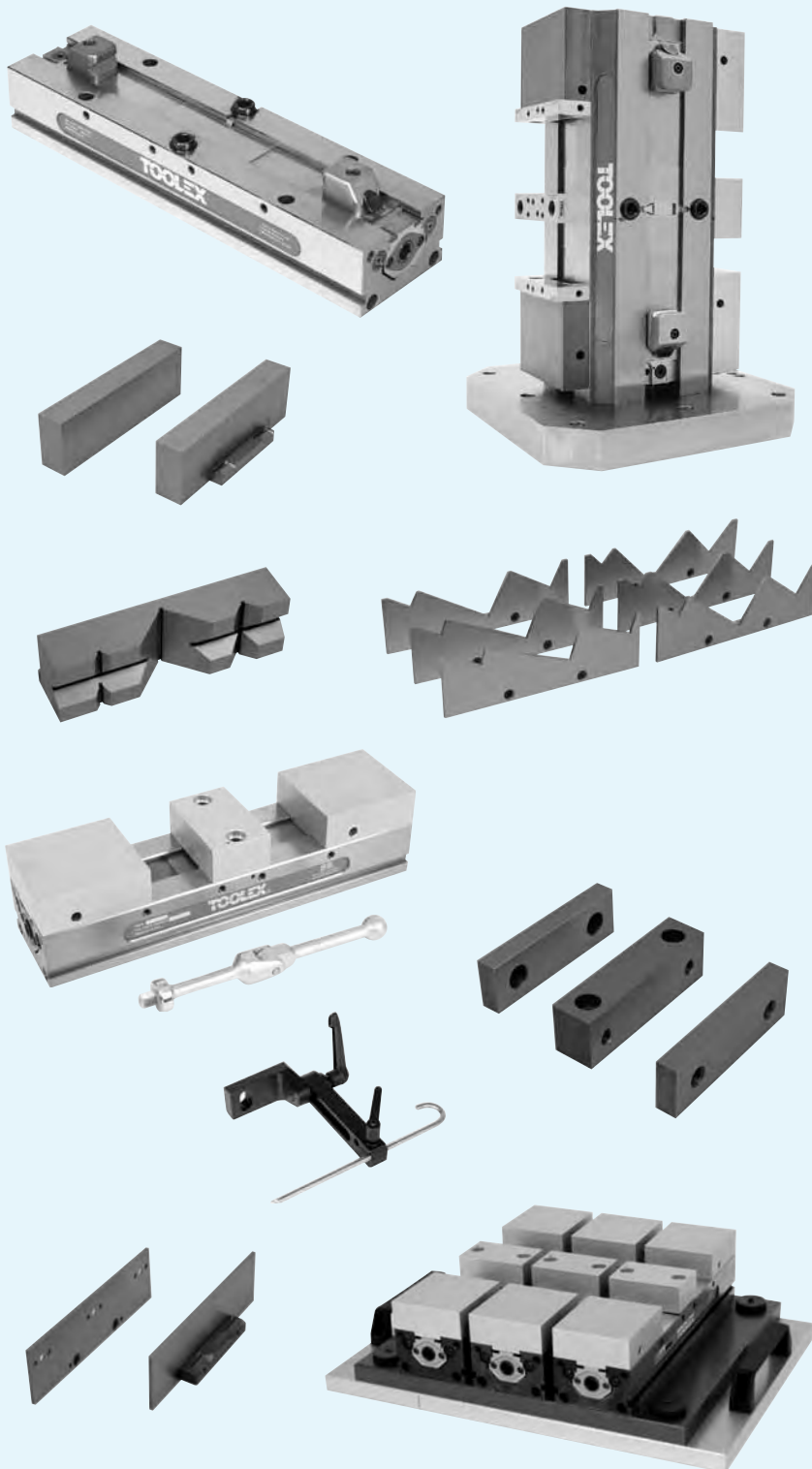


# TOOLEX VISE WORKHOLDING SYSTEMS



## ReLock Vise System

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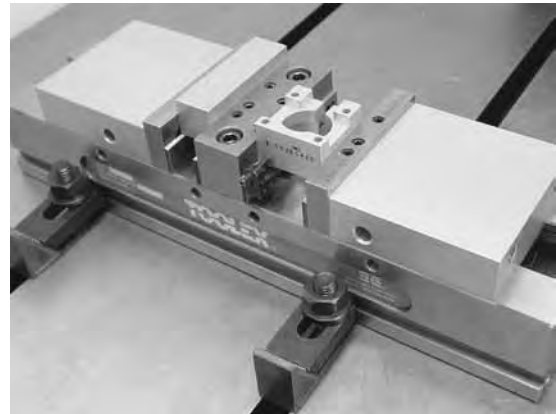
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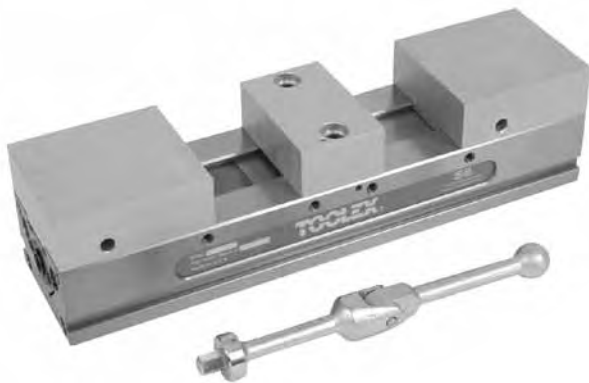
## ReLock® Modular Workholding System

The ReLock Vise System combines high manufactured tolerances with unequalled versatility in providing two-station and eight-station production vises. ReLock CNC vises, available with machinable soft jaws, hard jaws, master jaws and parallels, or fixture plates, allow the machinist a variety of configurations with the same vise. Bodies are manufactured from 80,000 PSI ductile cast iron, and ways are flame hardened and ground to accuracies of +/- .0005. Manual and hydraulic two-station and eight-station vises are available in widths of 4", 6" and 8".

- **Reduce setup times:** The system's SnapLock feature allows you to change or index jaws in a matter of seconds.
- **Extremely versatile:** Offers the most comprehensive array of jaws and accessories available for vertical or horizontal machining applications.
- **Accurate and durable:** Designed and precision manufactured from high grade materials to meet today's extreme accuracy and durability requirements.



# TOOLEX®



## Features and Benefits

### Optimized Table Space

Compact modular design allows a multitude of mounting configurations. Vises can be mounted close together without hindering removal or attachment of jaws. The ReLock 8-station (shown) is ideal for horizontal machining centers, as well as with rotary indexers on vertical machining centers. The unibody design makes it lightweight, compact and extremely rigid.



### Auto Offset Mechanism

Exclusive automatic offset mechanism allows non-simultaneous work piece clamping and unclamping to one of three optional offset settings: 4" and 6": .030", .125", or .250"; 8": .125", .250", or .375." The offset setting is the distance the rear jaw backs away from the work piece before the front jaw begins to back away from the work piece.



### 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 counter bored holes drilled through from the top surface for rugged mounting. Side toe clamp slots are also incorporated for mounting. See page 193 for mounting and locating information for 8-station vises.



### SnapLock Knuckle

Exclusive SnapLock Knuckle allows SnapLock soft jaws and SnapLock carrier jaws to be attached and removed in seconds. The knuckle's angle notch engages with the jaw's pressure pin, eliminating jaw deflection.



### ReLock Chip Shields

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



### Center Jaw Location

The ReLock's center jaw locating studs allow quick jaw mounting and indexing to accuracies of  $\pm .0005$ ". Fool-proof pin eliminates the possibility of the jaws being accidentally mounted in reverse.



### Single Station Conversion Plate

Used in conjunction with SnapLock carrier jaws, the conversion plate allows the ReLock system to be converted from a double to a single station vise – ideal for larger work pieces. See page 167 for the 2-station version. For 8-station version, see page 170.



## ReLock Vise System Accessories

### Snaplock Machinable Fixture Jaws

Jaws can be attached, reversed, removed or indexed in a matter of seconds. The jaws are extremely versatile, allowing endless customization possibilities. Jaws are manufactured from steel and high quality aluminum material. See pages 173-175.



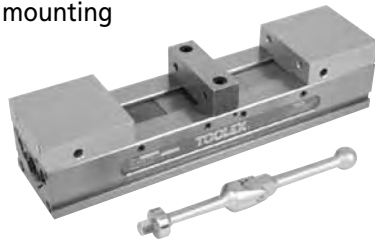
### AccuSnap Vise Jaw System

The AccuSnap Vise Jaw system (pictured) shows master jaws and parallels being used for workpiece setup. The AccuSnap system allows setup change-over in seconds with extreme accuracy. See pages 177-183 for the complete product line.



### SnapLock Carrier Jaws

Carrier jaws allow mounting of AccuSnap and QuickChange Master Jaws or standard bolt on jaws using an industry standard bolt pattern. See page 176.



### AccuSnap Machinable Fixture Jaws

Ideal for many workholding options of smaller workpieces. Jaws are offered in two thicknesses, from either aluminum or pre-hardened steel. See page 180.



### QuickChange Vise Jaw System

The QuickChange Vise Jaw System slides 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 vise systems. The QuickChange product line is located on pages 184-188.

### AccuSnap Workstops

Easily mount to AccuSnap parallels in a variety of configurations. Provides extreme work piece location accuracy and repeatability. Can be used in conjunction with the AccuSnap presetting gage to accurately reference your X, Y & Z machine datums. See page 182.



**BOTH THE ACCUSNAP AND QUICKCHANGE  
VISE JAW SYSTEMS CAN BE USED IN  
CONJUNCTION WITH MOST VISE SYSTEMS**



## ReLock Vise System Overview

### ACCUSNAP/QUICKCHANGE PARALLELS

AccuSnap and QuickChange Parallels are designed for a multitude of setup 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 & gib.

### ACCUSNAP/QUICKCHANGE MACHINABLE FIXTURE JAWS

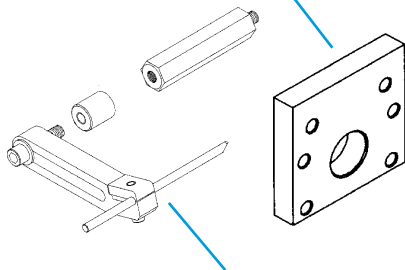
AccuSnap and QuickChange Machinable Fixture Jaws can be customized quickly to fixture a wide array of workpieces. The jaws snap or slide in and out of the master jaws in seconds. Available in either aluminum or pre-hardened steel.

### 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 or off the SnapLock knuckles in seconds.

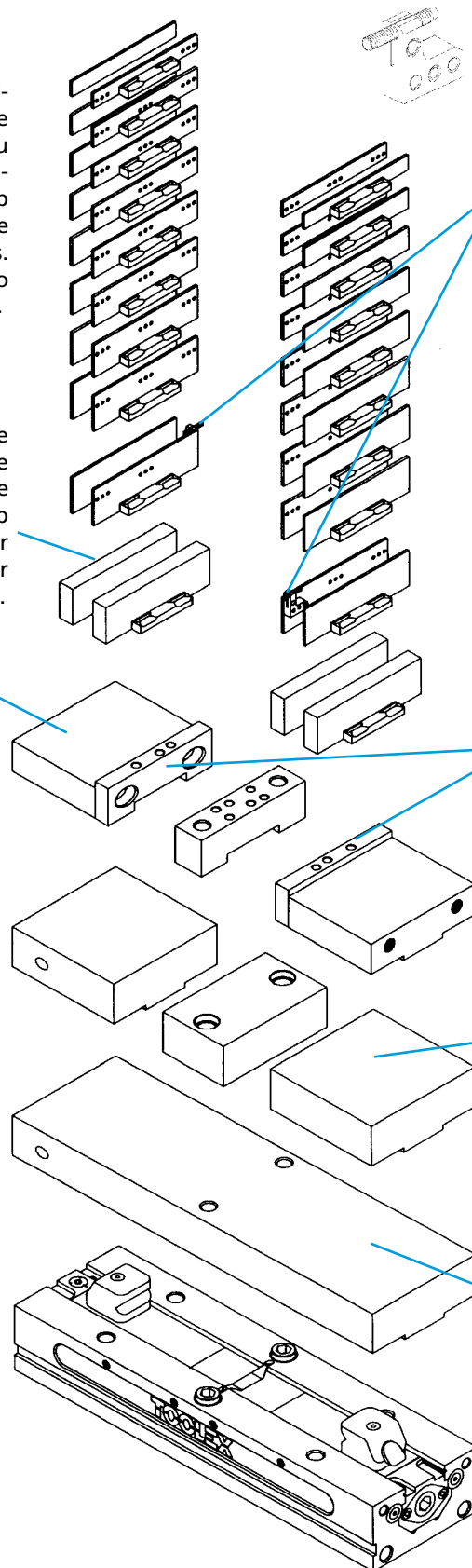
### SINGLE STATION CONVERSION PLATE

The Single Station Conversion Plate quickly converts the ReLock from double station to single station vise for larger workpieces.



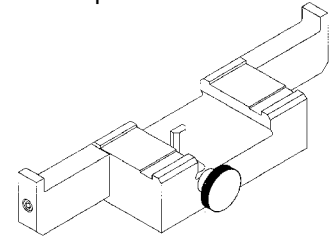
### UNIVERSAL WORKSTOP

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



### ACCUSNAP 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 setups.



### ACCUSNAP 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.

### ACCUSNAP/QUICKCHANGE MASTER JAWS

AccuSnap and QuickChange Master Jaws easily mount to the SnapLock Carrier Jaws by using an industry standard bolt size and pattern. AccuSnap master jaws patented locking receptacle accepts all AccuSnap accessories in seconds.

### SNAPLOCK REVERSIBLE MACHINABLE FIXTURE JAWS

SnapLock Machinable Fixture Jaws are the most versatile method of fixturing on the ReLock System. Customizing options are endless. Jaws can be machined on two faces for additional set-up. Manufactured from high quality aluminum.

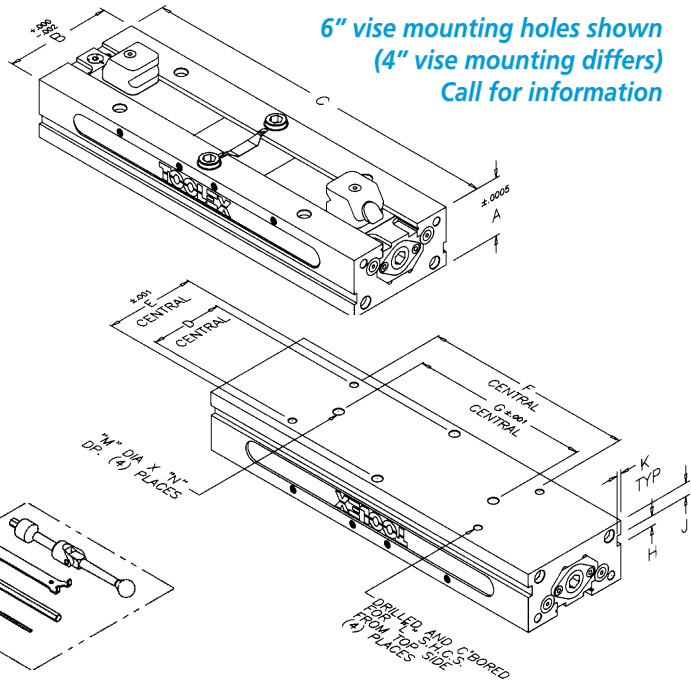
### SNAPLOCK FIXTURE PLATE

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 aluminum.

## ReLock Double Station Vice



**Starter packages available on page 172.**



### Specifications

Vise Size	Net Weight	Clamping Pressure
4"	33 lbs.	0 to 6,000 lbs.
6"	68 lbs.	0 to 12,000 lbs.
8"	110 lbs.	0 to 16,000 lbs.

Vise Size	Part Number	A	B	C	D	E	F	G	H	J	K	L	M	N
4"	RWS4002	2.500	4.000	16.000	3.000	3.000	9.000	10.000	.375	.500	.190	5/16-18	.501	.560
6"	RWS6002	3.250	6.000	20.500	4.000	5.000	12.000	10.000	.562	.750	.250	3/8-16	.501	.630
8"	RWS8002	4.000	8.000	28.500	6.000	6.000	16.000	14.000	.625	.750	.312	1/2-13	.751	.900

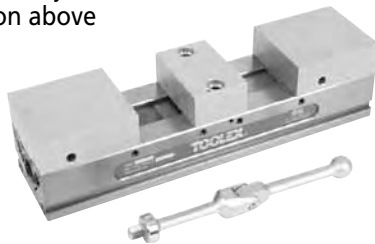
Replacement parts available on pages 196-197.

Jaws not included

**Bodies manufactured from 80,000 PSI ductile cast iron • Ways flame hardened to 40 R/C maximum**

## ReLock Double Station Vice with Machinable Soft Jaws

- Vise specifications and jaw capacities shown on above and on page 167.
- Includes handle and tool kit (pry wrench and hex wrenches).
- See page 173-175 for SnapLock machinable fixture jaw specifications.



*Package includes Double Station Vice and 3-piece Machinable Soft Jaw Set*

Vise Size	Package Number	Package Contents
4"	RWS4002SJ	1-RWS4002 1-SSJ4000
6"	RWS6002SJ	1-RWS6002 1-SSJ6000
8"	RWS8002SJ	1-RWS8002 1-SSJ8000

## ReLock Double Station Vice with Hard Jaws

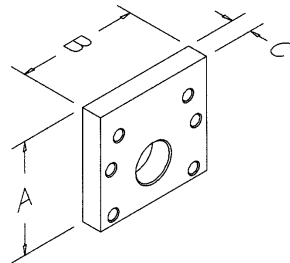
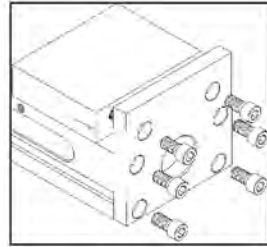
- Vise specifications and jaw capacities shown above and on page 167.
- Includes handle and tool kit (pry wrench and hex wrenches).
- Outside carrier jaws manufactured from high quality aluminum material (page 176).
- Standard hard jaw specifications are on page 190.



