



**Doble position and
Selfcentering machine
vices CF series**

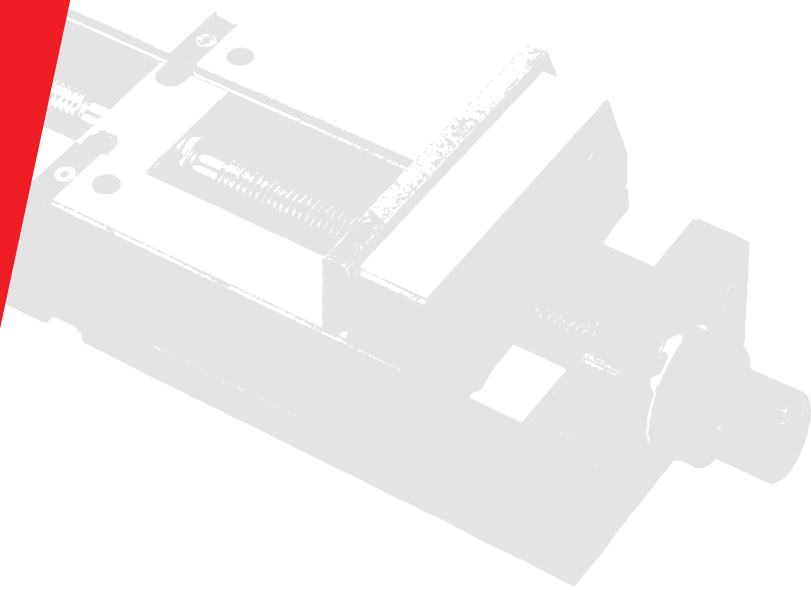
Manual



CF series

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■ **1. MECHANICAL MACHINE VICE TECHNICAL CHARACTERISTICS**

Manufactured in case-hardening material DIN 14CrMo13 (F155).

Bodies, jaw holder and jaw are hardened at 60HRc.

Completely rough grinding.

Finishing tolerance of the G7 body height.

Two mobile jaws are included. This allows two parts to be hold, even when these parts have different sizes.

Removing the central jaw holder, the machine vice becomes a self centering machine vice

Two possibilities of work with the same machine vice.

Clamping force 2 Ton.

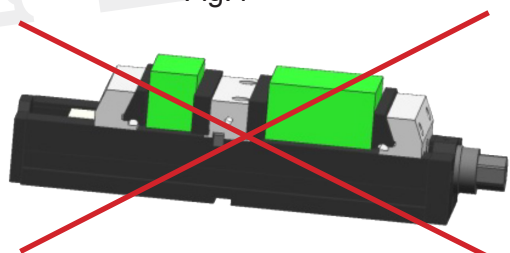
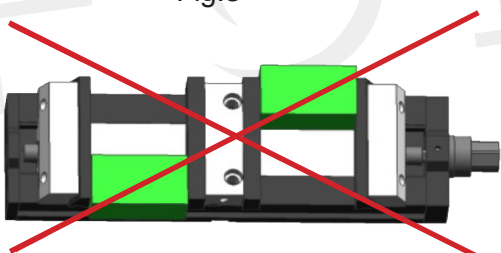
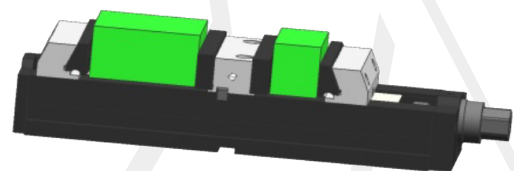
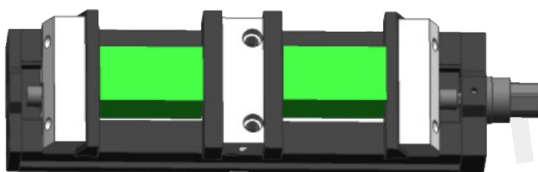
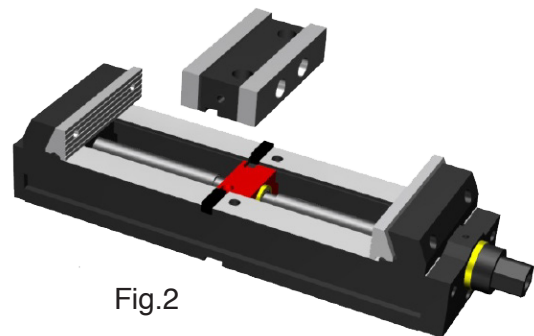
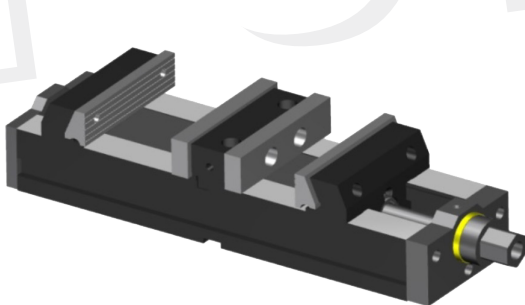
Fixed jaws with descending effect.

