

## 10290

STANDARD MANUAL CLAMPING

### Material

Steel, heat-treated and blackened.

### Technical Notes

Supplied in pairs.

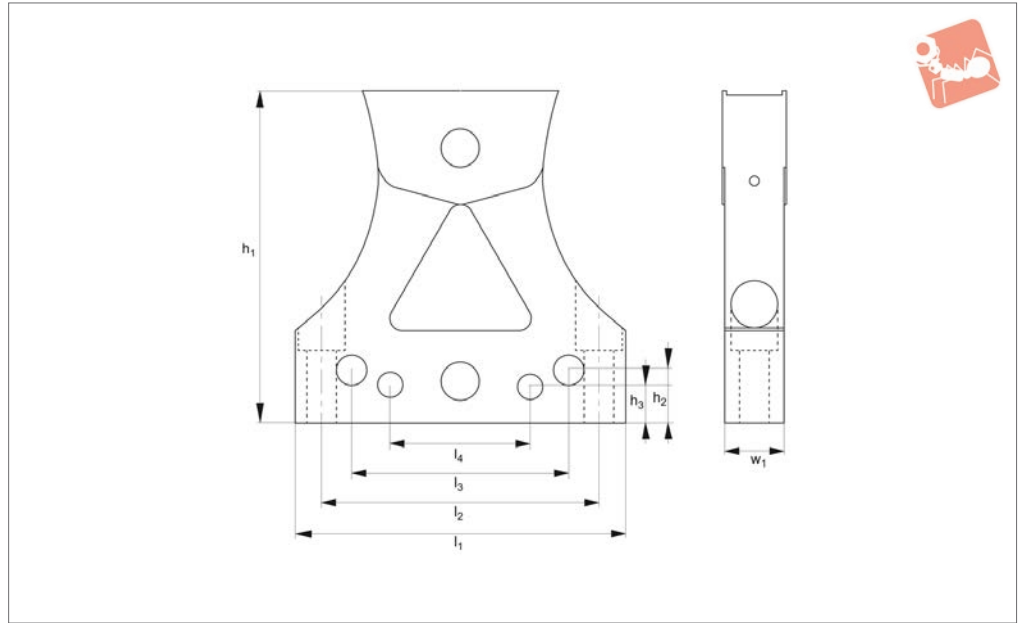
### Tips

Used with:  
21000 T-slot bolt, 21120 T-stud, 24400 collar nut, 25000 plain washer.

Order No.	For bolt	For vice jaw width	$h_1$	$h_2$	$h_3 \times l_2$	$l_1$	$l_3$	$l_4$	$w_1$	$w_2$	Weight g
<b>10290.W0015</b>	M12- M16	100	22.5	15	10x6,5	78	40	10.5	40	16.5	660
<b>10290.W0020</b>	M12- M16	125/160	27.5	20	10x6,5	78	40	10.5	40	16.5	705



12464



**Technical Notes**

Vice towers mount directly to your 4" or 6" vice to elevate your workpiece into the 5-axis envelope and allow machining on 5 sides of the workpiece. Incorporating talon, versagrip and pitbull clamps the system is exceptionally versatile in securing round or square stock material. As well as being suited for mounting to

your vice, the vice towers can also be mounted to your T-slot table.

**Tips**

Low profile clamping reduces material costs and eliminates the need for time-consuming workpiece preparation.

**Important Notes**

Full set contents:

- 2 x vice towers
- 4 x talon grips 12034.W0075
- 4 x versagrips 12036.W0175
- 1 x talon stop 12035.W0220
- 2 x pitbull clamp 12031.W0060
- 2 x each support bolts M12x65/100/200
- 4 x mounting bolts M12x55
- 4 x T-nuts M12x16

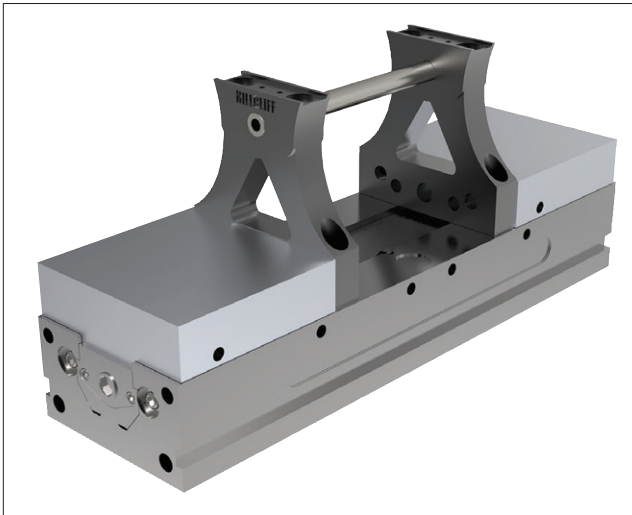
Order No.	Type	Suitable vice size	Mounting bolts	$h_1$	$h_2$	$h_3$	$l_1$	$l_2$	$l_3$	$l_4$	$w_1$
12464.W0066	Set	4" or 6"	M12x55	150	23.9	17.5	150	126.0	98.6	63.5	26.9





#### Vice Application

- Mount jaws to either 4 or 6 inch vice with logo facing outwards, keeping the mounting bolts loose.
- Determine which grippers will be used, install and hand-tighten the grippers. If VersaGrips are being used to grip round stock, place in outboard bores. Do not tighten screws at this point. Tighten vice lightly onto workpiece allowing jaws to centre themselves, adjust VersaGrips, and tighten gripper screws and mounting bolts for both jaws.
- Loosen vice jaw for load/unload clearance of workpiece. Install support/pivot bolt.
- Setup is complete. Tighten support bolt allowing grippers to penetrate 0.25-1.52mm on material < 40 HRC.
- For additional holding force, loosen vice handle which will eliminate any jaw lift that may have occurred and depending on amount of torque can increase pressure to over 4000 kg.



#### T-slot and Grid Table Application

- Using vertical counterbores on outboard edges of jaws, install mounting bolts into t-nuts or grid plate and adjust accordingly. Do not tighten at this time.
- Select appropriate support bolts and install in upper horizontal counterbore and thread into opposite tower.
- Place workpiece between jaws and lightly tighten upper support bolt until all grippers contact workpiece. Tighten vertical mounting bolts.
- Loosen upper support bolt one full turn or until adequate workpiece clearance is obtained.
- Upper support bolt is now the “drive bolt” for securing and releasing workpiece.
- Any size T-nuts can be utilised. We provide 16mm T-nuts.