*Package includes Double Station Vice, two Carrier Jaws and 3-piece Standard Hard Jaw Set*

Vise Size	Package Number	Package Contents
4"	RWS4002HJ	1-RWS4002 1-SCJ4000 1-SHJ4035
6"	RWS6002HJ	1-RWS6002 1-SCJ6000 1-SHJ6035
8"	RWS8002HJ	1-RWS8002 1-SCJ8000 1-SHJ8035

## Single Station Conversion Plate for ReLock 2-Station Vise



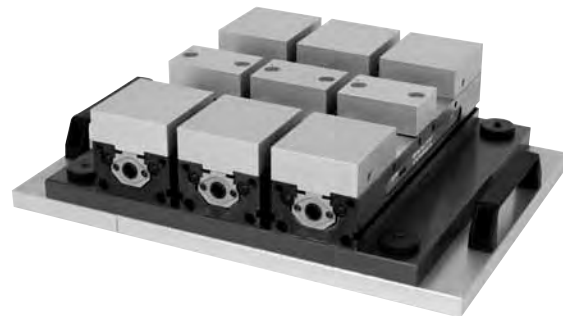
**Converts a double station vise to a single station!**

- The single station conversion plate, used in conjunction with SnapLock carrier jaw, allows the system to be converted from a double to a single station.
- Capacities and configuration examples are illustrated at left.
- Single station conversion plate is not compatible with DS6000 vise

Vise Size	Part Number	A	B	C
4"	RCP4002	4.163	4.000	.720
6"	RCP6002	5.538	6.000	.720
8"	RCP8002	7.093	8.000	.970

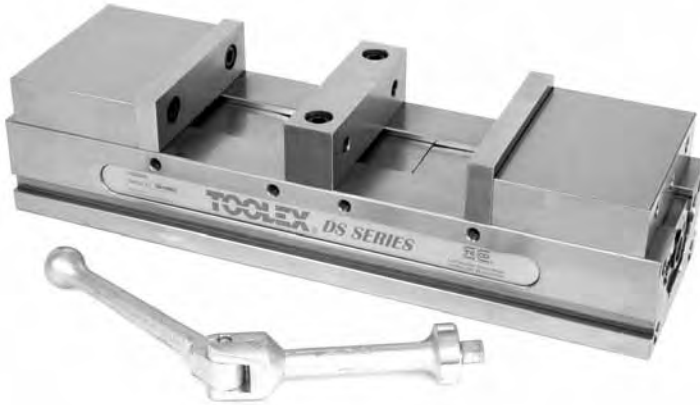
## ReLock 2 and 8-Station Capacities

The compact design of the Toolex vise allows you to mount the vises very closely to each other without interference. The SnapLock line of jaws allows you to literally "snap" jaws and accessories on and off the vise without the use of bolts or pins. For applications requiring a subplate or fixture plate, please fill out the Plate Quotation Worksheet found on page 202.



RELOCK 2 & 8 STATION CAPACITIES								
MACHINABLE JAWS	4"	6"	8"	CARRIER & HARD JAWS	4"	6"	8"	
	4.125	5.125	7.625		3.000	4.000	6.000	
	6.875	9.060	12.812		7.375	9.500	13.250	
	9.500	11.625	17.125		7.250	9.500	14.000	
	12.250	15.562	22.312		11.625	15.000	21.250	
	15.000	19.500	27.500		16.000	20.500	28.500	

## TOOLEX® DS Series – 6" Double Station Hard Jaw Vise



- Includes manual off-set mechanism with maximum .250" offset setting
- Standard Hard Jaw Set made of 1018 steel
- Carrier jaws will accept both AccuSnap and QuickChange master jaws

### Includes:

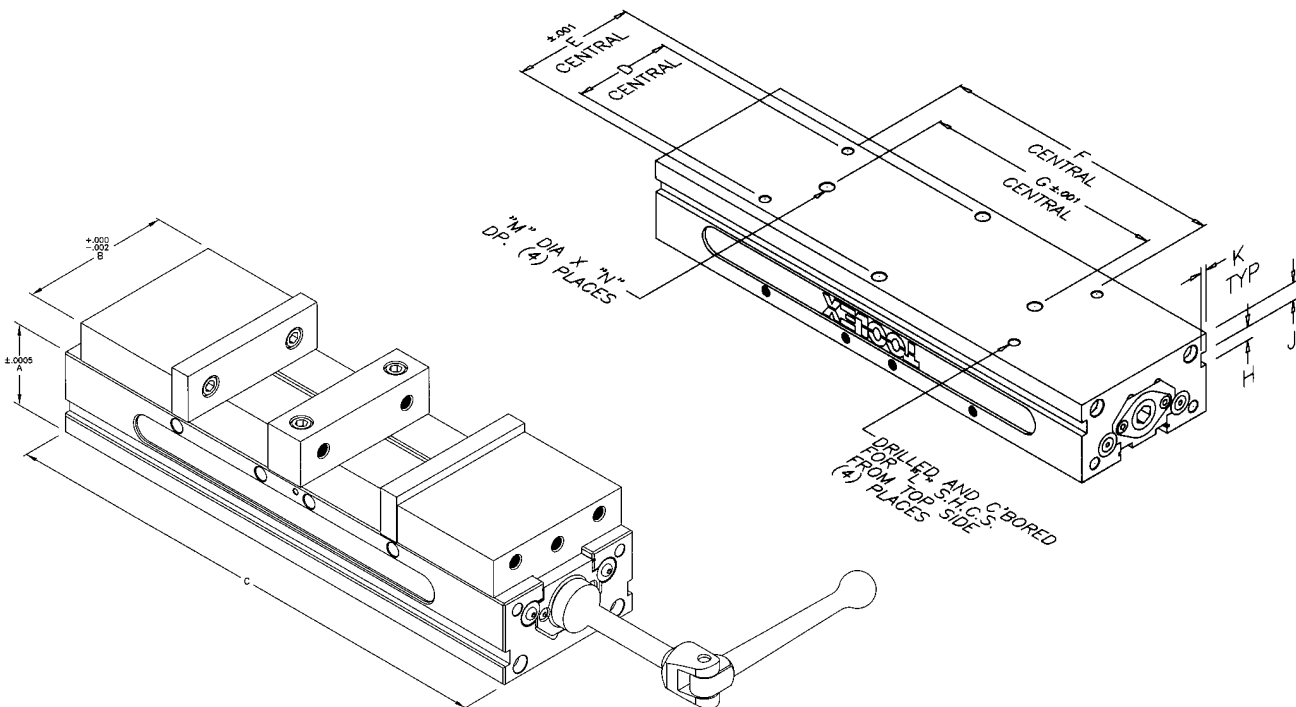
6" Vise, 2-piece cast iron Carrier Jaw Set and 3-piece Standard Hard Jaw Set

### Specifications

Vise Size	Net Weight	Clamping Pressure
6"	110 lbs.	0 to 12,000 lbs.



Vise Size	Part Number	A	B	C	D	E	F	G	H	J	K	L	M	N
6"	DS6000	3.250	6.000	20.500	4.000	5.000	12.000	10.000	.562	.750	.250	3/8-16	.501	.630



Bodies manufactured from 80,000 PSI ductile cast iron • Ways flame hardened to 40 R/C maximum

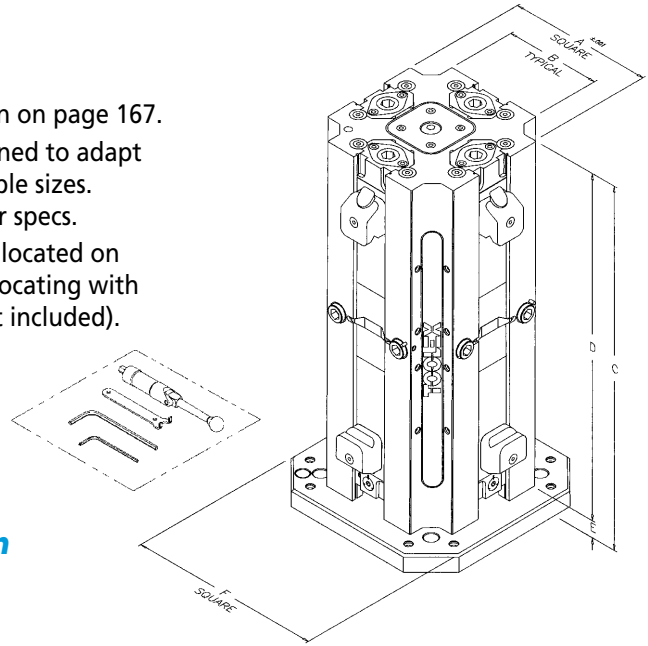


## ReLock 8-Station Vise



- Vise capacities shown on page 167.
- Baseplates are designed to adapt to many machine table sizes. See page 193-195 for specs.
- Vise columns can be located on a pallet using edge locating with shims or spacers (not included).

**Starter packages available on page 172.**



### Specifications

Vise Size	Net Weight	Clamping Pressure
4"	150 lbs.	0 to 6,000 lbs.
6"	280 lbs.	0 to 12,000 lbs.
8"	750 lbs.	0 to 16,000 lbs.

Vise Size	Part Number	A	B	C	D	E	F
4"	RWS4008	7.000	4.000	17.90	16.750	1.150	10.750
4"	RWS4408	7.000	4.000	17.90	16.750	1.150	400mm
6"	RWS6008	9.000	6.000	22.65	21.250	1.400	14.000
6"	RWS6408	9.000	6.000	22.65	21.250	1.400	400mm
8"	RWS8008	12.000	8.000	31.10	29.500	1.600	18.000

**Replacement parts available on pages 198-199**

**Bodies manufactured from 80,000 PSI ductile cast iron • Ways flame hardened to 40 R/C maximum**

## ReLock 8-Station Vise with Machinable Soft Jaws

- Includes handle and tool kit (pry wrench and hex wrenches).
- See page 174-175 for SnapLock machinable fixture jaw specifications.



Vise Size	Package Number	Package Contents
4"	RWS4008SJ*	1-RWS4008 4-SSJ4000
6"	RWS6008SJ**	1-RWS6008 4-SSJ6000
8"	RWS8008SJ	1-RWS8008 4-SSJ8000

**Package includes 8-Station Vise and four 3-piece Machinable Soft Jaw Sets**

\* Use RWS4408SJ for 4" ReLock Vise with 400mm baseplate w/soft jaws  
\*\* Use RWS6408SJ for 6" ReLock Vise with 400mm baseplate w/soft jaws

## ReLock 8-Station Vise with Hard Jaws

- Standard hard jaws specifications on page 190.
- Outside carrier jaws manufactured from high quality aluminum material (see page 176).



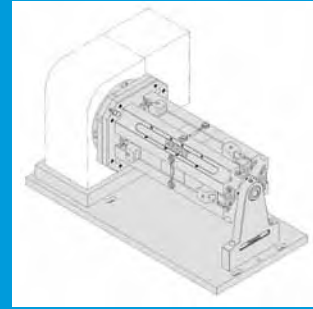
Vise Size	Package Number	Package Contents
4"	RWS4008HJ*	1-RWS4008 4-SCJ4000 4-SHJ4035
6"	RWS6008HJ**	1-RWS6008 4-SCJ6000 4-SHJ6035
8"	RWS8008HJ	1-RWS8008 4-SCJ8000 4-SHJ8035

**Package includes 8-Station Vise, eight Carrier Jaws and four 3-piece Standard Hard Jaw Sets**

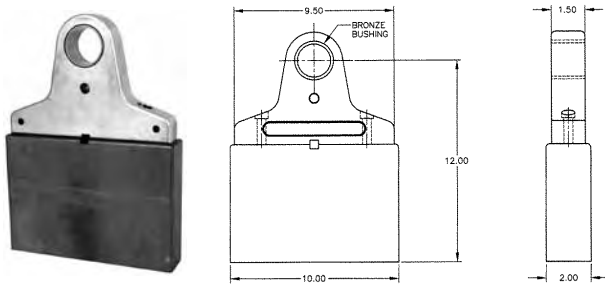
\* Use RWS4408HJ for ReLock Vise with 400mm baseplate w/hard jaws  
\*\* Use RWS6408HJ for ReLock Vise with 400mm baseplate w/hard jaws

## RELOCK-8 STATION WORKHOLDING SYSTEM

The ReLock 8-Station's compact and lightweight unibody design is perfect for horizontal machining centers. The unibody is manufactured from 80,000 PSI Ductile Cast Iron and the ways are flamed hardened and precision ground to accuracies of  $\pm .0005"$ . It's also ideal for use with rotary indexers in vertical machining center applications. For special requirements, please use the ReLock-8 Indexer Assembly Quotation Worksheet on page 203.

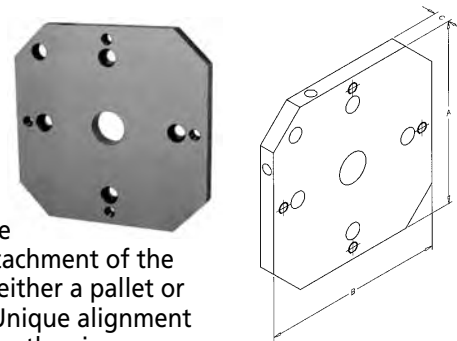


### ReLock-8 Support Bracket Part Number RSB4000



- Optional ReLock support bracket incorporates a bronze bushing and grease fitting for durability.
- Customer must modify base to required height.

### ReLock-8 Adapter Plate

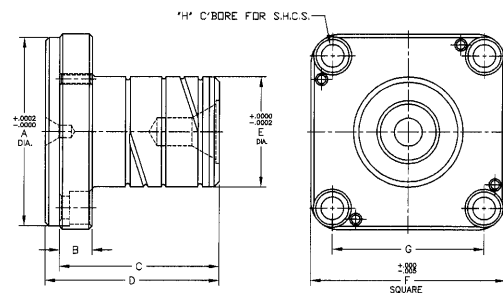


Optional adapter plate simplifies attachment of the ReLock-8 to either a pallet or an indexer. Unique alignment feature allows the vise to be oriented to indexing quickly and accurately.

Vise Size	Part Number	A	B	C
4"	RAP4008	9.000	9.000	.750
6"	RAP6008	12.000	12.000	1.000

### ReLock-8 Support/Alignment Nose

Optional support nose works in conjunction with the support bracket and adapter plate for long lasting precision to  $.001"$  T.I.R.



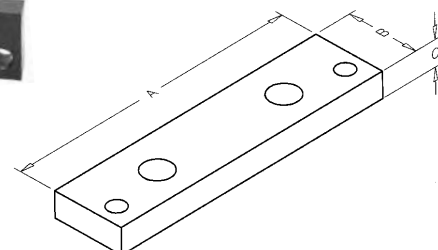
Vise Size	Part Number	A	B	C	D	E	F	G	H
4"	RSN4008	2.750	.469	2.750	3.000	1.9672	2.875	2.207	5/16-18
6"	RSN6008	3.375	.593	2.875	3.125	1.9672	3.500	2.726	3/8-16
8"	RSN8008	5.125	.718	3.000	3.250	1.9672	5.250	4.187	1/2-13

### Single Station Conversion Plate for ReLock-8

- Allows each station to be converted from double to single station when used in conjunction with SnapLock carrier jaw.
- Capacities and configuration examples are illustrated on page 171.
- Not compatible with ReLock Compact Quad.
- See pg. 172 for mounting info.



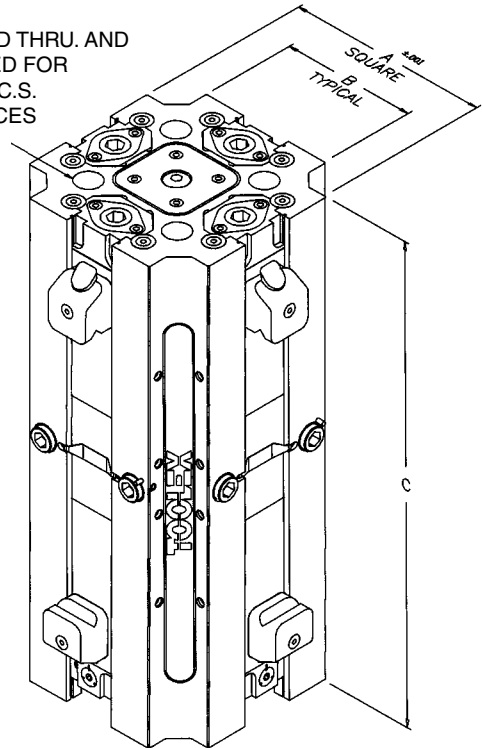
Vise Size	Part Number	A	B	C
4"	RCP4008	5.50	1.350	.720
6"	RCP6008	8.00	2.000	.720
8"	RCP8008	10.25	2.500	.970



## ReLock 8-Station Compact Quad



DRILLED THRU. AND  
C'BORED FOR  
"D" S.H.C.S.  
(4) PLACES



- Designed for machining center with small work envelopes like the Tsugami FMA3.
- Through column mounting holes are included to mount directly to the pallet of an HMC without the need for a baseplate.
- Clamping pressure = 0 to 6,000 lbs.
- Recommended foot lbs. = 45-50
- Mounting kit included.

*Call for print with mounting information*

Part Number	A	B	C	Package Contents
RWS40S8	7.000	4.000	13.90	1-RWS40S8 no jaws
RWS40S8SJ	7.000	4.000	13.90	1-RWS40S8 4-SSJ4000
RWS40S8HJ	7.000	4.000	13.90	1-RWS40S8 4-SCJ4000 4-SHJ4035

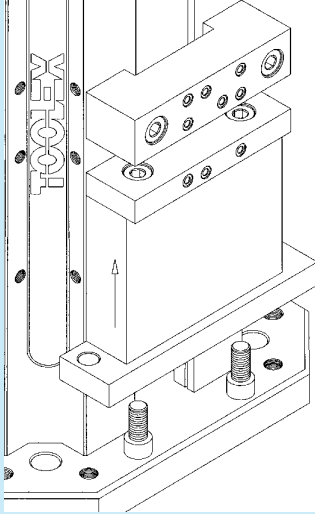
**ReLock-8  
Adapter  
Plate is  
available  
on page 170.**



MACHINABLE JAWS		CARRIER & HARD JAWS	
	2.700		1.575
	5.450		2.950
	6.650		4.400
	9.400		8.775
	12.150		13.150

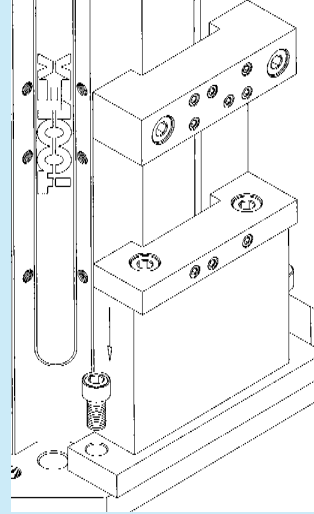
Bodies manufactured from 80,000 PSI ductile cast iron • Ways flame hardened to 40 R/C maximum

## Easy Mounting Instructions for the Single Station Conversion Plate on a ReLock 8-Station Vise



### Step 1

Crank bottom jaw toward center of vise. Mount single station conversion plate to the back carrier jaw as shown.



### Step 2

Crank bottom jaw down until the single station conversion plate touches baseplate. Mount the single station conversion plate to the baseplate.

