Centre Jaw	Tall	5.812	3.063	5.94	2.810	7.875	3.25	1.28
19794.W0065	6"	Outer Jaw - 2 x 19790.W0623, Centre Jaw - 1 x 19794.W0066	Wide	5.812	3.063	7.94	2.810	7.875	2.00	1.28
19794.W0066	6"	1 x Centre Jaw	Wide	5.812	3.063	7.94	2.810	7.875	2.00	1.28
19794.W0081	8"	Outer jaw - 2 x 19790.W0803, Centre jaw - 1 x 19794.W0082	Std.	7.500	3.125	7.94	2.625	11.500	2.50	1.50
19794.W0082	8"	1 x Centre Jaw	Std.	7.500	3.125	7.94	2.625	11.500	2.50	1.50
19794.W0083	8"	Outer Jaw - 2 x 19790.W0813, Centre Jaw - 1 x 19794.W0084	Tall	7.500	3.125	7.94	2.625	11.500	3.75	1.50
19794.W0084	8"	1 x Centre Jaw	Tall	7.500	3.125	7.94	2.625	11.500	3.75	1.50
19794.W0085	8"	Outer Jaw - 2 x 19790.W0823, Centre Jaw - 1 x 19794.W0086	Wide	7.500	3.125	9.94	2.625	11.500	2.50	1.50
19794.W0086	8"	1 x Centre Jaw	Wide	7.500	3.125	9.94	2.625	11.500	2.50	1.50



19796



Material

Outside jaws: aluminium.
Centre jaws: steel.

Technical Notes

Carrier jaws can be used in conjunction

with AccuSnap and QuickChange master jaws.

Outside jaws can be used in conjunction with single station conversion plates.

Tips

Only for use with our ReLock Vice system.

Important Notes

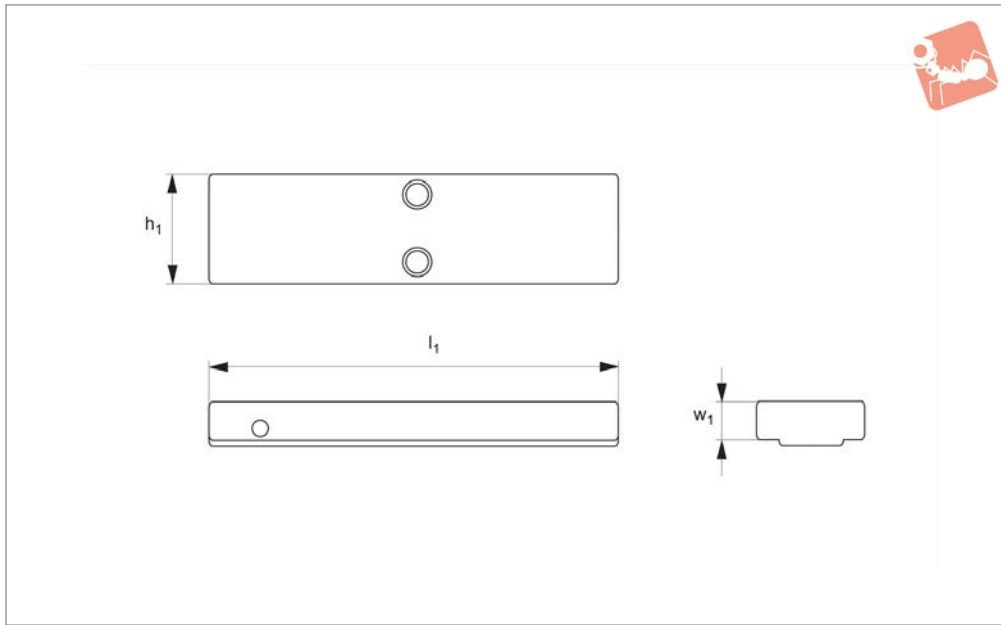
All dimensions are in inches.

