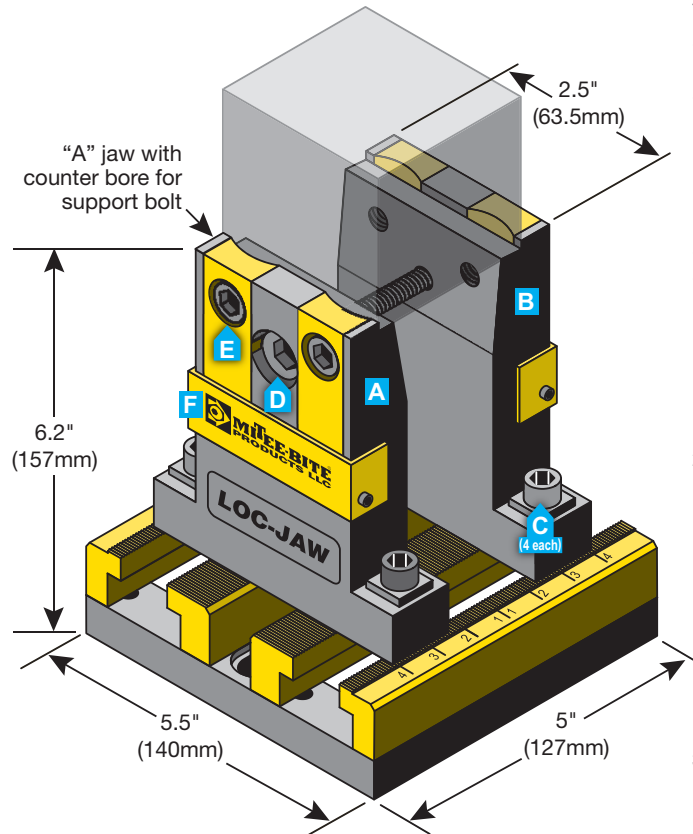


## Congratulations on the purchase of your New Loc-Jaw™ System!



The Loc-Jaw™ system was designed to be a simple solution for 4th and 5th axis machining without having to perform a pre-op prior to running your parts. Two heavy duty hex T-handles are included for quick adjustments and tightening.

**NOTE:** A centering disk 1.5" (38.1mm) can be mounted to bottom of base unit for quick centerline location on faceplates having centering hole feature. Base plate is also configured with two drill bushings for use with diamond and tapered pins. This provides a quick change and precise mounting option. (Centering disk and pins included in accessory pack.)

1. Mount unit to faceplate/sub-plate using (2) 1/2-13 or M12 SHCS.

**NOTE:** Gripping Jaws can be adjusted to workpiece size by simply loosening jaw bolts **C** with support bolt **D** removed. Serrated rails have inch and metric indicators, which align with inboard face of jaws.

2. Loosen Jaw bolts and adjust to approximate width using workpiece. Tighten Jaw bolts; ensuring jaws are properly aligned in serrations and not pinching workpiece between hard stops. Tighten support bolt until desired load/unload clearance is achieved.

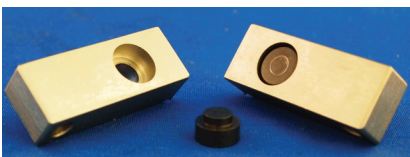
**NOTE:** An adjustable locator is provided if workpiece extends beyond jaw. Install on either jaw for precise repeatability of workpiece. Adjust and lock in place with provided locking nut. (Wrench and thumb screw in accessory pack)

**NOTE:** If precise location of workpiece is required a torque sequence on gripper bolts **E** is recommended and must be performed in same manner to achieve consistent results.

3. Secure workpiece by tightening both grippers bolts on one jaw then gripper bolts on opposite jaw. Grippers are capable of producing over 6,000 pounds of force and .060" penetration into workpiece.

*Part is now ready to machine*

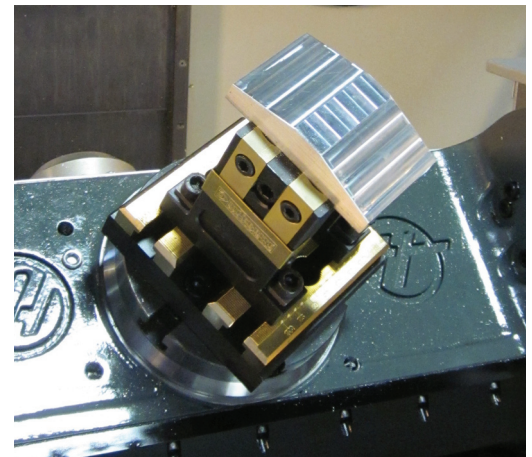
### GRIPPING ON WORKPIECES LESS THAN 1" WIDE:



1. Remove Jaw **A** (has counter bore for support bolt).
2. Remove chip cover **F** using 2.5mm hex key.
3. Remove gripper pivot pins, bolts and o-rings (place o-rings in accessory pack).



4. Place gripper plugs in counter bored holes of grippers and rotate grippers 180 degrees, reinstall pins.
5. Reinstall chip cover.
6. Place Jaw **A** back on base unit rotated 180 degrees from removed position.
7. Screw in gripper bolts and support bolt from back side of jaw.
8. Adjust jaws to desired location and tighten jaw bolts **C** and support bolt.
9. Part is ready to machine; tighten grippers on Jaw **A** first then grippers on opposite jaw.



### Replacement Parts

Part No.	Description
14501	Loc-Jaw™ Support Bolt #1 (M10 x 45mm)
14502	Loc-Jaw™ Support Bolt #2 (M10 x 65mm)
14503	Loc-Jaw™ Support Bolt #3 (M10 x 90mm)
14504	Loc-Jaw™ Support Bolt #4 (M10 x 110mm)
14505	Loc-Jaw™ Grips (2 per pack)
14510	Loc-Jaw™ Jaw Set - includes 2 Jaws, 4 Grips, Screws
14520	Loc-Jaw™ Rail Set - includes 4 Rails, Screws, Dowel Pins

Torque (Ft/lbs)	Holding Force (lbs)
10	2,000
15	3,000
20	4,000
25	5,000
30	6,000

\*Maximum 25 lbs. torque on material harder than 40RC