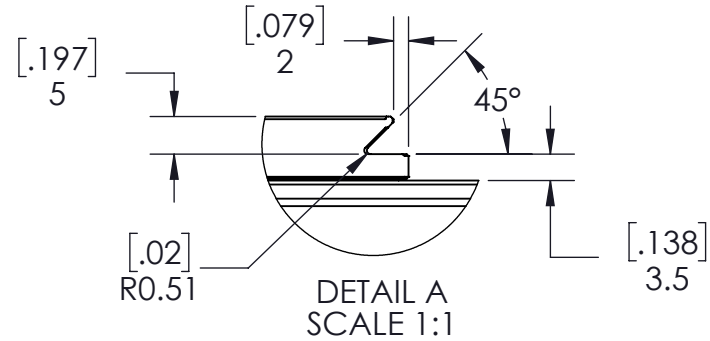
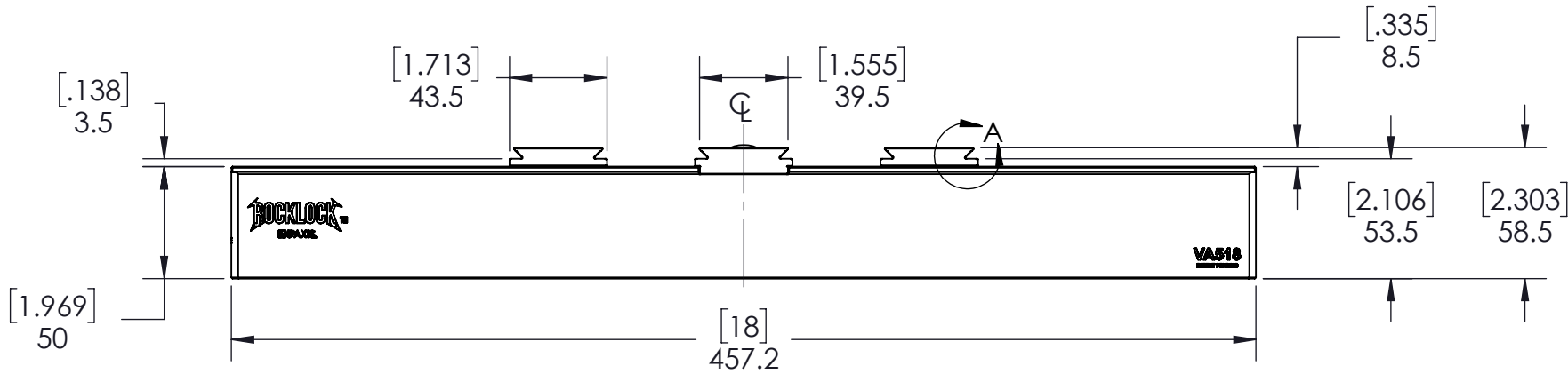
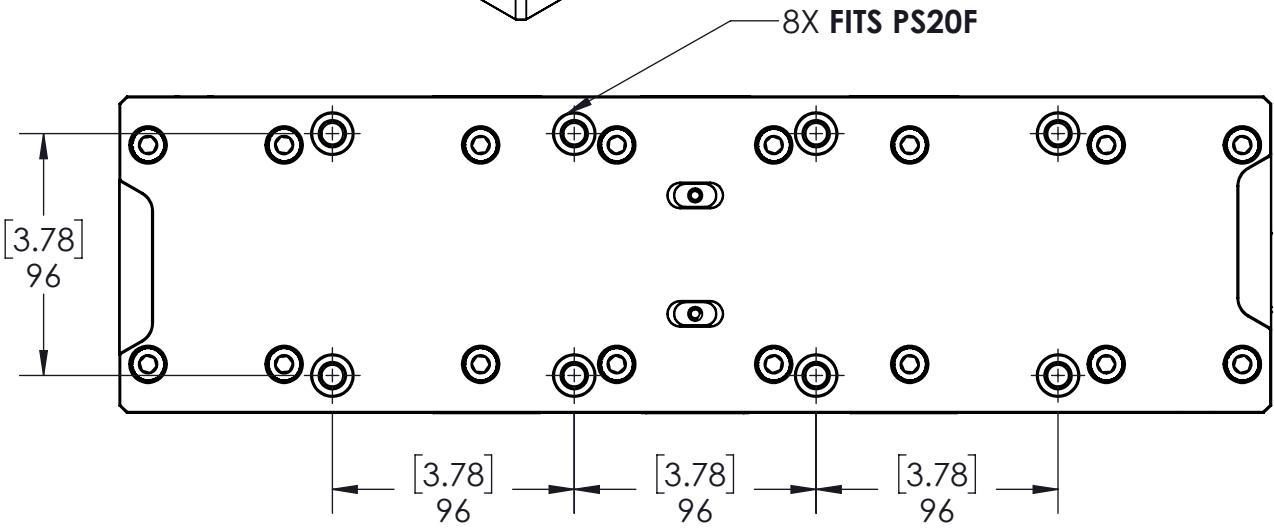
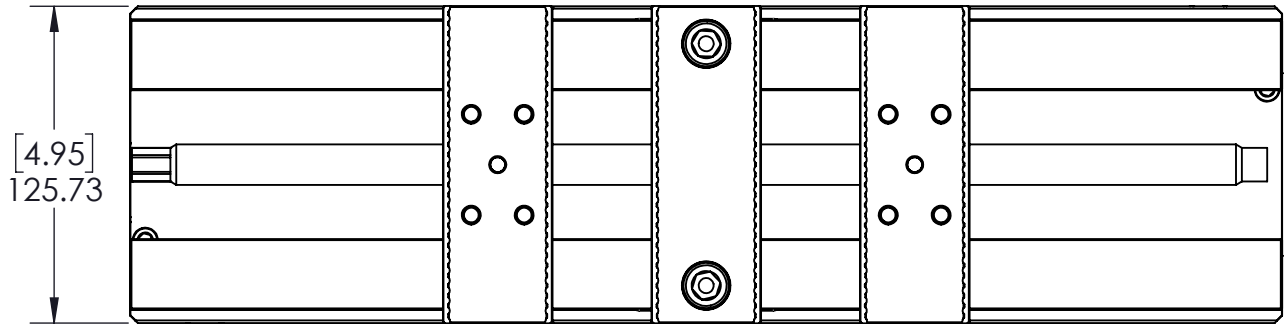
