



KURT WORKHOLDING

KURT 5-AXIS QUICK-CHANGE BASE

178 mm x 158 mm | 96 mm Spacing

Operating Instruction Manual

Model No. 96-A178



ENGLISH

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New Kurt PFW420 5-Axis Vise mounted on a 96-A178 Quick-Change Base

INTRODUCTION

Thank you for purchasing a Kurt 5-Axis vise pallet. This pallet is designed for quick vise changes using 96 mm pull stud spacing and works with Kurt PFW 5-Axis vises or other vises that support 96 mm pull stud mounting patterns.

Included in the box

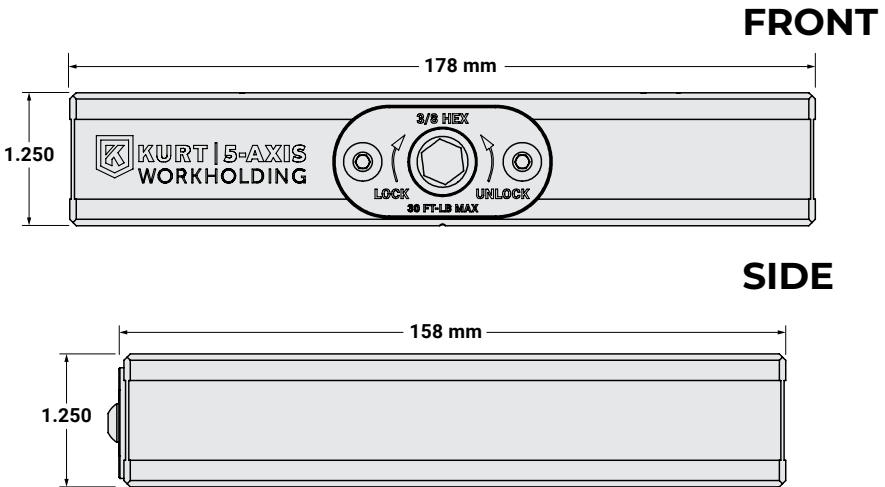
- Vise Pallet
- 4 pull studs
- 3/8" hex wrench



Fig.1

SIDE DIMENSIONS

Note: Dimensions below are in inches unless specified.



SET-UP INSTRUCTIONS

The Kurt 96 mm quick change base does not ship predrilled for mounting. Refer to machine table requirements for mounting patterns and drill and counterbore holes on Kurt pallet for your own machine application. Mounting hole locations can be machined into the base outside of the yellow areas in Fig.2 on page 5.

Once the base is drilled and counterbored holes have been made, secure the base to the machine table with socket head cap screws.

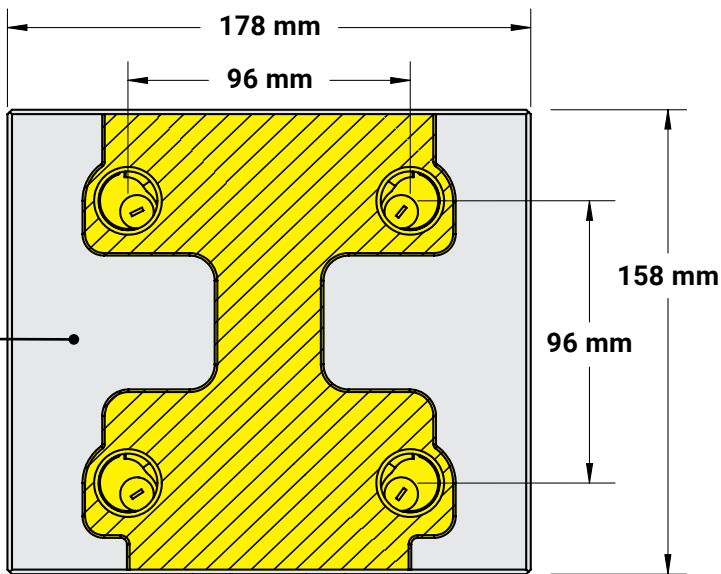
Pallet precision bores must be protected from chips and coolant. If pallet is not being utilized, leave vise mounted in pallet to cover bores. If this is not an option, utilize stand alone pull down studs to act as a chip guard.

NOTE: WHEN OPERATING PALLET INTO THE FULLY OPEN/ UNLOCKED POSITION (CCW), DO NOT OVER TORQUE THE LEADSCREW AS IT MAY LEAD TO FRONT COVER PLATE DAMAGE. STOP ROTATING LEADSCREW WHEN YOU FEEL IT COME INTO CONTACT WITH ITS INTERNAL STOP.

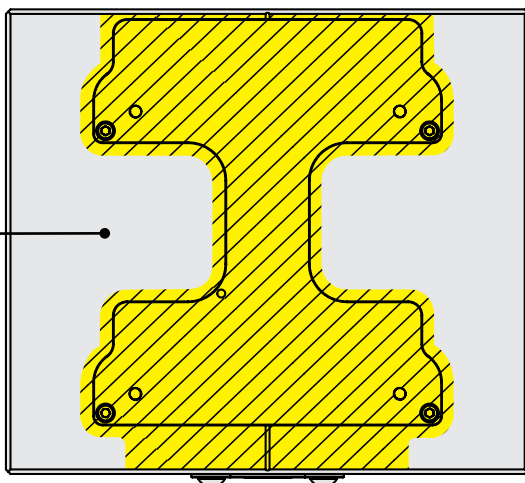
Fig.2

TOP & BOTTOM VIEWS SAFE BOLT-HOLE ZONES

TOP



BOTTOM



Through-bolt mounting holes and counter bores must only be machined into locations outside of the no-hole zones shown in yellow.

