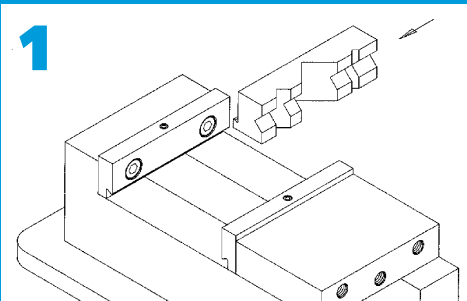


QuickChange Vise Jaw System



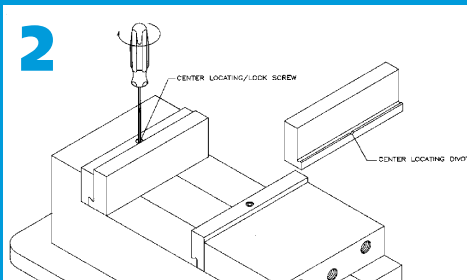
- Fast, accurate and versatile
- Drastically reduces setup time
- Adaptable to most vise systems

1



To install the QuickChange System, simply attach the master jaws to your carrier jaw system using the industry standard bolt pattern provided. Align the accessory's gib with the master jaw's dovetail and slide into position.

2



After the accessory is in position simply tighten the provided locking/self-centering screw to secure and locate properly. You are now ready to fixture your workpiece.