### 2-Station Vise Packages



#### Package #RSP4002 includes:

Qty.	PART NUMBER	Part Description
1	RWS4002	4" ReLock 2-Station Vise
1	SCJ4000	SnapLock Carrier Jaw Set*
1	AMJ4035	AccuSnap Master Jaws (3 pc. set)
2	APS4000	AccuSnap Basic Parallel Set

\*2 outside jaws per set

#### Package #RSP6002 includes:

Qty.	PART NUMBER	Part Description
1	RWS6002	6" ReLock 2-Station Vise
1	SCJ6000	SnapLock Carrier Jaw Set*
1	AMJ6035	AccuSnap Master Jaws (3 pc. set)
2	APS6000	AccuSnap Basic Parallel Set

\*2 outside jaws per set

#### Package #RSP8002 includes:

Qty.	PART NUMBER	Part Description
1	RWS8002	8" ReLock 2-Station Vise
1	SCJ8000	SnapLock Carrier Jaw Set*
1	AMJ8035	AccuSnap Master Jaws (3 pc. set)
2	APS8000	AccuSnap Basic Parallel Set

\*2 outside jaws per set

### 8-Station Vise Packages



#### Package #RSP4008 includes:

Qty.	PART NUMBER	Part Description
1	RWS4008	4" ReLock 8-Station Vise
4	SCJ4000	SnapLock Carrier Jaw Set*
4	AMJ4035	AccuSnap Master Jaws (3 pc. set)
8	APS4000	AccuSnap Basic Parallel Set

\*2 outside jaws per set

#### Package #RSP6008 includes:

Qty.	PART NUMBER	Part Description
1	RWS6008	6" ReLock 8-Station Vise
4	SCJ6000	SnapLock Carrier Jaw Set*
4	AMJ6035	AccuSnap Master Jaws (3 pc. set)
8	APS6000	AccuSnap Basic Parallel Set

\*2 outside jaws per set

#### Package #RSP8008 includes:

Qty.	PART NUMBER	Part Description
1	RWS8008	8" ReLock 8-Station Vise
4	SCJ8000	SnapLock Carrier Jaw Set*
4	AMJ8035	AccuSnap Master Jaws (3 pc. set)
8	APS8000	AccuSnap Basic Parallel Set

\*2 outside jaws per set

## SnapLock Machinable, Reversible Fixture Jaws

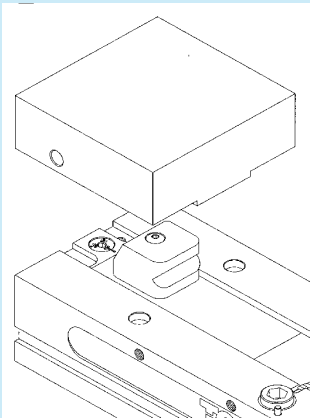
The SnapLock® system's patented design provides simple, quick changeovers between machinable and carrier jaws.

### Snaplock Machinable Fixture Jaws:

- Can be attached, reversed, removed or indexed in a matter of seconds.
- Extremely versatile, allowing endless customization possibilities.
- Manufactured from high quality aluminum.
- **SnapLock Carrier Jaws:**
- Allows mounting of AccuSnap and Quick-Change master jaws or standard bolt-on jaws using an industry standard bolt size and pattern.

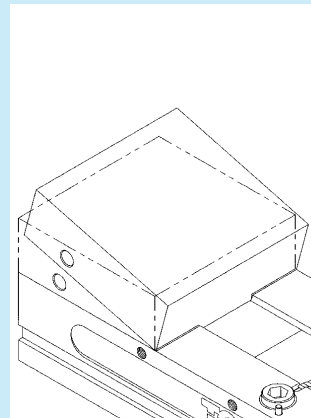



## How to use the SnapLock Jaw System



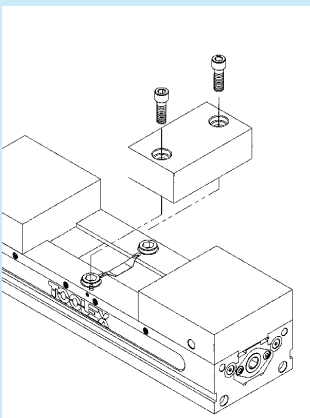
### Step 1

To use the SnapLock Jaw System, simply align the jaw over the appropriate ReLock knuckle.



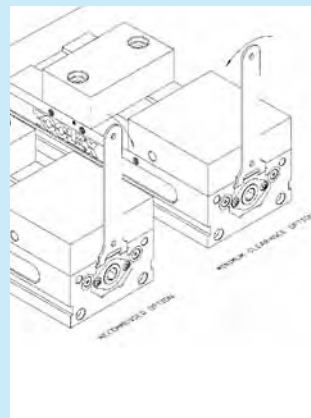
### Step 2

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



### Step 3

Finally, align the center over corresponding mounting and locating holes and fasten down with socket head cap screws.



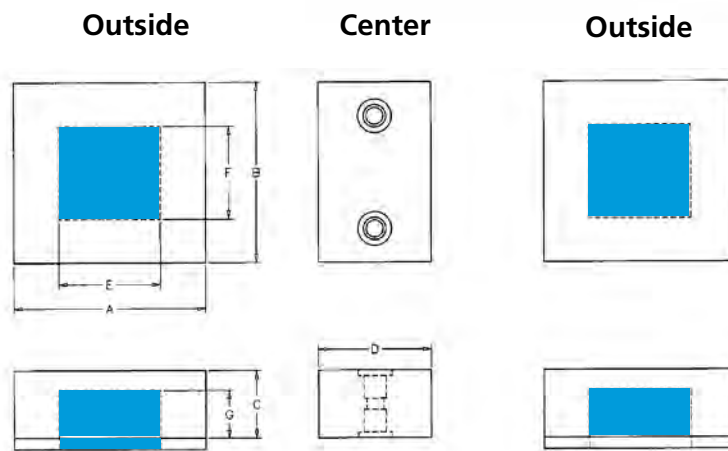
### Step 4

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



## SnapLock Machinable Fixture Jaws

- Manufactured from high quality aluminum, steel, and 4140 steel.
- Jaws are reversible for additional work piece set-up.
- SnapLock jaws are to be used with the ReLock system only.



■ Denotes non-machinable areas

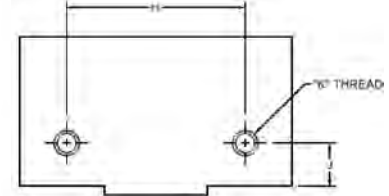
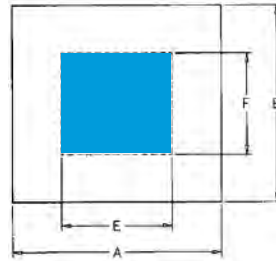
Vise Size	Part Desc.	PART NUMBER			A	B	C	D	E	F	G	Style
		Aluminum	1018 Steel	4140 Steel								
4"	3 pc. Set	SSJ4000	SSJ4020	SSJ4140	4.250	3.94	1.500	2.500	2.250	2.060	1.060	Standard
	1 Center	SSJ4100	SSJ4021	SSJ4023	---	3.94	1.500	2.500	---	---	---	
	1 Outside	SSJ4200	SSJ4022	SSJ4024	4.250	3.94	1.500	---	2.250	2.060	1.060	
4"	3 pc. Set	SSJ4275	---	---	4.250	3.94	2.75	2.500	2.250	2.060	1.060	Tall
	1 Center	SSJ4075	---	---	---	3.94	2.75	2.500	---	---	---	
	1 Outside	SSJ4175	---	---	4.250	3.94	2.75	---	2.250	2.060	1.060	
4"	3 pc. Set	SSJ4006	---	---	4.250	5.94	1.500	2.500	---	---	---	Wide
	1 Center	SSJ4016	---	---	---	5.94	1.500	2.500	---	---	---	
	1 Outside	SSJ4026	---	---	4.250	5.94	1.500	---	2.250	2.060	1.060	
6"	3 pc. Set	SSJ6000	SSJ6020	SSJ6140	5.812	5.94	2.000	3.500	3.063	2.810	1.280	Standard
	1 Center	SSJ6100	SSJ6021	SSJ6023	---	5.94	2.000	3.500	---	---	---	
	1 Outside	SSJ6200	SSJ6022	SSJ6024	5.812	5.94	2.000	---	3.063	2.810	1.280	
6"	3 pc. Set	SSJ6325	---	---	5.812	5.94	3.25	3.500	3.063	2.810	1.280	Tall
	1 Center	SSJ6125	---	---	---	5.94	3.25	3.500	---	---	---	
	1 Outside	SSJ6225	---	---	5.812	5.94	3.25	---	3.063	2.810	1.280	
6"	3 pc. Set	SSJ6008	---	---	5.812	7.94	2.000	3.500	3.063	2.810	1.280	Wide
	1 Center	SSJ6108	---	---	---	7.94	2.000	3.500	---	---	---	
	1 Outside	SSJ6208	---	---	5.812	7.94	2.000	---	3.063	2.810	1.280	
8"	3 pc. Set	SSJ8000	SSJ8020	SSJ8140	7.500	7.94	2.500	4.500	3.125	2.625	1.500	Standard
	1 Center	SSJ8100	SSJ8021	SSJ8023	---	7.94	2.500	4.500	---	---	---	
	1 Outside	SSJ8200	SSJ8022	SSJ8024	7.500	7.94	2.500	---	3.125	2.625	1.500	
8"	3 pc. Set	SSJ8375	---	---	7.500	7.94	3.75	4.500	3.125	2.625	1.500	Tall
	1 Center	SSJ8175	---	---	---	7.94	3.75	4.500	---	---	---	
	1 Outside	SSJ8275	---	---	7.500	7.94	3.75	---	3.125	2.625	1.500	
8"	3 pc. Set	SSJ8010	---	---	7.500	9.94	2.50	4.500	3.125	2.625	1.500	Wide
	1 Center	SSJ8110	---	---	---	9.94	2.50	4.500	---	---	---	
	1 Outside	SSJ8210	---	---	7.500	9.94	2.50	---	3.125	2.625	1.500	

## SnapLock Machinable Fixture Jaws for Single Station Application

- Manufactured from high quality aluminum, steel and 4140 steel.
- Tapped holes allow user to convert the Relock® vise into a single station vise using the single station conversion plate on page 167.
- SnapLock Jaws are only used with the ReLock® System.



Outside

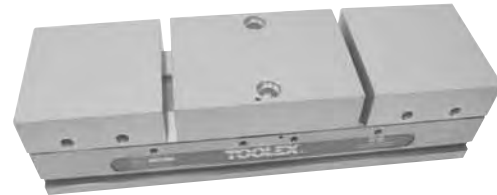


■ Denotes non-machinable areas

Vise Size	PART NUMBER			A	B	C	E	F	G	H	J	K	Style
	Aluminum	1018 Steel	4140 Steel										
4"	SSJ4200T	SSJ4022T	SSJ4024T	4.250	3.94	1.500	2.250	2.060	1.060	2.500	.687	3/8-16 x .63	Std.
4"	SSJ4175T	---	---	4.250	3.94	2.75	2.250	2.060	1.060	2.500	.687	3/8-16 x .63	Tall
6"	SSJ6200T	SSJ6022T	SSJ6024T	5.812	5.94	2.000	3.063	2.810	1.280	3.875	.937	1/2-13 x .75	Std.
6"	SSJ6225T	---	---	5.812	5.94	3.25	3.063	2.810	1.280	3.875	.937	1/2-13 x .75	Tall
8"	SSJ8200T	SSJ8022T	SSJ8024T	7.500	7.94	2.500	3.125	2.625	1.500	4.750	1.218	5/8-11 x 1.3	Std.
8"	SSJ8275T	---	---	7.500	7.94	3.75	3.125	2.625	1.500	4.750	1.218	5/8-11 x 1.3	Tall

## SnapLock Full-Coverage Machinable Fixture Jaws

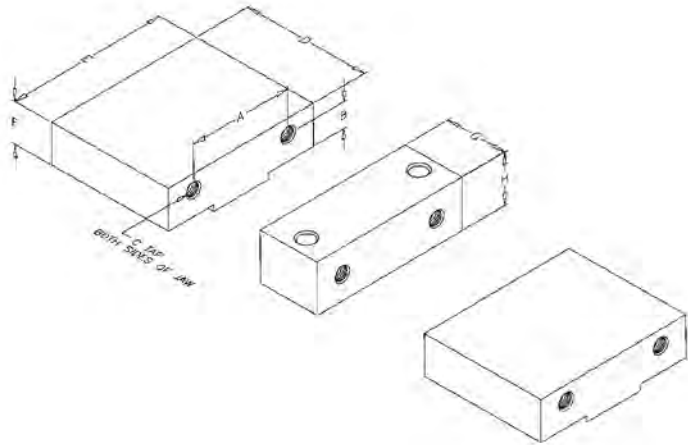
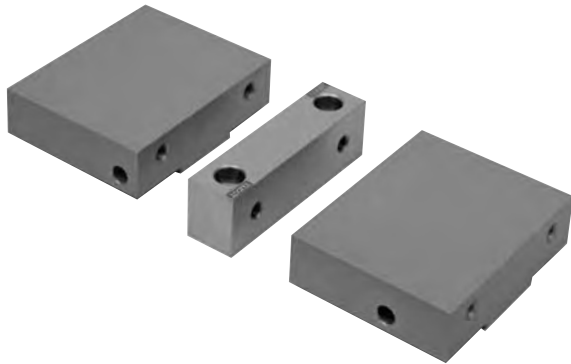
- Manufactured from high quality aluminum.
- Jaws are reversible for additional workpiece set-up.
- Jaws allow maximum part contact and part rigidity.
- SnapLock jaws are to be used with the ReLock system only.
- See page 174 for additional outside jaws to be used in conjunction with full coverage center jaws.



Please refer to drawing on page 174

Part No.	Part Desc.	A	B	C	D	E	F	G	Style	3-piece Sets Include:
SSJ4000FC	3 PC SET	4.250	3.94	1.500	6.500	2.250	2.060	1.060	Standard	2: SSJ4200 & 1: SSJ4100FC
SSJ4100FC	1 CENTER	4.250	3.94	1.500	6.500	2.250	2.060	1.060	Standard	Standard
SSJ4275FC	3 PC SET	4.250	3.94	2.750	6.500	2.250	2.060	1.060	Tall	2: SSJ4175 & 1: SSJ4075FC
SSJ4075FC	1 CENTER	4.250	3.94	2.750	6.500	2.250	2.060	1.060	Tall	Tall
SSJ4006FC	3 PC SET	4.250	5.94	1.500	6.500	2.250	2.060	1.060	Wide	2: SSJ4026 & 1: SSJ4016FC
SSJ4016FC	1 CENTER	4.250	5.94	1.500	6.500	2.250	2.060	1.060	Wide	Wide
SSJ6000FC	3 PC SET	5.812	5.94	2.000	7.875	3.063	2.810	1.280	Standard	2: SSJ6200 & 1: SSJ6100FC
SSJ6100FC	1 CENTER	5.812	5.94	2.000	7.875	3.063	2.810	1.280	Standard	Standard
SSJ6325FC	3 PC SET	5.812	5.94	3.250	7.875	3.063	2.810	1.280	Tall	2: SSJ6225 & 1: SSJ6125FC
SSJ6125FC	1 CENTER	5.812	5.94	3.250	7.875	3.063	2.810	1.280	Tall	Tall
SSJ6008FC	3 PC SET	5.812	7.94	2.000	7.875	3.063	2.810	1.280	Wide	2: SSJ6208 & 1: SSJ6108FC
SSJ6108FC	1 CENTER	5.812	7.94	2.000	7.875	3.063	2.810	1.280	Wide	Wide
SSJ8000FC	3 PC SET	7.500	7.94	2.500	11.500	3.125	2.625	1.500	Standard	2: SSJ8200 & 1: SSJ8100FC
SSJ8100FC	1 CENTER	7.500	7.94	2.500	11.500	3.125	2.625	1.500	Standard	Standard
SSJ8375FC	3 PC SET	7.500	7.94	3.750	11.500	3.125	2.625	1.500	Tall	2: SSJ8275 & 1: SSJ8175FC
SSJ8175FC	1 CENTER	7.500	7.94	3.750	11.500	3.125	2.625	1.500	Tall	Tall
SSJ8010FC	3 PC SET	7.500	9.94	2.500	11.500	3.125	2.625	1.500	Wide	2: SSJ8210 & 1: SSJ8110FC
SSJ8110FC	1 CENTER	7.500	9.94	2.500	11.500	3.125	2.625	1.500	Wide	Wide

## SnapLock Carrier Jaws



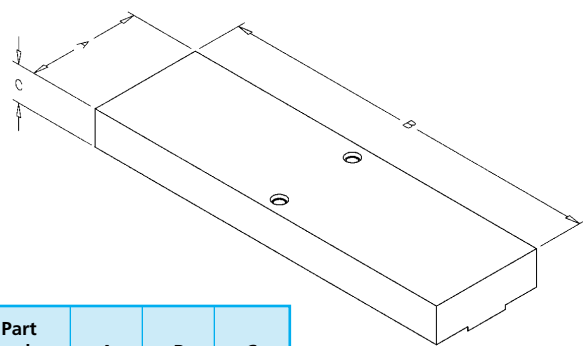
- Outside jaws manufactured from high quality aluminum material; center jaw manufactured from steel.
- Carrier jaws are to be used in conjunction with AccuSnap (page 178) and QuickChange master jaws (page 185).
- Outside jaws can be used in conjunction with single station conversion plates (pages 167 and 170).
- SnapLock Jaws are to be used with the ReLock system only.
- Two socket head cap screws included with each outside jaw.

**Single Station Conversion Plates are available on pages 167 and 170.**



Vise Size	Part Description	Part Number		A	B	C	D	E	F	G	H
		Aluminum	Steel								
4"	2 Outside	SCJ4000	SCJ4020	2.500	.687	3/8-16	3.812	3.94	1.12	-	-
	1 Center	-	SCJ4030	2.500	.687	3/8-16	-	3.94	1.12	1.250	1.350
	3 pc. Set	SCJ4035	SCJ4025	2.500	.687	3/8-16	3.812	3.94	1.12	1.250	1.350
6"	2 Outside	SCJ6000	SCJ6020	3.875	.937	1/2-13	4.750	5.94	1.52	-	-
	1 Center	-	SCJ6030	3.875	.937	1/2-13	-	5.94	-	1.500	1.850
	3 pc. Set	SCJ6035	SCJ6025	3.875	.937	1/2-13	4.750	5.94	1.52	1.500	1.850
8"	2 Outside	SCJ8000	SCJ8020	4.750	1.218	5/8-11	6.125	7.94	2.12	-	-
	1 Center	-	SCJ8030	4.750	1.218	5/8-11	-	7.94	-	1.980	2.35
	3 pc. Set	SCJ8035	SCJ8025	4.750	1.218	5/8-11	6.125	7.94	2.12	1.980	2.35

## SnapLock Fixture Plates



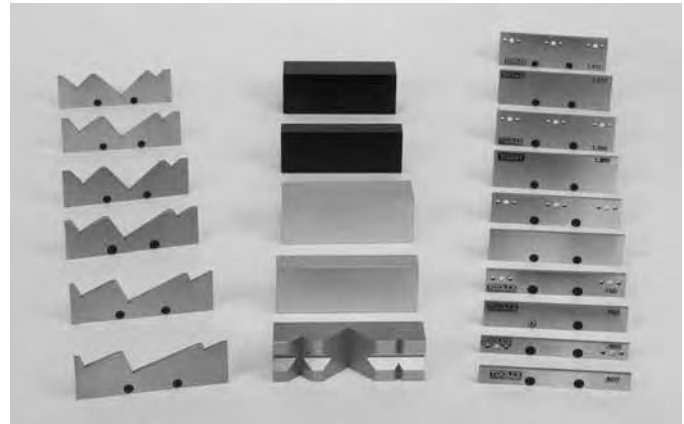
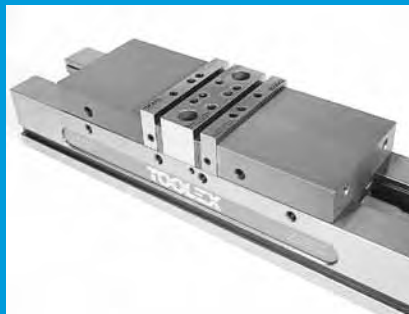
- Manufactured from high quality aluminum material.
- Ideal for holding many small parts or workpieces with difficult clamping or locating points.
- SnapLock plates are used only with the ReLock system.

