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WENBIXIA BG-6368

Allsome BG-6368 Cross-Sliding Vise Instruction Manual

Model: BG-6368

1. Product Overview

The Allsome BG-6368 3-inch Cross-Sliding Vise is a precision workholding device designed for use with mill and drilling presses. It features a compound slide mechanism, allowing for precise movement along both X and Y axes, which is essential for accurate positioning during machining operations.

Key features include:

- Designed for inspection, grinding, and other operations requiring precise clamping.
- Constant clamping mechanism ensures stability and reliability, reducing processing time.
- Adjustable clamping capacity for various workpiece sizes, offering flexibility and ease of use.
- Durable construction with hardened and precise surfaces for consistent accuracy.
- Versatile application for machine tools such as surface grinders, milling machines, and wire cutting, enabling the processing of angled planes, grooves, and oblique flat holes, and for measuring parts with various angles.

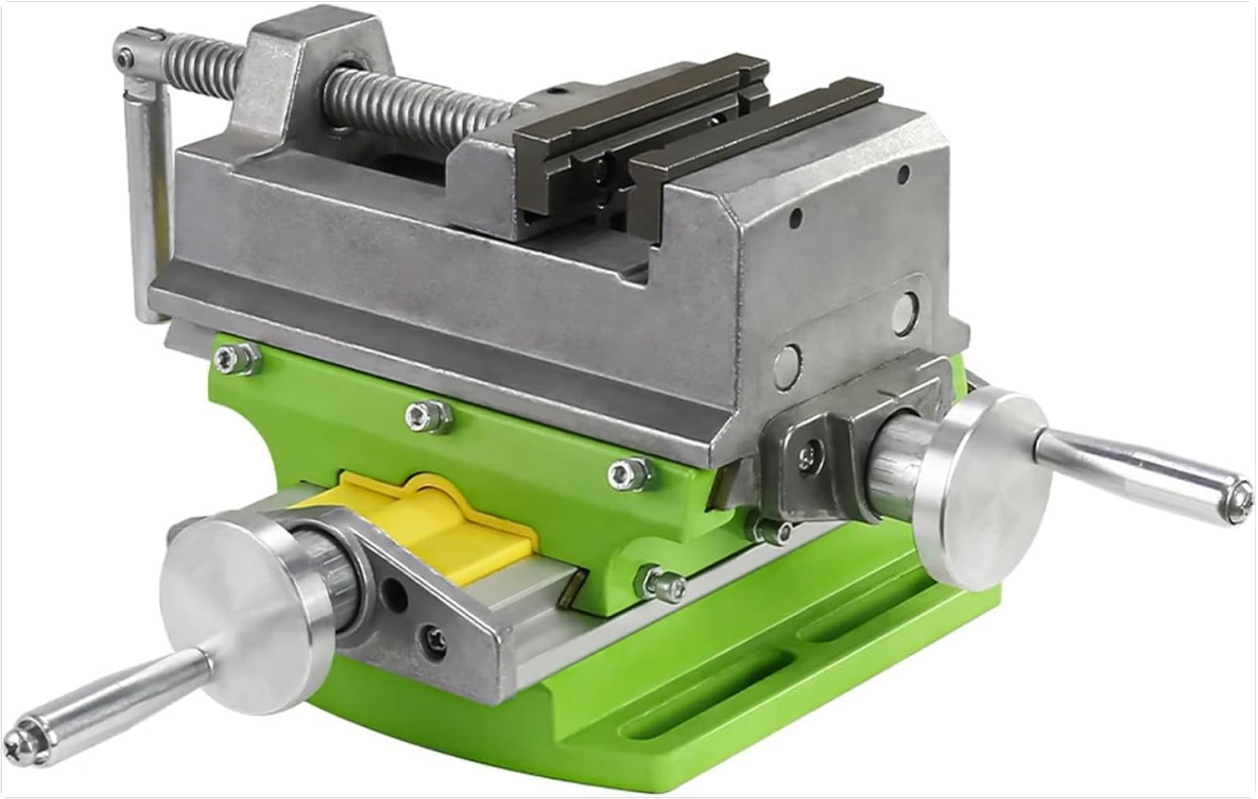

Figure 1: Front view of the Allsome BG-6368 Cross-Sliding Vise.