TOOLEX®

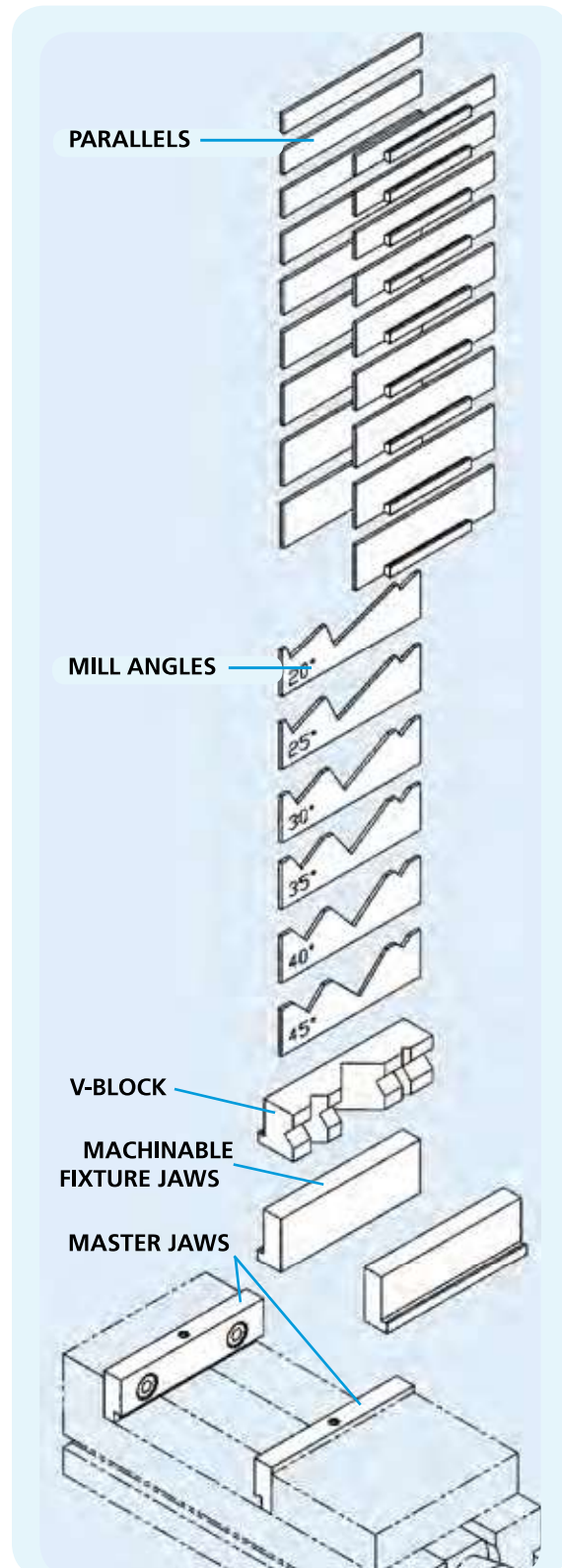
PARALLELS

MILL ANGLES

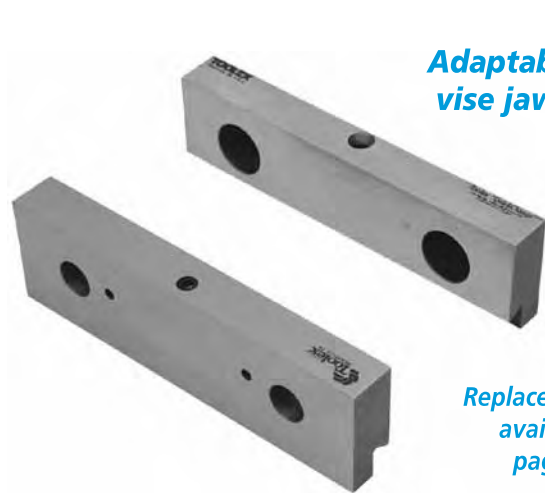
V-BLOCK

MACHINABLE
FIXTURE JAWS

MASTER JAWS

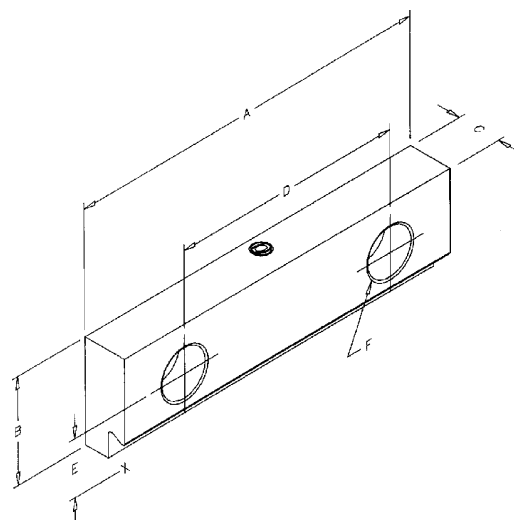


QuickChange Master Jaws



**Adaptable to most
vise jaw systems!**

**Replacement parts
available on
page 201.**

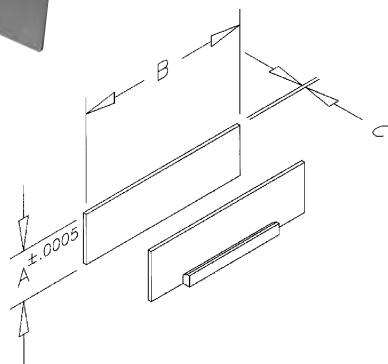


- For ReLock applications, QuickChange master jaws mount to the SnapLock carrier jaws and accept all QuickChange jaw components.
- Install QuickChange master jaws to Snaplock carrier jaws on vise for squareness.
- Accessories slide into position via a dovetail slot.

Vise Size	Part Number	A	B	C	D	E	F
4"	QMJ4000	4.06	1.235	.560	2.500	.687	3/8-16 SHCS
6"	QMJ6000	6.12	1.735	.735	3.875	.937	1/2-13 SHCS
8"	QMJ8000	8.12	2.230	1.105	4.750	1.128	5/8-11 SHCS

Before mounting QuickChange Master Jaws, thoroughly inspect, clean and remove any burrs or chips from mounting surface.

QuickChange Individual Parallel Sets

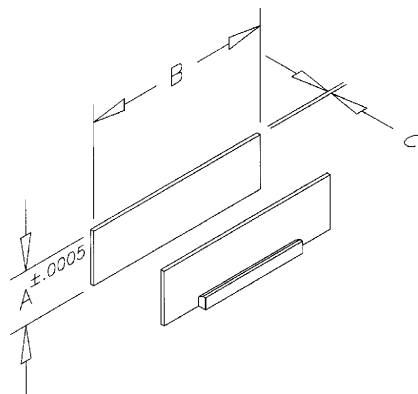


- QuickChange parallels are designed to be used with QuickChange master jaws.
- Parallels are packaged 2 per set.
- Expanded QuickChange parallel sets are available on page 186.

Before mounting QuickChange Master Jaws, thoroughly inspect, clean and remove any burrs or chips from mounting surface.