■ **2. WORKING AS DOUBLE POSITION MACHINE VICE**

Assemble the short sunk keys as shown in figure 2. These keys are shorter in order to avoid the block of the support part (red part). When the support part can be moved, part of different sizes can be clamped.

When two parts are clamped, we careful of placing both pieces in the line. (figure 3).

When the parts are of very different sizes, clamp always the longest part in the position shown in figure 4. That is to say, the big part should be kept as far as possible from the head of the spindle.



■ 3. WORKING AS SELF CENTERING MACHINE VICE

Remove the fixed jaw holder (central) and mount the sunk keys (green part) in order to block the support part (red part) in the figure 5, in this way the machine vice will become a self-centering vice.

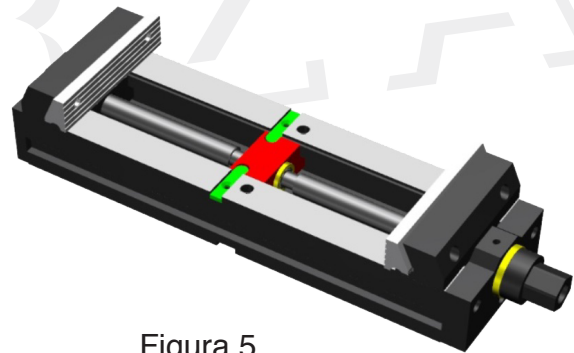
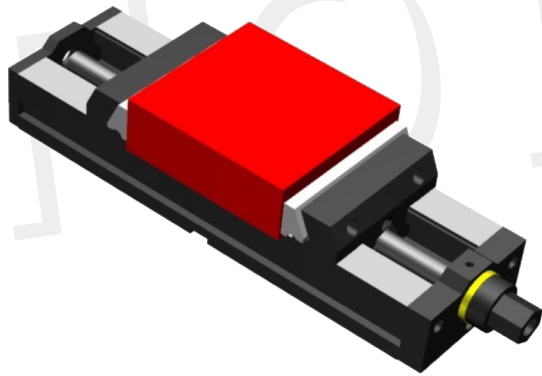
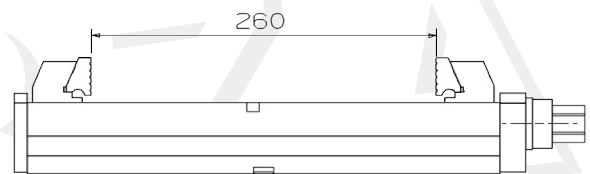
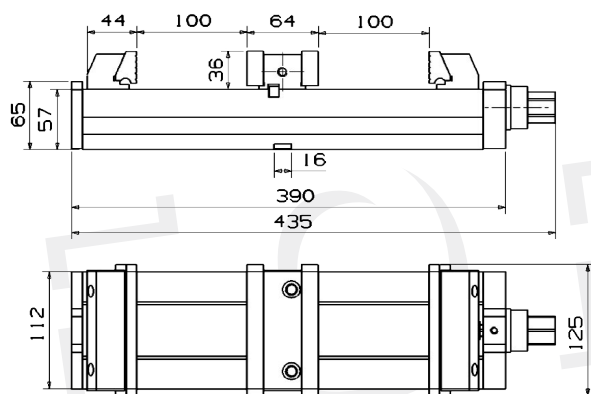
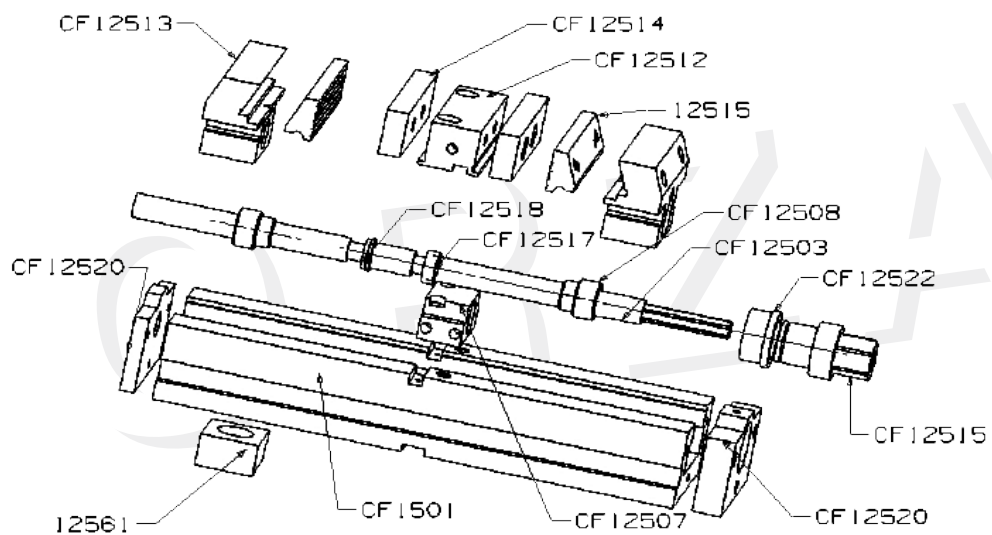