Order No.	Vice size	Contents	Material	l_1	l_2	w_1	w_2	w_3	h_1	h_2	d_1
19796.W0401	4"	2 x Outer, 1 x Centre	Aluminium	3.94	2.500	3.812	0.687	1.25	1.12	1.35	3/8-16
19796.W0403	4"	2 x Outer	Aluminium	3.94	2.500	3.812	0.687	-	1.12	-	3/8-16
19796.W0601	6"	2 x Outer, 1 x Centre	Aluminium	5.94	3.875	4.750	0.937	1.50	1.52	1.85	1/2-13
19796.W0603	6"	2 x Outer	Aluminium	5.94	3.875	4.750	0.937	-	1.52	-	1/2-13
19796.W0801	8"	2 x Outer, 1 x Centre	Aluminium	7.94	4.750	6.125	1.218	1.98	2.12	2.35	5/8-11
19796.W0803	8"	2 x Outer	Aluminium	7.94	4.750	6.125	1.218	-	2.12	-	5/8-11
19796.W1401	4"	2 x Outer, 1 x Centre	Steel	3.94	2.500	3.812	0.687	1.25	1.12	1.35	3/8-16
19796.W1402	4"	1 x Centre	Steel	3.94	2.500	-	0.687	1.25	1.12	1.35	3/8-16
19796.W1403	4"	2 x Outer	Steel	3.94	2.500	3.812	0.687	-	1.12	-	3/8-16
19796.W1601	6"	2 x Outer, 1 x Centre	Steel	5.94	3.875	4.750	0.937	1.50	1.52	1.85	1/2-13
19796.W1602	6"	1 x Centre	Steel	5.94	3.875	-	0.937	1.50	-	1.85	1/2-13
19796.W1603	6"	2 x Outer	Steel	5.94	3.875	4.750	0.937	-	1.52	-	1/2-13
19796.W1801	8"	2 x Outer, 1 x Centre	Steel	7.94	4.750	6.125	1.218	1.98	2.12	2.35	5/8-11
19796.W1802	8"	1 x Centre	Steel	7.94	4.750	-	1.218	1.98	-	2.35	5/8-11
19796.W1803	8"	2 x Outer	Steel	7.94	4.750	6.125	1.218	-	2.12	-	5/8-11



Fixture Plate - SnapLock for ReLock vices

Vice Clamping



19798

VICE CLAMPING

Material

Aluminium.

pieces with difficult clamping of locating points.

Important Notes

All dimensions are in inches.

Technical Notes

Ideal for holding many small parts or work-

Tips

Only for use with our ReLock Vice system.

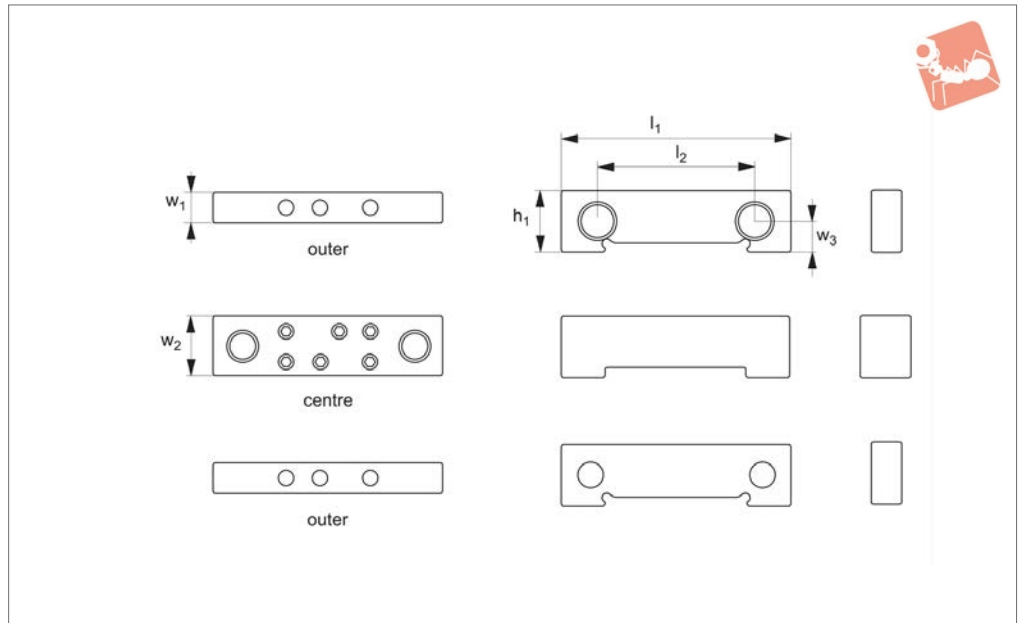
Order No.	Vice size	l_1	w_1	h_1
19798.W0040	4"	16.0	1.5	4
19798.W0041	4"	16.0	1.5	6
19798.W0060	6"	20.5	2.0	6
19798.W0061	6"	20.5	2.0	8
19798.W0080	8"	28.5	2.5	8
19798.W0081	8"	28.5	2.5	10



VICE CLAMPING



19810



Material

Body: 80000 psi ductile cast iron.