2. Safety Instructions

Always observe the following safety precautions when operating the cross-sliding vise:

- Wear appropriate personal protective equipment (PPE), including safety glasses, when operating machinery with the vise.
- Ensure the vise is securely mounted to the workbench or machine table before use.
- Do not overtighten the vise jaws, as this can damage the workpiece or the vise itself.
- Keep hands and fingers clear of moving parts, especially during clamping and sliding operations.
- Regularly inspect the vise for any signs of wear, damage, or loose components. Do not use if damaged.
- Keep the work area clean and well-lit.
- Do not modify the vise in any way. Use only as intended.

3. Components

The Allsome BG-6368 Cross-Sliding Vise consists of the following main components:

- **Fixed Jaw:** The stationary part of the vise that holds the workpiece.
- **Movable Jaw:** The adjustable part that clamps the workpiece against the fixed jaw.
- **Lead Screw (Clamping):** Used to open and close the vise jaws.
- **Handle (Clamping):** Rotates the lead screw for clamping.
- **X-Axis Slide:** Allows lateral movement of the vise.
- **Y-Axis Slide:** Allows longitudinal movement of the vise.
- **X-Axis Lead Screw & Handle:** Controls movement along the X-axis.
- **Y-Axis Lead Screw & Handle:** Controls movement along the Y-axis.
- **Base:** The main body of the vise, typically with mounting holes.

