

RoHS Compliant

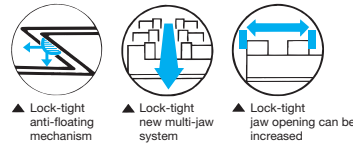


No.E-9275M

Lock-Tight Precision Machine Vises

Accessories Standard guide block (2 pieces per set) compatible groove width 18 mm ... 1 set
 Handle ... 1 piece
 Suspension bolt ... 2 pieces (LT250M and LT250MG only)

- The sliding jaw and workpiece are prevented from lifting up by an anti-floating mechanism.
- Made of ductile cast iron, preventing bending and breakage during tightening.
- Sliding parts have been flame heat treated (HRC45) and offer excellent wear resistance.
- High accuracy that surpasses the former JIS standards 0 grade.
- Even in the rare case that it becomes worn out, it can be dismantled and the accuracy can be restored easily.
- Parallel accuracy of matched specification products is within 0.01.



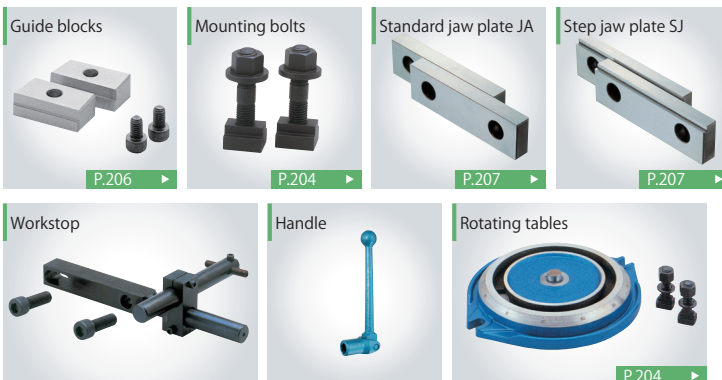
Size Chart

No.	A	B	C	D	E	F	G	H	I	J	K	L	M
LT100M	319	337	161	146	101	57	85	89	133	54	127.5	15	14
LT125M	356	387	187	178	126	64	97	102	156	59	140	15	16
LT150M	425	463	230	210	151	73	111	117	192	80	173	18	19
LT200M	553	588	290	279	202	84	134	141	250	92	215	22	22
LT250M	694	737	370	334	253	98.5	161.5	174	310	119	270	24	22

Specifications

No.	Jaw Width	Jaw Depth	Jaw Opening	Standard Guide Block Width	Clamping force kN	Weight (kg)	LT-M		LT-MG (Matched Specifications)	
							Order No.	No.	Order No.	No.
LT100M	101	32	102	18	40	16	932101	LT100M	932446	LT100MG
LT125M	126	38	112	18	40	25	932102	LT125M	932447	LT125MG
LT150M	151	44	143	18	40	36	932103	LT150M	932448	LT150MG
LT200M	202	57	190	18	40	65	932104	LT200M	932449	LT200MG
LT250M	253	75.5	248	18	50	135	932105	LT250M	932450	LT250MG

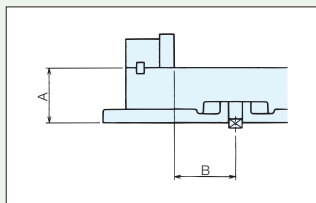
Accessories and Optional Parts (Refer to the Following Page) Reference Pages



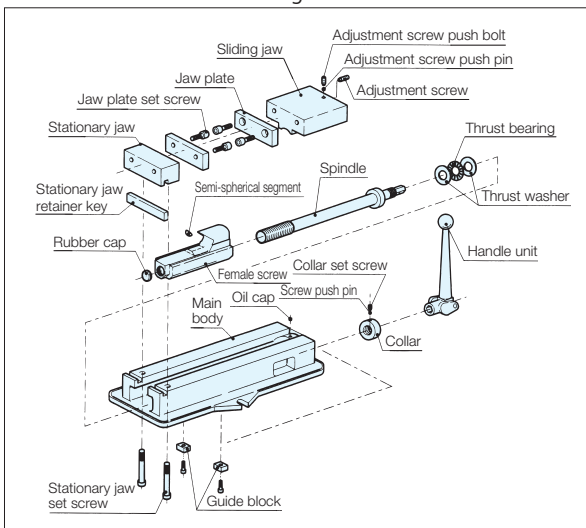
Ordering Parallel Products
(A and B can be aligned within 0.01 no matter how many pieces)

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 (for standard guide blocks). 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.



Dismantled Section Drawing



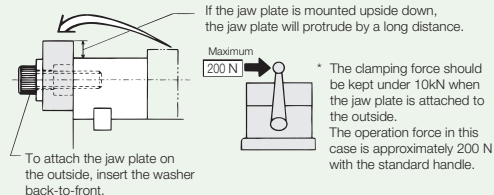
Increasing the Jaw Opening

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

◆ Jaw opening depending on the jaw plate attachment position

LT100M	0 - 102	48 - 150	115 - 217	163 - 265
LT125M	0 - 112	56 - 168	140 - 252	196 - 308
LT150M	0 - 143	63 - 206	160 - 303	223 - 366
LT200M	0 - 190	85 - 275	199 - 389	284 - 474
LT250M	0 - 248	110 - 358	233 - 501	366 - 614

◆ How to move the jaw plates

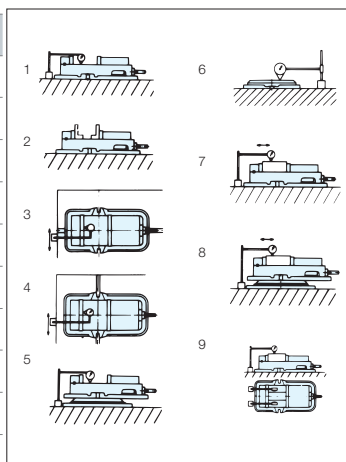


* The clamping force should be kept under 10kN when the jaw plate is attached to the outside. The operation force in this case is approximately 200 N with the standard handle.

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	Parallelism between bottom surface of rotating table and sliding surface	0.020	0.015
6	Parallelism between the bottom surface and top surface of the rotating table	-	0.010
(Clamping Accuracy)			
7	Parallelism between top surface of clamped test block and bottom surface of main body	0.020	0.015
8	Parallelism between top surface of clamped test block and bottom surface of rotating table	0.030	0.020
9	Lift-up of top surface of test block when clamped	0.030	0.015



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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