Technical Notes

Adaptable to most vice jaw systems. When

used with ReLock vice, mount AccuSnap master jaws to SnapLock carrier jaws to fit all AccuSnap jaw components. Install AccuSnap master jaws to SnapLock carrier

jaws on vice for squareness.

Important Notes

All dimensions are in inches.

Order No.	Vice size	Contents	l_1 ± 0.001	l_2	w_1 ± 0.0005	w_2 ± 0.0005	w_3	h_1 ± 0.001
19810.W0401	4"	2 x Outer, 1 x Centre	3.98	2.500	0.560	-	0.687	1.35
19810.W0403	4"	2 x Outer	3.98	2.500	0.560	-	0.687	1.35
19810.W0402	4"	1 x Centre	3.98	2.500	-	1.25	0.687	1.35
19810.W0601	6"	2 x Outer, 1 x Centre	5.98	3.875	0.750	-	0.937	1.85
19810.W0603	6"	2 x Outer	5.98	3.875	0.750	-	0.937	1.85
19810.W0602	6"	1 x Centre	5.98	3.875	-	1.50	0.937	1.85
19810.W0801	8"	2 x Outer, 1 x Centre	7.98	4.750	1.125	-	1.218	2.35
19810.W0802	8"	2 x Outer	7.98	4.750	1.125	-	1.218	2.35
19810.W0803	8"	1 x Centre	7.98	4.750	-	2.00	1.218	2.35

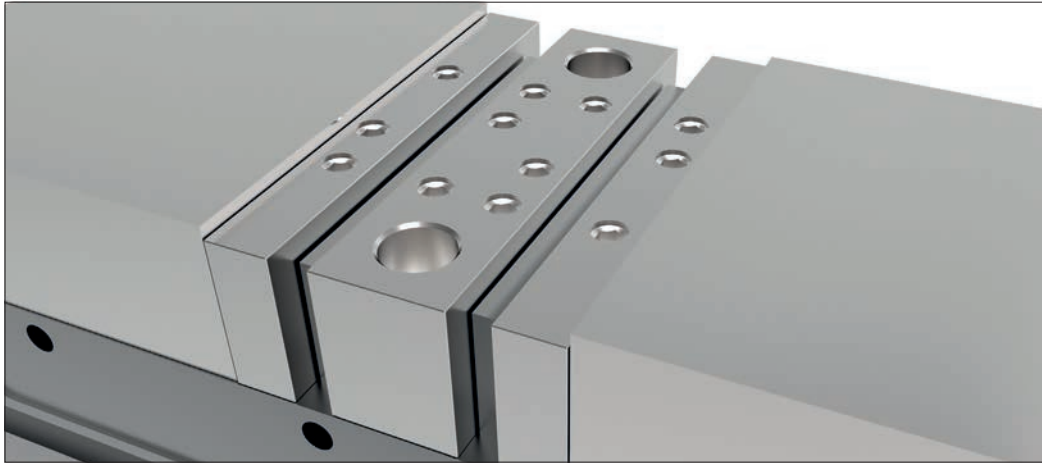
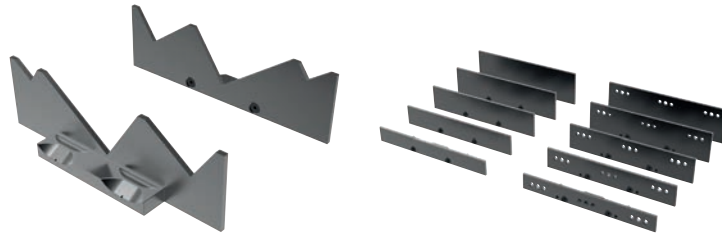


