

BY GRS®



QC ADVANCED SET

#500-517 • INSTRUCTIONS

MASTER JAWS

INSTRUCTIONS

Instructions apply to the following product(s):



500-018

IMPORTANT NOTE:

The MicroBlock® and MicroBlock® XL Jura by GRS sets include a pair of Master Jaws instead of the original jaws with pin holes.

Skip to **Installation of Master Jaws** unless you need to remove original MicroBlock jaws from a previously purchased vise.

Products that include Master Jaws instead of original MicroBlock jaws:

#500-508, #500-510, #500-517,
#500-526, #500-527

✓ Included with this set.

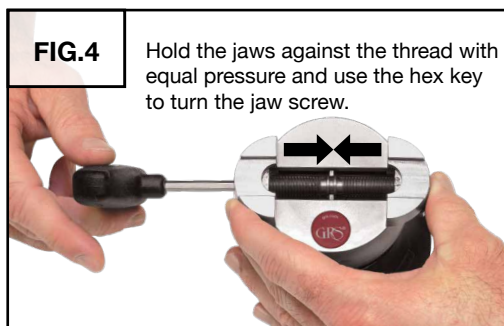
♦ Not included with this set. Available separately.

Removal of Original MicroBlock® Jaws

Skip to **Installation of Master Jaws** unless you need to remove original MicroBlock jaws from a previously purchased vise.



Installation of Master Jaws



Microblock® shown with Jura Master Jaws #500-018
(See instructions for installation on pg 2).

MICROBLOCK® WITHOUT JAWS

INSTRUCTIONS AND PARTS LIST

FIG.1

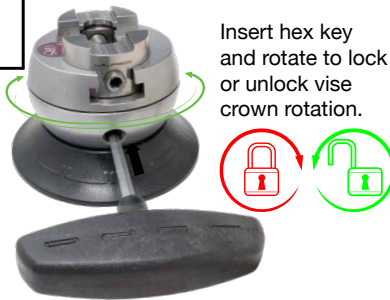
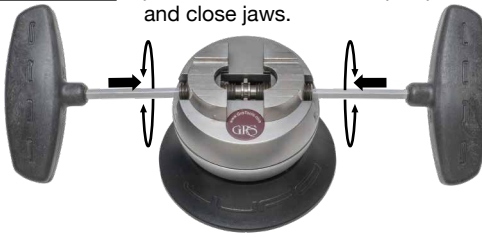


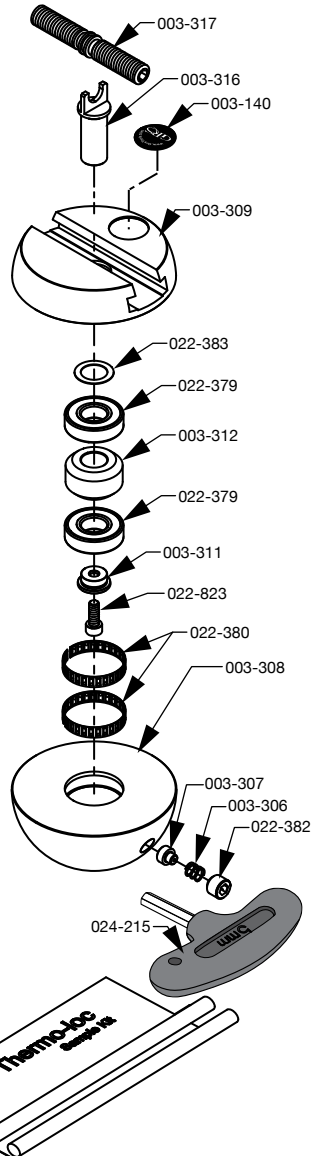
FIG.2

Insert hex key into either end of jaw screw and rotate to open jaws and close jaws.



