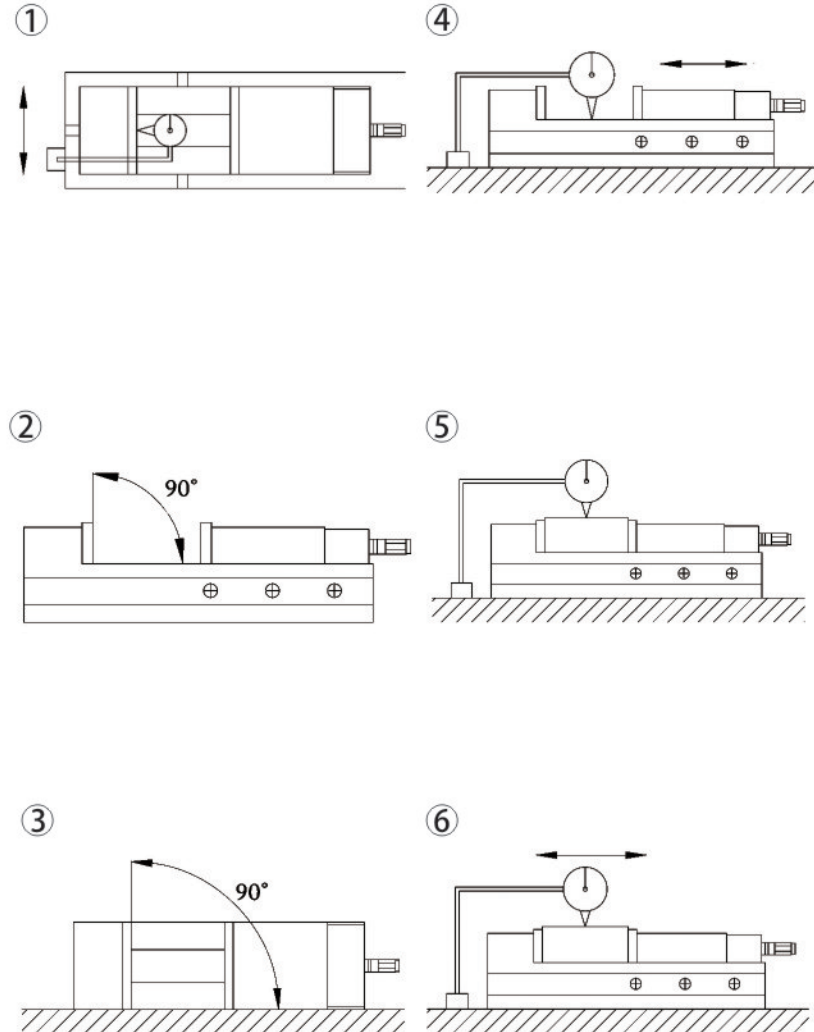
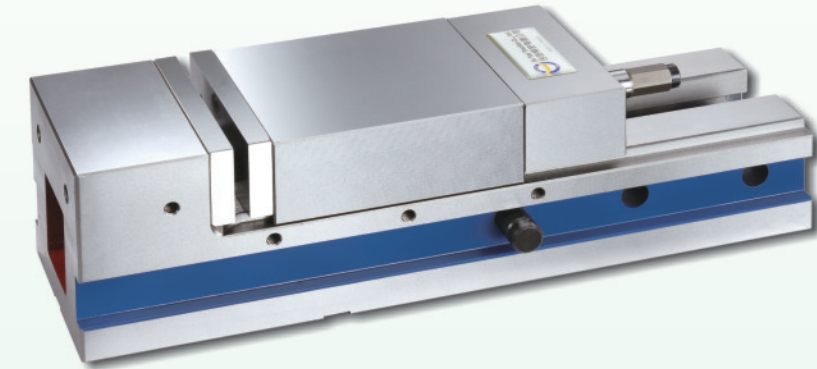


NO	檢查項目 Inspection Item (100mm)	容許值 Allowance	
		JIN YEAR	JIS CLASS
1	鉗口面對本台底面導正鍵槽之平行度。 Parallelism of keyways of body bottom face and fixed jaw clamp face.	0.01	0.015
2	鉗口面對滑動面之垂直度。 Vertical of fixed jaw clamp face and body slideface.	0.015	0.03
3	雙側面對滑動面之垂直度。 Vertical of vise side-lock on the bottom with the slideface.	0.02	0.02
4	本台滑動面對底面之平行度。 Parallelism of body bottom face and body slideface.	0.01	0.015
5	工件夾緊後之上浮量。 Top face lift of test block in clamping.	0.02	0.03
6	工件夾緊後之平行度。 Parallelism of top face of clamped test block in clamping.	0.015	0.02



吉益精密有限公司

JIN YEAR PRECISION CO., LTD.