Vise Size	Part Number	A	B	C
4"	SFP4000	4.000	16.000	1.500
	SFP4001	6.000	16.000	1.500
6"	SFP6000	6.000	20.500	2.000
	SFP6001	8.000	20.500	2.000
8"	SFP8000	8.000	28.500	2.500
	SFP8001	10.000	28.500	2.500

## AccuSnap Jaws and Parallels

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

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

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

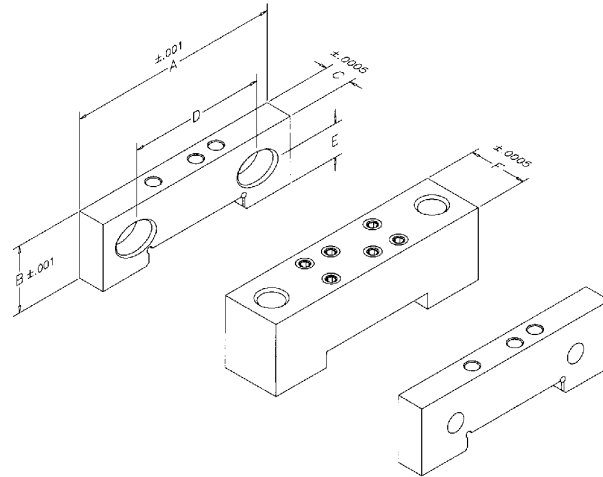


Snap in the parallels or soft jaws that you require for your setup and begin machining. Two lock screws are provided for extra holding assurance, but are not necessary to hold parallels in place. Do not overtighten lock screws.



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.

## AccuSnap Master Jaws

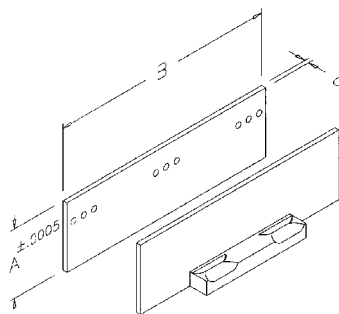


**Adaptable to most vise jaw systems!**

- For ReLock applications, AccuSnap master jaws mount to the SnapLock carrier jaws and accept all AccuSnap jaw components.
- Install AccuSnap master jaws to SnapLock carrier jaws on vise for squareness.
- Replacement parts are available (page 200).
- 3-piece set includes wrench.

Vise Size	Part Description	Part Number	A	B	C	D	E	F
4"	3 pc. Set	<b>AMJ4035</b>	3.980	1.350	.560	2.500	.687	–
	2 Outside	<b>AMJ4000</b>	3.980	1.350	.560	2.500	.687	–
	1 Center	<b>AMJ4030</b>	3.980	1.350	–	2.500	.687	1.250
6"	3 pc. Set	<b>AMJ6035</b>	5.980	1.850	.750	3.875	.937	–
	2 Outside	<b>AMJ6000</b>	5.980	1.850	.750	3.875	.937	–
	1 Center	<b>AMJ6030</b>	5.980	1.850	–	3.875	.937	1.500
8"	3 pc. Set	<b>AMJ8035</b>	7.980	2.350	1.125	4.750	1.218	–
	2 Outside	<b>AMJ8000</b>	7.980	2.350	1.125	4.750	1.218	–
	1 Center	<b>AMJ8030</b>	7.980	2.350	–	4.750	1.218	2.000

## AccuSnap Individual Parallel Sets



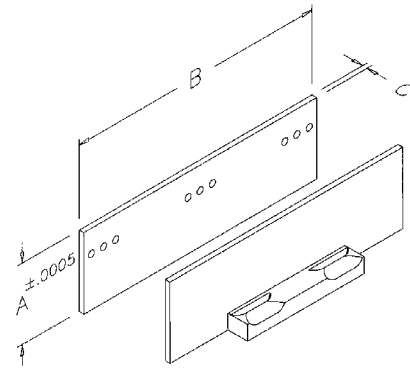
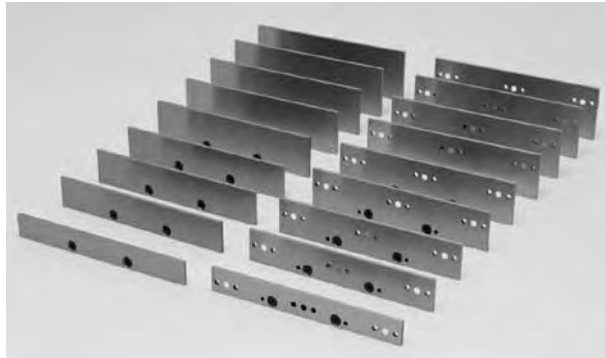
- Use in conjunction with AccuSnap master jaws (above).
- Parallels "snap" into position quickly and easily.
- Parallels are ejected from the master jaws via a patented kick out pawl assembly.
- Packaged two to a set.
- Can be used in conjunction with AccuSnap modular workstops shown on page 182.
- Expanded parallel sets available on page 179.

Vise Size	Part Number	A	B	C
4"	<b>AIP4001*</b>	.500	3.980	.118
	<b>AIP4002*</b>	.625	3.980	.118
	<b>AIP4003*</b>	.750	3.980	.118
	<b>AIP4004</b>	.875	3.980	.118
	<b>AIP4005</b>	1.000	3.980	.118
	<b>AIP4006</b>	1.125	3.980	.118
	<b>AIP4007</b>	1.250	3.980	.118
	<b>AIP4008</b>	1.312	3.980	.118
6"	<b>AIP6001*</b>	.750	5.980	.118
	<b>AIP6002*</b>	1.000	5.980	.118
	<b>AIP6003</b>	1.125	5.980	.118
	<b>AIP6004</b>	1.250	5.980	.118
	<b>AIP6005</b>	1.375	5.980	.118
	<b>AIP6006</b>	1.500	5.980	.118
	<b>AIP6007</b>	1.625	5.980	.118
	<b>AIP6008</b>	1.750	5.980	.118
8"	<b>AIP6009</b>	1.812	5.980	.118
	<b>AIP8001*</b>	1.000	7.980	.118
	<b>AIP8002</b>	1.250	7.980	.118
	<b>AIP8003</b>	1.375	7.980	.118
	<b>AIP8004</b>	1.500	7.980	.118
	<b>AIP8005</b>	1.625	7.980	.118
	<b>AIP8006</b>	1.750	7.980	.118
	<b>AIP8007</b>	1.875	7.980	.118
	<b>AIP8008</b>	2.000	7.980	.118
	<b>AIP8009</b>	2.125	7.980	.118
<b>AIP8010</b>	2.250	7.980	.118	

\*Do not include center mounting holes for AccuSnap Modular Workstops



## AccuSnap Parallel Kits



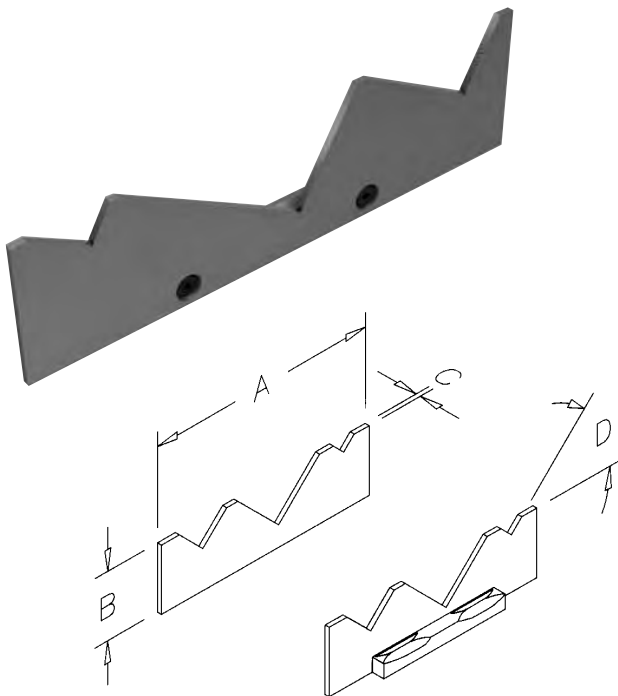
CONTAINS 1 PAIR PER SIZE

- AccuSnap parallels are to be used in conjunction with AccuSnap master jaws (page 178).
- Parallels “snap” into position quickly and easily.
- Parallels are ejected from the master jaws via a kick out pawl assembly.
- Can be used in conjunction with AccuSnap modular workstops (page 182).
- Individual parallel sets available (page 178).
- Holder racks available for 4” and 6” sets (page 183).

Vise Size	Part Number		Basic A	Advanced A		B	C
	Basic	Advanced					
4"	APS4000	APS4001	.500*	.500*	1.000	3.980	.118
			.750*	.625*	1.125		
			1.000	.750*	1.250		
			1.250	.875	1.312		
			1.312				
6"	APS6000	APS6001	.750*	.750*	1.500	5.980	.118
			1.000*	1.000*	1.625		
			1.250	1.125	1.750		
			1.500	1.250	1.812		
			1.750	1.375			
8"	APS8000	APS8001	1.000*	1.000*	1.750	7.980	.118
			1.250	1.250	1.875		
			1.500	1.375	2.000		
			1.750	1.500	2.125		
			2.000	1.625	2.250		
2.250							

\*Do not include center mounting holes for AccuSnap Modular Workstops

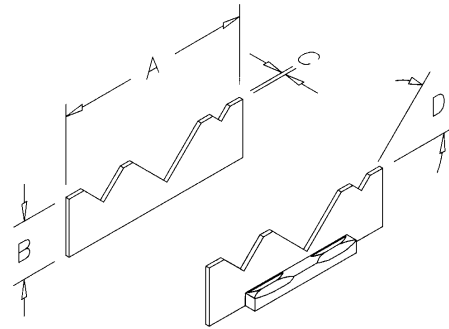
## AccuSnap Mill Angles



- AccuSnap mill angles are designed to be used with the AccuSnap master jaws (page 178).
- AccuSnap mill angle parallel sets available on page 180.
- Sold as individual units or matched sets.

Vise Size	Part Number		A	B	C	(Degree)
	Individual	Matched Set				D
4"	AMA4020	AMM4020	4.000	1.240	.118	20
	AMA4025	AMM4025				25
	AMA4030	AMM4030				30
	AMA4035	AMM4035				35
	AMA4040	AMM4040				40
AMA4045	AMM4045	45				
6"	AMA6020	AMM6020	6.000	1.740	.118	20
	AMA6025	AMM6025				25
	AMA6030	AMM6030				30
	AMA6035	AMM6035				35
	AMA6040	AMM6040				40
AMA6045	AMM6045	45				
8"	AMA8020	AMM8020	8.000	2.230	.118	20
	AMA8025	AMM8025				25
	AMA8030	AMM8030				30
	AMA8035	AMM8035				35
	AMA8040	AMM8040				40
AMA8045	AMM8045	45				

## AccuSnap Mill Angle Kits

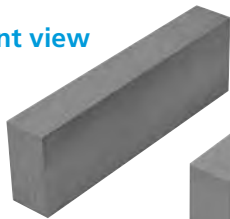


- Designed to be used with the AccuSnap master jaws on page 178.
- AccuSnap individual mill angles are on page 179.

Vise Size	Part Number	A	B	C	(1 of each degree) D
4"	AMA4000	4.000	1.240	.118	20 25 30
					35 40 45
6"	AMA6000	6.000	1.740	.118	20 25 30
					35 40 45
8"	AMA8000	8.000	2.230	.118	20 25 30
					35 40 45

## AccuSnap Machinable Fixture Jaws

Front view



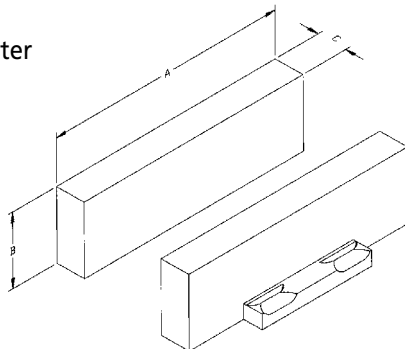
Sold as individual units



Back view

Can be modified to fit your individual needs.

- Use in conjunction with AccuSnap master jaws on page 178.
- Jaws "snap" into position quickly and easily.
- Jaws are ejected from the master jaws via a kick out pawl assembly.



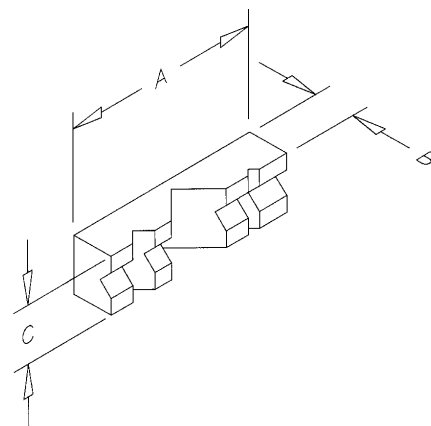
Vise Size	Part Number		A	B	C
	Aluminum	Steel			
4"	ASJ4000	ASJ4020	3.980	1.500	.690
	ASJ4001	ASJ4021			1.255
6"	ASJ6000	ASJ6020	5.980	2.000	.750
	ASJ6001	ASJ6021			1.500
8"	ASJ8000	ASJ8020	7.980	2.500	1.250
	ASJ8001	ASJ8021			2.500

## AccuSnap "V" Jaws



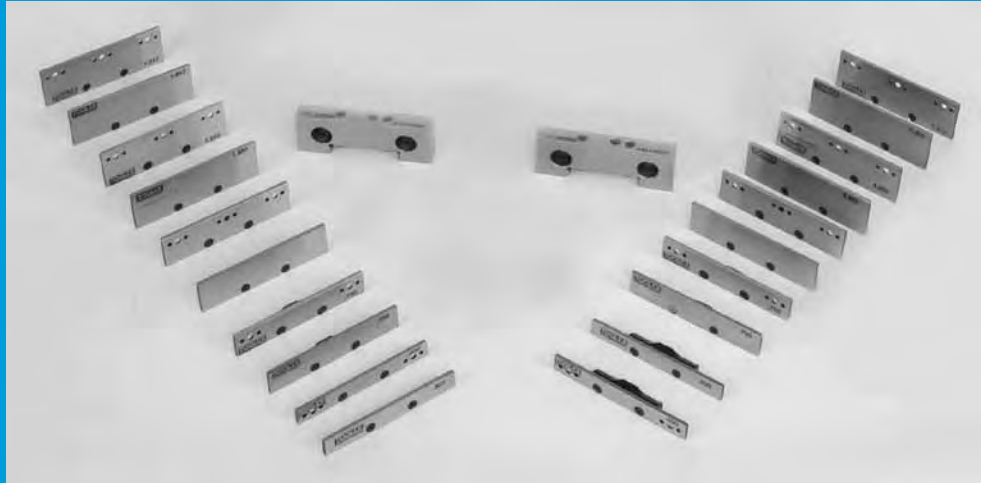
Sold as individual units

AccuSnap "V" jaws are designed to be used with AccuSnap master jaws on page 178.



Vise Size	Part Number	A	B	C
4"	AVJ4000	4.00	1.00	1.24
6"	AVJ6000	6.00	1.25	1.74
8"	AVJ8000	8.00	1.75	2.24

## AccuSnap Packages



### Packages Available for Single Station Vises

#### THREE STARTER PACKAGES AVAILABLE

Each package contains the following AccuSnap items:

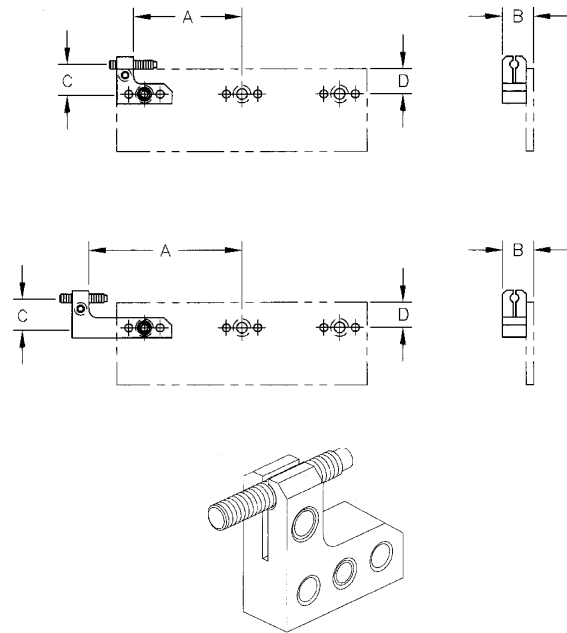
Vise Size	Part Number	Outside Master Jaws	Basic Parallel Set	Advanced Parallel Set	Mill Angle Set	Aluminum Fixture Jaws	V-Jaws	QuickStop	Holder Rack
<b>BASIC STARTER PACKAGE</b>									
4"	ABP4000	1 Pair	1 Set						
6"	ABP6000	1 Pair	1 Set						
8"	ABP8000	1 Pair	1 Set						
<b>ADVANCED STARTER PACKAGE</b>									
4"	AAP4000	1 Pair		1 Set					1 Piece
6"	AAP6000	1 Pair		1 Set					1 Piece
8"	AAP8000	1 Pair		1 Set					
<b>TOOLMAKER/MOLDER PACKAGE</b>									
4"	ATM4000	1 Pair		1 Set	1 Set	2 Pieces	1 Piece	1 Piece	1 Piece
6"	ATM6000	1 Pair		1 Set	1 Set	2 Pieces	1 Piece	1 Piece	1 Piece
8"	ATM8000	1 Pair		1 Set	1 Set	2 Pieces	1 Piece	1 Piece	

### Packages Available for Competitor Double Station Vises

Each package contains the following AccuSnap items:

Vise Size	Part Number	Outside Master Jaws	Basic Parallel Set
4"	AAP4002	2 Pairs	2 Sets
6"	AAP6002	2 Pairs	2 Sets
8"	AAP8002	2 Pairs	2 Sets

## AccuSnap Modular Workstops



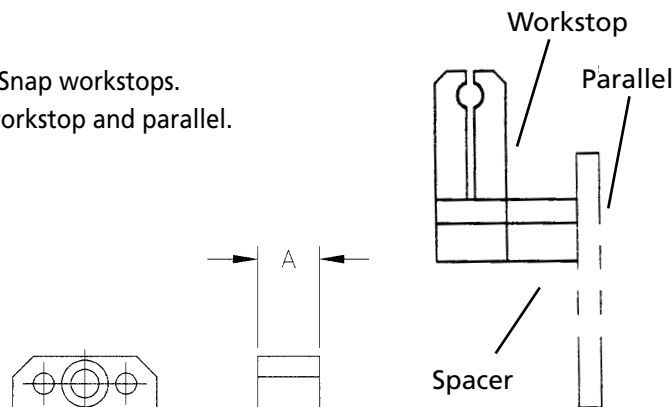
- Ideal for off-line set-up applications.
- Provides extremely accurate workpiece location and repeatability when used in conjunction with the Accu-Snap modular workstop presetting gage (page 183).
- Designed to be used with the AccuSnap parallel sets (pages 178-179).
- The AccuSnap modular workstop is attached by inserting the locating dowel pin into desired stop location on face of parallel. Secure the workstop by tightening supplied flat head cap screw.