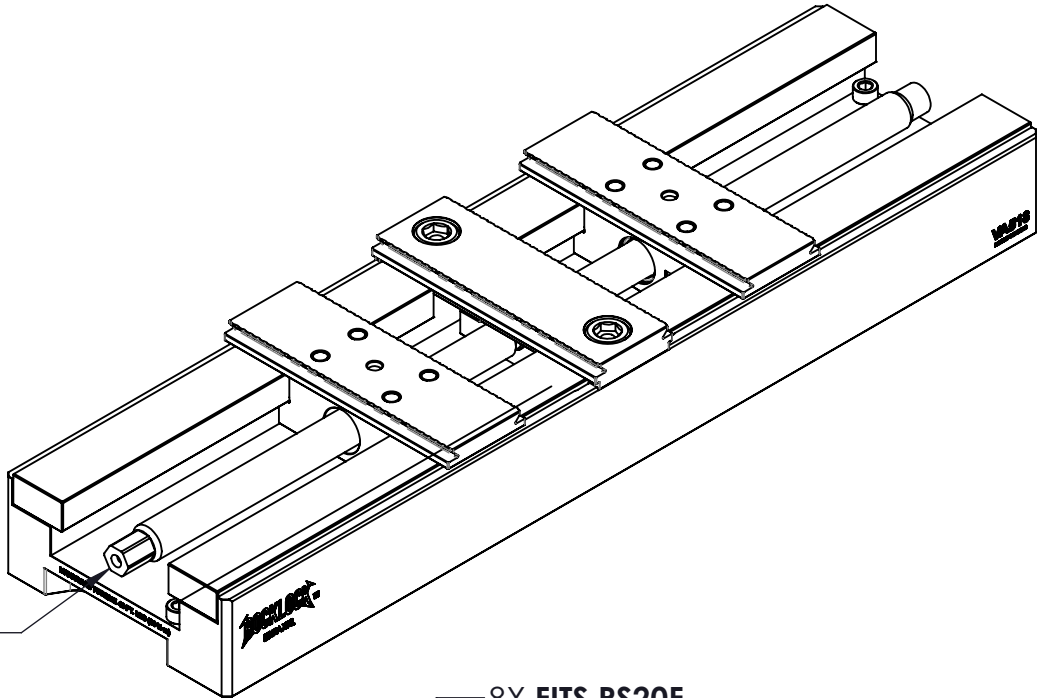
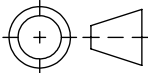
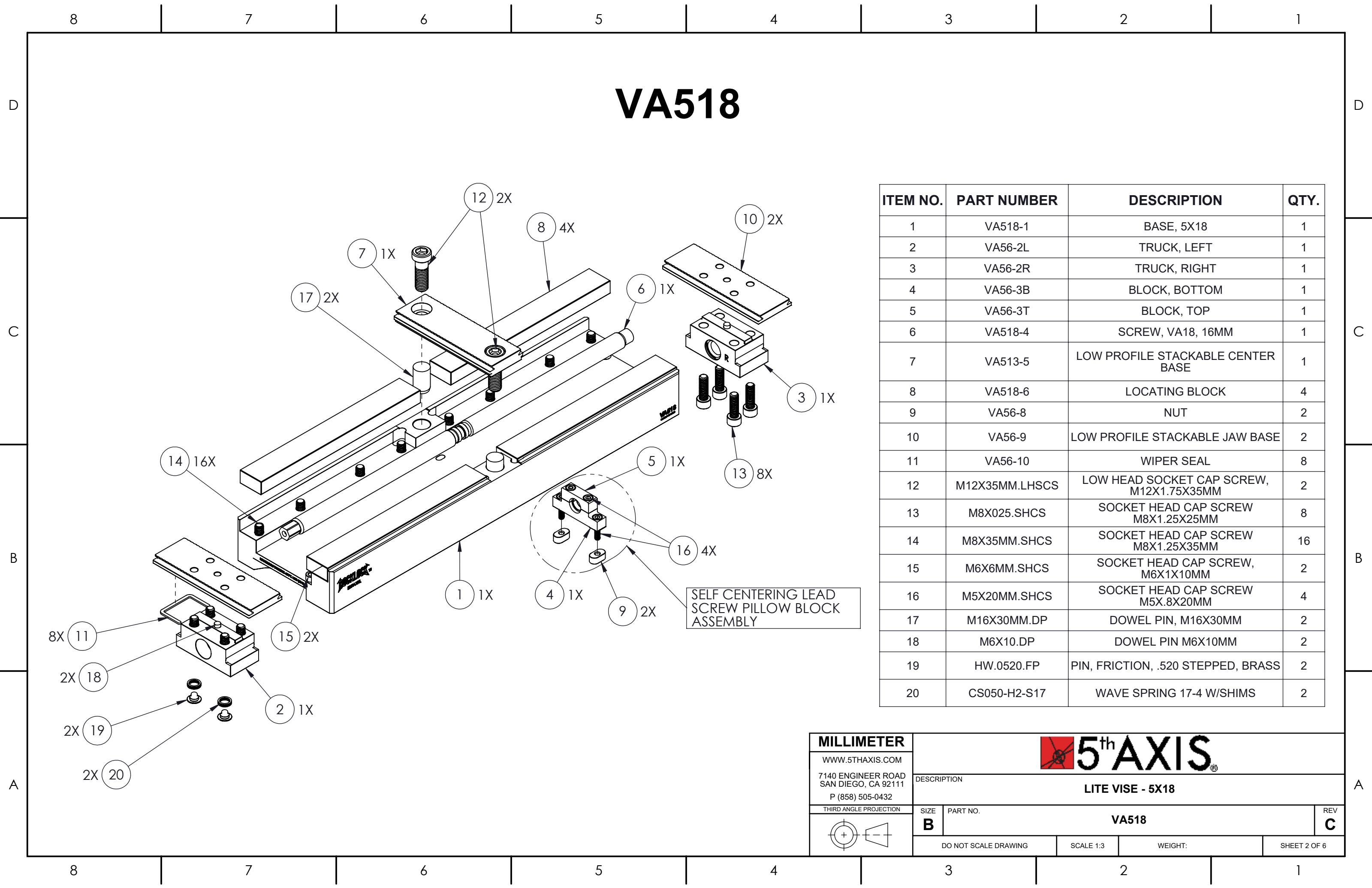