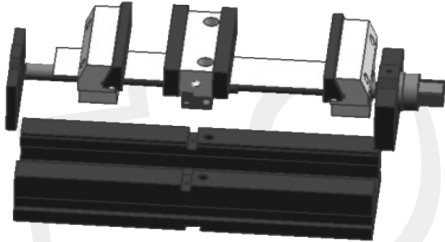
Figura 5



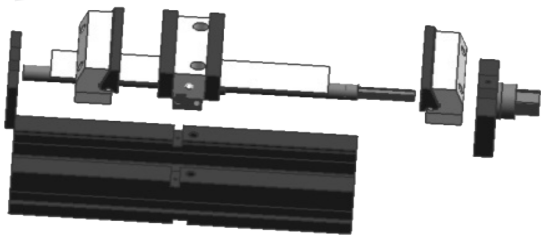
Exploded view



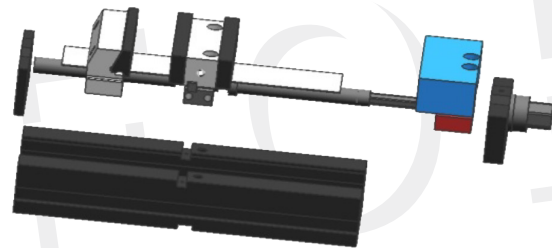
■ **4. CHANGE OF THE MOBILE JAW HOLDER**



Release the lateral covers.

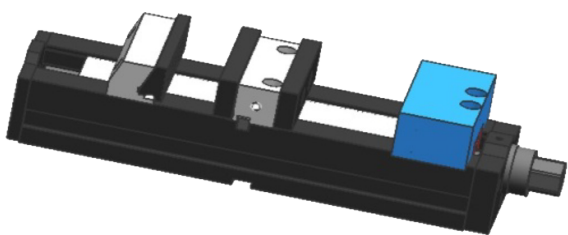


Unscrew the jaw holder which will be changed



Mount a new jaw holder.

This can belongs to CF/125, CFA125 OR CFB125 machine vices



Mount again the lateral covers

■ **5. CFA MACHINE VICE**

Shearing the same features as the previous on. In this model the jaws and the jaw holders are replaced by aluminum parts in order to reuse custom-made tools (Figure 6).

