



# VICES

## DOUBLE CLAMP VISES

- Double clamp set ~ one handle can simultaneously operate two moveable jaws and clamps 2 workpieces of same or different size or one large workpiece
- This model can increase efficiency and productivity of CNC machines
- The movable jaw ANTI-LIFT mechanism provides alignment to workpiece without jaw lift
- There are 6 kinds of clamping ways to meet workpieces of different shapes and sizes
- The whole body is precisely ground and height tolerance is within  $\pm 0.025\text{mm}$  ( $\pm 0.001''$ ), therefore several vises can be lined up for production
- The vise is made of FDC-80,000 PSI (55kg/cm<sup>2</sup>) Ductile iron, and slide ways are hardened to HRC45
- The rigid construction prevents base distortion
- Precision made to high accuracy standard

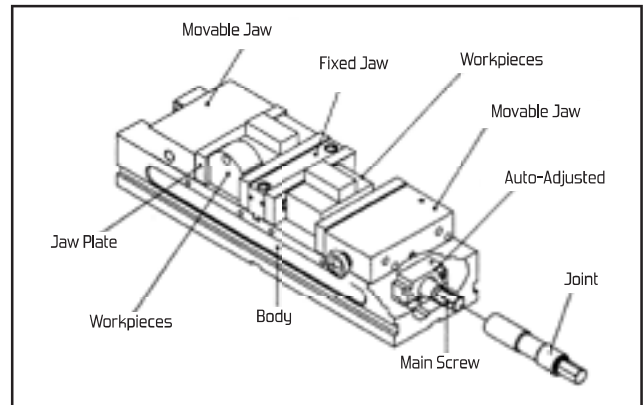


GS Double Clamp Vise  
(TLD-40G/HV, TLD-60G/HV)

## Double Clamp Vises

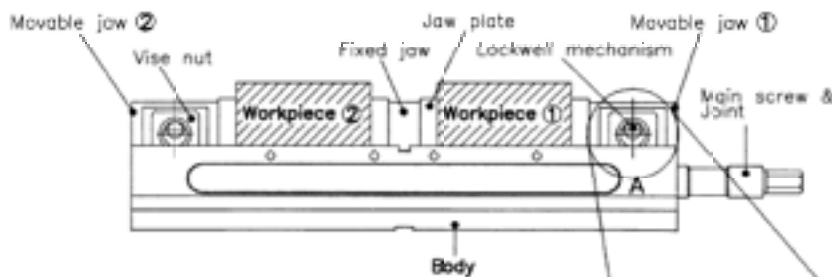
**Model No.**

4" - TLD-40G/HV  
6" - TLD-60G/HV



### Feature:

### ANTI-LIFT MECHANISM



- Clamping force equalization and ANTI-LIFT mechanism features virtually eliminate the deflection of fixed center jaw and movable jaw lift
- Clamping range for clamping 2 workpieces simultaneously is 125 mm (4,9") each or 275 mm (10,8") for one large workpiece
- Double clamp seat

