QC BASIC SET
INCLUDING MICROBLOCK® XL

#500-526 • INSTRUCTIONS
MASTER JAWS
INSTRUCTIONS

Instructions apply to the following product(s):

500-018

**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

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**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)

**Installation of Master Jaws**

Replace with Jura Master Jaws.

![Fig. 3](image3)

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

![Fig. 4](image4)
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>
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<tbody>
<tr>
<td>002-067</td>
<td>SHCS, #10-32 X .50” BLK</td>
<td>1</td>
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<tr>
<td>003-140</td>
<td>LABEL, GRS</td>
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<tr>
<td>003-306</td>
<td>BRAKE AND DRAG SPRING</td>
<td>1</td>
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<td>003-307</td>
<td>BRAKE ELEMENT FOR MICROBLOCK VISE</td>
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<td>003-311</td>
<td>BEARING RETAINER FOR MICROBLOCK VISE</td>
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<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>
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<tr>
<td>003-487</td>
<td>JAW SCREW FOR MICROBLOCK XL VISE</td>
<td>1</td>
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<tr>
<td>003-488</td>
<td>416 STAINLESS STEEL MICROBLOCK XL BALL BASE FOR MEDIUM VISE</td>
<td>1</td>
</tr>
<tr>
<td>003-489</td>
<td>CROWN FOR MICROBLOCK XL VISE</td>
<td>1</td>
</tr>
<tr>
<td>003-679</td>
<td>THERMO-LOC SAMPLE KIT</td>
<td>1</td>
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<tr>
<td>022-379</td>
<td>R8 SHIELDED BEARING</td>
<td>2</td>
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<td>022-380</td>
<td>TOLERANCE RING</td>
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<td>022-382</td>
<td>FLAT NOSE SET SCREW</td>
<td>1</td>
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<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>

MUTROBLOCK® XL
WITHOUT JAWS
INSTRUCTIONS AND PARTS LIST

PART #   DESCRIPTION
003-773-LJ  MICROBLOCK® XL
003-487  YOKE TO SUPPORT AND CENTER JAW SCREW
003-486  JAW SCREW FOR MICROBLOCK XL VISE
003-488  416 STAINLESS STEEL MICROBLOCK XL BALL BASE FOR MEDIUM VISE
003-489  CROWN FOR MICROBLOCK XL VISE
003-679  THERMO-LOC SAMPLE KIT
022-379  R8 SHIELDED BEARING
022-380  TOLERANCE RING
022-382  FLAT NOSE SET SCREW
022-383  .015 X .513 X .750 SS SHIM WASHER
024-215  5 mm X 25 mm PLASTIC “T” HANDLE WRENCH
003-679  MICROBLOCK® XL
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
- 500-011
- 500-012
- 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.
INSIDE RING HOLDER SCREW SET

Instructions apply to the following product(s):

500-011
ROUND-BASE QC FIXTURES
INSTRUCTIONS

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
ORGANIZERS WITH TAPE ATTACHMENT

INSTRUCTIONS

Instructions apply to the following product(s):

- ✓ 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.

Place organizer where desired and press firmly for 60 seconds.