The rest of the parts are the same as in the CF/125 machine vice.

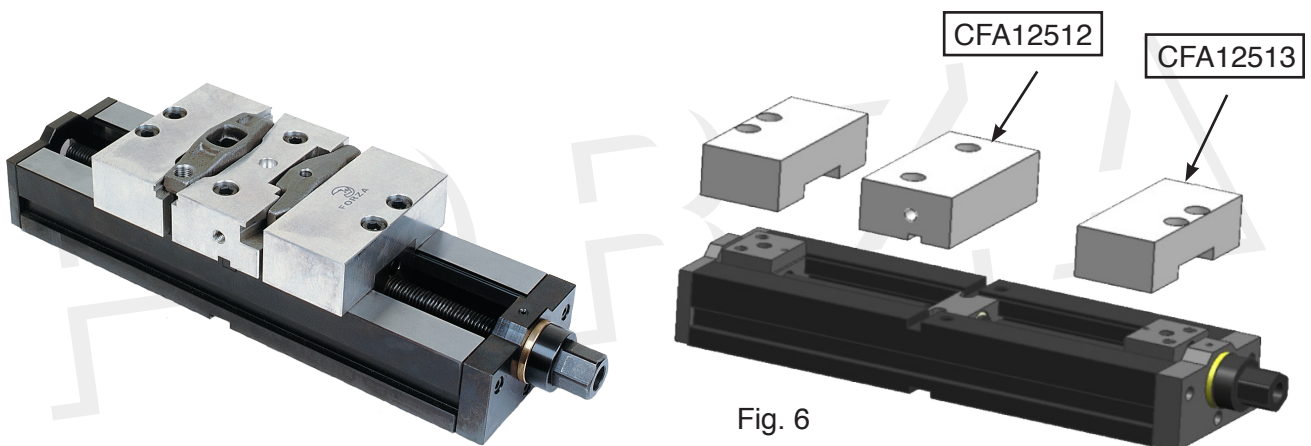
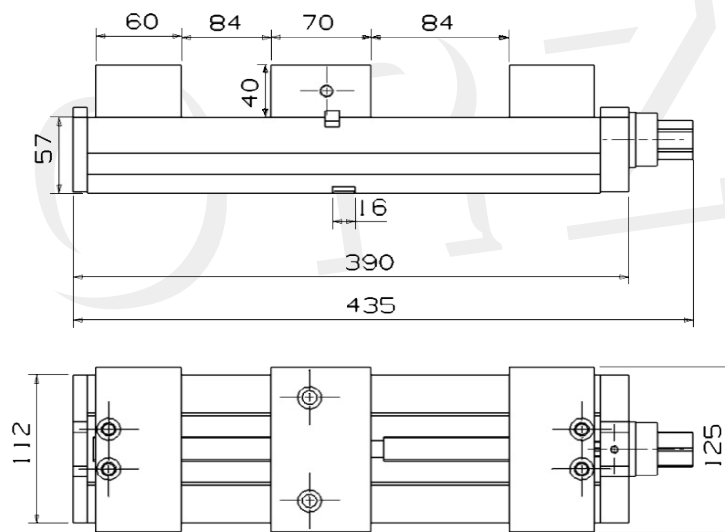
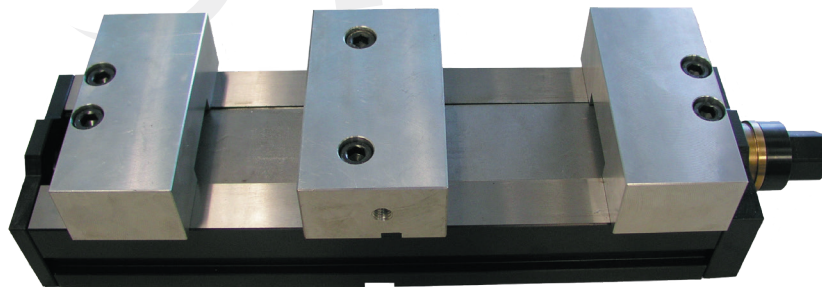