TECHNICAL DATA	VA518
JAW WIDTH	4.95" (125.73mm)
BASE LENGTH	18" (457.2mm)
CLAMPING FORCE	5000 lbf @ 45 ft-lb (22 kN @ 60 Nm)
MAXIMUM TORQUE (LEADSCREW)	45 ft-lb (60 Nm)

VA518



MILLIMETER				
WWW.5THAXIS.COM		DESCRIPTION		
7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432		LITE VISE - 5X18		
THIRD ANGLE PROJECTION		SIZE B	PART NO. VA518	REV C
		DO NOT SCALE DRAWING	SCALE 1:3	WEIGHT: 11.3 KG
		SHEET 1 OF 6		



VA518

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VA518-1	BASE, 5X18	1
2	VA56-2L	TRUCK, LEFT	1
3	VA56-2R	TRUCK, RIGHT	1
4	VA56-3B	BLOCK, BOTTOM	1
5	VA56-3T	BLOCK, TOP	1
6	VA518-4	SCREW, VA18, 16MM	1
7	VA513-5	LOW PROFILE STACKABLE CENTER BASE	1
8	VA518-6	LOCATING BLOCK	4
9	VA56-8	NUT	2
10	VA56-9	LOW PROFILE STACKABLE JAW BASE	2
11	VA56-10	WIPER SEAL	8
12	M12X35MM.LHSCS	LOW HEAD SOCKET CAP SCREW, M12X1.75X35MM	2
13	M8X025.SHCS	SOCKET HEAD CAP SCREW M8X1.25X25MM	8
14	M8X35MM.SHCS	SOCKET HEAD CAP SCREW M8X1.25X35MM	16
15	M6X6MM.SHCS	SOCKET HEAD CAP SCREW, M6X1X10MM	2
16	M5X20MM.SHCS	SOCKET HEAD CAP SCREW M5X.8X20MM	4
17	M16X30MM.DP	DOWEL PIN, M16X30MM	2
18	M6X10.DP	DOWEL PIN M6X10MM	2
19	HW.0520.FP	PIN, FRICTION, .520 STEPPED, BRASS	2
20	CS050-H2-S17	WAVE SPRING 17-4 W/SHIMS	2

MILLIMETER

WWW.5THAXIS.COM

7140 ENGINEER ROAD
SAN DIEGO, CA 92111

P (858) 505-0432

THIRD ANGLE PROJECTION

DESCRIPTION

LITE VISE - 5X18

SIZE

B

PART NO.

VA518

REV

C

DO NOT SCALE DRAWING

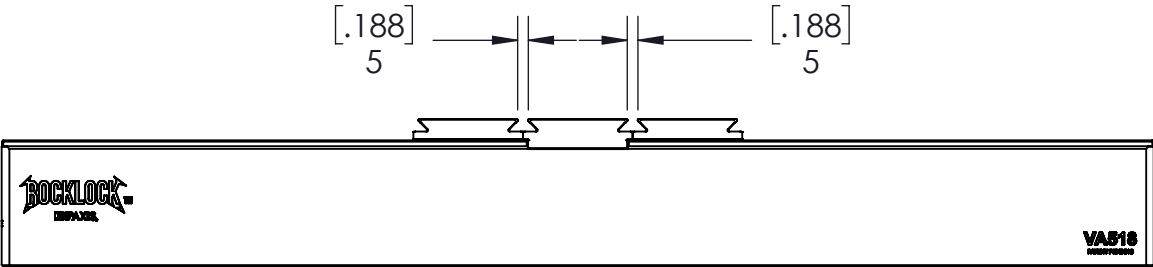
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WEIGHT:

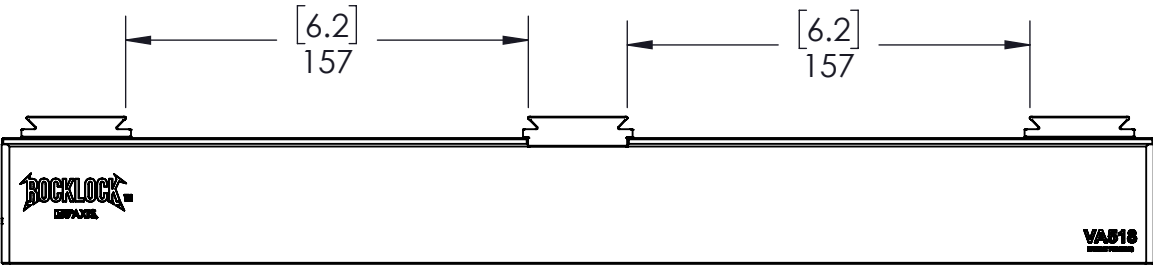
SHEET 2 OF 6

NOTES: USING DOVETAIL ALLOWS VISE TO CLAMP LARGER PART.
BELOW CLAMPING RANGE ONLY SHOWS THE CAPABILITY OF THE GRIPPER TEETH.