Vise Size	Part Number	A	B	C
4"	QIP4001	.500	3.980	.118
	QIP4002	.625	3.980	.118
	QIP4003	.750	3.980	.118
	QIP4004	.875	3.980	.118
	QIP4005	1.000	3.980	.118
	QIP4006	1.062	3.980	.118
	QIP4007	1.125	3.980	.118
	QIP4008	1.190	3.980	.118
6"	QIP6001	.750	5.980	.118
	QIP6002	.875	5.980	.118
	QIP6003	1.000	5.980	.118
	QIP6004	1.125	5.980	.118
	QIP6005	1.250	5.980	.118
	QIP6006	1.375	5.980	.118
	QIP6007	1.500	5.980	.118
	QIP6008	1.625	5.980	.118
8"	QIP8001	1.000	7.980	.118
	QIP8002	1.250	7.980	.118
	QIP8003	1.375	7.980	.118
	QIP8004	1.500	7.980	.118
	QIP8005	1.625	7.980	.118
	QIP8006	1.750	7.980	.118
	QIP8007	1.875	7.980	.118
	QIP8008	2.000	7.980	.118
	QIP8009	2.125	7.980	.118

QuickChange Parallel Kits



CONTAINS 1 PAIR PER SIZE

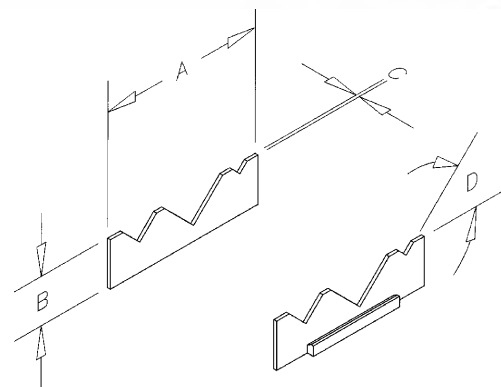
- QuickChange parallels are designed to be used with the QuickChange master jaws shown on page 185.
- Individual QuickChange parallel sets available on page 185.
- QuickChange Starter Package available on page 188.

Vise Size	Part Number Basic	Part Number Advanced	Basic A	Advanced A	B	C
4"	QPS4000	QPS4001	.500	.500	1.000	.118
			.750	.625	1.125	
			1.000	.750	1.062	
			1.125	.875	1.190	
			1.190			
6"	QPS6000	QPS6001	.750	.750	1.375	.118
			1.000	.875	1.500	
			1.250	1.000	1.625	
			1.500	1.125	1.690	
			1.625	1.250		
8"	QPS8000	QPS8001	1.000	1.000	1.750	.118
			1.250	1.250	1.875	
			1.500	1.375	2.000	
			1.750	1.500	2.125	
			2.000	1.625		

QuickChange Individual Mill Angles



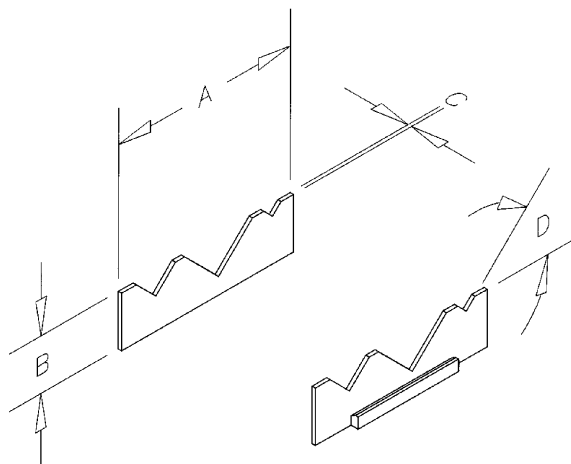
- QuickChange mill angles are designed to be used with the QuickChange master jaws (page 185).
- QuickChange mill angle parallel set is available on page 187.
- QuickChange starter package is on page 188.



Sold as individual units

Vise Size	Part Number Individual	A	B	C	(Degree) D
4"	QMA4020	4.000	1.240	.118	20
	QMA4025				25
	QMA4030				30
	QMA4035				35
	QMA4040				40
6"	QMA6020	6.000	1.740	.118	20
	QMA6025				25
	QMA6030				30
	QMA6035				35
	QMA6040				40
8"	QMA8020	8.000	2.230	.118	20
	QMA8025				25
	QMA8030				30
	QMA8035				35
	QMA8040				40
	QMA8045				45