Vise Size	Part Number		A	B	C	D
	Right Hand	Left Hand				
4"	AWS4000	AWS4020	1.75	.493	.469	.28
	AWS4001	AWS4021	2.50	.493	.469	.28
	AWS4010	AWS4030	1.75	.493	.969	.28
	AWS4011	AWS4031	2.50	.493	.969	.28
6"	AWS6000	AWS6020	2.68	.493	.657	.47
	AWS6001	AWS6021	3.68	.493	.657	.47
	AWS6010	AWS6030	2.68	.493	1.157	.47
	AWS6011	AWS6031	3.68	.493	1.157	.47
8"	AWS8000	AWS8020	3.50	.618	.626	.44
	AWS8001	AWS8021	5.00	.618	.626	.44
	AWS8010	AWS8030	3.50	.618	1.126	.44
	AWS8011	AWS8031	5.00	.618	1.126	.44

## AccuSnap Spacers

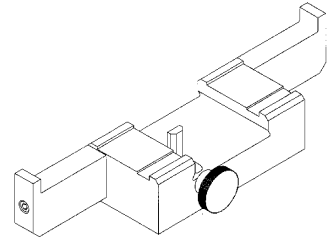
- Used in conjunction with AccuSnap workstops.
- Allows spacing between the workstop and parallel.

Vise Size	Part Number	A
4"	AWS4040	.375
6"	AWS6040	.375
8"	AWS8040	.500



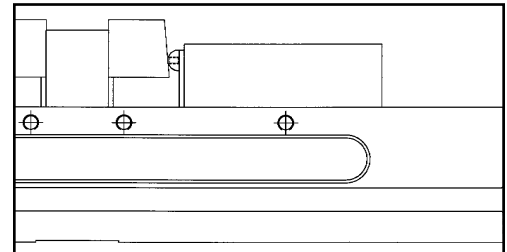
## AccuSnap Presetting Gage

- Ideal for off-line set-up applications.
- Provides extremely accurate workpiece location and repeatability.
- Designed to be used with the AccuSnap modular workstops
- Using the presetting gage is simple:
  - Attach AccuSnap modular workstop onto parallel in the desired position
  - Place parallel into the presetting gage, making sure that the parallel is properly seated against the reference edge. Tighten screw clamp.
  - Loosen the adjustment screw on top of the workstop and adjust stop screw to desired position using a micrometer. Tighten lock screw.



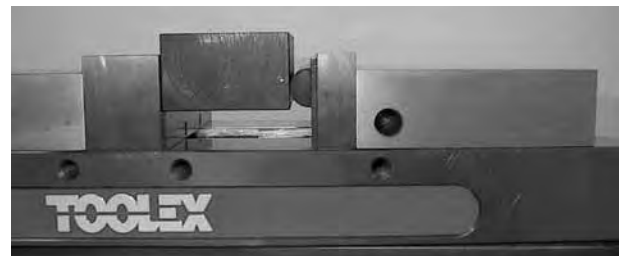
Vise Size	Part Number
4"	AWG4000
6"	AWG6000
8"	AWG8000

## Bumper Assembly for AccuSnap Parallels



- Gives you single point contact when clamping.
- Helps compensate for any out-of-squareness of your stock.
- Black oxide Finish and case-hardened
- Available for 4", 6" & 8" parallel sizes.
- Also available with a special brass finish for aluminum parts.
- Two screws included with bumper assembly.
- Sold individually

Vise Size	Part Number
4"	APS4010
6"	APS6010
8"	APS8010



## Holder Racks for AccuSnap Parallels

- Manufactured from steel.
- Allows convenient storage of parallels.



Vise Size	Part Number	Fits Parallel Kit
4"	AHR4000	APS4001 Advanced
4"	AHR4001	APS4000 Basic
6"	AHR6000	APS6001 Advanced
6"	AHR6001	APS6000 Basic

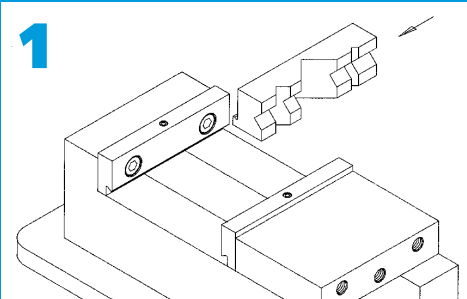


## QuickChange Vise Jaw System



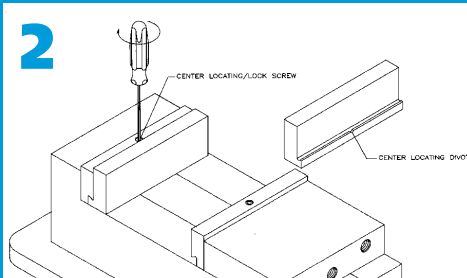
- Fast, accurate and versatile
- Drastically reduces setup time
- Adaptable to most vise systems

**1**



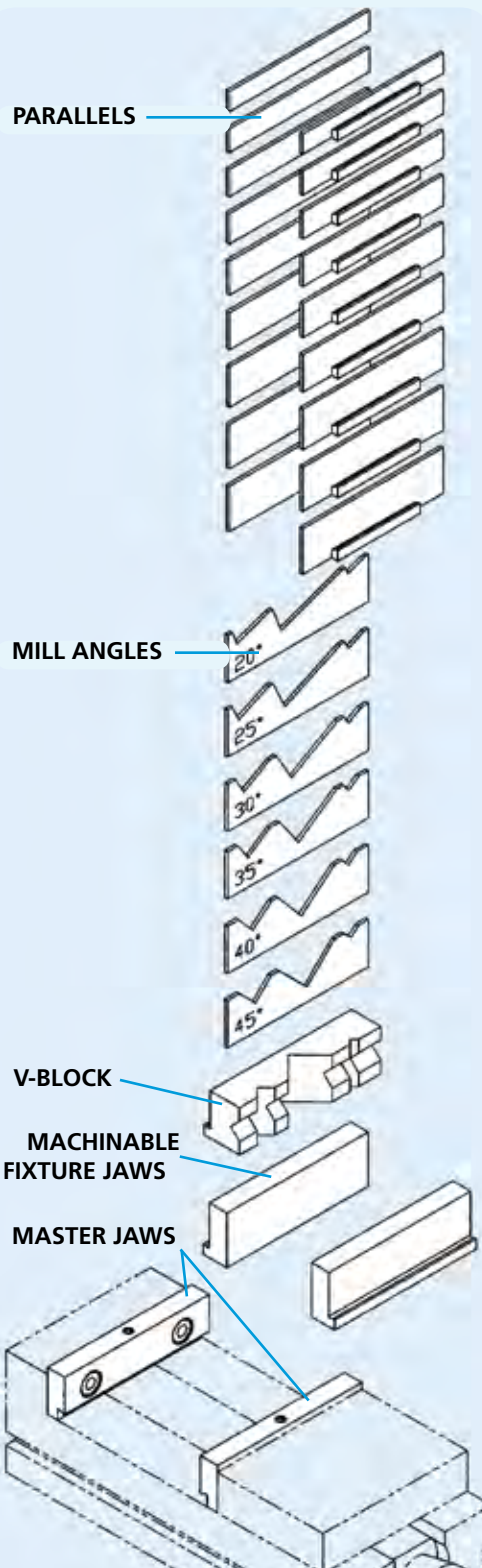
To install the QuickChange System, simply attach the master jaws to your carrier jaw system using the industry standard bolt pattern provided. Align the accessory's gib with the master jaw's dovetail and slide into position.

**2**



After the accessory is in position simply tighten the provided locking/self-centering screw to secure and locate properly. You are now ready to fixture your workpiece.

# TOOLEX®

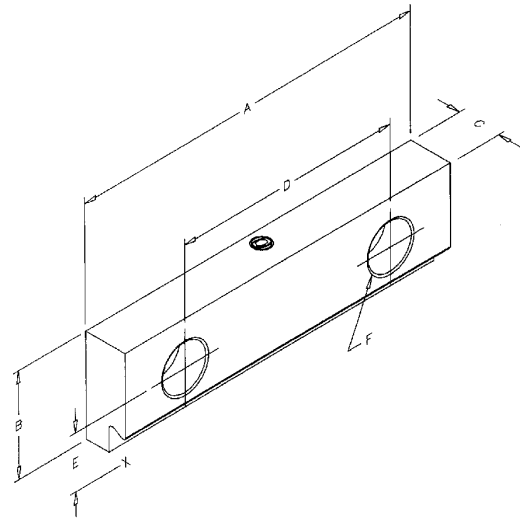


## QuickChange Master Jaws



**Adaptable to most vise jaw systems!**

**Replacement parts available on page 201.**

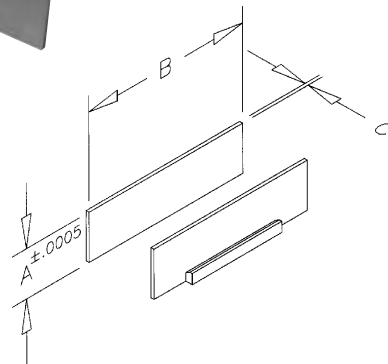


- For ReLock applications, QuickChange master jaws mount to the SnapLock carrier jaws and accept all QuickChange jaw components.
- Install QuickChange master jaws to Snaplock carrier jaws on vise for squareness.
- Accessories slide into position via a dovetail slot.

Vise Size	Part Number	A	B	C	D	E	F
4"	QMJ4000	4.06	1.235	.560	2.500	.687	3/8-16 SHCS
6"	QMJ6000	6.12	1.735	.735	3.875	.937	1/2-13 SHCS
8"	QMJ8000	8.12	2.230	1.105	4.750	1.128	5/8-11 SHCS

Before mounting QuickChange Master Jaws, thoroughly inspect, clean and remove any burrs or chips from mounting surface.

## QuickChange Individual Parallel Sets

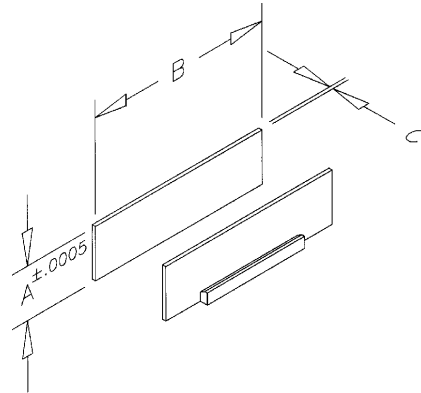


- QuickChange parallels are designed to be used with QuickChange master jaws.
- Parallels are packaged 2 per set.
- Expanded QuickChange parallel sets are available on page 186.

Before mounting QuickChange Master Jaws, thoroughly inspect, clean and remove any burrs or chips from mounting surface.

Vise Size	Part Number	A	B	C
4"	QIP4001	.500	3.980	.118
	QIP4002	.625	3.980	.118
	QIP4003	.750	3.980	.118
	QIP4004	.875	3.980	.118
	QIP4005	1.000	3.980	.118
	QIP4006	1.062	3.980	.118
	QIP4007	1.125	3.980	.118
	QIP4008	1.190	3.980	.118
6"	QIP6001	.750	5.980	.118
	QIP6002	.875	5.980	.118
	QIP6003	1.000	5.980	.118
	QIP6004	1.125	5.980	.118
	QIP6005	1.250	5.980	.118
	QIP6006	1.375	5.980	.118
	QIP6007	1.500	5.980	.118
	QIP6008	1.625	5.980	.118
	QIP6009	1.690	5.980	.118
8"	QIP8001	1.000	7.980	.118
	QIP8002	1.250	7.980	.118
	QIP8003	1.375	7.980	.118
	QIP8004	1.500	7.980	.118
	QIP8005	1.625	7.980	.118
	QIP8006	1.750	7.980	.118
	QIP8007	1.875	7.980	.118
	QIP8008	2.000	7.980	.118
	QIP8009	2.125	7.980	.118

## QuickChange Parallel Kits



CONTAINS 1 PAIR PER SIZE

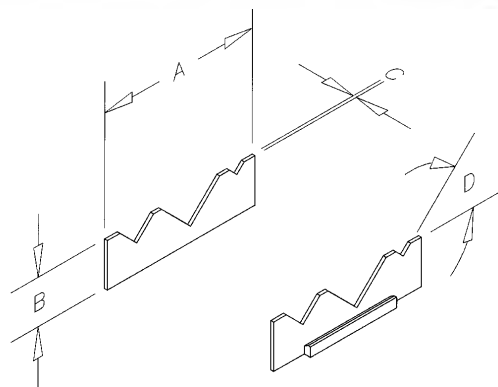
Vise Size	Part Number		Advanced			B	C
	Basic	Advanced	Basic A	A			
4"	QPS4000	QPS4001	.500	.500	1.000	3.980	.118
			.750	.625	1.125		
			1.000	.750	1.062		
			1.125	.875	1.190		
			1.190				
6"	QPS6000	QPS6001	.750	.750	1.375	5.980	.118
			1.000	.875	1.500		
			1.250	1.000	1.625		
			1.500	1.125	1.690		
			1.625	1.250			
8"	QPS8000	QPS8001	1.000	1.000	1.750	7.980	.118
			1.250	1.250	1.875		
			1.500	1.375	2.000		
			1.750	1.500	2.125		
			2.000	1.625			

- QuickChange parallels are designed to be used with the QuickChange master jaws shown on page 185.
- Individual QuickChange parallel sets available on page 185.
- QuickChange Starter Package available on page 188.

## QuickChange Individual Mill Angles



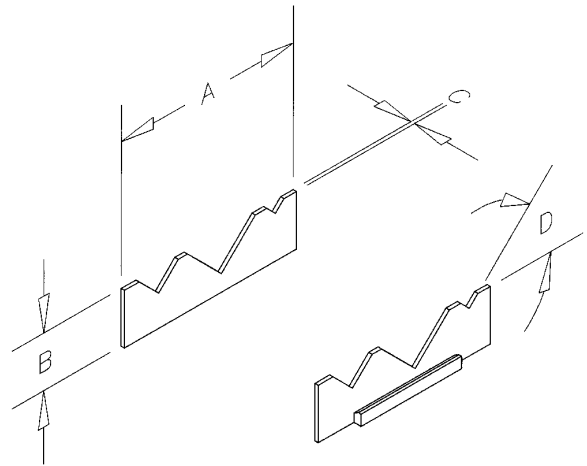
- QuickChange mill angles are designed to be used with the QuickChange master jaws (page 185).
- QuickChange mill angle parallel set is available on page 187.
- QuickChange starter package is on page 188.



*Sold as individual units*

Vise Size	Part Number Individual	A	B	C	(Degree) D
4"	QMA4020	4.000	1.240	.118	20
	QMA4025				25
	QMA4030				30
	QMA4035				35
	QMA4040				40
QMA4045	45				
6"	QMA6020	6.000	1.740	.118	20
	QMA6025				25
	QMA6030				30
	QMA6035				35
	QMA6040				40
QMA6045	45				
8"	QMA8020	8.000	2.230	.118	20
	QMA8025				25
	QMA8030				30
	QMA8035				35
	QMA8040				40
QMA8045	45				

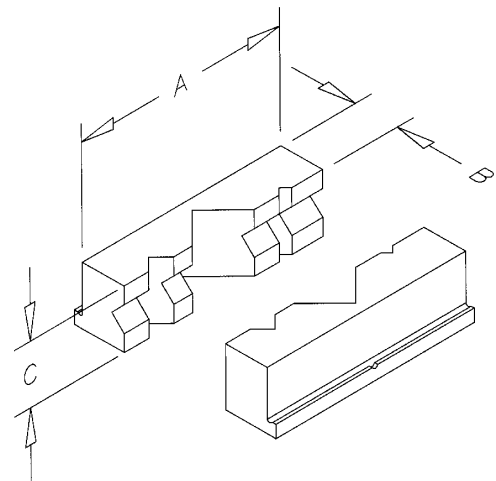
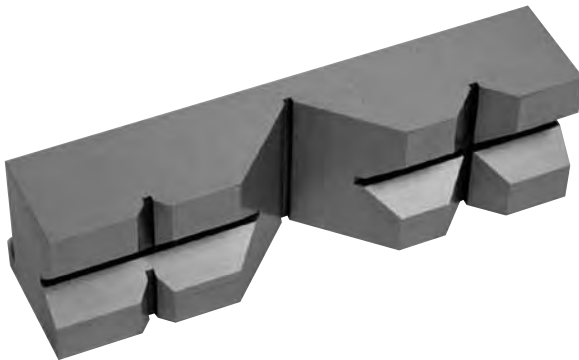
## QuickChange Mill Angle Sets



- QuickChange Mill Angles are designed to be used with QuickChange Master Jaws on page 185.
- Individual QuickChange Mill Angles are on page 186.
- QuickChange Starter Package available on page 188.

Vise Size	Part Number	A	B	C	(1 of each degree) D
4"	QMA4000	4.000	1.240	.118	20 25 30 35 40 45
6"	QMA6000	6.000	1.740	.118	20 25 30 35 40 45
8"	QMA8000	8.000	2.230	.118	20 25 30 35 40 45

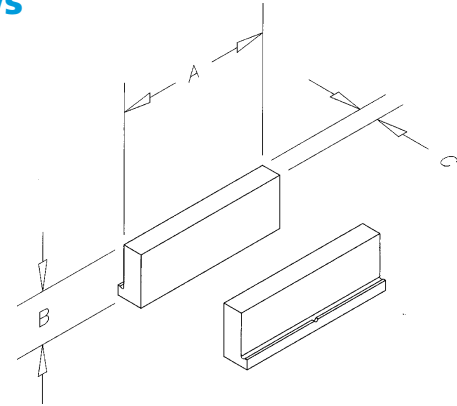
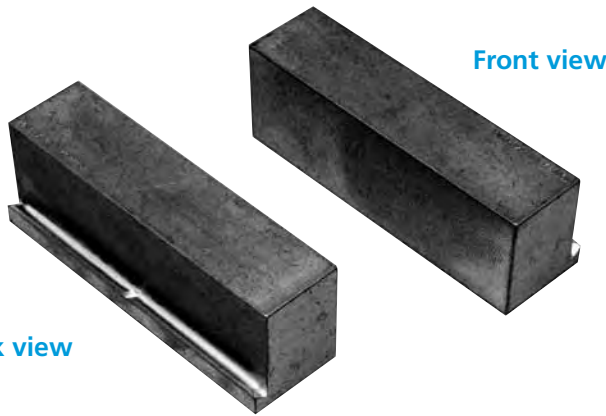
## QuickChange "V" Jaws



- Designed to be used with QuickChange Master Jaws on page 185.
- QuickChange Starter Package available on page 188.
- Sold as individual units.

Vise Size	Part Number	A	B	C
4"	QVJ4000	4.00	1.00	1.24
6"	QVJ6000	6.00	1.25	1.74
8"	QVJ8000	8.00	1.75	2.24

## QuickChange Machinable (Soft) Fixture Jaws



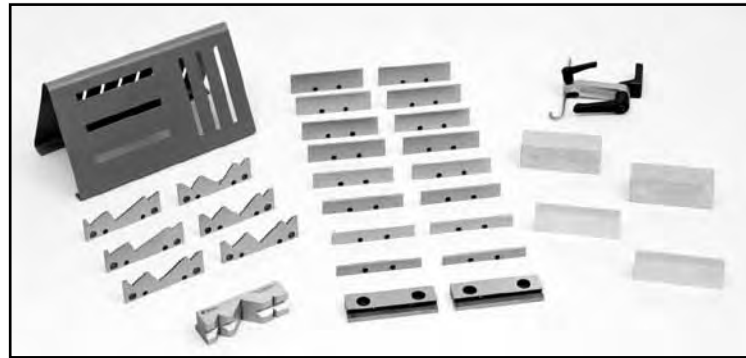
Back view

Sold as individual units

- QuickChange Machinable Fixture Jaws are to be used in conjunction with QuickChange Master Jaws shown on page 185.
- QuickChange Machinable Fixture Jaws can be modified to fit your individual needs.