| PART # | DESCRIPTION | QTY |
|---------|---------------------------------|-----|
| 002-067 | 10-32 x 1/2" SHCS | 1 |
| 003-140 | GRS Label | 1 |
| 003-306 | Drag Spring | 1 |
| 003-307 | Lock Pin | 1 |
| 003-308 | Stainless Steel 80 mm Base | 1 |
| 003-309 | Crown | 1 |
| 003-311 | Bearing Retainer | 1 |
| 003-312 | Bearing Spacer Brake Rotor | 1 |
| 003-316 | Jaw Screw Yoke | 1 |
| 003-317 | Jaw Screw | 1 |
| 003-679 | Thermo-Loc Sample Kit | 1 |
| 022-379 | Shielded Bearing | 2 |
| 022-380 | Tolerance Ring | 2 |
| 022-382 | Flat Nose Set Screw | 1 |
| 022-383 | .015" x .513" x .750" SS Washer | 1 |
| 024-215 | T-Wrench 5 mm Hex | 1 |

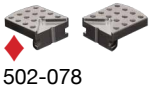
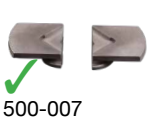
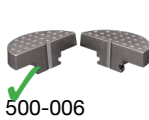
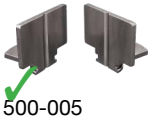
006-510-LJ



SEATED QC FIXTURES

INSTRUCTIONS

Instructions apply to the
following product(s):



✓ Included with this set.

◆ Not included with this set. Available separately.

Fixture Attachment



BOTTOM



SIDE



ANGLE

Master Jaw Seat



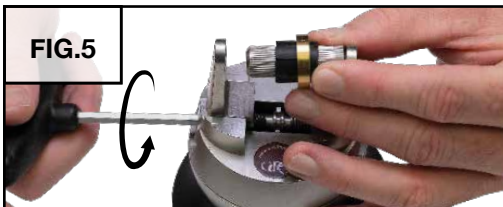
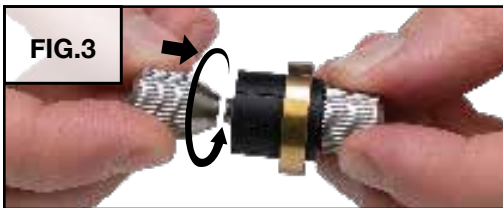
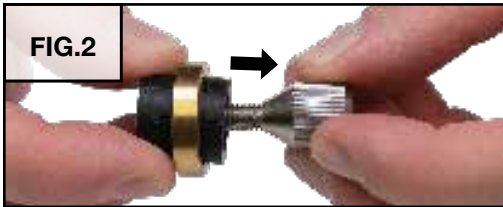
Fixture Installation

FIG.1



FIG.2





INSIDE RING HOLDER SCREW SET

INSTRUCTIONS

Instructions apply to the
following product(s):



✓
500-011

SHELLAC CYLINDER

INSTRUCTIONS

Instructions apply to the
following product(s):



502-015



Follow the shellac instructions to apply shellac
and workpiece to cylinder.

THERMO-LOC® CYLINDER

INSTRUCTIONS

Instructions apply to the
following product(s):



502-502



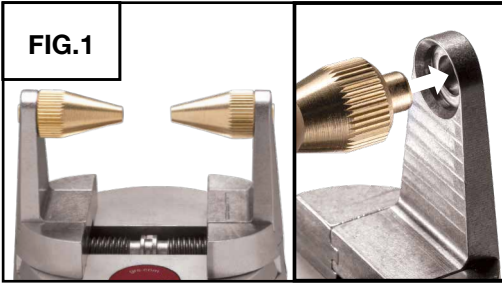
Follow the Thermo-Loc® instructions to apply
Thermo-Loc® and workpiece to cylinder.

✓ Included with this set.

♦ Not included with this set. Available separately.