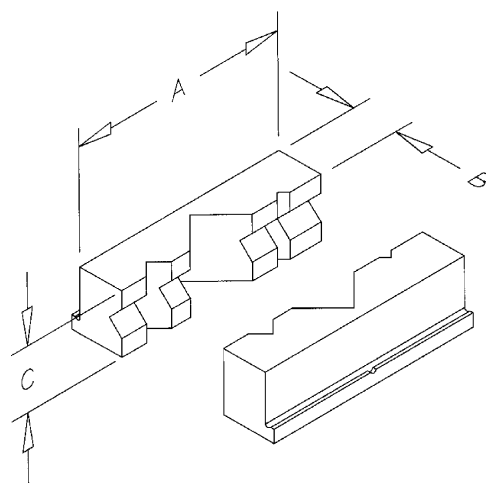
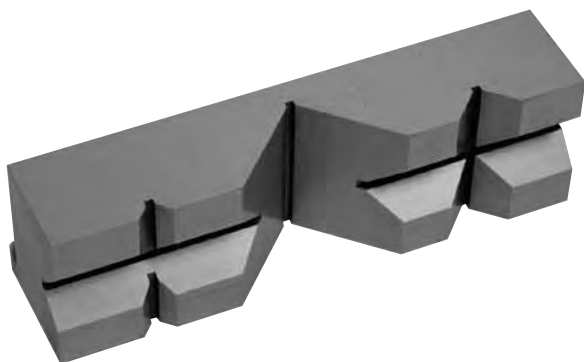
QuickChange Mill Angle Sets



- QuickChange Mill Angles are designed to be used with QuickChange Master Jaws on page 185.
- Individual QuickChange Mill Angles are on page 186.
- QuickChange Starter Package available on page 188.

Vise Size	Part Number	A	B	C	(1 of each degree) D
4"	QMA4000	4.000	1.240	.118	20 25 30 35 40 45
6"	QMA6000	6.000	1.740	.118	20 25 30 35 40 45
8"	QMA8000	8.000	2.230	.118	20 25 30 35 40 45

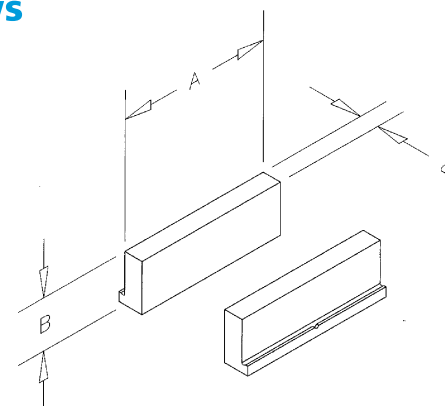
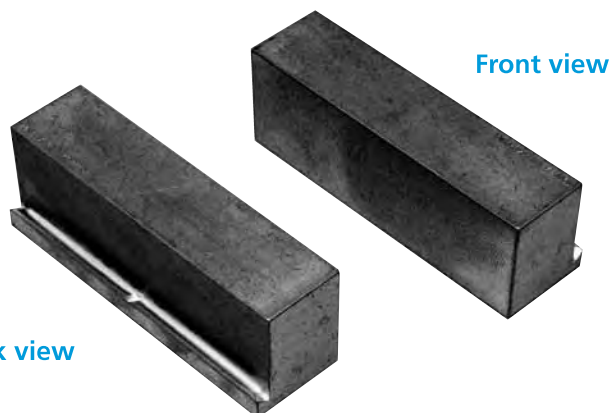
QuickChange "V" Jaws



- Designed to be used with QuickChange Master Jaws on page 185.
- QuickChange Starter Package available on page 188.
- Sold as individual units.

Vise Size	Part Number	A	B	C
4"	QVJ4000	4.00	1.00	1.24
6"	QVJ6000	6.00	1.25	1.74
8"	QVJ8000	8.00	1.75	2.24

QuickChange Machinable (Soft) Fixture Jaws

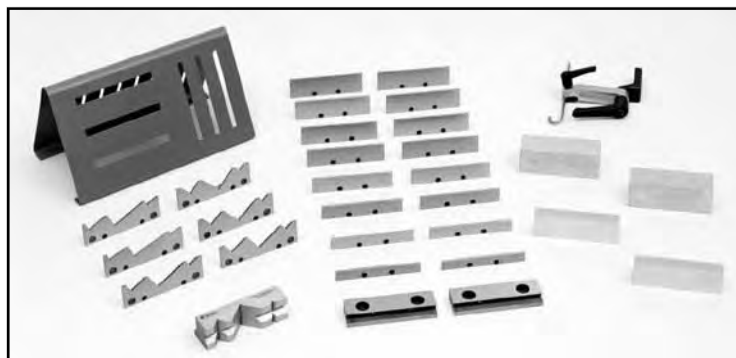


Sold as individual units

Vise Size	Part Number		A	B	C
	Aluminum	Steel			
4"	QSJ4000	QSJ4020	4.00	1.50	.69
	QSJ4001	QSJ4021			1.38
6"	QSJ6000	QSJ6020	6.00	2.00	.75
	QSJ6001	QSJ6021			1.50
8"	QSJ8000	QSJ8020	8.00	2.50	1.25
	QSJ8001	QSJ8021			2.50