Vise Size	Part Number		A	B	C
	Aluminum	Steel			
4"	QSJ4000	QSJ4020	4.00	1.50	.69
	QSJ4001	QSJ4021			
6"	QSJ6000	QSJ6020	6.00	2.00	.75
	QSJ6001	QSJ6021			
8"	QSJ8000	QSJ8020	8.00	2.50	1.25
	QSJ8001	QSJ8021			

## QuickChange Starter Packages



Toolmaker/Molder Package shown

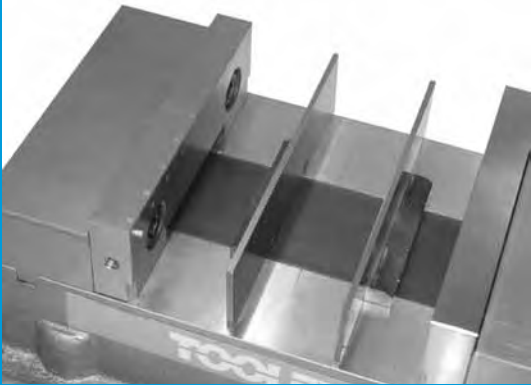
Each package contains the following QuickChange items:

Vise Size	Part Number	Master Jaws	Basic Parallel Set	Advanced Parallel Set	Mill Angle Set	Aluminum Fixture Jaws	V-Jaws	QuickStop	Holder Rack
<b>BASIC STARTER PACKAGE</b>									
4"	QBP4000	1 Pair	1 Set						
6"	QBP6000	1 Pair	1 Set						
8"	QBP8000	1 Pair	1 Set						
<b>ADVANCED STARTER PACKAGE</b>									
4"	QAP4000	1 Pair		1 Set					1 Piece
6"	QAP6000	1 Pair		1 Set					1 Piece
8"	QAP8000	1 Pair		1 Set					1 Piece
<b>TOOLMAKER/MOLDER PACKAGE</b>									
4"	QTM4000	1 Pair		1 Set	1 Set	2 Pieces	1 Piece	1 Piece	1 Piece
6"	QTM6000	1 Pair		1 Set	1 Set	2 Pieces	1 Piece	1 Piece	1 Piece
8"	QTM8000	1 Pair		1 Set	1 Set	2 Pieces	1 Piece	1 Piece	1 Piece


**THREE  
STARTER  
PACKAGES  
AVAILABLE**



## Locator Jaw Parallel System with built-in workstop pins for 6" single station vises



Simply bolt the master jaws to your existing vise. Parallels literally snap in and out for quick set-ups.

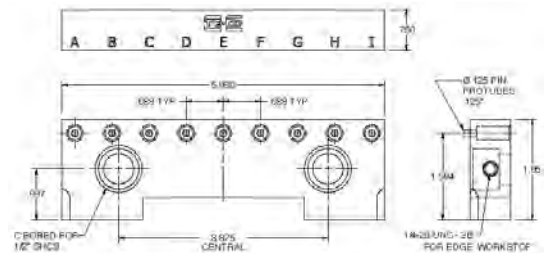


Locating pins push in and out to accurately locate your part. No-guess repeatability!

### 2-piece Master Jaw Set

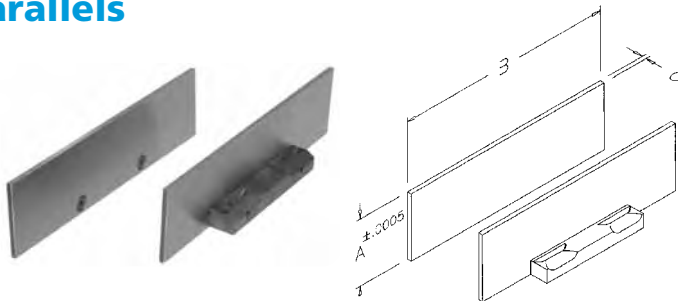
#### Part No. TLJ6000

- Set includes one plain master jaw (no pins) and one jaw with locating pins
- Just bolt them on to your existing vise!



### Individual Parallels

- Snap into position quickly and easily
- Use in conjunction with Locator Master Jaws



Part Number	A	B	C
TLP6001	.750	5.980	.125
TLP6002	1.000	5.980	.125
TLP6003	1.125	5.980	.125
TLP6004	1.250	5.980	.125
TLP6005	1.375	5.980	.125
TLP6006	1.500	5.980	.125

### Basic Parallels Set

#### Part No. TPS6000

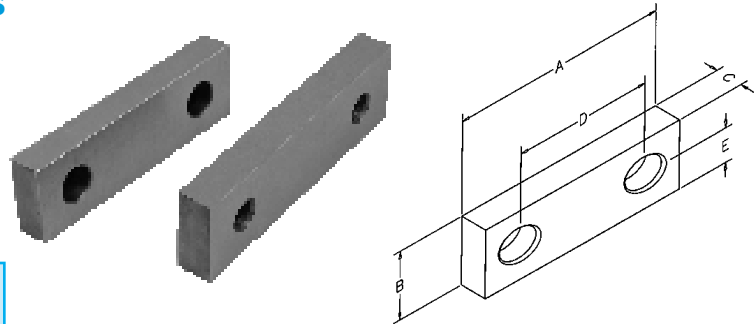
- Set includes 4 pairs of parallels (one pair each of the following heights): 3/4", 1", 1-1/4" & 1-1/2"
- Use in conjunction with Locator Master Jaws



## WISE ACCESSORIES

### Bolt-on Aluminum Soft Jaws

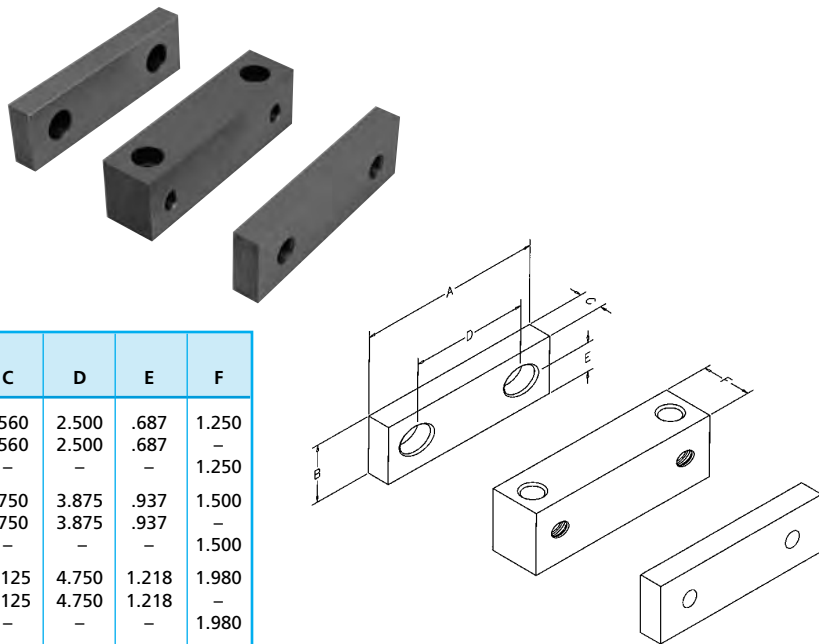
- Fits most industry vises including all Toolex vises.
- Aluminum Soft Jaws can be modified quickly and inexpensively.



Vise Size	Part Number	A	B	C	D	E
4"	SJB4000	5.00	1.50	1.00	2.500	.687
6"	SJB6000	7.00	2.00	1.25	3.875	.937
8"	SJB8000	9.00	2.50	2.00	4.750	1.128

### Standard Hard Jaws

- Manufactured from steel.
- Center jaw is only adaptable to the Toolex ReLock System.
- Outside jaws fit most vises via universal bolt hole pattern.
- Install Hard Jaws to SnapLock Carrier Jaws on vise for squareness.



Vise Size	Part Description	Part Number	A	B	C	D	E	F
4"	3 pc. Set	SHJ4035	3.980	1.350	.560	2.500	.687	1.250
	2 Outside	SHJ4000	3.980	1.350	.560	2.500	.687	-
	1 Center	SCJ4030	3.980	1.350	-	-	-	1.250
6"	3 pc. Set	SHJ6035	5.980	1.850	.750	3.875	.937	1.500
	2 Outside	SHJ6000	5.980	1.850	.750	3.875	.937	-
	1 Center	SCJ6030	5.980	1.850	-	-	-	1.500
8"	3 pc. Set	SHJ8035	7.980	2.350	1.125	4.750	1.218	1.980
	2 Outside	SHJ8000	7.980	2.350	1.125	4.750	1.218	-
	1 Center	SCJ8030	7.980	2.350	-	-	-	1.980

### Universal Workstop



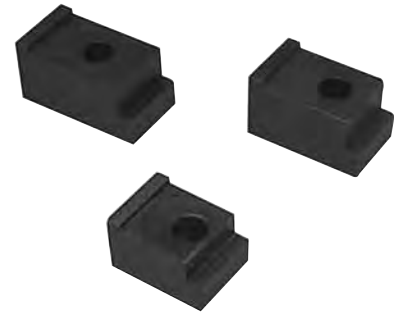
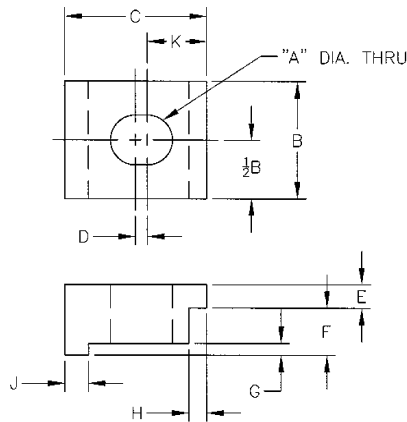
More than one extension can be used for larger workpieces.

Vise Size	Part Description	Part Number	Extension Length	Thread Size
4"	Workstop Extension	UWS4000	4.000	5/16-18
		UWS4001		
6"	Workstop Extension	UWS6003*	6.000	5/16-18
		UWS6004*		
6"	Workstop Extension	UWS6000*	6.000	3/8-16
		UWS6001*		
8"	Workstop Extension	UWS8000	8.000	1/2-13
		UWS8001		

\*DESIGN CHANGE WAS MADE TO THE RWS6002 VISE: 3/8-16 tapped hole was modified to a 5/16-18 tapped hole. Check your vise to verify the size you need before ordering.

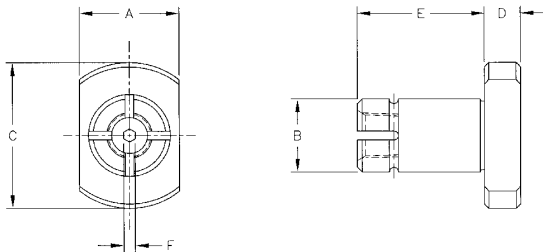
## Vise Clamps

- Adaptable to most vises
- Vise Clamps are used to secure vise to tooling plate or machine table.
- Insert clamp nose into groove on side of vise.
- Use clamps with standard socket head cap screws.
- Black Oxide Finish and Case Hardened
- Material: 1018 Steel



Vise Size	Part Number	Screw Size A	B	C	D	E	F	G	H	J	K
4"	RWS4553	3/8	1.25	1.50	.13	.25	.50	.13	.19	.25	.63
4"	RWS4554	1/2	1.25	1.50	.13	.25	.50	.13	.19	.25	.63
6"	RWS6553	3/8	1.25	2.12	.13	.50	.75	.19	.25	.25	.85
6"	RWS6554	1/2	1.25	2.12	.13	.50	.75	.19	.25	.25	.85
6"	RWS6555	5/8	1.25	2.12	.13	.50	.75	.19	.25	.25	.85

## Sine Fixture Keys



Vise Size	Part Number	A	B	C	D	E	F
4" and 6"	81651	.4995	.5004	1.00	.250	.50	.156
	81656	.687	.5004	1.00	.250	.50	.156
	81661	.8115	.5004	1.00	.250	.875	.156
8"	81666	.8115	.7504	1.812	.250	.875	.188
	81667	1.062	.7504	1.812	.250	.875	.188

Precision keys allow accurate and precise positioning of vise to machine table.

## Chip Shield Covers for Toolex Double Station Vise



- Three piece set includes two outside and one center chip shield.
- Fits the Toolex Double Station and Eight Station Vises only.
- Chip shields cover vise segment screw mechanism to keep out chips and debris.

Vise Size	Part Number
4"	RWS4561
6"	RWS6561
8"	RWS8561

## Torque Wrench

- Come with the pre-set foot poundage, providing consistent torque and preventing operators from over-tightening the vise.
- The TWR4002 has been pre-set to 55 foot pounds. The TWR6002 has foot poundage pre-set at 100 foot pounds.
- Using the torque wrenches for Toolex 8-station vises requires an adapter that fits onto the hex drive.



Part Number	Description
TWR4002	*Torque wrench for RWS4002 and RWS4008
TWR6002	*Torque wrench for RWS6002 and RWS6008

\*Adapter required for 8-station vises

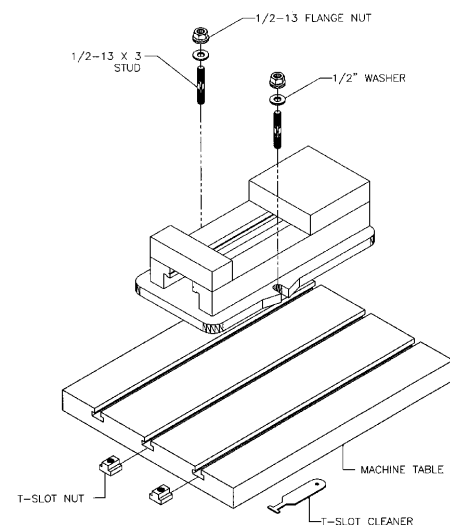
## Vise Mounting Kit: Part No. 90442

Designed for 6" single station vises



### Kit contains:

- Two 1/2 x 3 Studs
- Two 1/2 x 5/8 T-Nuts
- Two 1/2 - 13 Flange Nuts
- Two 1/2 Flat Washers
- One T-Slot Cleaner



## QuickStop

- Universal mounting bracket mounts to many vise configurations.
- After tightening, handles can be rotated 360 degrees for tool and cutter clearance.
- Fully adjustable to adapt to many workpiece configurations.

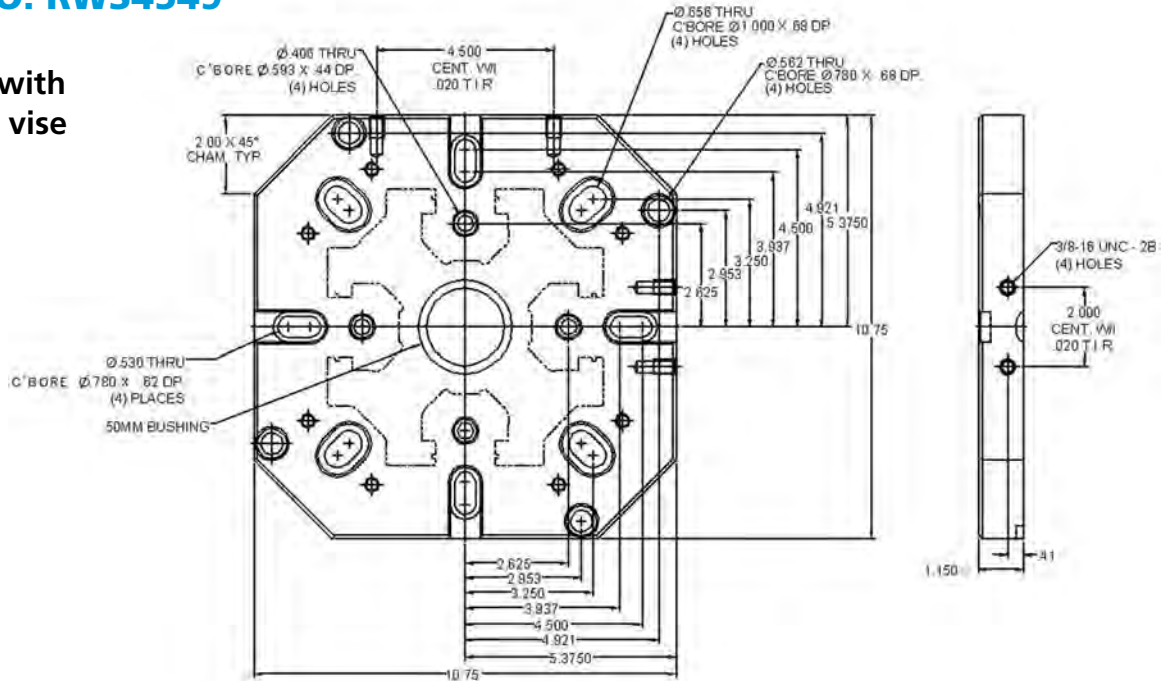


Vise Size	Part Number	Thread Size
4"	QVS4000	3/8-16
6"	QVS6000	1/2-13
8"	QVS8000	5/8-11