AccuSnap Jaws and Parallels

for use on SnapLock Jaw System for ReLock Vices

19810 - 19838
Clamping & Height Setting

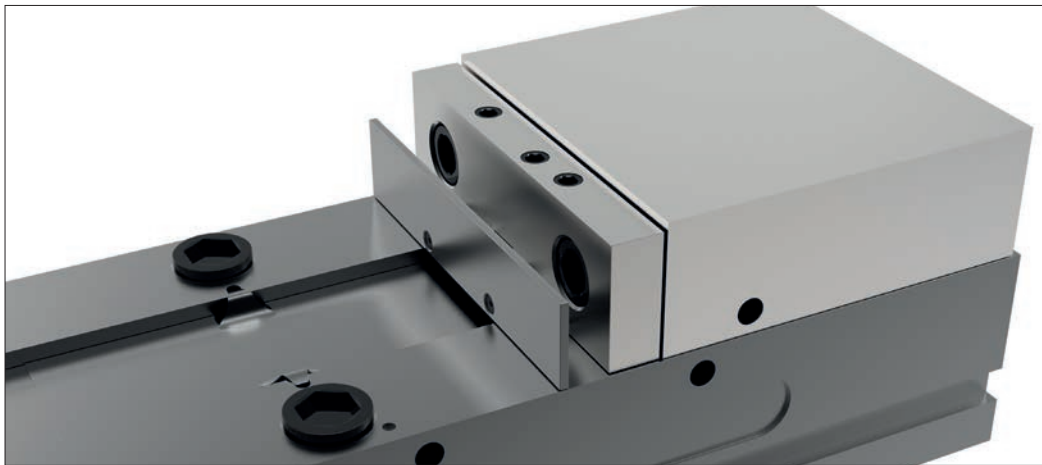
- Fast, accurate and versatile.
- Reduces setup time drastically.
- $\pm 0,0002''$ repeatability.
- Adaptable to most vice systems.



Step 1:

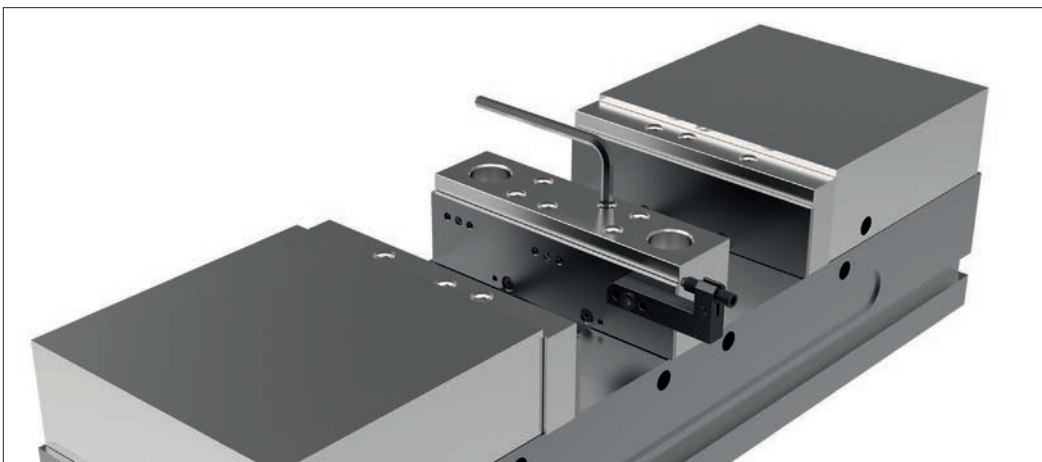
Before mounting AccuSnap master jaws, thoroughly inspect, clean and remove any burrs or chips from the mounting surface.

Simply attach the AccuSnap master jaws to the carrier jaw system using the industry standard bolt system.



Step 2:

Snap in the parallels or soft jaws that you require for your set-up and begin machining. Two lock screws are provided for extra holding assurance, but are not necessary to hold parallels in place. Do not overtighten lock screws.



Step 3:

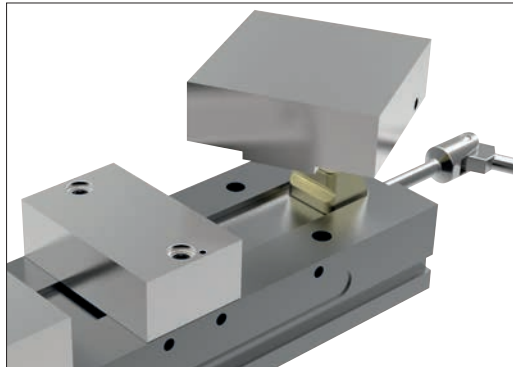
When finished with your job, unlock parallels (if needed) and turn the kick out screw to eject the jaw or parallel.

You are ready to repeat the process for your next job.



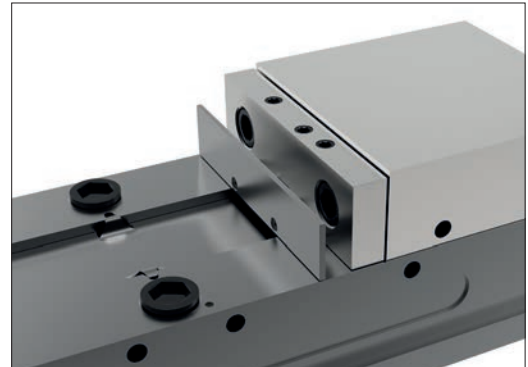
ReLock Accessories

Both the AccuSnap and QuickChange vice jaw systems can be used in conjunction with most vice systems.



