



Optimal for machining centers and NC milling machine!

RoHS Compliant

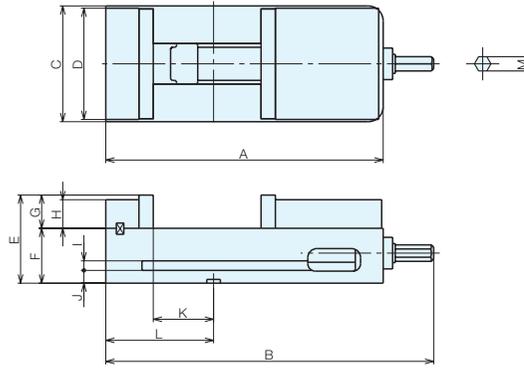
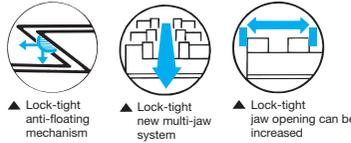


No.E-9275M

Lock-Tight MC Precision Machine Vises

Accessories Standard guide block (2 pieces per set) compatible groove width 18 mm ... 1 set
Handle ... 1 piece

- Parallel accuracy of matched specification products is within 0.01.
- Can also be used facing horizontally.



Size Chart

No.	A	B	C	D	E	F	G	H	I	J	K	L	M
LT100MC	268	316	104	101	89	57	32	28	12	12	54	102	14
LT150MC	368	435	154	151	117.2	73	44.2	38	12.7	17	80	143	19

Specifications

No.	Jaw Width	Jaw Depth	Jaw Opening	Standard Guide Block Width	Clamping force kN	Weight (kg)	LTMC			LTMC-G (Matched Specifications)		
							Order No.	No.		Order No.	No.	
LT100MC	101	32	102	18	30	11	932186	LT100MC		932451	LT100MCG	
LT150MC	151	44	143	18	40	32	932187	LT150MC		932452	LT150MCG	

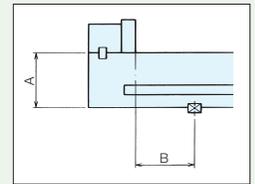
Usage Examples



Ordering Parallel Products

(A and B can be aligned within 0.01 no matter how many pieces)
If the suffix of the manufacture no. (attached to the outer box and main body) is the same letter, then the product are parallel no matter how many pieces. There is no charge for parallel products.

- ◆ When purchasing for the first time
Order matched specification products (suffix G)
When ordering, specify the groove width of the machine you are using.
- ◆ For additional orders
Contact us with the suffix letter of the manufacture no. (stamped on the name plate) and the guide block width of a vise that you have.



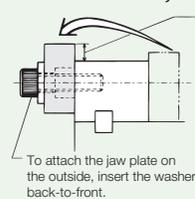
Increasing the Jaw Opening

A large jaw opening can be obtained by changing the jaw plate positions.

◆ Jaw opening depending on the jaw plate attachment position

LT100MC	0 - 102	48 - 150	115 - 217	163 - 265
LT150MC	0 - 143	63 - 206	160 - 303	223 - 366

◆ How to move the jaw plates



If the jaw plate is mounted upside down, the jaw plate will protrude by a long distance.

Maximum 200 N



* The clamping force should be kept under 10kN when the jaw plate is attached to the outside.
The operation force in this case is approximately 200 N with the standard handle.

Jig Set-up Systems (Q-lock)

Base Elements

Clamp Units

Clamping Parts

Mechanical Parts

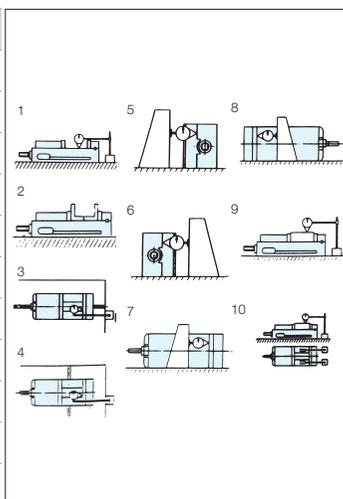
Machine Vises

Surface Plates and Measurement Instruments

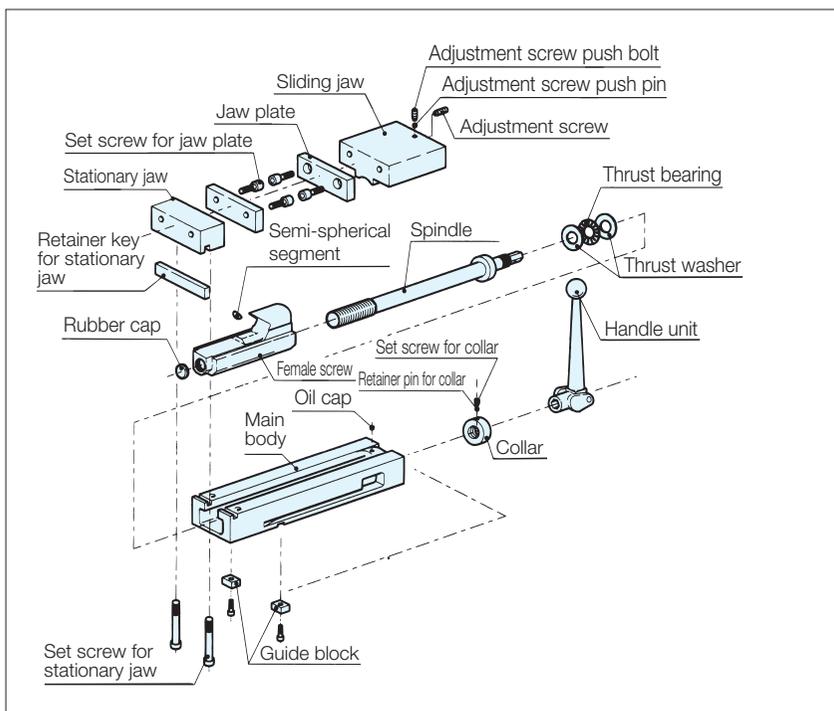
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Accuracy Standards
(Static Accuracy)

No.	Inspection Points (per 100 mm)	Former JIS Standard (O Grade)	Nabeya SPEC
1	Parallelism between bottom surface of main body and sliding surface	0.015	0.010
2	Perpendicularity between jaw plate and sliding surface (smaller than right angle)	0.030	0.015
3	Perpendicularity between T-slot and jaw plate surface of stationary jaw side.	0.015	0.010
4	Parallelism between T-slot and jaw plate surface of stationary jaw side.	0.015	0.010
5	Perpendicularity between side face of main body and sliding surface	-	0.030
6	Perpendicularity between side face of main body and sliding surface	-	0.030
7	Perpendicularity between side face of main body and jaw plate surface of stationary jaw side	-	0.050
8	Perpendicularity between side face of main body and jaw plate surface of stationary jaw side	-	0.050
(Clamping Accuracy)			
9	Parallelism between top surface of clamped test block and bottom surface of main body	0.020	0.015
10	Lift-up of top surface of test block when clamped	0.030	0.015



Parts details



Accessories and Optional Parts (Refer to the Following Page)
Reference Pages



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