

User guide

HRK 44, HRK 58, HRK 90, HRK 165, HRK 260
HRK 44 UKB, HRK 58 UKB, HRK 90 UKB, HRK 165 UKB, HRK 260 UKB

The HRK and HRK UKB Centring vice have been specifically developed from the DERO Feinmechanik AG for the reliable clamping of unmachined parts by stepped jaws with claws without pre-stamping or for the second clamping with stepped jaws.

The centring vices have been developed for use on 5-axis machining centres such as CNC milling machines for the individual part clamping and for pallet clamping on clamping systems.

The special feature of the centring vice is the central clamping which is achieved with a spindle with right and left thread.

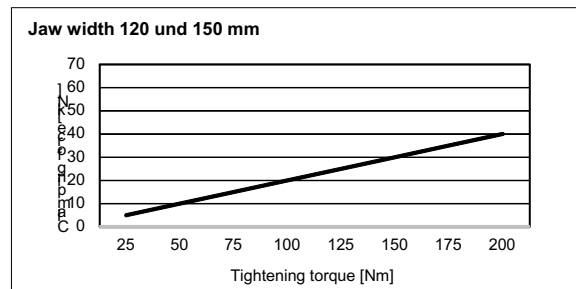
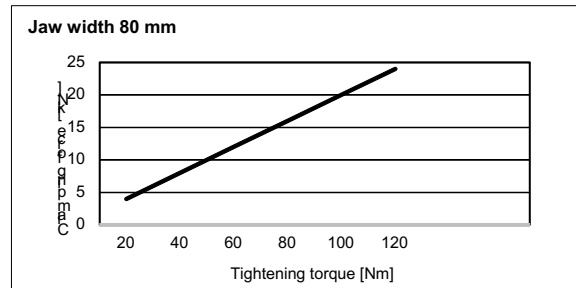
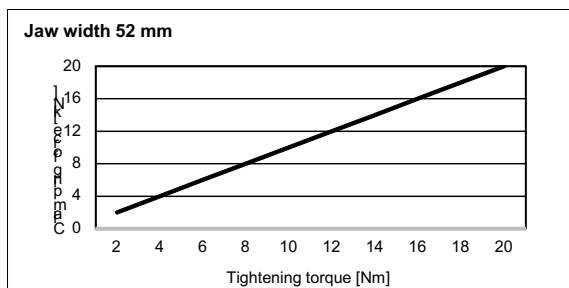
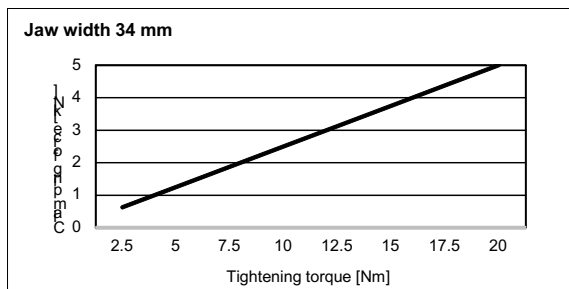
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The centring vice can either be clamped onto the machine table on the side circumferential groove with clamping claws or screwed onto the pallet by centring bolts and fastening screws. Attachment is also possible by customised bores and threads on the underside of the centring vice.

For tightening and loosening of the centring vice the use of a torque wrench is recommended. A reliable clamping can only be guaranteed through tightening with a torque wrench.

Jaw width (mm)	Wrench width (mm)	Maximum permissible tightening torque (kN)	Maximum clamping force (kg)
34	5.5	20	500
52	7	40	1600
80	10	120	2400
120	16	300	6000
150			

Clamping forces and tightening torques

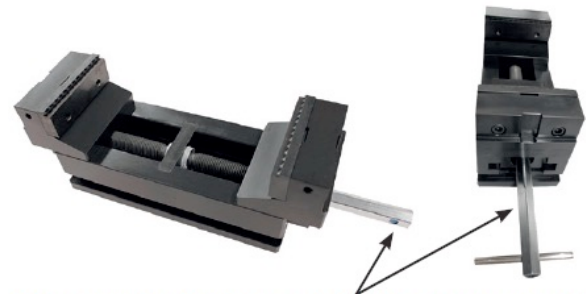


Maintenance

The centring vice is a quality product. To guarantee its functioning for many years, the centring vice must be disassembled, cleaned, and lubricated according to instructions.

Instructions for disassembling and for turning the reversible jaws

- » Disassemble the jaws.
- » Disassemble the jaw holders through complete unscrewing of the spindle with the supplied socket wrench (see photo). As an alternative to the socket wrench, the spindle can also be unscrewed by using a M3 screw screwed into the front end side of the spindle.
- » Take out the spindle fixing bridge (only for maintenance). Loosen the 2 screws on the underside of the vice and pull out the fixing bridge.
- » Clean all the parts. Pay special attention to the pushed in chips and remove them.
- » Lubricate the fixing bridge and the spindle collar with grease.
- » Oil the guides lightly with slideway oil.
- » Oil the spindle at the threads with slideway oil. (no grease!)
- » Assemble all parts in the reverse order. Make sure that the spindle engages with both jaw holders at the same time.



Socket wrenches for disassembling and changing the jaw holders