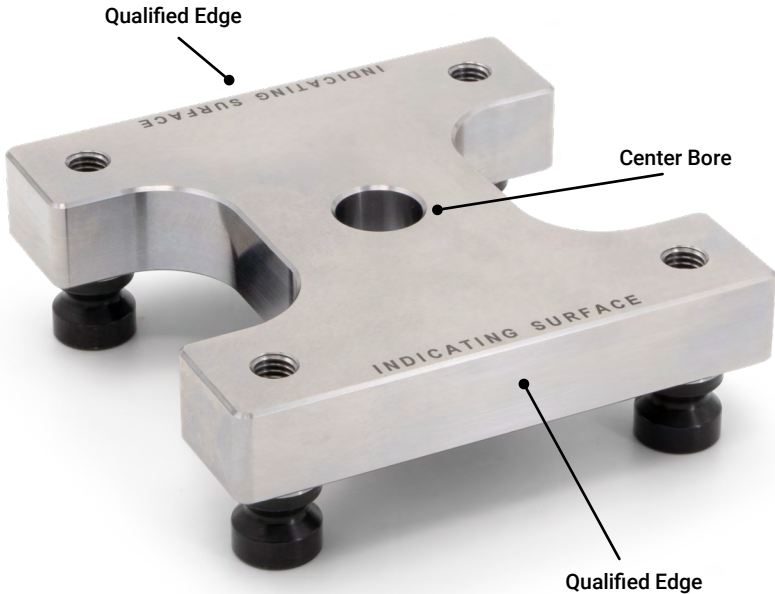
INDICATING TOOL (MASTER PLATE)

To reduce setup time, an optional precision set up tool is available through Kurt.

This tool has the same precision tolerance as the base and body to ensure accurate pallet locating. The pallet has machined scallops to help reach fasteners during setup procedure.

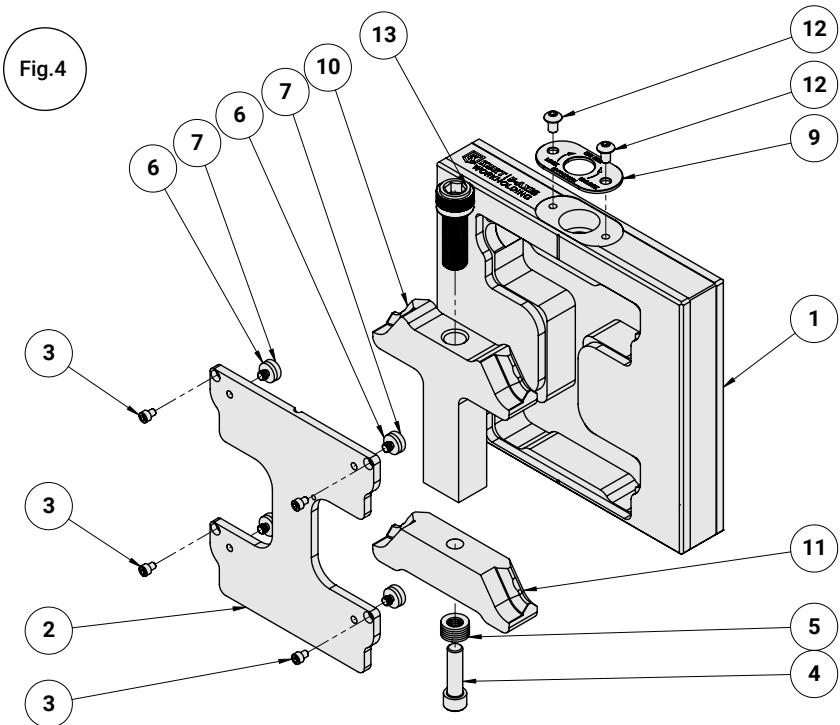
Locate and a pallet:

1. Insert indicating tool into pallet, tighten to a maximum of 30 lb-ft.
2. Using the center bore and/or qualified edges, align the pallet to the center of rotation and/or square to the machine axis. Tighten mounting bolts.
3. Using the marked qualified edges, adjust the pallet to be square to the machine axis.



PARTS LIST

ITEM#	PART#	DESCRIPTION	QTY.
1	96-158178	Base	1
2	96-53	Bottom Cover	1
3	00-1157	SHCS, Cover	4
4	00-0356	SHCS	1
5	96-160	Belleville Disc Spring	6
6	96-305	O-Ring Holder	4
7	40-3201	O-Ring	4
8	96-204	Thrust Washer	1
9	96-118	Bolt Cover	1
10	96-329	Upper Wedge	1
11	96-392	Lower Wedge	1
12	03-00205	Button Head Cap Screw	2
13	96-18	Leadscrew	1



MAINTENANCE SCHEDULE

It is very important to perform regular maintenance on your Kurt pallet to ensure proper operation. Improper maintenance will result in poor performance and pallet operation.

Daily / Weekly

1. Keep surface of pallet clean and free of chips.
2. Visually inspect precision bores for damage.
3. Apply a small dab of high/extreme pressure grease (NLGI #2) to pull down mechanism.

Yearly / Or any time pallet is removed from mounted position

1. Remove bottom cover, clean, dry, and grease internal lead screw and pull down mechanism using high/extreme pressure grease NLGI #2.

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purchase! If you have any
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