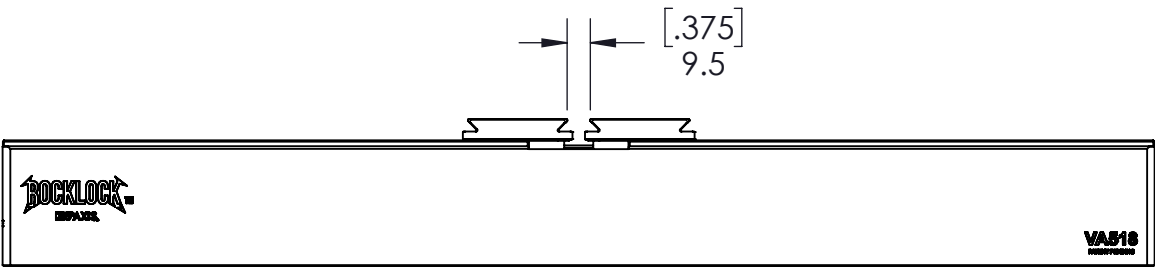
VA518



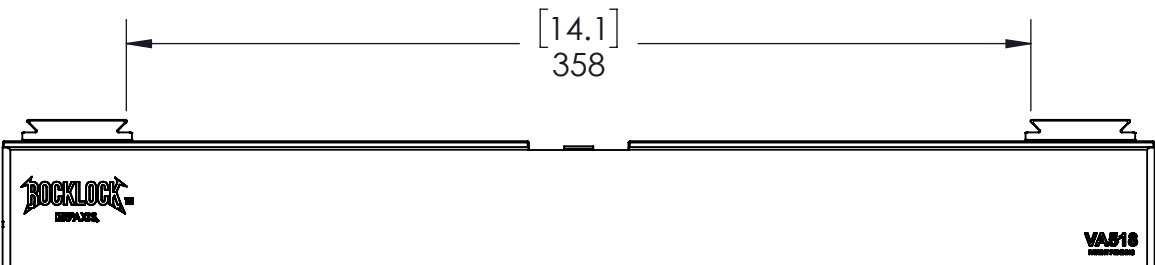
DOUBLE STATION (MINIMUM CLAMPING RANGE)



DOUBLE STATION (MAXIMUM CLAMPING RANGE)



SELF CENTERING (MINIMUM CLAMPING RANGE)

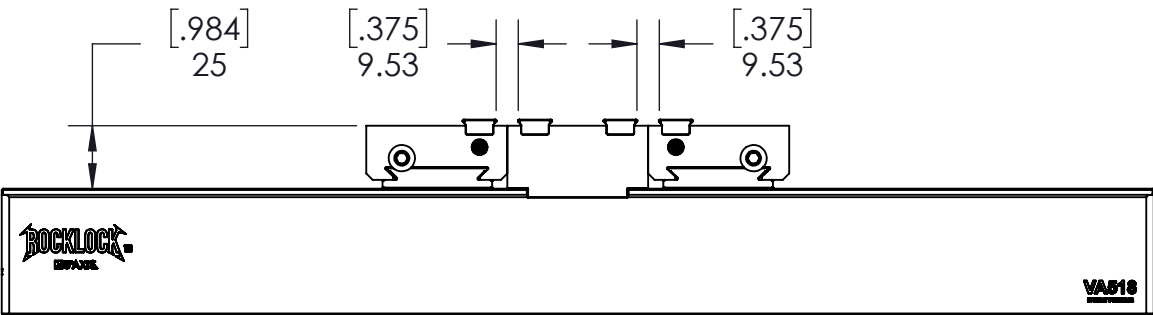


SELF CENTERING (MAXIMUM CLAMPING RANGE)

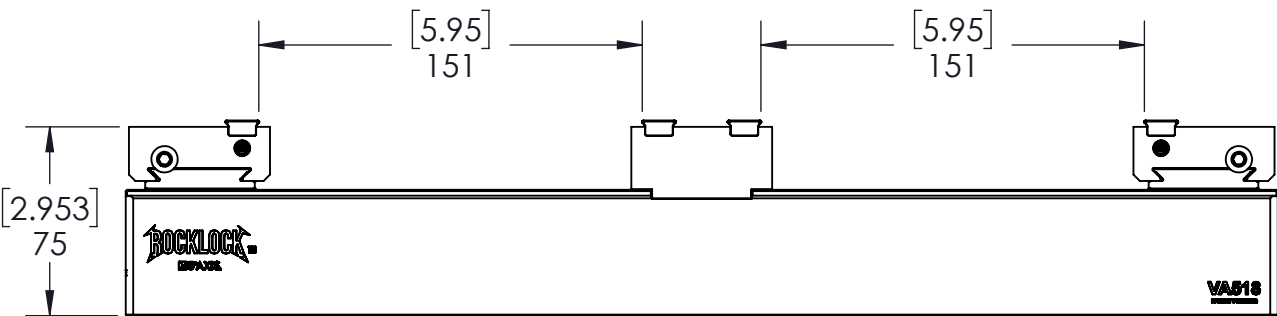
MILLIMETER WWW.5THAXIS.COM 7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432 THIRD ANGLE PROJECTION					
	DESCRIPTION LITE VISE - 5X18				
	SIZE B	PART NO. VA518			REV C
	DO NOT SCALE DRAWING		SCALE 1:3	WEIGHT:	SHEET 3 OF 6

NOTES: USING DOVETAIL ALLOWS VISE TO CLAMP LARGER PART.
BELOW CLAMPING RANGE ONLY SHOWS THE CAPABILITY OF THE GRIPPER TEETH.