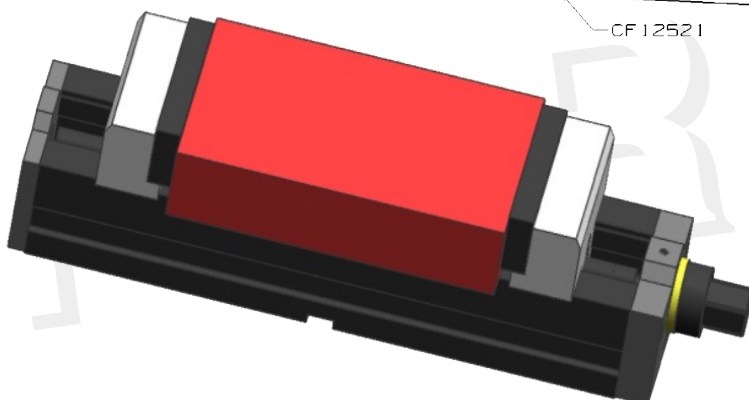
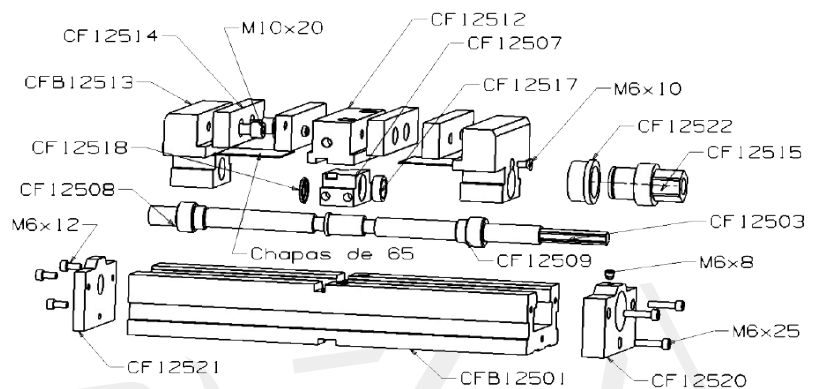
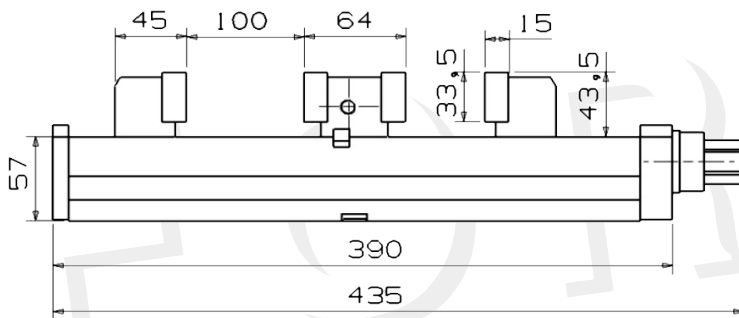
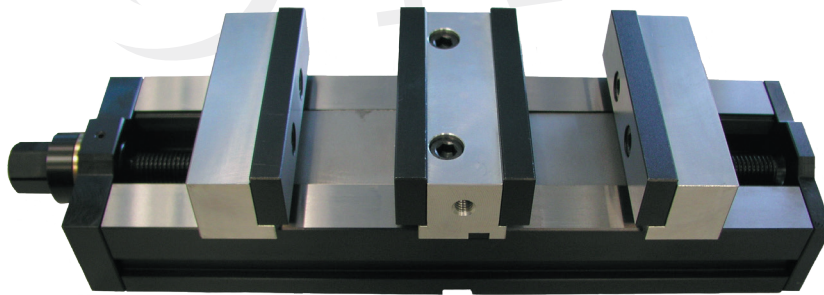
Fig. 6

■ **6. CFB MACHINE VICE**

With the same characteristics as the CF/125 machine vice. In this case, the case-hardening jaw holders are replaced by aluminium jaw holders.

The jaws are straight. In consequence, the descending effect is lost.

This jaw can work as self-centering vice changing the central jaw holder.





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