SnapLock Machinable Fixture Jaws

Jaws can be attached, reversed, removed or indexed in a matter of seconds. The jaws are extremely versatile, allowing endless customising possibilities. Jaws are manufactured from steel and high quality aluminium.



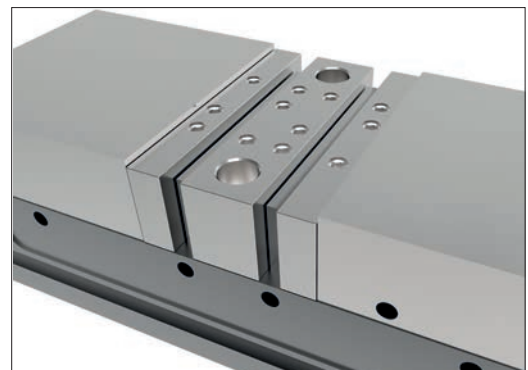
SnapLock Carrier Jaws

Carrier jaws allow mounting of AccuSnap and QuickChange master jaws or standard bolt-on jaws using an industry standard bolt pattern.



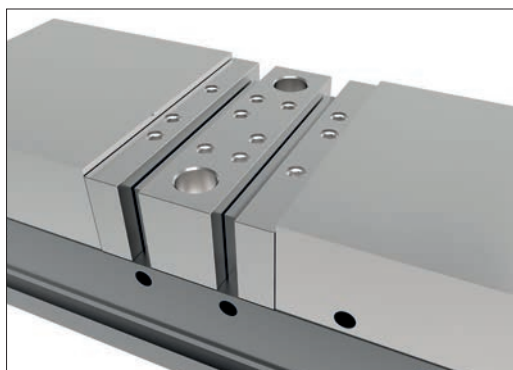
QuickChange Vice System

QuickChange jaws slide into position via a dovetail slot, as shown. The system includes master jaws, parallels, V-blocks, mill angles and machinable soft jaws. Adaptable to most vice systems.



AccuSnap Vice Jaw System

The AccuSnap vice jaw system (pictured), shows master jaws and parallels being used for workpiece set-up. The AccuSnap system allows setup change-over in seconds with extreme accuracy.



AccuSnap Machinable Fixture Jaws

Ideal for many workholding options of smaller workpieces. Jaws are offered in two thicknesses, from either aluminium or pre-hardened steel.



AccuSnap Workstops

Easily mount to AccuSnap parallels in a variety of configurations. Provides extreme workpiece location accuracy and repeatability. Can be used in conjunction with the AccuSnap presetting gauge to accurately reference your X, Y and Z machine datums.



How to use the SnapLock Jaw System

19790-19862
Clamping & Height Setting



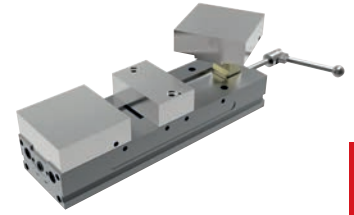
The SnapLock system's allows simple, quick changeovers between machinable and carrier jaws.

SnapLock Machinable Fixture Jaws

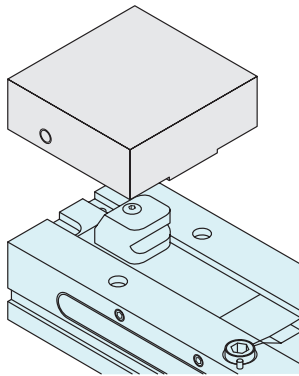
- Can be attached, reversed, removed or indexed in a matter of seconds.
- Extremely versatile, allowing endless customisation possibilities.
- Manufactured from high quality aluminium.

SnapLock Carrier Jaws

- Allows mounting of AccuSnap and QuickChange master jaws or standard bolt-on jaws using an industry standard bolt size and pattern.