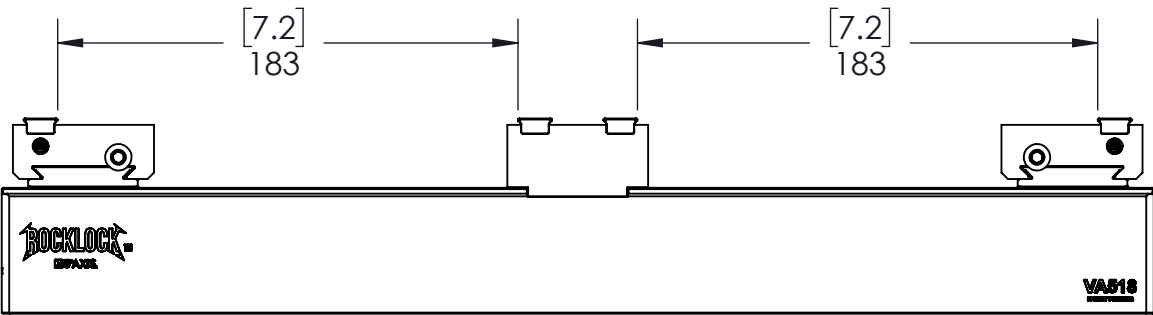
VA518 SHOWN W/ OPTIONAL VA513-GJ-A



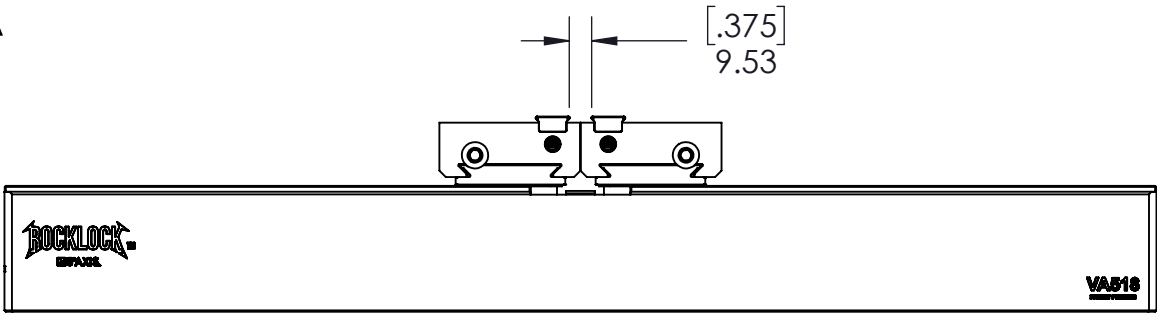
DOUBLE STATION (MINIMUM CLAMPING RANGE)



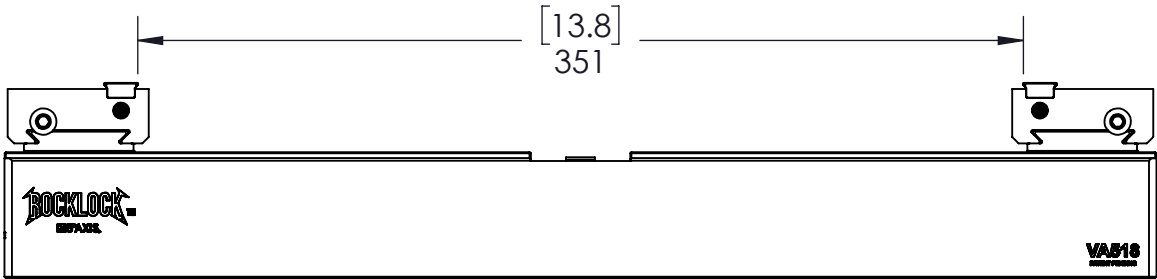
DOUBLE STATION (MAXIMUM CLAMPING RANGE)



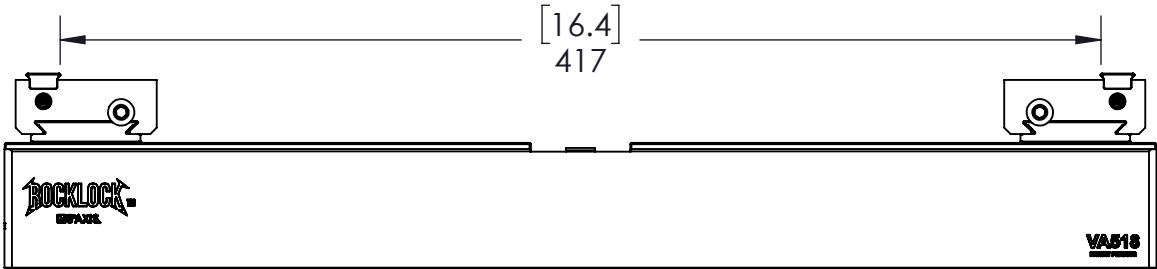
DOUBLE STATION W/JAWS REVERSED (MAXIMUM CLAMPING RANGE)



