



DOUBLE CLAMP VICE DV78 AND DV126

USER MANUAL



1. Description

- Double clamp vice NGV DV78 and DV126 produced by NOVA GRUP VICES is recommended for serial production and also for small batches production.
- The different body length and reverse jaws ensures a wide clamping range.
- The DV78 is designed to be fix on □52 Zero point system plate while the DV126 can be fixed on the horizontal machine table using the side channels on the body and with the four centering pins can also be mounted on a □96 Zero point system.

2. Safety precautions

- Before starting the machine tool process it has to be excluded any possibility of collision with the vice.
- Set the vice firmly on the machine table with clamps and bolts or on the Zero point plates.
- In order to correctly and safely use the vice, it is necessary to correlate the following factors: clamping force, cutting regime, the contact surface between parts and jaws and the rigidity of working piece.

3. Maintenance and Use

- Clean lead screw with soft brush.
- Do not let chips build up during use.
- Do not torque vice past 70Nm for DV78 or 100Nm for the DV126.
- At regular intervals oil or grease the lead screw.
- Do not side load the vice (See illustration below).
- **When clamping parts on both sides of the vice the clamping dimension should not have a difference more then 1mm.**

4. Special notes:

Failure to follow these instructions will cause self centering accuracy and/or repetability to fail and may cause damage to the vice.