## 8-STATION VISE BASEPLATE MOUNTING INFORMATION

### Universal Baseplate for 4" ReLock 8-Station Vise PART NO. RWS4549

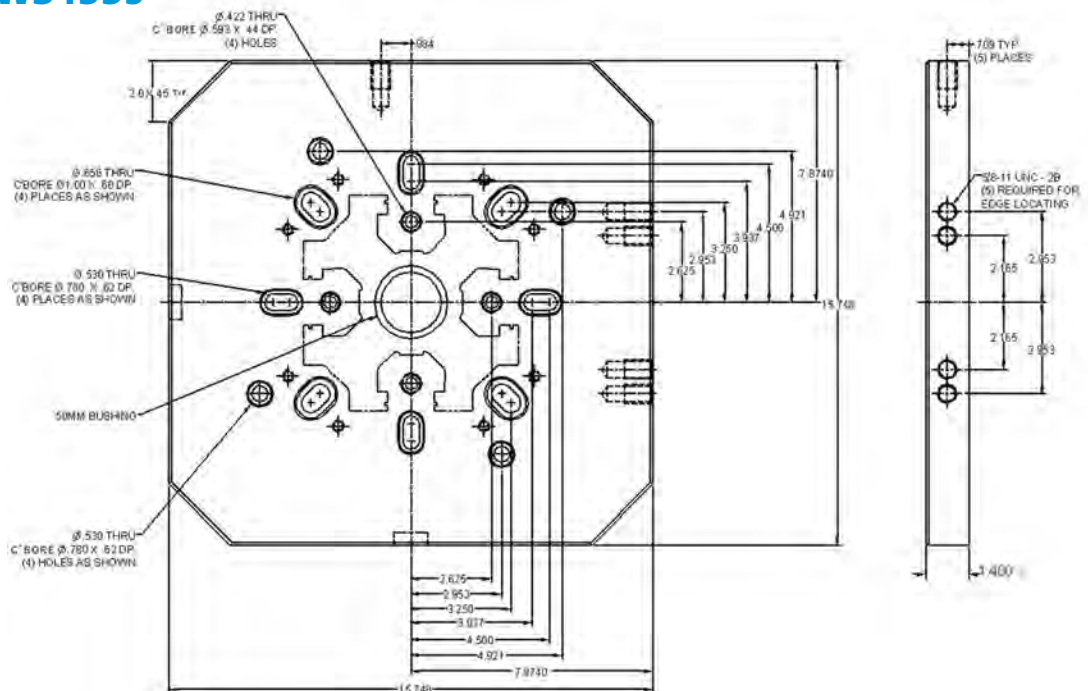
Included with  
RWS4008 vise



Visit [www.te-co.com](http://www.te-co.com) for larger view of drawings

### 400mm Baseplate for 4" ReLock 8-Station Vise PART NO. RWS4559

Included with  
RWS4408 vise

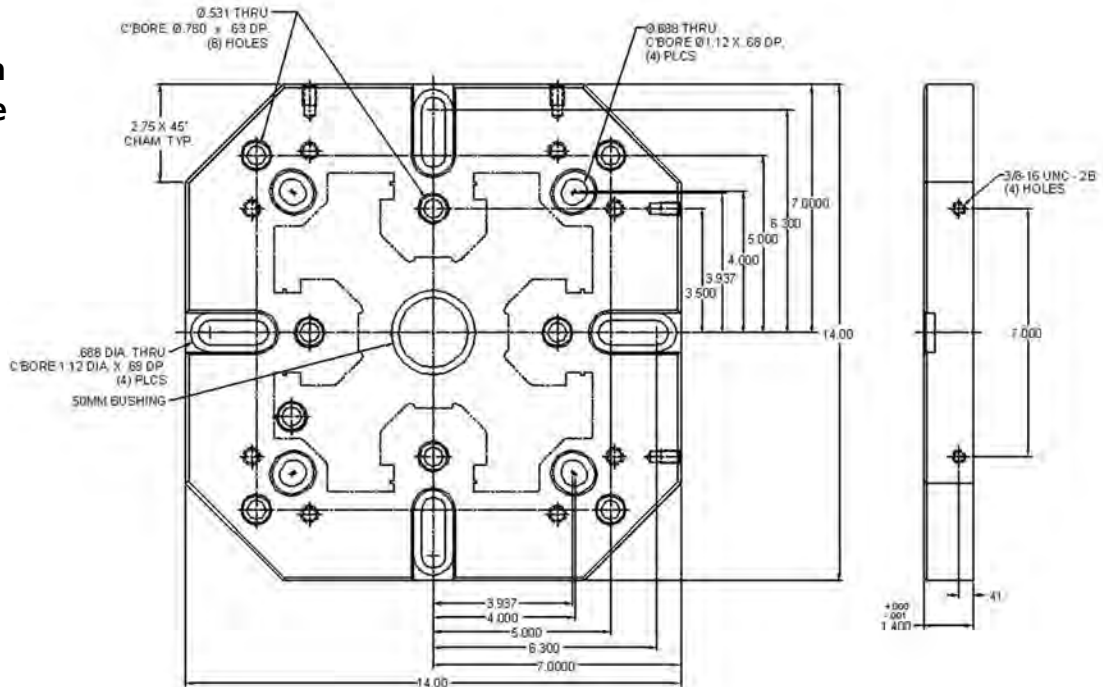




**8-STATION VISE BASEPLATE MOUNTING INFORMATION**

**Universal Baseplate for 6" ReLock 8-Station Vise  
PART NO. RWS6549**

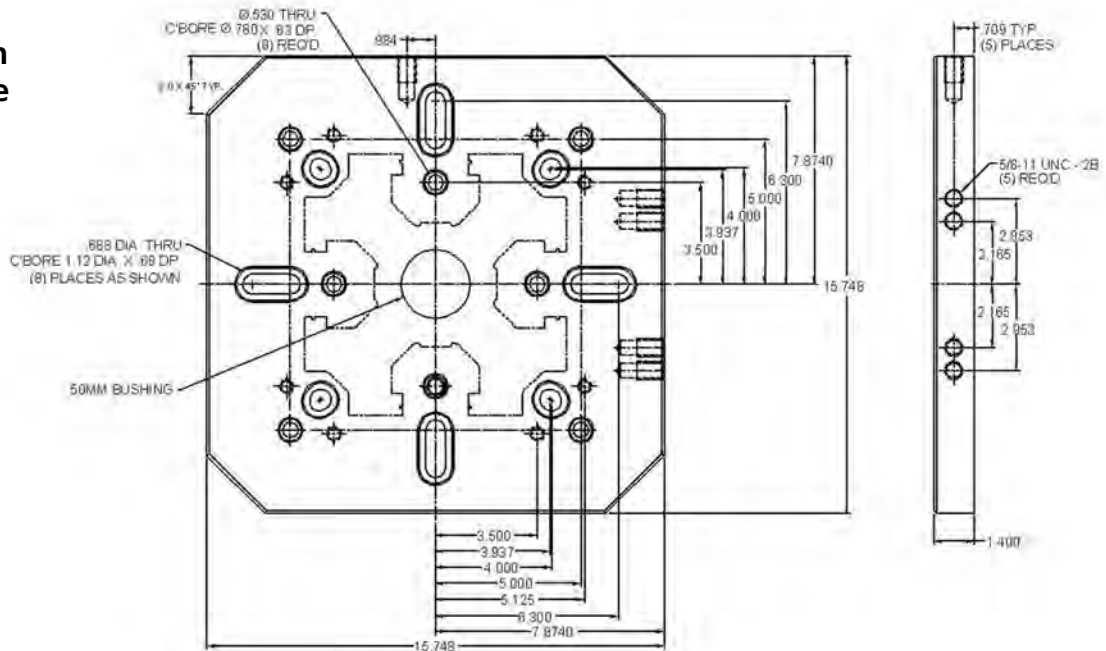
Included with  
RWS6008 vise



Visit [www.te-co.com](http://www.te-co.com) for larger view of drawings

**400mm Baseplate for 6" ReLock 8-Station Vise  
PART NO. RWS6559**

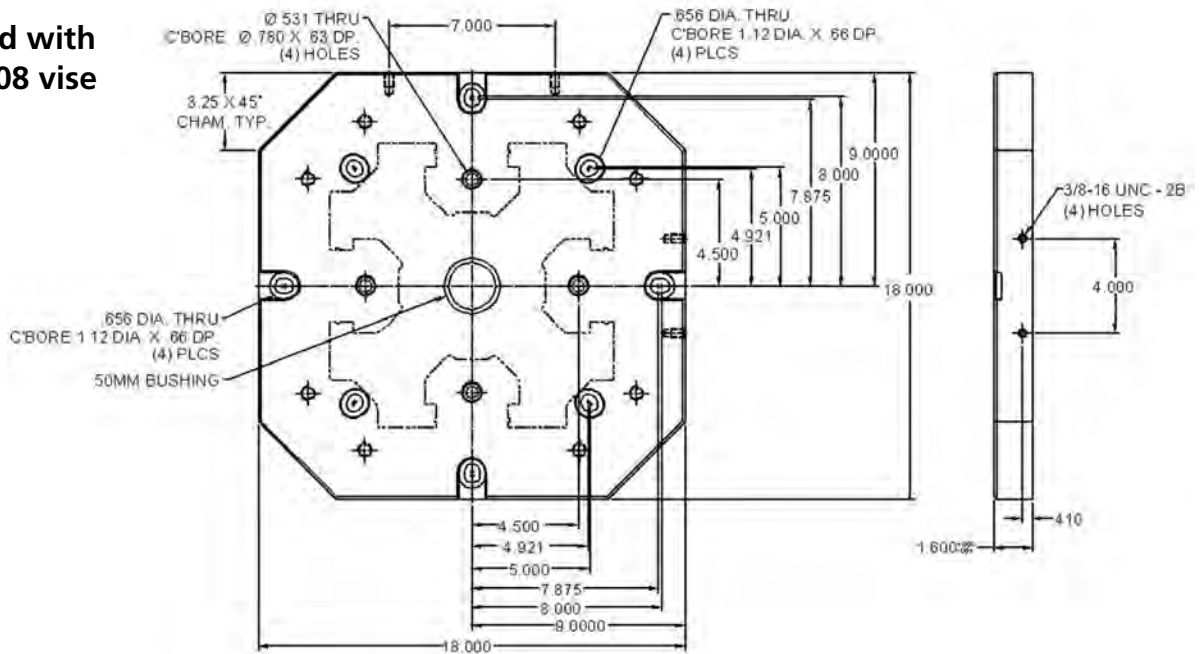
Included with  
RWS6408 vise



## 8-STATION VISE BASEPLATE MOUNTING INFORMATION

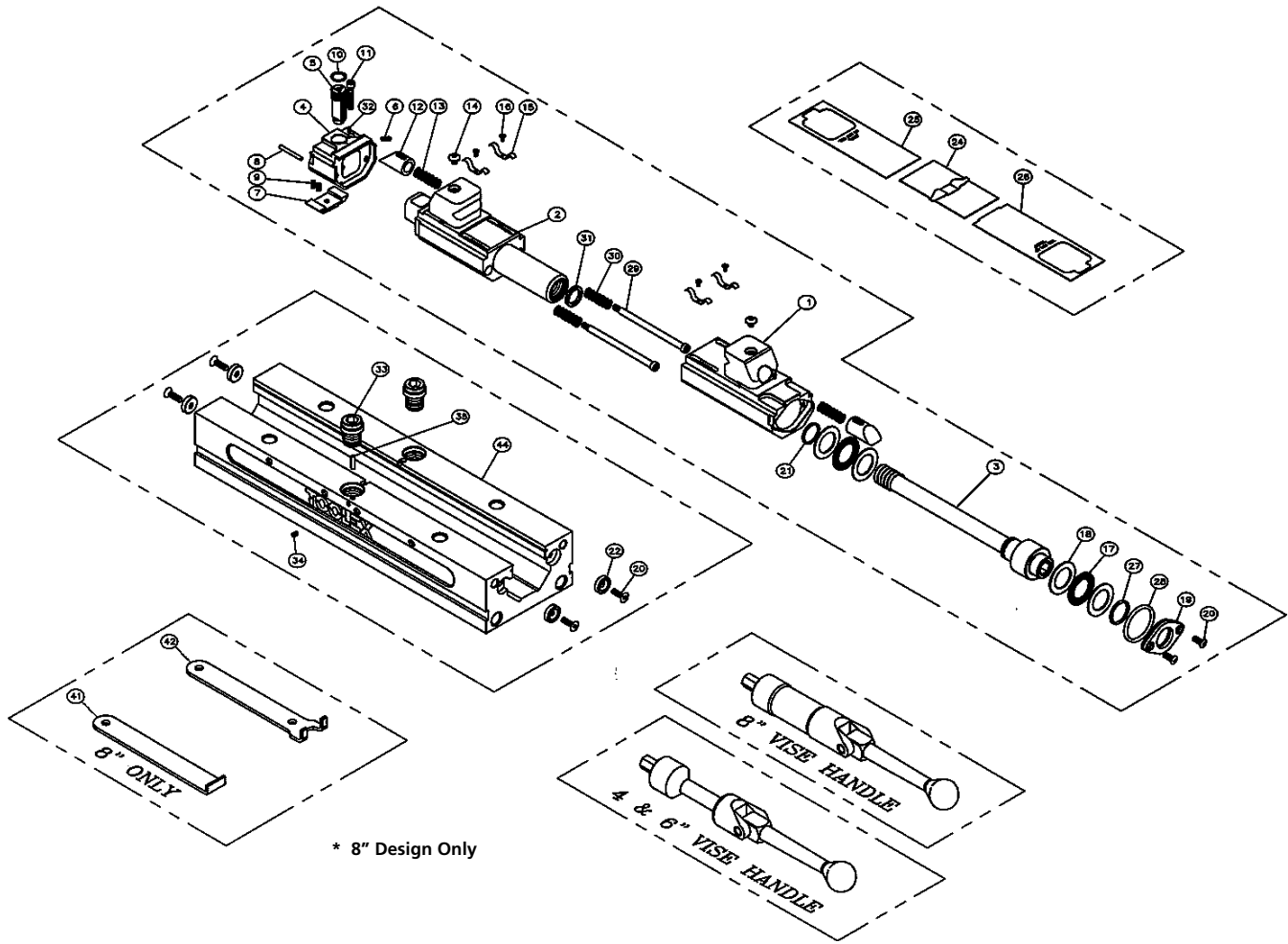
### Universal Baseplate for 8" ReLock 8-Station Vise PART NO. RWS8549

Included with  
RWS8008 vise



Visit [www.te-co.com](http://www.te-co.com) for larger view of drawing

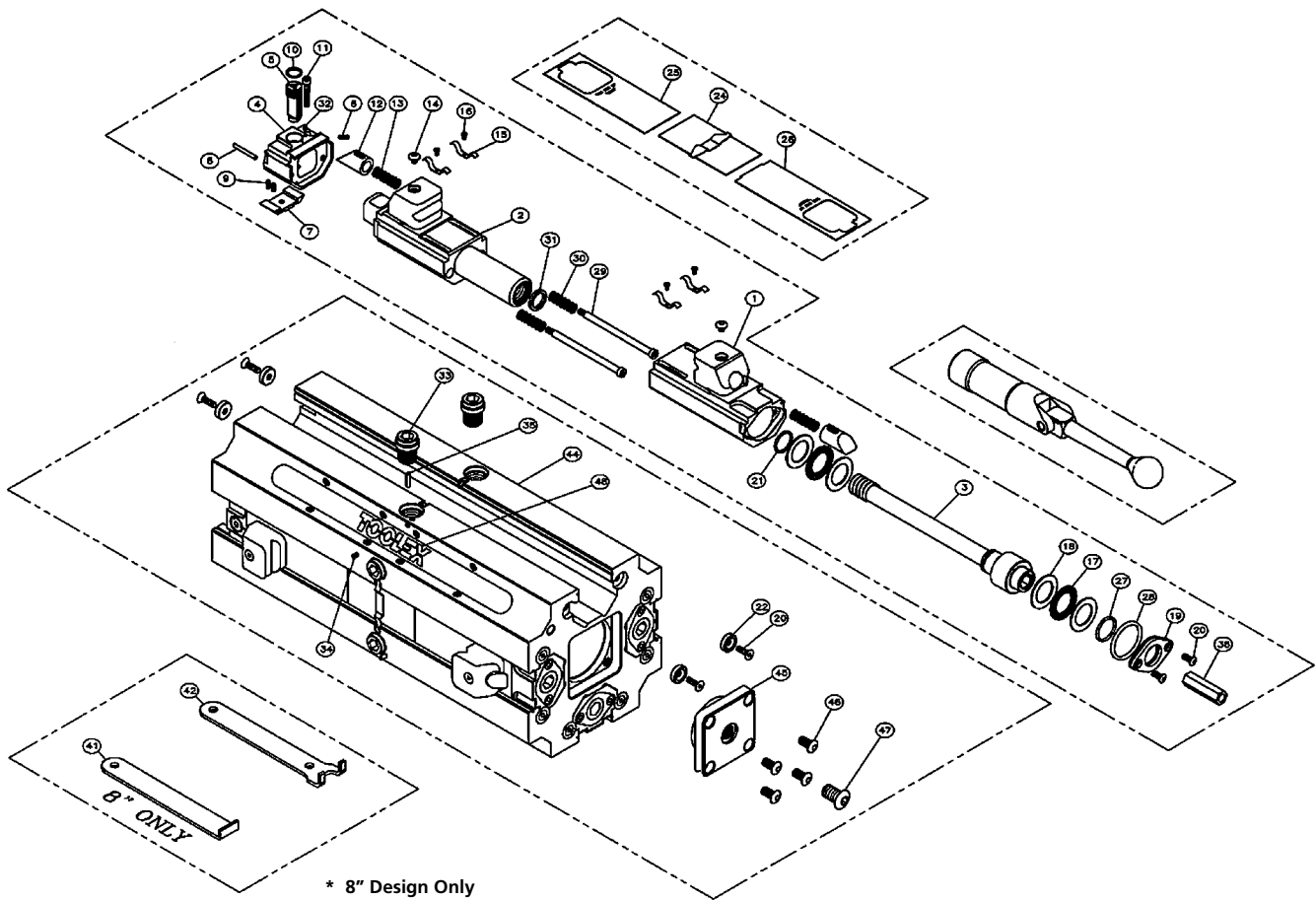
## RELOCK®-2 PARTS LIST



RELOCK 2-STATION VISE PARTS LIST				
#	Description	4" Vise	6" Vise	8" Vise
1	ReLock Front Slide Segment	RWS4500RP	RWS6500	RWS8500
2	ReLock Rear Slide Segment	RWS4501RP	RWS6501	RWS8501
3	ReLock Slide Segment Screw	RWS4502	RWS6502	RWS8502
4	ReLock Brake Housing	RWS4503	RWS6503	RWS8503
5	ReLock Auto Offset Dial	RWS4504	RWS6504	RWS8504
6	ReLock Brake Dial Spring Plunger	53402X	53402X	57021X
7	ReLock Brake Spring	RWS4506	RWS6506	RWS8506
8	Brake Spring Dowel Pin	RWS4507	RWS6507	RWS8507
9	Brake Compression Spring	RWS6508	RWS6508	RWS8508
10	Offset Dial O-Ring Seal	RWS4509	RWS6509	RWS8509
11	ReLock Brake Spring Screw	RWS4510	RWS4539	RWS8510
12	ReLock Segment Latch Plunger	RWS4511	RWS6511	RWS8511
13	Latch Plunger Compression Spring	RWS4512	RWS6512	RWS8512
14	ReLock Retaining Screw	RWS4513	RWS6513	RWS8513
15	ReLock Chip Shield Spring	RWS6514	RWS6514	RWS8514
16	Shield Spring Screw	RWS6515	RWS6515	RWS8515
17	ReLock Thrust Bearing	RWS4516	RWS6516	RWS8516
18	ReLock Thrust Washer	RWS4517	RWS6517	RWS8517
19	ReLock Screw Retainer Plate	RWS4518	RWS6518	RWS8518
20	Retainer Plate Screw	RWS4519	RWS6519	RWS8519
21	ReLock Screw O-Ring Seal	RWS6509	RWS6520	RWS6526
22	ReLock Stop Button	RWS4521	RWS6521	RWS8521
23	Stop Button Screw	RWS4522	RWS6519	RWS8522
24	ReLock Center Chip Shield	RWS4523	RWS6523	RWS8523
25	ReLock Rear Chip Shield	RWS4524	RWS6524	RWS8524
26	ReLock Front Chip Shield	RWS4525	RWS6525	RWS8525
27	Retaining Plate O-Ring Seal - Small	RWS4526	RWS6526	RWS4527
28	Retaining Plate O-Ring Seal - Large	RWS4527	RWS6527	RWS8527
29	ReLock Shoulder Screw	RWS4528	RWS6528	RWS8528
30	ReLock Compression Spring	RWS4529	RWS6529	RWS8569
31	ReLock U-Seal	RWS4530	RWS6530	RWS8530
32	ReLock Brake Screw	RWS4531	RWS6531	RWS8531
33	ReLock Jaw Locating Stud	RWS4532	RWS6532	RWS8532
34	ReLock Set Screw	RWS4533	RWS6533	RWS8533
35	ReLock Dowel Pin	RWS4534	RWS6534	RWS8534
41	ReLock Pry Wrench	*****	*****	RWS8545
42	ReLock Chip Shield Wrench	RWS4540	RWS6540	RWS8540
43	ReLock 2-Station Vise Body	RWS4543	RWS6543	RWS8543
****	Center Jaw Socket Head Cap Screw (not shown)	RWS4550	RWS6550	RWS8010
****	ReLock Vise Label	RWS4010	RWS6010	RWS8550
RELOCK 2-STATION VISE SUBASSEMBLY				
#	Description	4" Vise	6" Vise	8" Vise
	ReLock Segment Assembly (Items 1-21, 27-32)	RWS4560DI	RWS6560	RWS8560
	ReLock Chip Shield Assembly (Items 24-26)	RWS4561	RWS6561	RWS8561
	ReLock Handle Assembly	RWS4566	RWS6566	RWS8562
	ReLock Vise Tool Kit (Items 41-43)	RWS4563	RWS6563	RWS8563

To order vise handle components, please contact your local distributor or TE-CO at 800-543-4071.