Fixture Installation

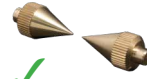
FIG.1



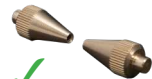
POINTED AND TAPERED BALL HOLDERS

INSTRUCTIONS

Instructions apply to the
following products:



500-506



500-507

Fixture Usage

FIG.2

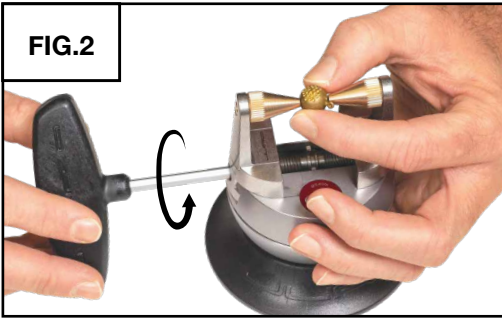


FIG.3

Use the pointed
ball holders
(#500-506) with
workpieces that
have holes in
each side. The
points will rest
in the holes.



FIG.4

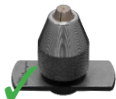
Use the tapered
ball holders
(#500-507)
with round
workpieces.



ROUND-BASE QC FIXTURES

INSTRUCTIONS

Instructions apply to the
following product(s):



500-501



502-501

Fixture Attachment



BOTTOM



SIDE



ANGLE

Fixture Installation

FIG.1

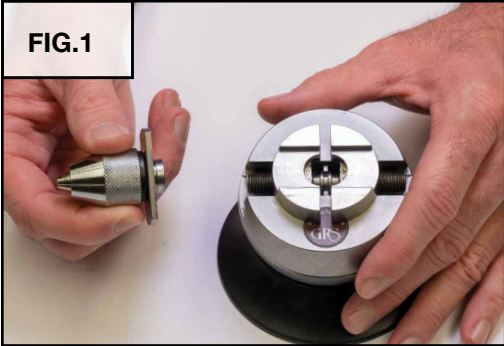
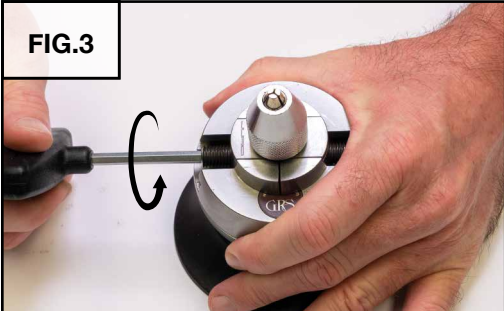


FIG.2

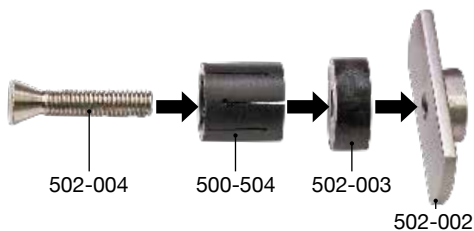


FIG.3



✓ Included with this set.

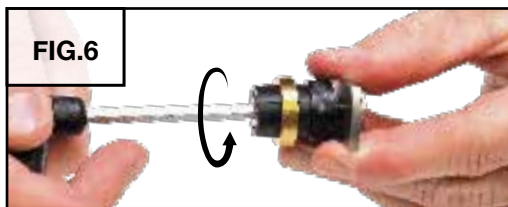
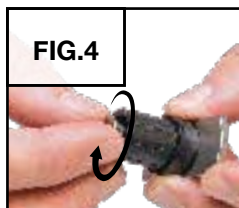
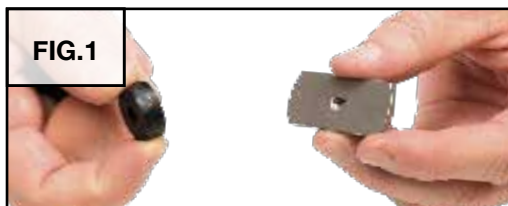
♦ Not included with this set. Available separately.



