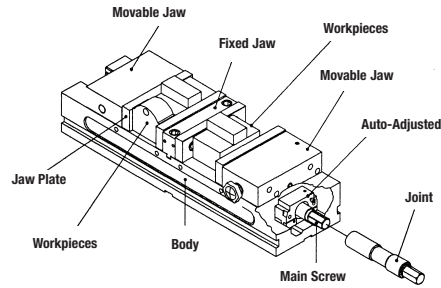


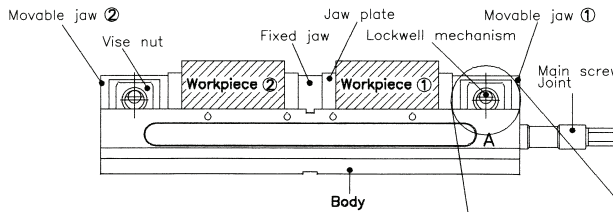
## Double Clamp Vise

- Double clamp set - one handle can simultaneously operate two moveable jaws and clamps 2 workpieces of same or different size or one large workpiece
- This model can increase efficiency and productivity of CNC machines
- The movable jaw ANTI-LIFT mechanism provides alignment to workpiece without jaw lift
- There are 6 kinds of clamping ways to meet workpieces of different shapes and sizes
- The whole body is precisely ground and height tolerance is within  $\pm 0.025\text{mm}$  ( $\pm 0.001''$ ), therefore several vises can be lined up for production
- The vise is made of FDC-80.000 psi (55kg/cm<sup>2</sup>) Ductile iron, and slide ways are hardened to 45HRC
- The rigid construction prevents base distortion
- Precision made to high accuracy standard

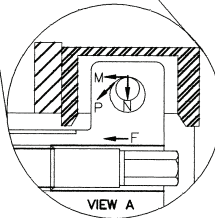
Model No.	Code No.	Price \$
4" - TLD-40G/HV	382610	1,718.00
6" - TLD-60G/HV	382600	2,260.00



## ANTI-LIFT MECHANISM



- Clamping force equalization and ANTI-LIFT mechanism features virtually eliminate the deflection of fixed centre jaw and movable jaw lift
- Clamping range for clamping 2 workpieces simultaneously is 125 mm (4.9") each or 275 mm (10.8") for one large workpiece
- Double clamp seat



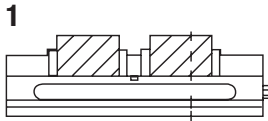
### ANTI-LIFT Mechanism

- M: Jaws forward movement force
- N: Gravity
- P: Resultant 45° component force forces the workpiece down while clamping
- F: Direction of jaw movement

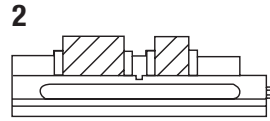


GS Double Clamp Vise  
(TLD-40G/HV, TLD-60G/HV)

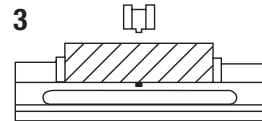
## Clamping Examples For Different Applications:



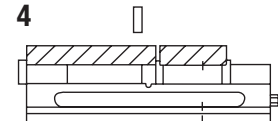
Clamping 2 pieces of same size workpieces.  
Max. Capacity: 90mm (3.5")  
125mm (4.9")



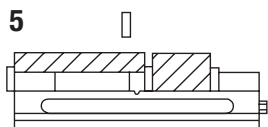
Clamping 2 pieces of different size of workpieces.  
Max. Capacity: 90mm (3.5")  
125mm (4.9")



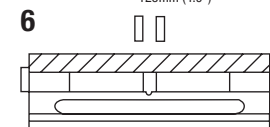
Large workpieces are able to be clamped after moving fixed jaw.  
Max. Capacity: 237mm (9.3")  
1315mm (12.4")



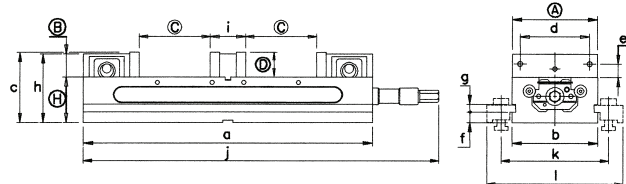
Stepped jaw plate for thin workpiece.  
Max. Capacity: 215mm (8.4")  
275mm (10.8")



Clamping 2 different workpieces.  
Max. Capacity: 215mm (8.4")  
275mm (10.8")



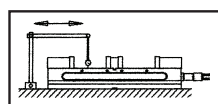
Large thin workpiece is able to be clamped after removing jaw plate on fixed jaw.  
Max. Capacity: 405mm (15.9")  
520mm (20.5")



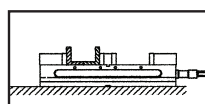
## Dimensional Information For Double Clamp Visers:

Model No.	A	B	C	D	a	b	c	d	e	f	g	h	H	i	j	k	l	Guide Block	Weight (kg/lb)
TLD-40G	103	33	90	38	405	104	101.5	63.5	17.5	13	31	96.5	63.5	55	430	143	195	18	20
(TLD-40HV)	4.05	1.29	3.54	1.49	15.9	4.09	3.99	2.5	0.68	0.51	1.22	3.79	2.5	2.16	16.9	5.62	7.67	0.709	44
TLD-60G	152	41.5	125	44.5	520	154	123.5	98.42	23.8	18	16	126.5	82.55	64	639	193	245	18	48
(TLD-60HV)	5.98	1.6	4.9	1.75	20.47	6	4.98	3.87	0.94	0.7	0.63	4.86	3.25	2.52	25.15	7.59	9.64	0.709	105.6

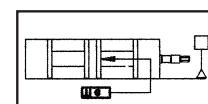
## TLD-40G, TLD-60G; match vise, TLD-40HV, TLD-60H (horizontal and vertical 2 way) Inspection Specification:



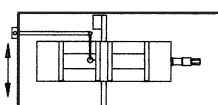
- 1 Parallelism: running face to bottom of bed.  
Guaranteed: 0.01 mm (0.0004")



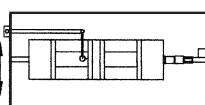
- 2 Squareness: between running face and jaw plate.  
Guaranteed: 0.03 mm (0.0012")



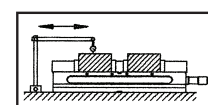
- 3 Squareness both sides to fixed jaw plate.  
Guaranteed: 0.02 mm (0.0008")



- 4 Parallelism: keyways on bottom of bed to jaw plate.  
Guaranteed: 0.02 mm (0.0008")



- 5 Squareness: keyways on bottom of bed to jaw plate.  
Guaranteed: 0.02 mm (0.0008")



- 6 Parallelism: running face of the test block to bottom.  
Guaranteed: 0.02 mm (0.0008")