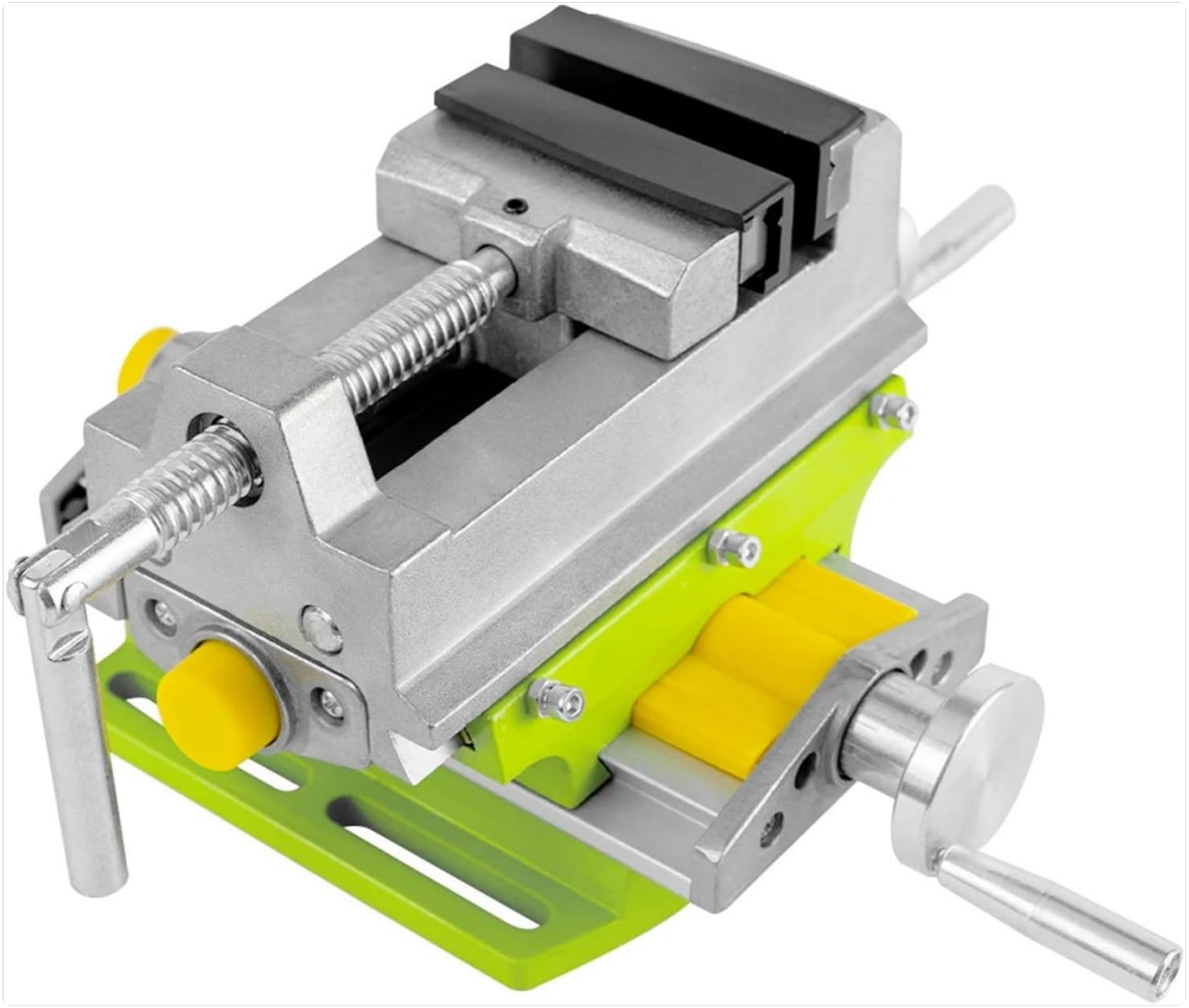

Figure 2: Top-down view showing the X and Y axis handles.