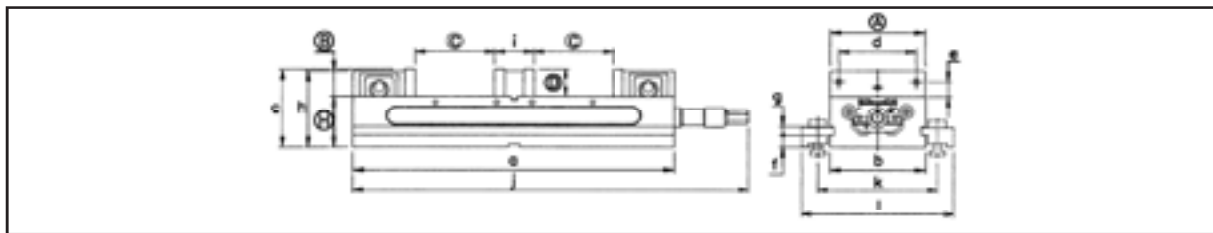


ANTI-LIFT Mechanism



**CLAMPING EXAMPLES FOR DIFFERENT APPLICATIONS:**

<p>Clamping 2 pieces of same size workpieces. Max. Capacity: 90mm (3,5") 125mm (4,9")</p>	<p>Clamping 2 pieces of different size of workpieces. Max. Capacity: 90mm (3,5") 125mm (4,9")</p>	<p>Large workpieces are able to be clamped after moving fixed jaw. Max. Capacity: 237mm (9,3") 1315mm (12,4")</p>
<p>Stepped jaw plate for thin workpiece. Max. Capacity: 215mm (8,4") 275mm (10,8")</p>	<p>Clamping 2 different workpieces. Max. Capacity: 215mm (8,4") 275mm (10,8")</p>	<p>Large thin workpiece is able to be clamped after removing jaw plate on fixed jaw. Max. Capacity: 405mm (15,9") 520mm (20,5")</p>



**Dimensional Information For Double Clamp Vises**

(mm/in.)

Model No.	A	B	C	D	a	b	c	d	e	f	g	h	H	i	j	k	l	Guide Block	Weight (kg/lb)
TLD-40G	103	33	90	38	405	104	101,5	63,5	17,5	13	31	96,5	63,5	55	430	143	195	18	20
(TLD-40HV)	4,05	1,29	3,54	1,49	15,9	4,09	3,99	2,5	0,68	0,51	1,22	3,79	2,5	2,16	16,9	5,62	7,67	0,709	44
TLD-60G	152	41,5	125	44,5	520	154	123,5	98,42	23,8	18	16	126,5	82,55	64	639	193	245	18	48
(TLD-60HV)	5,98	1,6	4,9	1,75	20,47	6	4,98	3,87	0,94	0,7	0,63	4,86	3,25	2,52	25,15	7,59	9,64	0,709	105,6

TLD-40G, TLD-60G; match vise, TLD-40HV, TLD-60H (horizontal and vertical 2 way)

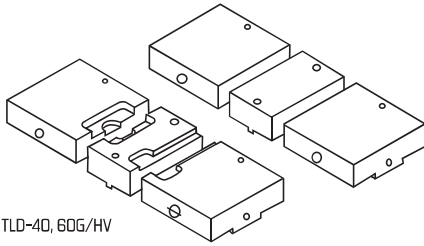
**Inspection Specification:**

	<p>Parallelism: running face to bottom of bed. Guaranteed: 0,01 mm (0,0004")</p>		<p>Parallelism: keyways on bottom of bed to jaw plate. Guaranteed: 0,02 mm (0,0008")</p>
	<p>Squareness: between running face and jaw plate. Guaranteed: 0,03 mm (0,0012")</p>		<p>Squareness: keyways on bottom of bed to jaw plate. Guaranteed: 0,02 mm (0,0008")</p>
	<p>Squareness both sides to fixed jaw plate. Guaranteed: 0,02 mm (0,0008")</p>		<p>Parallelism: running face of the test block to bottom. Guaranteed: 0,02 mm (0,0008")</p>



# VISES

## Machinable Fixture Jaws



Soft Jaws for TLD-40, 60G/HV

### Description

- 4" aluminum soft jaws
- 4" step jaws
- 6" aluminum soft jaws
- 6" step jaws

## Steel Jaw Sets

### Model No.

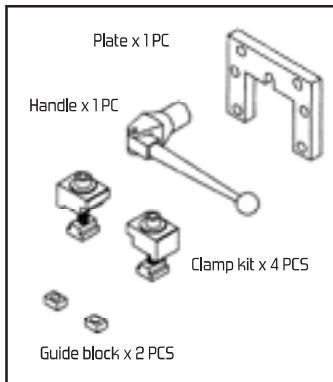
- 4" steel jaw set for TLD40
- 6" steel jaw set for TLD60