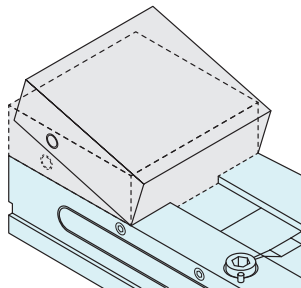


Operation



Step 1

Align the SnapLock outer jaw over the appropriate ReLock vice knuckle

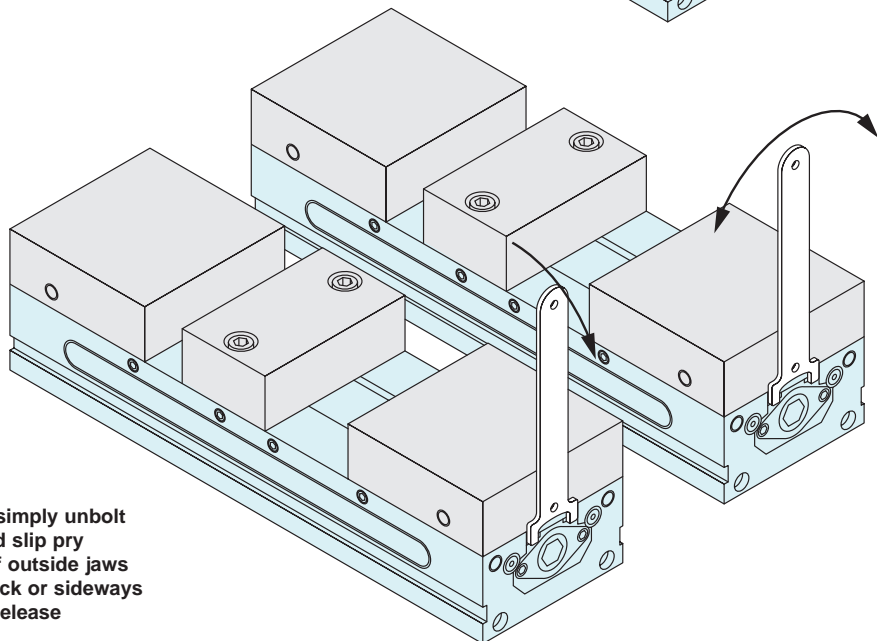
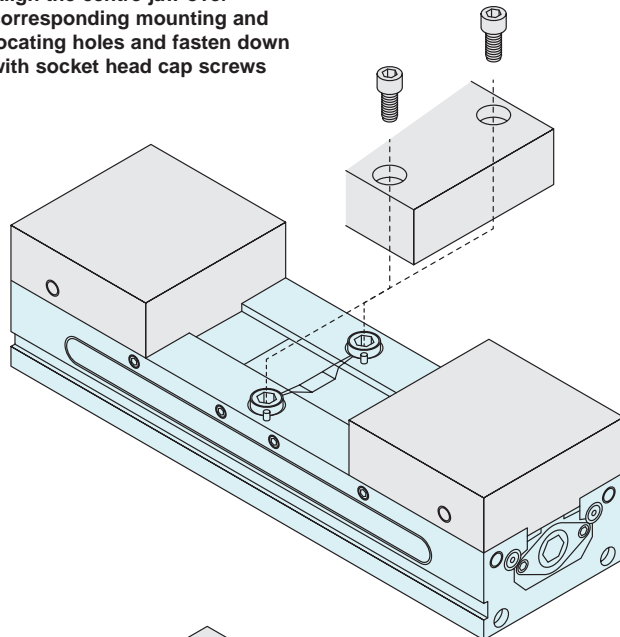


Step 2

Place the front edge of the jaw over the knuckle and press firmly down to "snap" into place

Step 3

Align the centre jaw over corresponding mounting and locating holes and fasten down with socket head cap screws

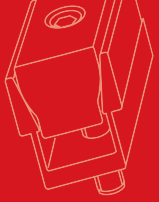


Step 4

For jaw removal, simply unbolt the centre jaw and slip pry wrench in slots of outside jaws as shown; pull back or sideways on the handle to release

VICE CLAMPING

ov-W19790-A-T-W19862-A-T-how-to-use-snaplock-jaw-system-rmh - Updated - 26-10-2022