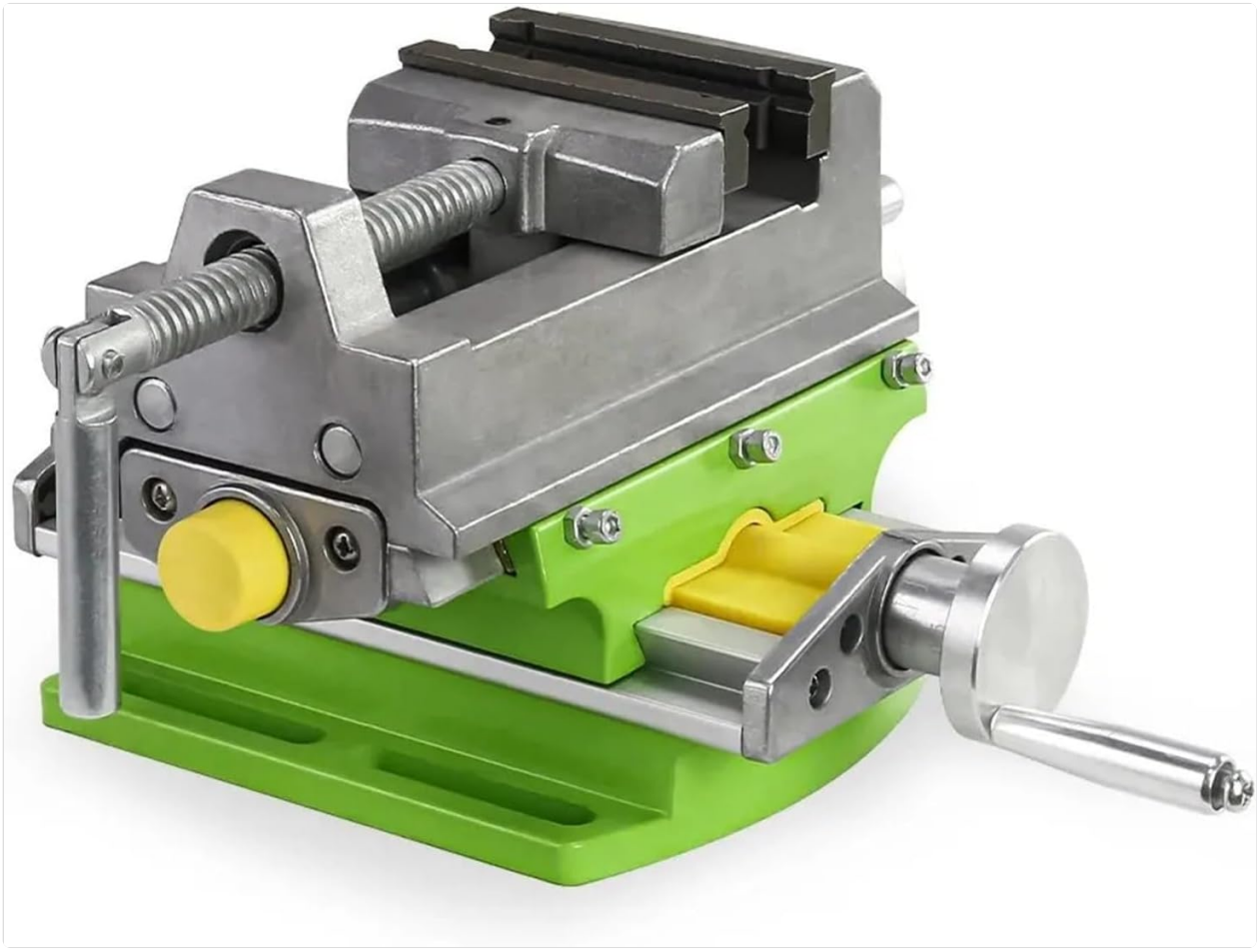

Figure 3: Side view highlighting the clamping mechanism.

4. Setup

Proper setup is crucial for the stability and accuracy of the vise.

1. **Unpacking:** Carefully remove the vise from its packaging. Inspect for any shipping damage.
2. **Cleaning:** Wipe down the vise with a clean cloth to remove any protective oils or debris.
3. **Mounting:**
    - Position the vise on your mill or drilling press table.
    - Align the mounting holes on the vise base with the T-slots or mounting holes on your machine table.
    - Secure the vise using appropriate T-slot nuts, bolts, and washers. Ensure all fasteners are tightened securely to prevent movement during operation.
4. **Lubrication:** Apply a thin layer of machine oil to the lead screws and sliding surfaces to ensure smooth operation.

5. Operating Instructions

Follow these steps for effective and safe operation of your cross-sliding vise:

1. **Clamping a Workpiece:**
    - Rotate the clamping handle counter-clockwise to open the vise jaws sufficiently to accommodate your workpiece.
    - Place the workpiece firmly against the fixed jaw.
    - Rotate the clamping handle clockwise to close the movable jaw until the workpiece is securely clamped. Do not overtighten.
2. **Adjusting X-Axis Position:**
    - To move the workpiece left or right, rotate the X-axis handle.
    - The graduated dial on the handle allows for precise adjustments. One full rotation of the scale corresponds to 1.5mm of travel.
3. **Adjusting Y-Axis Position:**
    - To move the workpiece forward or backward, rotate the Y-axis handle.
    - The graduated dial on the handle allows for precise adjustments.
4. **Drilling/Milling Operations:** Once the workpiece is securely clamped and precisely positioned using the X and Y axis adjustments, proceed with your drilling or milling operation according to your machine's instructions.
5. **Releasing Workpiece:** After completing the operation, rotate the clamping handle counter-clockwise to release the workpiece.

