

## V75100X FAQ

The Next Generation V75100X has two major changes:  
How the jaws mount to the trucks & how the center block locks on the lead screw.

### **NEW V75100X Jaw/Truck**

- Keyed slot and dowel pin locate the jaw
- Uses 4ea Standard M8 SHCS per jaw

### **Original V75100 Jaw/Truck**

- Used custom shoulder bolt (SB87) to mount jaws either positioned towards center or farther apart for extended clamping
- Only two SB87 used per jaw

### **NEW V75100X Centerblock**

- Centerblock is located with shoulder bolts from the bottom, but the locking of the leadscrew is done separately from the top to allow the entire internals to be removed without losing all accuracy
- Does not need grease in the centerblock

### **Original V75100 Centerblock**

- Centerblock was both located and locked with shoulder bolts from the bottom of the vise
- Grease in the centerblock required

### **Q. Why did you change the vise?**

A. The new V75100X reduces jaw lift, is easier to service, has sharper teeth for better bite, and is strengthened by using 4 standard bolts per jaw eliminating the custom shoulder bolts.

### **Q. Is there a price increase?**

A. No, V75100X will be offered at same price as V75100.

### **Q. How much jaw lift does the new V75100X reduce?**

A. With the new V75100X, the maximum jaw lift is reduced to 0.004" or less at max torque. The original V75100 could have as much as 0.015" jaw lift.

### **Q. Has the clamping range changed?**

A. Yes, the dovetail gripper teeth clamping range has been adjusted (see below), but you can still clamp larger material by using the recommended dovetail stock prep found on our website.

NEW V75100X:

Standard: 3.25mm – 40mm

Reversed: 40mm – 77mm

Original V75100:

Standard: 14.30mm - 58mm

Reversed: 45mm - 85mm

### **Q. Can I use both V75100 and V75100X together?**

A. It would depend on the tool clearances. The Jaw lift on the new V75100X will be less than the original V75100 which could cause inconsistencies.

### **Q. If I have programming for the original V75100, do I need to change the set-up?**

A. The new V75100X jaws are wider in one direction, so the tool paths should be checked for clearance.

### **Q. Can I use my existing risers? (VPY75, R96-V75100-1)**

A. Yes, the vise bases are identical except for the part marking, therefore, it uses the same locating and mounting features.

### **Q. What is the weight?**

A. The weight of the vise is about 6lbs for both the new V75100 and the original V75100X.

### **Q. What is the height?**

A. The height of the jaws is the same as the original: 35mm to the top of the base and 56.15mm to the top of the jaws.

### **Q. Is the thumbscrew/leadscrew hex the same?**

A. Yes, TS10 or a 10mm socket can accommodate both the V75100 and V75100X leadscrew.

### **Q. Is the hardware the same?**

A. No, please see the bill of material.

### **Q. What are the torque specs for the hardware on the NEW V75100X?**

A. M8 SHCS for jaws to trucks (item 12): 20 ft-lbs  
Shoulder bolts locating centerblock (item 10): 48 in-lbs.  
M4 SHCS locking the lead screw (item 13): should not be removed by the customer as this could cause the vise to be off-center.

### **Q. Is the clamping force the same?**

A. Yes, the maximum clamping force is 13.5kN. It will increase if you go over the maximum torque value, but we do not recommend that.

### **Q. Is the centering accuracy the same?**

A. Yes, the self-centering accuracy is the same: plus-minus .0005" or 13 microns.

### **Q. Does the NEW V75100X still accept PS16F for the RockLock 52mm system.**

A. Yes, the base will still accept the PS16F pull studs or other compatible brands of pull studs.

**Q. Will the machinable jaws for the NEW V75100X (VAJ75X/VSJ75X) work with the original V75100? Will the original machinable jaws (VAJ75/VSJ75) work on the NEW V75100X?**

A. The new machinable jaws (VAJ75X/VSJ75X) are universal and compatible with both the original V75100 and the new V75100X and will be the only version available moving forward. The original VAJ75/VSJ75 will only work on the original V75100.

**Q. What maintenance do I need to perform?**

A. Keep the lead screw clean and coated with anti-seize. Use a nylon or soft wire brush to clean chips and debris off the leadscrew. After the lead screw has been cleaned, re-apply a coat of anti-seize to the lead screw, ensuring that an even coat covers the threads. The recommended anti-seize for the lead screw is copper-based anti-seize lubricant.

**Q. When is the self-centering accuracy guaranteed?**

A. The self-centering accuracy is guaranteed only when the leadscrew and centerblock have not been separated after receipt from the factory.

**Q. Why are the NEW V75100X Jaws black instead of gold, are they still the same material?**

A. The material is still hardened steel but we changed the finish so you can easily tell the difference between the new V75100X & the original V75100.

**Q. Is retrofitting the V75100 to V75100X possible?**

A. Yes, retrofitting is possible. If the vise is sent to the factory to retrofit, then we can guarantee 0.0005" self-centering accuracy. If a retrofit kit is sent to the customer to install, then we can guarantee 0.001" self-centering accuracy.

**Q. Is the original V75100 still available for purchase?**

A. For customers who are not yet using the original V75100, we strongly recommend purchasing the new and improved V75100X. For customers who have the original V75100 already, we will have a limited supply of the original vise available.

**Q. Are replacement parts for the original V75100 still available?**

A. Yes, we will continue to support any replacement parts for the original V75100 including the Master Hard Jaws (V75100-5).

**BILL OF MATERIAL FOR NEXT GENERATION V75100X**

#	PART NUMBER	DESCRIPTION	QTY
1	V75100X-1	BASE	1
2	V75100X-2L	LEFT TRUCK	1
3	V75100X-2R	RIGHT TRUCK	1
4	V75100X-3	CENTER BLOCK	1
5	V75100-4	LEAD SCREW	1
6	V75100X-5	JAW	2
7	V75100-6	CENTER RING	2
8	TIM-34	THREADED INSERT	3
9	TS10	THUMB SCREW	1
10	SB3V	CUSTOM SHOULDER BOLT FOR CENTERBLOCK LOCATION	2
11	LP8	LOCATING PIN FOR BASE	2
12	76232	M8 X 16MM SHCS JAW TO TRUCK	8
13	76048	M4 X 5MM SHCS FOR CENTER BLOCK LOCKING	1
14	M5X10.DP	5MM DOWEL PIN FOR TRUCK SLOT	2
15	76252	M8 X 40MM SHCS FOR MOUNTING	2
16	ANTI-SEIZE	ANTI-SEIZE FOR LEAD SCREW	1

**BILL OF MATERIAL FOR ORIGINAL V75100**

#	PART NUMBER	DESCRIPTION	QTY
1	V75100-1	BASE	1
2	V75100-2L	LEFT TRUCK	1
3	V75100-2R	RIGHT TRUCK	1
4	V75100-3	CENTERBLOCK	1
5	V75100-4	LEAD SCREW	1
6	V75100-5	JAW	2
7	V75100-6	CENTER RING	2
8	SB87	CUSTOM JAW BOLT	4
9	M3X3.CPSS	SET SCREW FOR CENTERBLOCK	1
10	SB54	CUSTOM SHOULDER BOLT FOR CENTERBLOCK	2
11	TIM-34	THREADED INSERT	3
12	LP8	LOCATING PIN FOR BASE	2
13	ANTI-SEIZE	ANTI-SEIZE FOR LEAD SCREW	1
14	TS10	THUMB SCREW	1
15	76252	M8 X 40MM SHCS	2