## RELOCK®-8 PARTS LIST



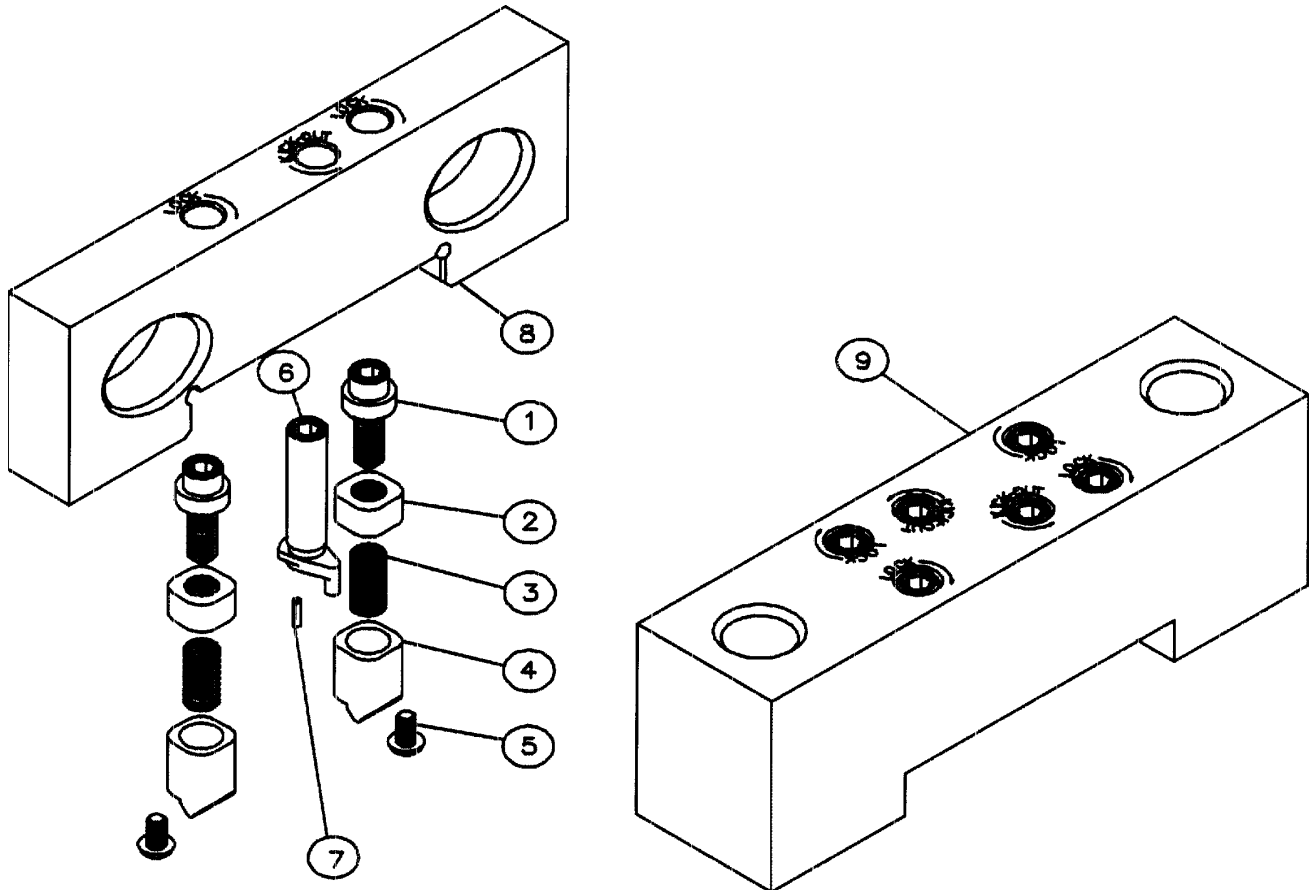


RELOCK 8-STATION VISE PARTS LIST				
#	Description	4" Vise	6" Vise	8" Vise
1	ReLock Front Slide Segment	RWS4500RP	RWS6500	RWS8500
2	ReLock Rear Slide Segment	RWS4501RP	RWS6501	RWS8501
3	ReLock Slide Segment Screw	RWS4502	RWS6502	RWS8502
4	ReLock Brake Housing	RWS4503	RWS6503	RWS8503
5	ReLock Auto Offset Dial	RWS4504	RWS6504	RWS8504
6	ReLock Brake Dial Spring Plunger	53402X	53402X	57021X
7	ReLock Brake Spring	RWS4506	RWS6506	RWS8506
8	Brake Spring Dowel Pin	RWS4507	RWS6507	RWS8507
9	Brake Compression Spring	RWS6508	RWS6508	RWS8508
10	Offset Dial O-Ring Seal	RWS4509	RWS6509	RWS8509
11	ReLock Brake Spring Screw	RWS4510	RWS4539	RWS8510
12	ReLock Segment Latch Plunger	RWS4511	RWS6511	RWS8511
13	Latch Plunger Compression Spring	RWS4512	RWS6512	RWS8512
14	ReLock Retaining Screw	RWS4513	RWS6513	RWS8513
15	ReLock Chip Shield Spring	RWS6514	RWS6514	RWS8514
16	Shield Spring Screw	RWS6515	RWS6515	RWS8515
17	ReLock Thrust Bearing	RWS4516	RWS6516	RWS8516
18	ReLock Thrust Washer	RWS4517	RWS6517	RWS8517
19	ReLock Screw Retainer Plate	RWS4518	RWS6518	RWS8518
20	Retainer Plate Screw	RWS4519	RWS6519	RWS8519
21	ReLock Screw O-Ring Seal	RWS6509	RWS6520	RWS6526
22	ReLock Stop Button	RWS4521	RWS6521	RWS8521
23	Stop Button Screw	RWS4522	RWS6519	RWS8522
24	ReLock Center Chip Shield	RWS4523	RWS6523	RWS8523
25	ReLock Rear Chip Shield	RWS4524	RWS6524	RWS8524
26	ReLock Front Chip Shield	RWS4525	RWS6525	RWS8525
27	Retaining Plate O-Ring Seal - Small	RWS4526	RWS6526	RWS4527
28	Retaining Plate O-Ring Seal - Large	RWS4527	RWS6527	RWS8527
29	ReLock Shoulder Screw	RWS4528	RWS6528	RWS8528
30	ReLock Compression Spring	RWS4529	RWS6529	RWS8569
31	ReLock U-Seal	RWS4530	RWS6530	RWS8530
32	ReLock Brake Screw	WS4531	RWS6531	RWS8531
33	ReLock Jaw Locating Stud	RWS4532	RWS6532	RWS8532
34	ReLock Set Screw	RWS4533	RWS6533	RWS8533
35	ReLock Dowel Pin	RWS4534	RWS6534	RWS8534
41	ReLock Pry Wrench	****	****	RWS8545
42	ReLock Chip Shield Wrench	RWS4540	RWS6540	RWS8540
43	ReLock 2-Station Vise Body	RWS4543	RWS6543	RWS8543
****	Center Jaw Socket Head Cap Screw (not shown)	RWS4550	RWS6550	RWS8010
****	ReLock Vise Label	RWS4010	RWS6010	RWS8550
RELOCK 8-STATION VISE SUBASSEMBLY				
#	Description	4" Vise	6" Vise	8" Vise
	ReLock Segment Assembly (Items 1-21, 27-32)	RWS4560DI	RWS6560	RWS8560
	ReLock Chip Shield Assembly (Items 24-26)	RWS4561	RWS6561	RWS8561
	ReLock Handle Assembly	RWS4562	RWS6562	RWS8562
	ReLock Vise Tool Kit (Items 41-43)	RWS4563	RWS6563	RWS8563

To order vise handle components, please contact your local distributor or TE-CO at 800-543-4071.

## ACCUSNAP® PARTS LIST

### AccuSnap Master Jaws



ACCUSNAP MASTER JAW PARTS LIST				
#	Description	4" Vise	6" Vise	8" Vise
1	AccuSnap Lock Screw	AMJ4500	AMJ6500	AMJ8500
2	AccuSnap Lock	AMJ4501	AMJ6501	AMJ8501
3	AccuSnap Spring	AMJ4502	AMJ6502	AMJ8502
4	AccuSnap Spring Plunger	AMJ4503	AMJ6503	AMJ8503
5	AccuSnap Cap Screw	AMJ4504	AMJ6504	AMJ8504
6	AccuSnap Kick Out Pawl	AMJ4505	AMJ6505	AMJ8505
7	AccuSnap Spring Pin	AMJ6506	AMJ6506*	SCJ6501
8	AccuSnap Plain Outside Jaw	AMJ4507	AMJ6507	AMJ8507
9	AccuSnap Plain Center Jaw	AMJ4508	AMJ6508	AMJ8508

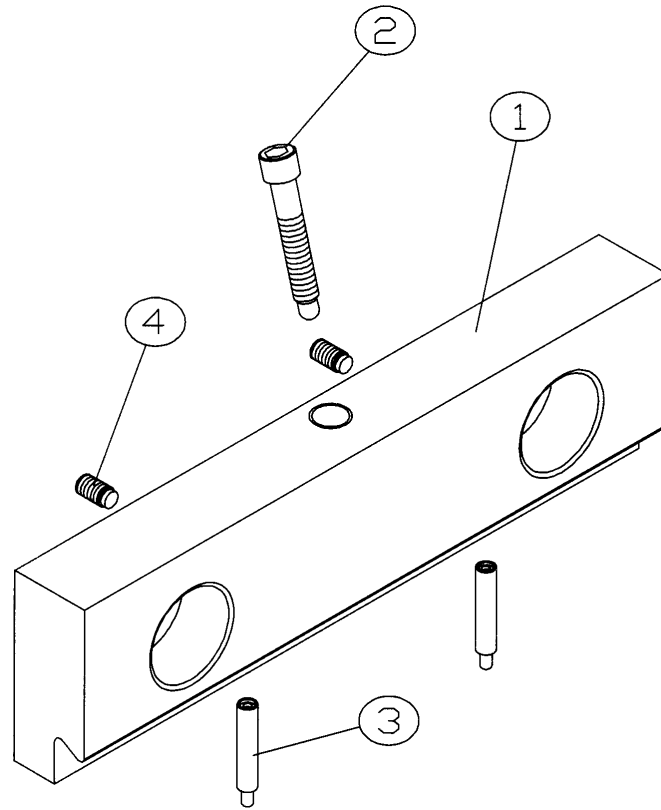
\*For 6" Center Jaw Order AccuSnap Spring Pin # SCJ6501

**PARTS  
AVAILABLE  
INDIVIDUALLY  
OR IN  
REPAIR KITS**

Qty.	ACCUSNAP REPAIR KITS Description	ARK4000 CONTAINS	ARK6000 CONTAINS	ARK8000 CONTAINS
2	AccuSnap Lock Screw	AMJ4500	AMJ6500	AMJ8500
2	AccuSnap Lock	AMJ4501	AMJ6501	AMJ8501
2	AccuSnap Spring	AMJ4502	AMJ6502	AMJ8502
2	AccuSnap Spring Plunger	AMJ4503	AMJ6503	AMJ8503
2	AccuSnap Cap Screw	AMJ4504	AMJ6504	AMJ8504
1	AccuSnap Kick Out Pawl	AMJ4505	AMJ6505	AMJ8505
1	AccuSnap Spring Pin	AMJ4506	AMJ6506	SCJ6501

## QUICKCHANGE™ PARTS LIST

### QuickChange Master Jaws



QUICKCHANGE MASTER JAW PARTS LIST				
#	Description	4" Vise	6" Vise	8" Vise
1	QuickChange Plain Master Jaw	QMJ4500	QMJ6500	QMJ8500
2	QuickChange Locking Screw	QMJ4501	QMJ6501	QMJ8501
3	QuickChange Plunger Assembly	QMJ6502	QMJ6502	QMJ6502
4	QuickChange Locking Screw	QMJ6503	QMJ6503	QMJ6503

## FIXTURE PLATE QUOTATION WORKSHEET

### Special Request For Quotation:

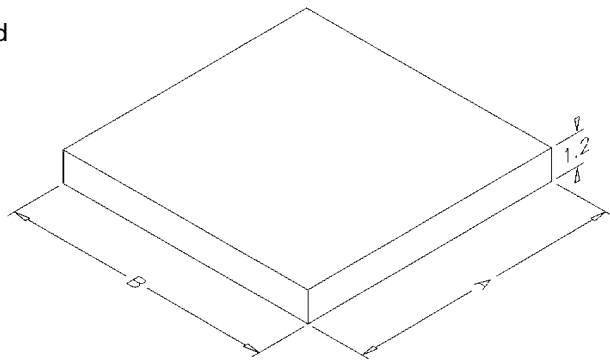
If you have a requirement that can not be met with one of our standards, please do the following:

1. Photocopy this page for an accurate quote.
2. Fill in the information concerning the product that will be quoted. Sketch in any information that is not provided. Be as detailed as possible.
3. Mail or Fax the RFQ sheet to TE-CO.
4. **Note: If ordered, this item will be manufactured directly from the information provided on this page. Please be sure information is correct. Authorized Signature is required.**
5. Please draw in mounting holes or specification required for mounting to a pallet or machine table.
6. Please draw in and dimension holes needed in the face for fixtures. Please be sure to include all information requested in the chart below.

Quantity: \_\_\_\_\_

	A	B	*Thickness
1.			
2.			
3.			
4.			

\*If other than specified on drawing (i.e. 1/2")



### Hole Specifications

	Hole Type	Hole Size	Hole Tolerance	Location Tolerance	Quantity of Holes
Ex.	Dowel	1/2"	± .0005	.00±20	
1.					
2.					
3.					

### Cut Corners on Base:

(Specify Size and Angle)

Yes \_\_\_\_\_

No \_\_\_\_\_

Company Name: \_\_\_\_\_

Address: \_\_\_\_\_

City: \_\_\_\_\_

State: \_\_\_\_\_ Zip: \_\_\_\_\_

Phone: \_\_\_\_\_

Fax: \_\_\_\_\_

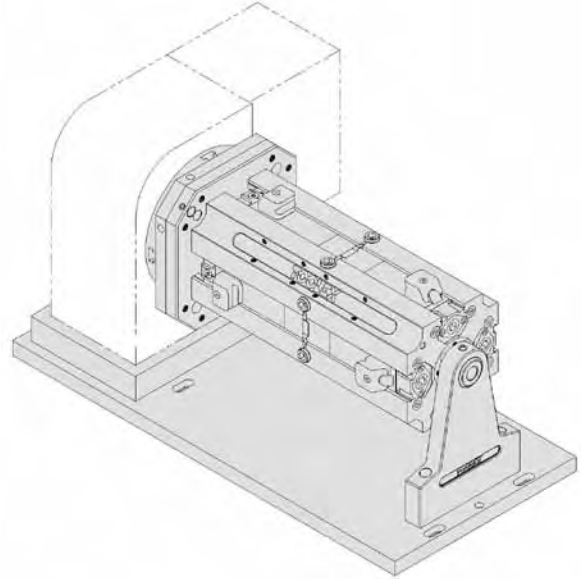
Authorized Signature: \_\_\_\_\_ Date: \_\_\_\_\_

## RELOCK-8 INDEXER ASSEMBLY QUOTATION WORKSHEET

### Special Request For Quotation:

If you have a requirement that can not be met with one of our standards, please do the following:

1. Photocopy this page for an accurate quote.
2. Fill in the information concerning the product that will be quoted. Sketch in any information that is not provided. Be as detailed as possible.
3. Mail or Fax the RFQ sheet to TE-CO.
4. **Note: If ordered, this item will be manufactured directly from the information provided on this page. Please be sure information is correct. Authorized signature is required.**



Machining Center Make: \_\_\_\_\_ Model #: \_\_\_\_\_

Indexer/Rotary Table Make: \_\_\_\_\_ Model #: \_\_\_\_\_

Minimum desired distance for part clearance: \_\_\_\_\_

If mounting to a Pallet System, please indicate:

Make: \_\_\_\_\_ Model #: \_\_\_\_\_

Company Name: \_\_\_\_\_

Address: \_\_\_\_\_

City: \_\_\_\_\_

State: \_\_\_\_\_ Zip: \_\_\_\_\_

Phone: \_\_\_\_\_

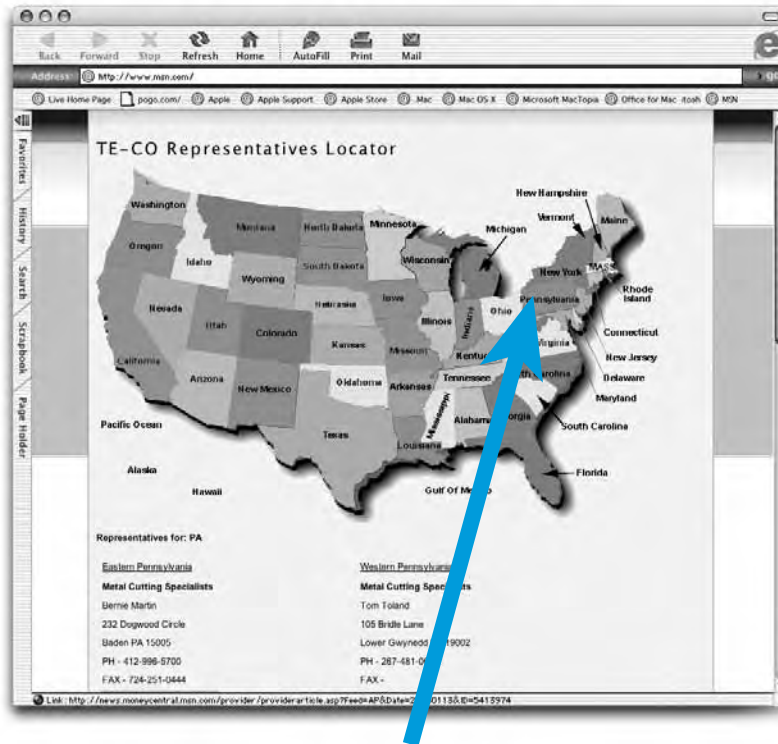
Fax: \_\_\_\_\_

Authorized Signature: \_\_\_\_\_ Date: \_\_\_\_\_

**\*Specials may require extended delivery time.**



# TE-CO Representative Locator



Click state for your local TE-CO Representative



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