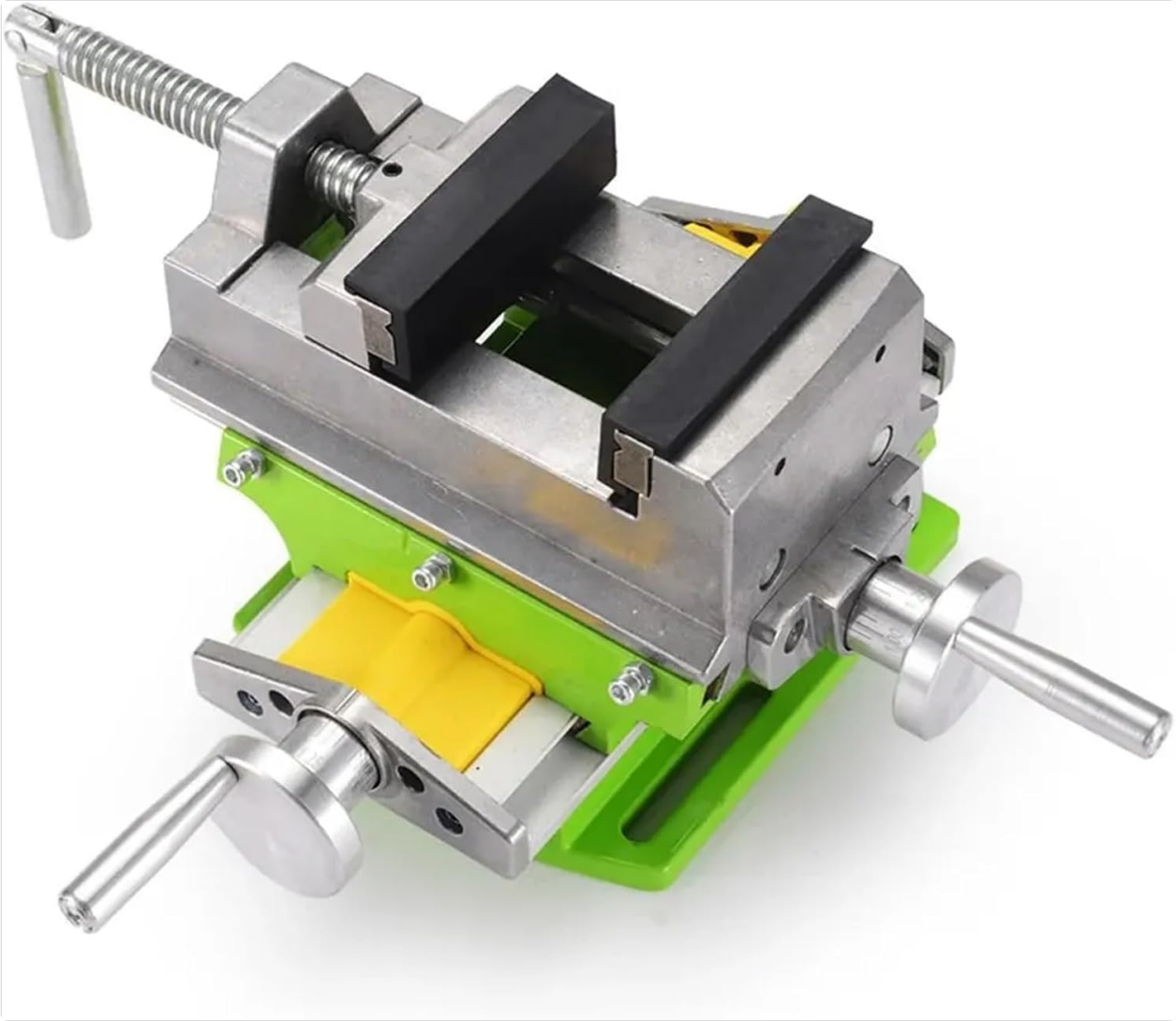

Figure 4: Top view showing the vise jaws and sliding mechanisms.

6. Maintenance

Regular maintenance will extend the life and maintain the accuracy of your vise.

- **Cleaning:** After each use, clean the vise to remove chips, dust, and debris. Use a brush or compressed air.
- **Lubrication:** Periodically apply a light machine oil to all moving parts, including lead screws, sliding surfaces, and pivot points. This prevents rust and ensures smooth operation.
- **Inspection:** Regularly check for loose bolts, excessive wear on jaws or lead screws, and any signs of damage. Tighten loose fasteners as needed.
- **Storage:** Store the vise in a clean, dry environment to prevent corrosion.

7. Troubleshooting

This section addresses common issues you might encounter:

Problem	Possible Cause	Solution

Problem	Possible Cause	Solution
Jaws not clamping securely	Debris in screw threads; Worn lead screw; Workpiece not seated properly	Clean threads; Lubricate lead screw; Ensure workpiece is flat against fixed jaw
Sliding mechanisms stiff or jerky	Lack of lubrication; Dirt/chips on slides; Overtightened gibs (if adjustable)	Clean and lubricate slides; Check for debris; Adjust gibs if applicable (refer to advanced maintenance)
Inaccurate positioning	Loose mounting; Play in lead screws; Worn components	Ensure vise is securely mounted; Inspect lead screws for excessive play; Consider professional service if components are worn

8. Specifications

The following are the technical specifications for the Allsome BG-6368 Cross-Sliding Vise:

Feature	Specification
Model	BG-6368
Material	Aluminum alloy
X-Travel	80mm
Y-Travel	67mm
Vise Capacity (Jaw Opening)	75mm
One Round Scale (X/Y axis)	1.5mm
Function	Fixed bench drilling
Item Weight	2.2 pounds (approx. 1000 grams)
Color	Green
Country of Origin	China