## Steel Jaw Plates

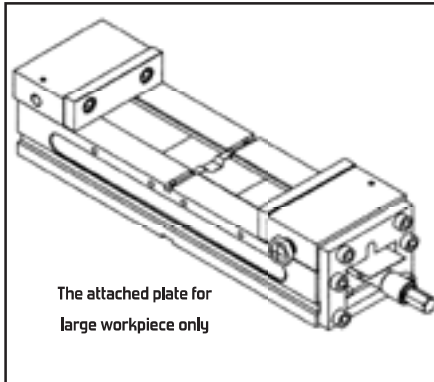
### Description

- 6" steel jaw plate set (4) for TLD60

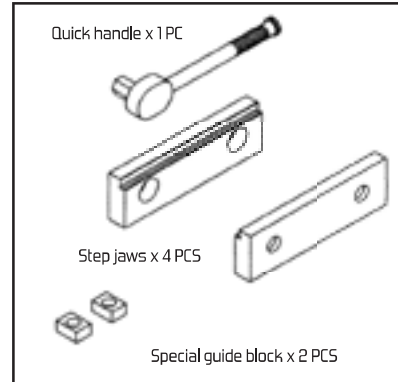
## Standard Accessories



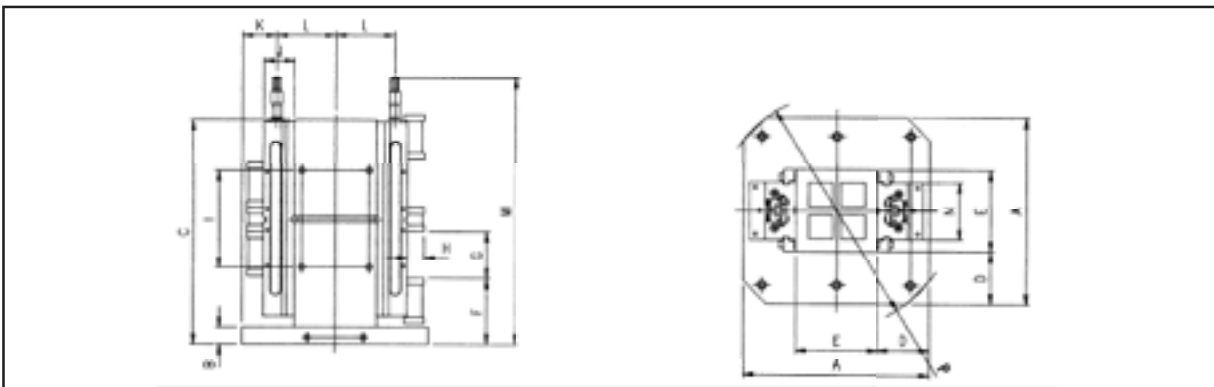
## Usage of "Plate"



## Optional Accessories



## JIG BLOCK



## Jig Block Dimensional Specifications

(mm/in.)

Model NO.	Use Vise	Pallet Size	A	B	C	D	E	F	G	H	I	J	K	L	M	N	P	Weight (kg/lb)
GS-40-4C	TLD-40	400 x 400	400	40	500	110	180	168	90	38	203	63,5	75,5	124,5	543	104	506	118
GS-40-4C	TLD-40	400 x 400	15,74	1,57	19,68	4,33	7,08	6,61	3,54	1,49	7,99	2,5	2,907	4,90	21,3	4,09	19,92	259,6
GS-60-4C	TLD-60	500 x 500	500	45	600	140	220	175	125	44,5	260	82,5	92	158	714	154	628	233
GS-60-4C	TLD-60	500 x 500	19,68	1,77	23,62	5,51	8,66	6,88	4,92	1,75	10,23	3,25	3,62	6,25	28,11	6,02	24,72	512,6