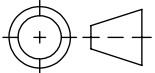
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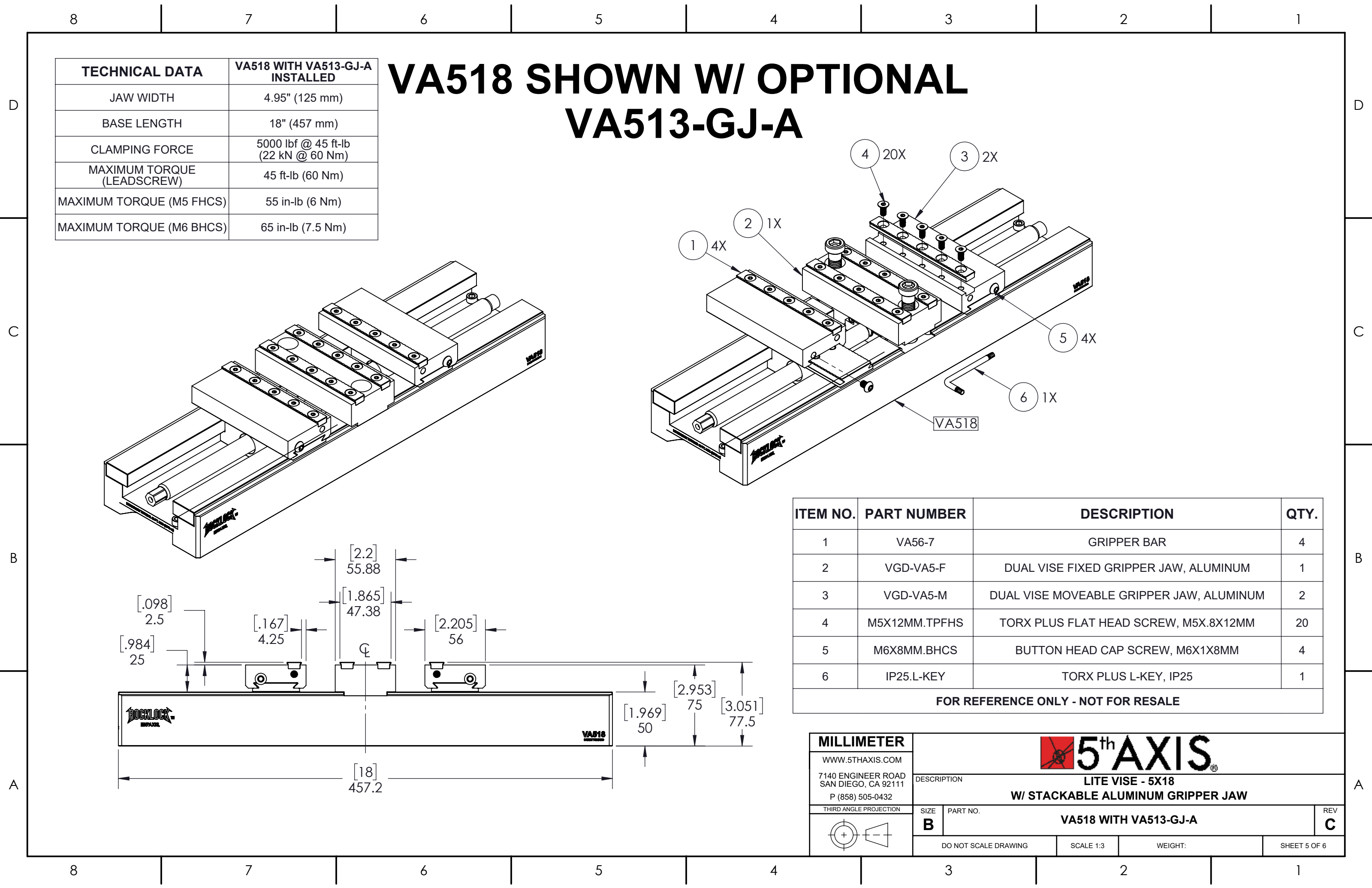


SELF CENTERING (MAXIMUM CLAMPING RANGE)



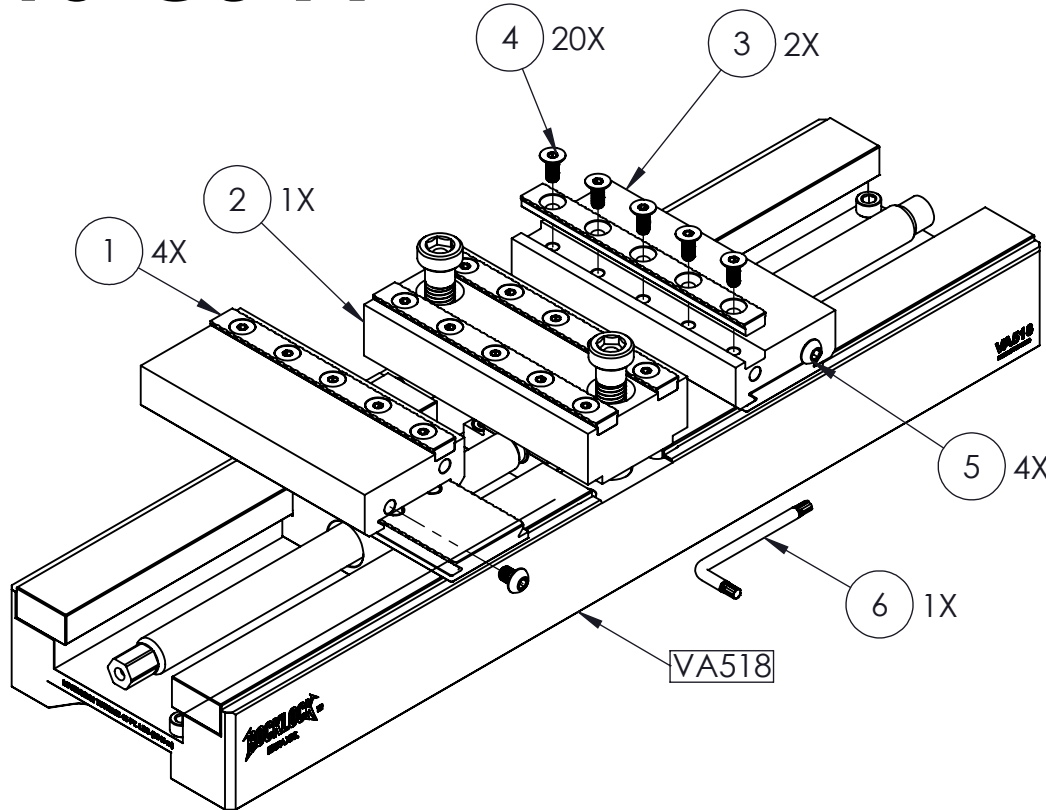
SELF CENTERING W/JAWS REVERSED (MAXIMUM CLAMPING RANGE)

MILLIMETER					
WWW.5THAXIS.COM		DESCRIPTION			
7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432		LITE VISE - 5X18			
THIRD ANGLE PROJECTION		SIZE B	PART NO. VA518		
		DO NOT SCALE DRAWING	SCALE 1:3	WEIGHT:	SHEET 4 OF 6
				REV C	