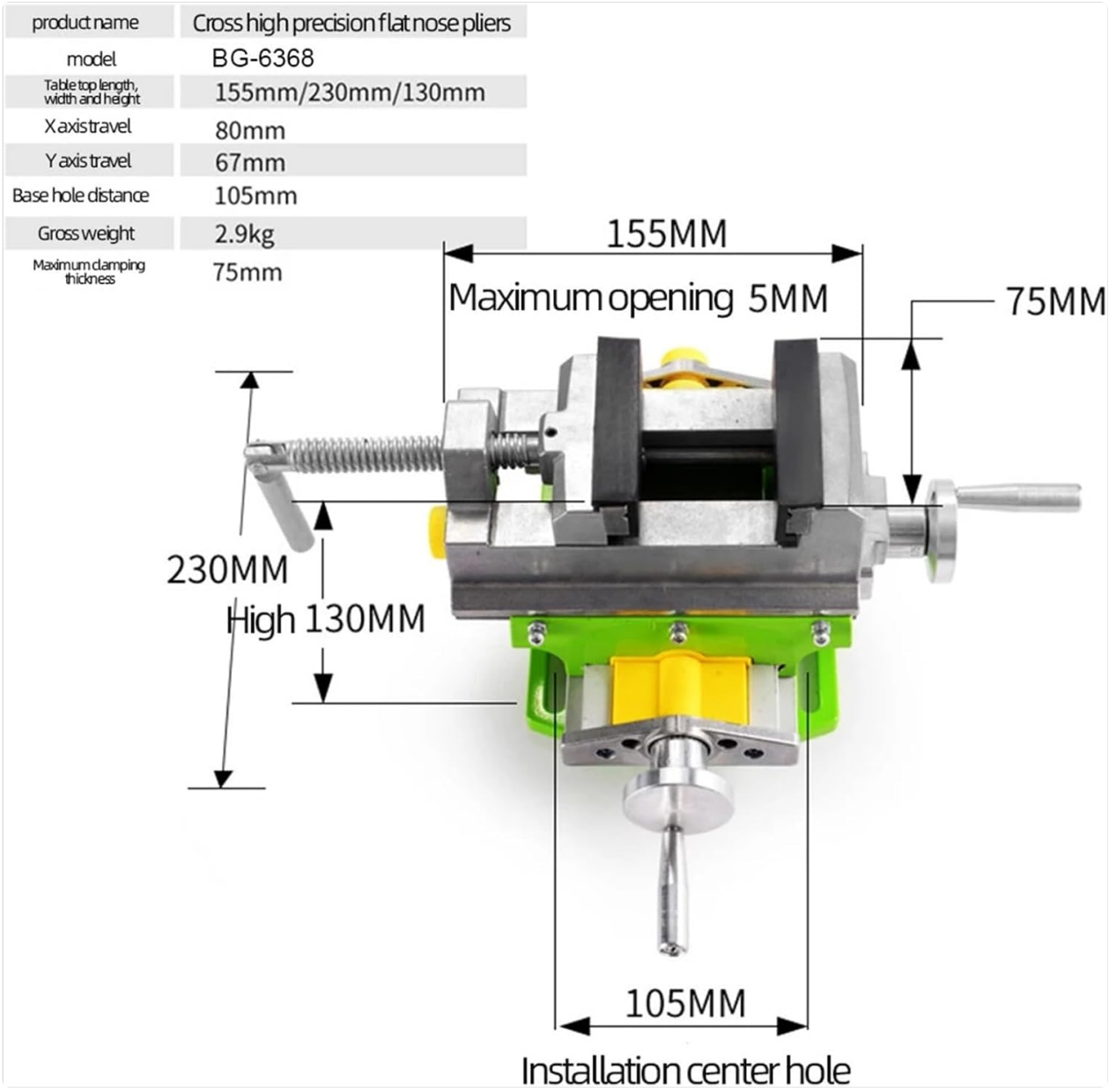

Figure 5: Dimensional diagram of the Allsome BG-6368 Cross-Sliding Vise.

9. Warranty and Support

For warranty information or technical support, please refer to the seller's policies or contact the manufacturer directly. Specific warranty details are not provided in this manual.

Manufacturer: WENBIXIA