- QuickChange Machinable Fixture Jaws are to be used in conjunction with QuickChange Master Jaws shown on page 185.
- QuickChange Machinable Fixture Jaws can be modified to fit your individual needs.

QuickChange Starter Packages



Toolmaker/Molder Package shown

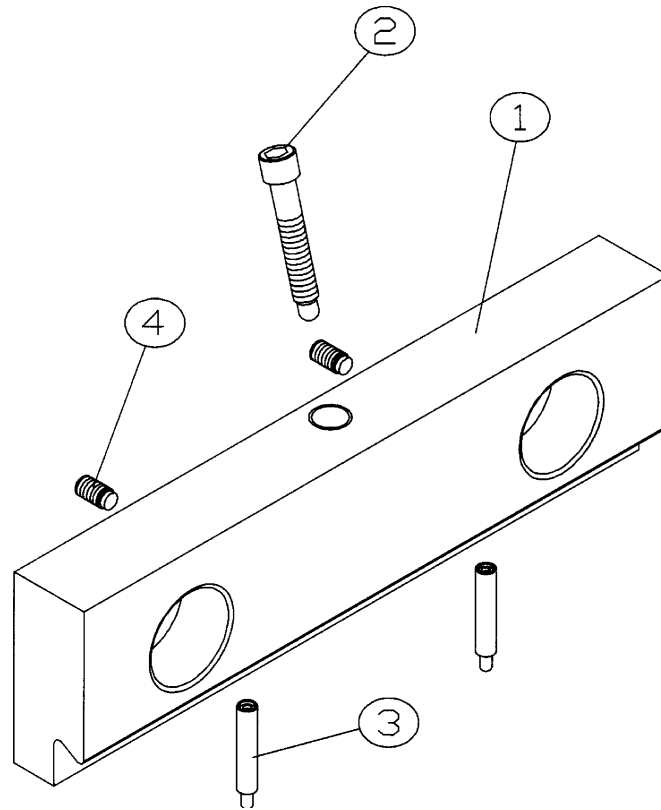
Each package contains the following QuickChange items:

Vise Size	Part Number	Master Jaws	Basic Parallel Set	Advanced Parallel Set	Mill Angle Set	Aluminum Fixture Jaws	V-Jaws	QuickStop	Holder Rack
BASIC STARTER PACKAGE									
4"	QBP4000	1 Pair	1 Set						
6"	QBP6000	1 Pair	1 Set						
8"	QBP8000	1 Pair	1 Set						
ADVANCED STARTER PACKAGE									
4"	QAP4000	1 Pair		1 Set					1 Piece
6"	QAP6000	1 Pair		1 Set					1 Piece
8"	QAP8000	1 Pair		1 Set					1 Piece
TOOLMAKER/MOLDER PACKAGE									
4"	QTM4000	1 Pair		1 Set	1 Set	2 Pieces	1 Piece	1 Piece	1 Piece
6"	QTM6000	1 Pair		1 Set	1 Set	2 Pieces	1 Piece	1 Piece	1 Piece
8"	QTM8000	1 Pair		1 Set	1 Set	2 Pieces	1 Piece	1 Piece	1 Piece

**THREE
STARTER
PACKAGES
AVAILABLE**

QUICKCHANGE™ PARTS LIST

QuickChange Master Jaws



QUICKCHANGE MASTER JAW PARTS LIST				
#	Description	4" Vise	6" Vise	8" Vise
1	QuickChange Plain Master Jaw	QMJ4500	QMJ6500	QMJ8500
2	QuickChange Locking Screw	QMJ4501	QMJ6501	QMJ8501
3	QuickChange Plunger Assembly	QMJ6502	QMJ6502	QMJ6502
4	QuickChange Locking Screw	QMJ6503	QMJ6503	QMJ6503