QC COMPLETE SET
INCLUDING MICROBLOCK® XL

#500-527 • INSTRUCTIONS
MASTER JAWS
INSTRUCTIONS

Instructions apply to the following product(s):

500-018

Removal of Original MicroBlock® Jaws
Skip to Installation of Master Jaws unless you need to remove original MicroBlock jaws from a previously purchased vise.

![Fig. 1](image1.png)

![Fig. 2](image2.png)

![Fig. 3](image3.png)

Installation of Master Jaws

Replace with Jura Master Jaws.

![Fig. 4](image4.png)

Hold the jaws against the thread with equal pressure and use the hex key to turn the jaw screw.

IMPORTANT NOTE:
The MicroBlock® and MicroBlock® XL Jura by GRS sets include a pair of Master Jaws instead of the original jaws with pin holes.

Skip to Installation of Master Jaws unless you need to remove original MicroBlock jaws from a previously purchased vise.

Products that include Master Jaws instead of original MicroBlock jaws:
#500-508, #500-510, #500-517, #500-526, #500-527

✓ Included with this set.
♦ Not included with this set. Available separately.
Microblock® XL shown with Jura Master Jaws #500-018 (See instructions for installation on pg 2).

**FIG. 1**
Insert hex key and rotate to lock or unlock vise crown rotation.

**FIG. 2**
Insert hex key into either end of jaw screw and rotate to open jaws and close jaws.

<table>
<thead>
<tr>
<th>PART #</th>
<th>DESCRIPTION</th>
<th>QTY</th>
</tr>
</thead>
<tbody>
<tr>
<td>002-067</td>
<td>SHCS, #10-32 X .50” BLK</td>
<td>1</td>
</tr>
<tr>
<td>003-140</td>
<td>LABEL, GRS</td>
<td>1</td>
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<tr>
<td>003-306</td>
<td>BRAKE AND DRAG SPRING</td>
<td>1</td>
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<tr>
<td>003-307</td>
<td>BRAKE ELEMENT FOR MICROBLOCK VISE</td>
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<tr>
<td>003-311</td>
<td>BEARING RETAINER FOR MICROBLOCK VISE</td>
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<tr>
<td>003-312</td>
<td>BEARING SPACER BRAKE ROTOR MICROBLOCK</td>
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</tr>
<tr>
<td>003-486</td>
<td>YOKE TO SUPPORT AND CENTER JAW SCREW</td>
<td>1</td>
</tr>
<tr>
<td>003-487</td>
<td>JAW SCREW FOR MICROBLOCK XL VISE</td>
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<tr>
<td>003-488</td>
<td>416 STAINLESS STEEL MICROBLOCK XL BALL BASE FOR MEDIUM VISE</td>
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</tr>
<tr>
<td>003-489</td>
<td>CROWN FOR MICROBLOCK XL VISE</td>
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<tr>
<td>003-679</td>
<td>THERMO-LOC SAMPLE KIT</td>
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<tr>
<td>022-379</td>
<td>R8 SHIELDED BEARING</td>
<td>2</td>
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<tr>
<td>022-380</td>
<td>TOLERANCE RING</td>
<td>2</td>
</tr>
<tr>
<td>022-382</td>
<td>FLAT NOSE SET SCREW</td>
<td>1</td>
</tr>
<tr>
<td>022-383</td>
<td>.015 X .513 X .750 SS SHIM WASHER</td>
<td>1</td>
</tr>
<tr>
<td>024-215</td>
<td>5 mm X 25 mm PLASTIC “T” HANDLE WRENCH</td>
<td>1</td>
</tr>
</tbody>
</table>
SEATED QC FIXTURES

Instructions apply to the following product(s):

- 500-001
- 500-002
- 500-003
- 500-004
- 500-005
- 500-006
- 500-007
- 500-008
- 500-009
- 500-010
- 500-013
- 502-078

Fixture Attachment

- BOTTOM
- SIDE
- ANGLE

Master Jaw Seat

Fixture Installation

- FIG.1
- FIG.2

✓ Included with this set.
♦ Not included with this set. Available separately.
Instructions apply to the following product(s):

500-011
SHELLAC CYLINDER

Instructions apply to the following product(s):

502-015

Follow the shellac instructions to apply shellac and workpiece to cylinder.

THERMO-LOC® CYLINDER

Instructions apply to the following product(s):

502-502

Follow the Thermo-Loc® instructions to apply Thermo-Loc® and workpiece to cylinder.
Instructions apply to the following products:

500-506
500-507

Fixture Installation

FIG.1

Fixture Usage

FIG.2

FIG.3
Use the pointed ball holders (#500-506) with workpieces that have holes in each side. The points will rest in the holes.

FIG.4
Use the tapered ball holders (#500-507) with round workpieces.
Instructions apply to the following product(s):

- **500-501**
- **502-501**

**Fixture Attachment**

- **BOTTOM**
- **SIDE**
- **ANGLE**

**Fixture Installation**

**FIG.1**

**FIG.2**

**FIG.3**

✓ Included with this set.
♦ Not included with this set. Available separately.
VERTICAL RING HOLDER

INSTRUCTIONS

Instructions apply to the following product(s):

FIG.1

FIG.2

FIG.3

FIG.4

FIG.5

FIG.6

FIG.7
QC SHELLAC PLATE

INSTRUCTIONS

Instructions apply to the following product(s):

![QC Shellac Plate](image)

500-014

Fixture Attachment

- **FIXTURE BOTTOM**
  - Fits in Master Jaws.
  - Fits around Master Jaws.

Fixture Installation

**FIG.1**

- ![Incorrect Fixture Attachment](image)
- **X**
- The jaws need to be closed slightly for the QC Shellac Plate to fit.

**FIG.2**

- ![Correct Fixture Attachment](image)

Follow the shellac instructions to apply shellac and workpiece to cylinder.

- ✓ Included with this set.
- ♦ Not included with this set. Available separately.
Clean organizer back and bench surface with isopropyl alcohol according to manufacturer's instructions.

Instructions apply to the following product(s):

- 500-523
- 500-524
- 502-034
- 502-045
- 523-011
- 523-012
- 523-013
- 523-029
- 523-030

Place organizer where desired and press firmly for 60 seconds.