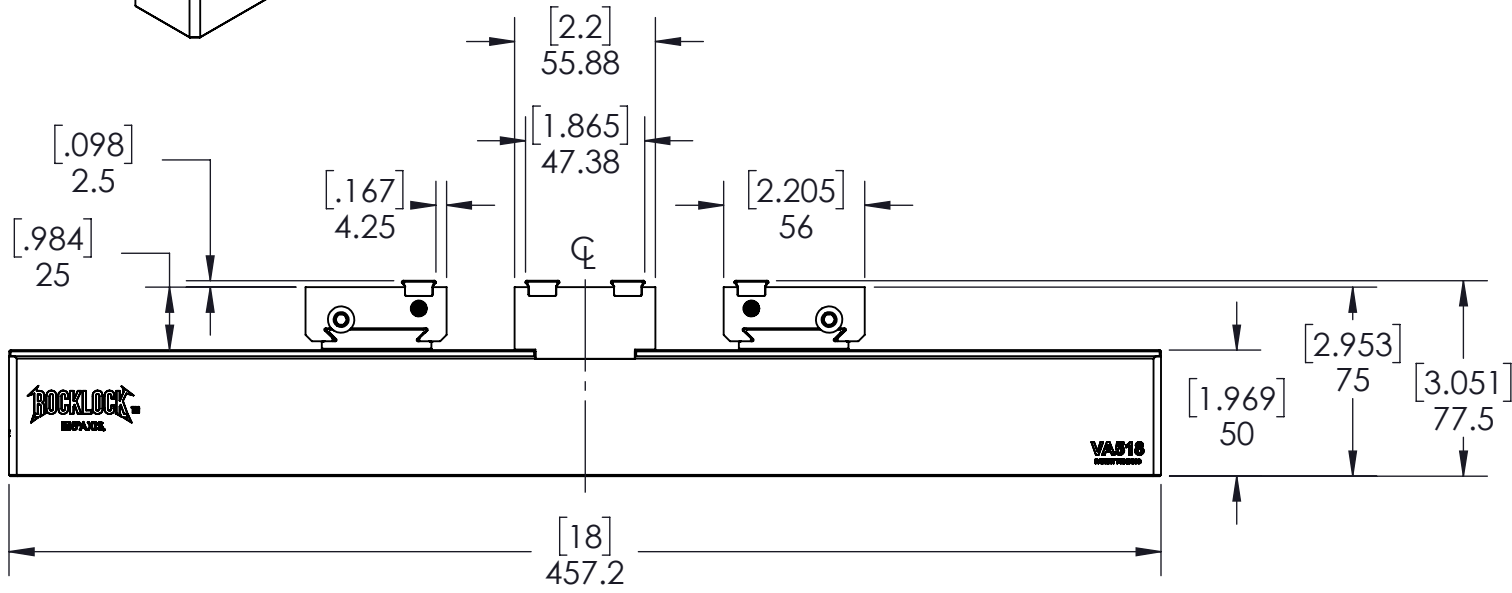


TECHNICAL DATA	VA518 WITH VA513-GJ-A INSTALLED
JAW WIDTH	4.95" (125 mm)
BASE LENGTH	18" (457 mm)
CLAMPING FORCE	5000 lbf @ 45 ft-lb (22 kN @ 60 Nm)
MAXIMUM TORQUE (LEADSCREW)	45 ft-lb (60 Nm)
MAXIMUM TORQUE (M5 FHCS)	55 in-lb (6 Nm)
MAXIMUM TORQUE (M6 BHCS)	65 in-lb (7.5 Nm)

VA518 SHOWN W/ OPTIONAL VA513-GJ-A



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	VA56-7	GRIPPER BAR	4
2	VGD-VA5-F	DUAL VISE FIXED GRIPPER JAW, ALUMINUM	1
3	VGD-VA5-M	DUAL VISE MOVEABLE GRIPPER JAW, ALUMINUM	2
4	M5X12MM.TPFHS	TORX PLUS FLAT HEAD SCREW, M5X.8X12MM	20
5	M6X8MM.BHCS	BUTTON HEAD CAP SCREW, M6X1X8MM	4
6	IP25.L-KEY	TORX PLUS L-KEY, IP25	1
FOR REFERENCE ONLY - NOT FOR RESALE			



MILLIMETER

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7140 ENGINEER ROAD
SAN DIEGO, CA 92111

P (858) 505-0432

THIRD ANGLE PROJECTION

DESCRIPTION

LITE VISE - 5X18
W/ STACKABLE ALUMINUM GRIPPER JAW

SIZE
B

PART NO.
VA518 WITH VA513-GJ-A

REV
C

DO NOT SCALE DRAWING

SCALE 1:3

WEIGHT:

SHEET 5 OF 6

8 7 6 5 4 3 2 1

D

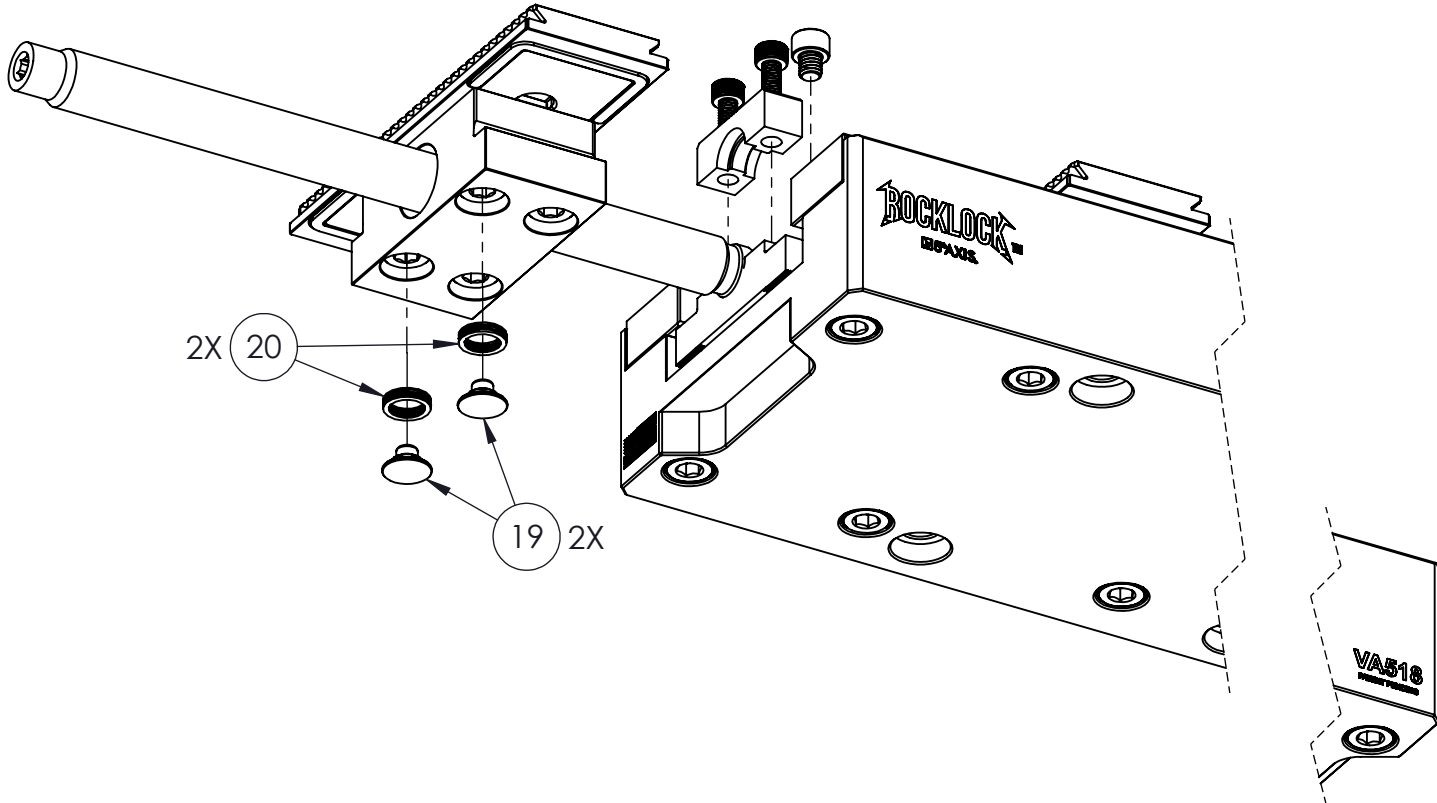
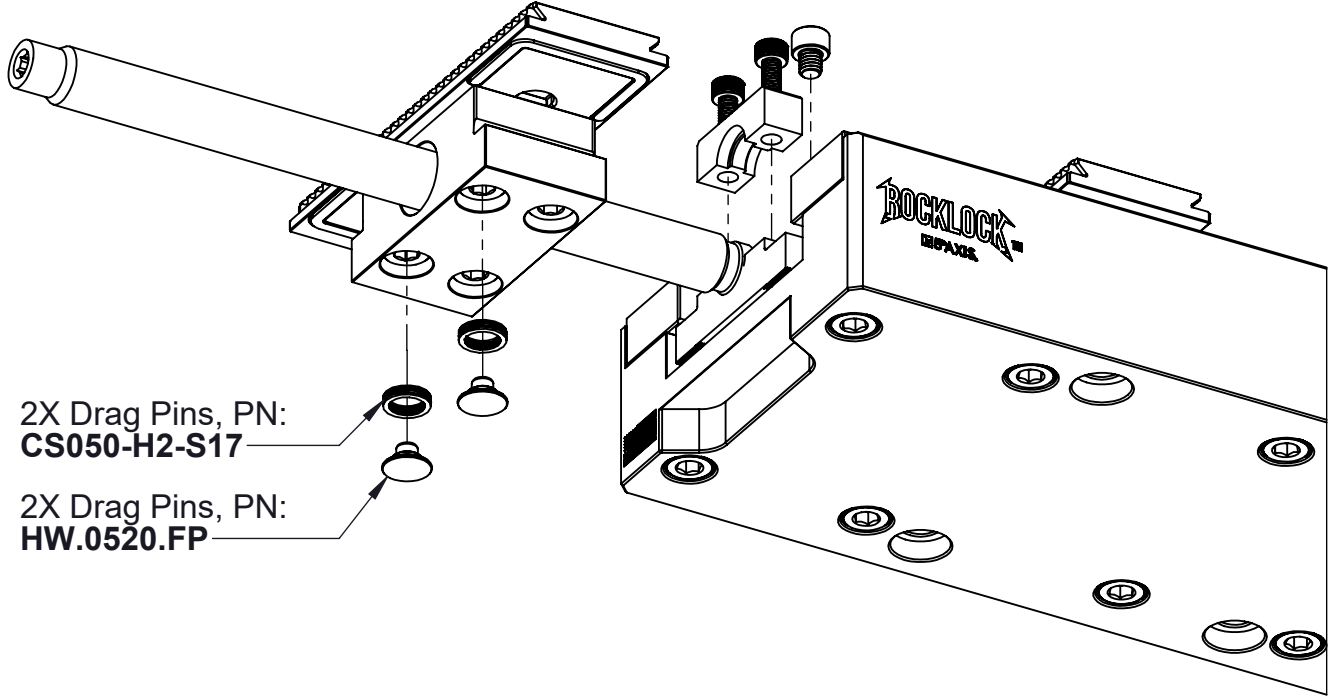
VA518

DRAG PIN & SPRING DETAIL

C

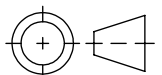
B

A



The latest revision of VA513 and VA518 include 2x Drag Pins and Compression Springs (shown above) to provide friction when vise is used in a vertical orientation, so the trucks do not slide freely (in dual station configuration only).

Use caution when sliding truck and jaw assembly partially out of base during maintenance or conversion between dual station and self-centering configurations, as these components will eject themselves. Upon re-installation of the truck and lead screw assembly, the pins and springs must be assembled as shown, and compressed as the truck is slid into the base. Pins and springs can be installed in any or all of the jaw bolt counterbores on the underside of the trucks for more or less friction. Replacement pins and springs are available to purchase separately.

MILLIMETER					
WWW.5THAXIS.COM		DESCRIPTION LITE VISE - 5X18 - DRAG PIN DETAIL			
7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432					
THIRD ANGLE PROJECTION		SIZE	PART NO.		REV
		B	VA518		C
		DO NOT SCALE DRAWING		SCALE 1:2	WEIGHT:
				SHEET 6 OF 6	