Guaranty

MC 內藏式角固虎鉗合格證
MC HYDRAULIC ANGLE LOCK VISE (Built-In Type)
ONE-YEAR LIMITED WARRANTY UNDER NORMAL USE

使用說明書

一、使用方法：

1. 視工作物大小適當將止動銷插入 X.Y.Z 三孔中之一孔，再轉動把手至夾住工作物為止。
2. 輕敲把手，以瞬間之力（勿用鐵鎚）自動轉換成增壓進給，然後視需要轉至 a.b.c 三刻度間(表B)勿超過 a 刻度。

二、注油方法(圖A)：

1. 將上蓋支持座螺絲鬆開，取出主螺桿。
2. 將 ⑫ 螺絲鬆開。
3. 將 ⑤ 油壓缸依逆時針方向鬆開。
4. 將 ⑪ 心軸抽出，倒滿油壓油，再將附在保證書之心軸先插入到底後再拔出，然後再把 ⑪ 心軸插入，即完成注油，最後再依序裝回即可。

三、注意事項：

1. 注意勿過份開啓虎鉗口(表A)
2. 如果過分開啓虎鉗口(圖A)
 - (1) 將次螺桿之 ⑳ 防塵螺絲鬆開。
 - (2) 換上附在保證書之切換螺絲鎖緊。
 - (3) 然後將 ⑰ 次螺桿依順時針方向旋轉約 5 圈。
 - (4) 再將切換螺絲換回 ⑳ 防塵螺絲即可。
3. 使用增壓系統時，勿超過 a 刻度(圖A)

Operation Manual

一、Method of use：

1. Put stop moving spindle into one of the X, Y, and Z. hole, depending on the size of the processing items. Rotate the handle till it clips the workpiece.
2. Knock slightly on the handle to switch to pressure increase filling with the strength and rotate to the scale among point a, b and c as required. (See Graph B). Do not exceed scale a.

二、Oil Filling (See picture A)：

1. Loose the screw of the moveable jaw and take out of main screw.
2. Loose the ⑫ screw .
3. Loose the ⑤ hydraulic spindle counterclockwise.
4. Draw the ⑪ spindle and fill the hydraulic oil. Insert the spindle appended with the guaranty first and draw it out. Then insert ⑪ spindle. This is complete that filled the oil. Finally put them in sequence.

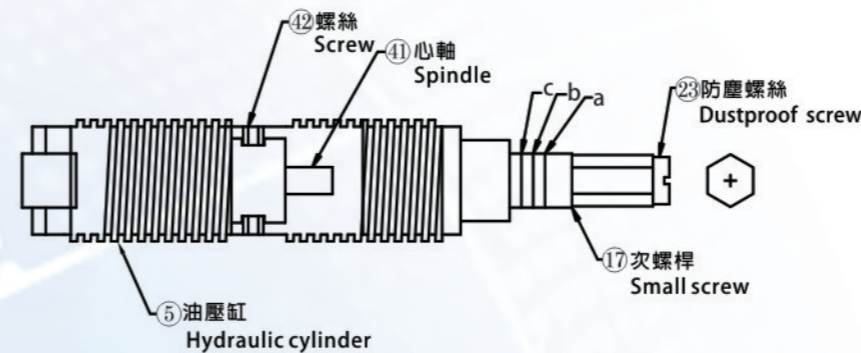
三、Attention

1. Please do not open the jaw exceeded clamping range. (See Graph A)
2. If open the jaw exceeded clamping range. (See picture A)
 - (1) Loose the ⑳ dustproof screw .
 - (2) Tight the change screw which appended with the guaranty.
 - (3) Circle around the ⑰ small screw five times in clockwise.
 - (4) Then, put the ⑳ dustproof screw replace the change screw.
3. When use the hydraulic system, please do not exceed point a. (See picture A)

表A (Graph A) Unit: mm

	X	Y	Z
MHA-100	0-85	85-170	
MHA-150	0-90	90-180	180-270
MHA-150A	0-100	100-200	200-300
MHA-200	0-100	100-200	200-300

主螺桿 Main screw



圖A (Picture A)

表B (Graph B)

規格 Specifications	MHA-100	MHA-150	MHA-150A	MHA-200
a 刻度壓力約 a Scale Line	2500kgf	5000kgf	5000kgf	7000kgf
b 刻度壓力約 b Scale Line	1500kgf	3000kgf	3000kgf	5000kgf
c 刻度壓力約 c Scale Line				2500kgf

MC 內藏式增壓角固虎鉗 MC HYDRAULIC ANGLE LOCK VISE (Built - In Type)