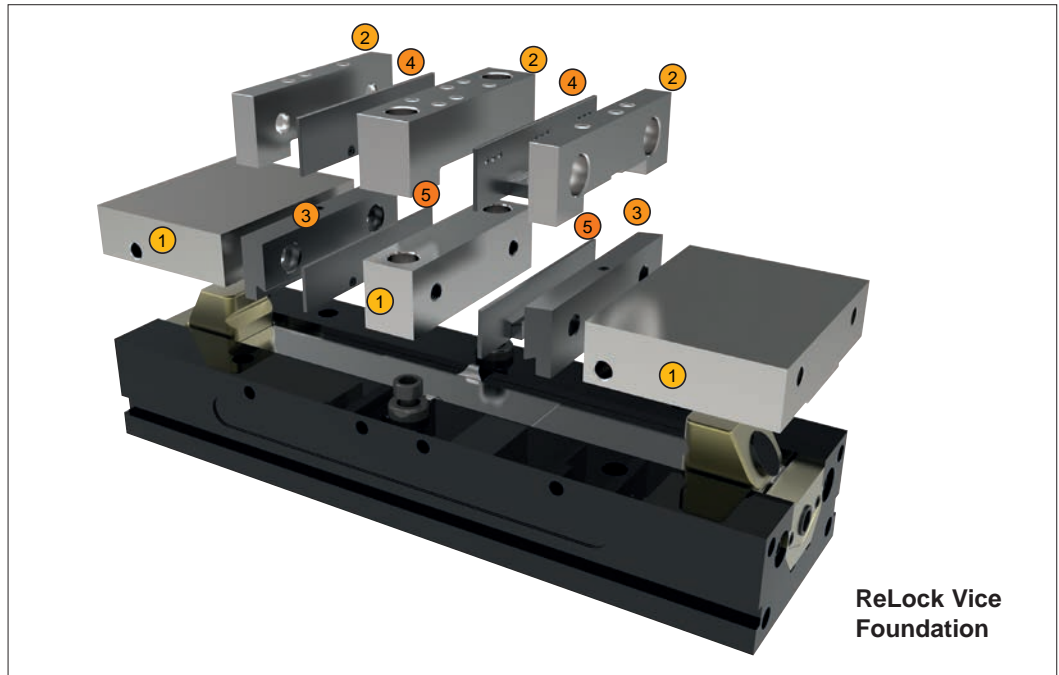
Foundation

The ReLock vice is the foundation for a fully flexible vice system, with a multitude of interchangeable jaws, parallels or mill angles to suit your application.

Base vice - ReLock 2 or ReLock 8.

- SnapLock® Carrier Jaws - accepts both AccuSnap® and QuickChange™ Jaw systems.
- AccuSnap or QuickChange Parallels and Mill Angles - select the approach best suited to your application.

Flexibility



ReLock Vice Foundation

1 SnapLock Carrier Jaws

SnapLock carrier jaws allow mounting of AccuSnap and QuickChange master jaws by using an industry standard bolt size and pattern. Carrier jaws snap on and off the SnapLock knuckles in seconds.

2 3 AccuSnap and QuickChange Master Jaws

AccuSnap QuickChange master jaws easily mount to the SnapLock carrier jaws by using an industry bolt size and pattern. AccuSnap master jaws patented locking receptacle accepts all AccuSnap accessories.

4 5 AccuSnap and QuickChange Parallels

AccuSnap and QuickChange parallels are designed for a range of set up variations when you need to position a workpiece between hardened jaws. AccuSnap parallels snap in and out of the AccuSnap master jaws in seconds. QuickChange parallels slide into position via a dovetail slot and gib.

Also available:

Machinable Fixture Jaws

AccuSnap and QuickChange machinable fixture jaws can be customised quickly to fixture a wide range of workpieces. The jaws snap or slide in and out of the master jaws in seconds. Available in either aluminium or hardened steel.

SnapLock Reversible Machinable Fixture Jaws

SnapLock reversible machinable fixture jaws are the most versatile method of fixturing on the ReLock System. Customising options are endless. Jaws can be machined on two faces for additional set up. Manufactured from high quality aluminium.

Fixture Plate

Ideal for a wide variety of fixturing applications, such as holding many small parts or parts with difficult clamping or locating requirements. Fixture plates can be attached or removed in seconds and are offered in two widths. Manufactured from high quality aluminium.

Modular Workstops

AccuSnap modular workstops quickly mount to parallels in many different positions. As many as three stops can be mounted to a single parallel to accommodate multi-piece set-ups.

Universal Workstop

The universal workstop easily mounts to the side of the ReLock in numerous positions. Optional extension is available for larger workpieces.

Workstop Presetting Gauge

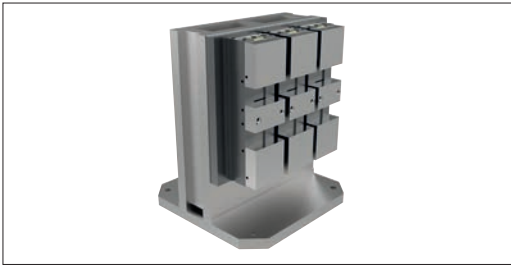
The AccuSnap workstop presetting gauge, in combination with a standard micrometer, allows you to precisely preset your modular workstop positions in relation to the X, Y, and Z machine datums.

Single Station Conversion Plate

The single station conversion plate quickly converts the ReLock from double station to single station vice for larger workpieces.