VERTICAL RING HOLDER

INSTRUCTIONS

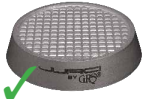
Instructions apply to the following product(s):



QC SHELLAC PLATE

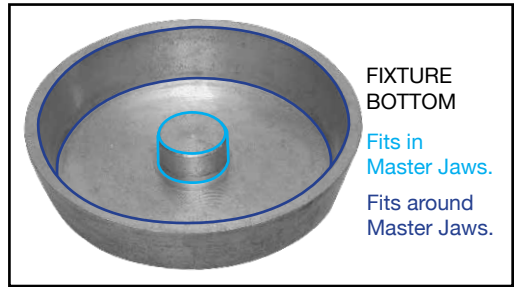
INSTRUCTIONS

Instructions apply to the
following product(s):



500-014

Fixture Attachment



Fixture Installation

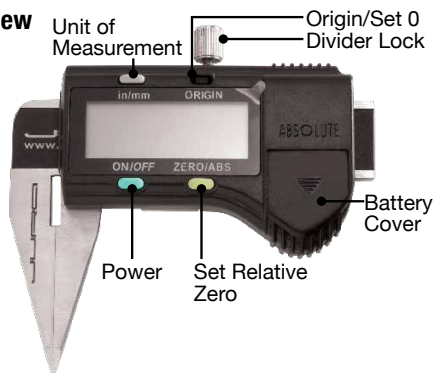


✓ Included with this set.

♦ Not included with this set. Available separately.

Follow the shellac instructions to apply shellac
and workpiece to cylinder.

Overview



DIGITAL DIVIDER

INSTRUCTIONS

Instructions apply to the following product(s):



523-021

Battery Installation

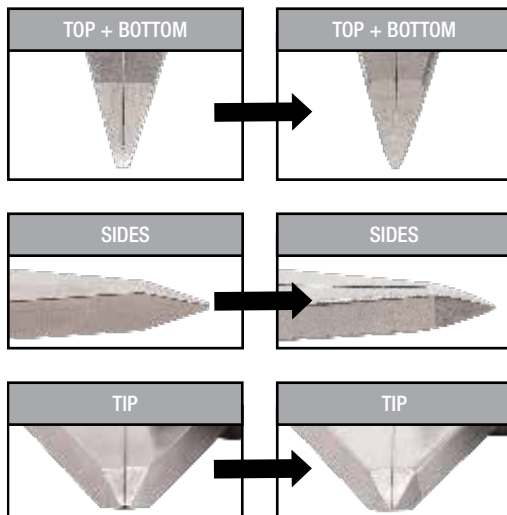


Divider Sharpening

Divider must be sharpened to use for marking metal. Use rotary handpiece diamond wheels (#023-123 and #023-120) to sharpen. With divider jaws closed, grind away excess metal to form point.

Unsharpened

Sharpened



ORGANIZERS WITH TAPE ATTACHMENT

INSTRUCTIONS

Instructions apply to the following product(s):



500-523



500-524



502-034



502-045



523-011



523-012



523-013



523-029



523-030

FIG.1



FIG.2



FIG.3



FIG.4



FIG.5



FIG.6

Place organizer where desired and press firmly for 60 seconds.



✓ Included with this set.

♦ Not included with this set. Available separately.

FIG.1

Hold the organizer where you would like it to be attached and mark where the screw holes will be.



FIG.2

Drill $\frac{7}{64}$ " diameter pilot holes, $\frac{5}{8}$ " deep in the spots you marked.



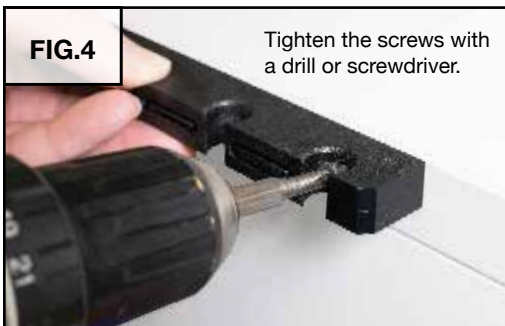
FIG.3

Place the screws in the holes.



FIG.4

Tighten the screws with a drill or screwdriver.



ORGANIZERS WITH SCREW ATTACHMENT

INSTRUCTIONS

Instructions apply to the
following product(s):



523-014

NOTES

