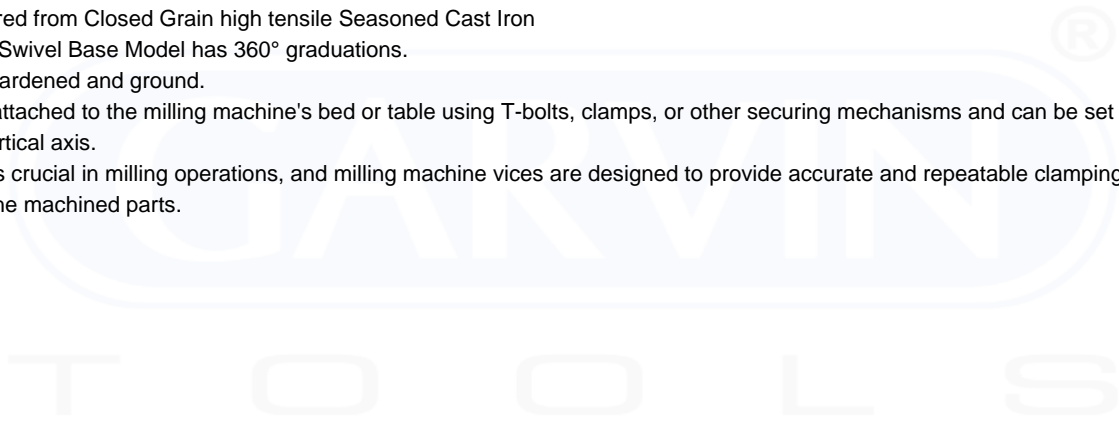


MILLING MACHINE VICE - SUPER PRECISION



- Manufactured from Closed Grain high tensile Seasoned Cast Iron
- Horizontal Swivel Base Model has 360° graduations.
- Jaws are hardened and ground.
- Vices are attached to the milling machine's bed or table using T-bolts, clamps, or other securing mechanisms and can be set at any angle along with the vertical axis.
- Precision is crucial in milling operations, and milling machine vices are designed to provide accurate and repeatable clamping to ensure the quality of the machined parts.



Cat. No.	Jaw Width		Jaw Opening		Jaw Depth	
Swivel Base	Inch	mm	Inch	mm	Inch	mm
GMV-0105	2	50	2	50		1
GMV-0109	3	75	3	75		1-1/4
GMV-0106	4	100	4	100		1-1/2
GMV-0107	5	125	5	125		2
GMV-0108	6	150	6	150		2-1/8

Cat. No.	Jaw Width		Jaw Opening		Jaw Depth	
Fixed Base	Inch	mm	Inch	mm	Inch	mm
GMV-0100	2	50	2	50		1
GMV-0104	3	75	3	75		1-1/4
GMV-0101	4	100	4	100		1-1/2
GMV-0102	5	125	5	125		2
GMV-0103	6	150	6	150		2-1/8

How to Use

Using a milling machine vice with a swivel base involves adjusting the swivel feature to hold the workpiece at a desired angle for milling. Here's a general guide on how to use a milling machine vice with a swivel base:

1. Inspect the Vice:

- Ensure that the milling machine vice and swivel base are in good condition with no damage or wear that could affect their performance.

2. Prepare the Milling Machine:

- Set up your milling machine on a stable surface and secure it in place.
- Make sure the milling machine's table is clean and free from any debris.

3. Choose the Right Tooling:

- Select the appropriate milling cutter and tooling for the specific milling operation you plan to perform.

4. Mount the Vice:

- Securely mount the milling machine vice on the milling machine table using T-bolts, clamps, or other appropriate mounting methods.

5. Adjust the Swivel Base:

- Loosen the swivel base locking mechanism. This is typically a bolt or lever that holds the swivel base in place.
- Rotate the swivel base to the desired angle for your milling operation. Most swivel bases allow rotation within a certain range, often up to 360 degrees.

6. Secure the Swivel Base:

- Once you have set the swivel base to the desired angle, tighten the locking mechanism to secure it in place. Ensure that it is tight enough to prevent movement during milling.

7. Insert the Workpiece:

- Place your workpiece between the jaws of the milling machine vice.
- Adjust the movable jaw to accommodate the size of the workpiece.

8. Secure the Workpiece:

- Tighten the vice jaws securely around the workpiece to hold it in place during milling. Ensure that the workpiece is stable and properly aligned.

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9. Perform the Milling Operation:

- Start the milling machine and perform the milling operation as needed. The swivel base allows you to mill at an angle, providing flexibility in machining complex shapes or features.

10. Check for Accuracy:

- After milling, check the machined features for accuracy. The swivel base should have allowed you to achieve the desired angles and dimensions.

11. Release and Reset:

- When you need to change the angle or reposition the workpiece, release the swivel base, make the necessary adjustments, and secure it again before continuing with the milling operation.

Always follow the instructions and safety guidelines for your specific milling machine vice and swivel base. Proper setup and secure clamping are crucial to ensure the safety of the operator and the accuracy of the milling operation.