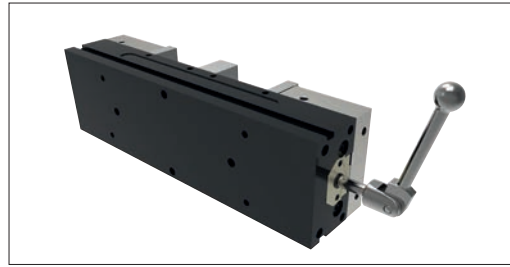


Features and Benefits



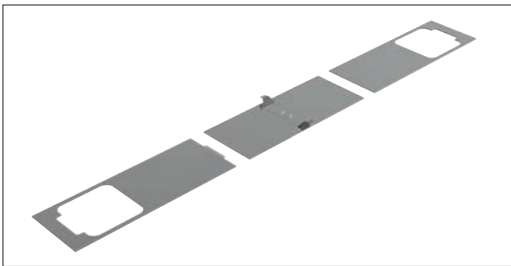
Optimised Table Space

Compact modular design allows a multitude of mounting configurations. Vices can be mounted close together without hindering the removal or attachment of jaws. The ReLock 8-station (shown) is ideal for horizontal machining centres, as well as for use with rotary indexers on vertical machining centres.



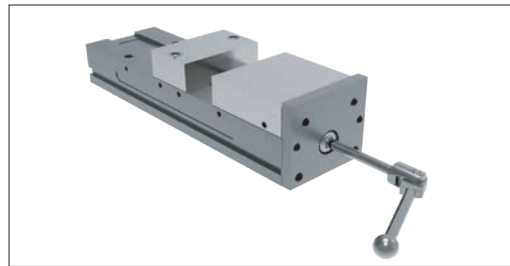
Locating and Mounting

Locating and mounting options are simple and accurate. The bottom surface of the system has four precision dowel pin holes for locating and four drilled and counterbored holes drilled through from the top surface for rugged mounting. Side clamp slots are also incorporated.



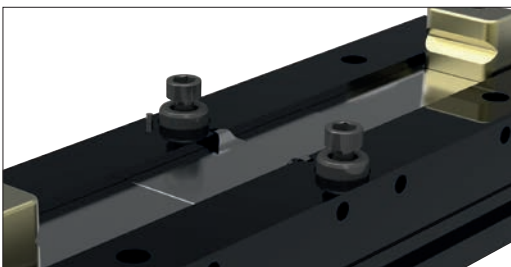
ReLock Chip Shields

ReLock's unique three piece telescopic chip shield wraps completely around the SnapLock knuckles, keeping swarf from getting into the vice's clamping mechanism. Shields can be quickly and easily removed for maintenance purposes.



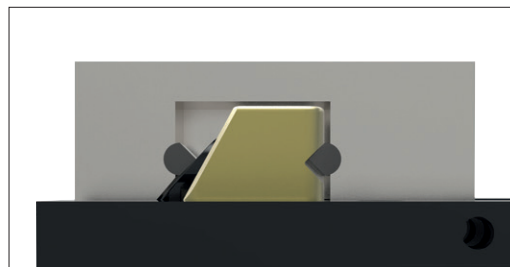
Single Station Conversion

Used in conjunction with SnapLock carrier jaws, the conversion plate allows the ReLock system to be converted from a double to a single station vice – ideal for larger workpieces.



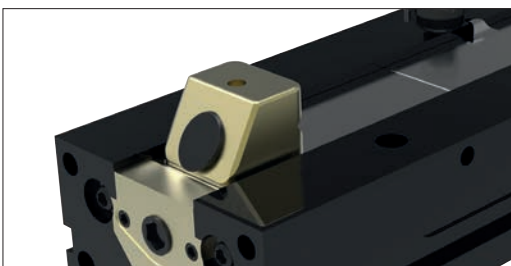
Centre Jaw Location

The ReLock's centre jaw locating studs allow quick jaw mounting and indexing to accuracies of $\pm 0.0005"$. Foolproof pin eliminates the possibility of the jaws being accidentally mounted in reverse.



SnapLock Knuckle

Exclusive SnapLock knuckle allows SnapLock soft jaws and SoftLock carrier to be attached and removed in seconds.



Auto Offset Mechanism

Exclusive automatic offset mechanism allows non-simultaneous workpiece clamping and unclamping to one of the three optional offset settings: 4" and 6": 0.030", 0.125", or 0.250"; 8": 0.125", 0.250", or 0.375". The offset setting is the distance the rear jaw backs away from the workpiece before the front jaw begins to back away from the workpiece.