QC COMPLETE SET
INCLUDING MICROBLOCK®

#500-510 • INSTRUCTIONS
MASTER JAWS

Instructions apply to the following product(s):

500-018

REM AR M E N T O F O R I G IN A L M IC R O B L O C K® JAWS

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

<table>
<thead>
<tr>
<th>FIG.1</th>
</tr>
</thead>
<tbody>
<tr>
<td><img src="image1.png" alt="Image" /></td>
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</tbody>
</table>

<table>
<thead>
<tr>
<th>FIG.2</th>
</tr>
</thead>
<tbody>
<tr>
<td><img src="image2.png" alt="Image" /></td>
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</table>

<table>
<thead>
<tr>
<th>FIG.3</th>
</tr>
</thead>
<tbody>
<tr>
<td><img src="image3.png" alt="Image" /></td>
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</table>

<table>
<thead>
<tr>
<th>FIG.4</th>
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<tbody>
<tr>
<td><img src="image4.png" alt="Image" /></td>
</tr>
</tbody>
</table>

**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

.include with this set.

♦ Not included with this set. Available separately.
Microblock® 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>10-32 x 1/2&quot; SHCS</td>
<td>1</td>
</tr>
<tr>
<td>003-140</td>
<td>GRS Label</td>
<td>1</td>
</tr>
<tr>
<td>003-306</td>
<td>Drag Spring</td>
<td>1</td>
</tr>
<tr>
<td>003-307</td>
<td>Lock Pin</td>
<td>1</td>
</tr>
<tr>
<td>003-308</td>
<td>Stainless Steel 80 mm Base</td>
<td>1</td>
</tr>
<tr>
<td>003-309</td>
<td>Crown</td>
<td>1</td>
</tr>
<tr>
<td>003-311</td>
<td>Bearing Retainer</td>
<td>1</td>
</tr>
<tr>
<td>003-312</td>
<td>Bearing Spacer Brake Rotor</td>
<td>1</td>
</tr>
<tr>
<td>003-316</td>
<td>Jaw Screw Yoke</td>
<td>1</td>
</tr>
<tr>
<td>003-317</td>
<td>Jaw Screw</td>
<td>1</td>
</tr>
<tr>
<td>003-679</td>
<td>Thermo-Loc Sample Kit</td>
<td>1</td>
</tr>
<tr>
<td>022-379</td>
<td>Shielded Bearing</td>
<td>2</td>
</tr>
<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&quot; x .513&quot; x .750&quot; SS Washer</td>
<td>1</td>
</tr>
<tr>
<td>024-215</td>
<td>T-Wrench 5 mm Hex</td>
<td>1</td>
</tr>
</tbody>
</table>

**INSTRUCTIONS AND PARTS LIST**

**MICROBLOCK® WITHOUT JAWS**

Insert hex key into either end of jaw screw and rotate to open jaws and close jaws.
SEATED QC FIXTURES

INSTRUCTIONS

Instructions apply to the following product(s):

- 500-001
- 500-002
- 500-003
- 500-004
- 500-005
- 500-006
- 500-007
- 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.
INSIDE RING HOLDER SCREW SET

Instructions apply to the following product(s):

![500-011](image)

FIG.1

FIG.2

FIG.3

FIG.4

FIG.5

FIG.6
SHELLAC CYLINDER

Instructions apply to the following product(s):

✓ Included with this set.
♦ Not included with this set. Available separately.

502-015

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

THERMO-LOC® CYLINDER

Instructions apply to the following product(s):

✓ Included with this set.
♦ Not included with this set. Available separately.

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

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**Fixture Installation**

**FIG. 1**

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**Fixture Usage**

**FIG. 2**

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

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**FIG. 3**

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

INSTRUCTIONS

Instructions apply to the following product(s):

500-014

- Included with this set.
- Not included with this set. Available separately.

Fixture Attachment

FIXTURE BOTTOM

Fits in Master Jaws.
Fits around Master Jaws.

Fixture Installation

FIG. 1

The jaws need to be closed slightly for the QC Shellac Plate to fit.

FIG. 2

Follow the shellac instructions to apply shellac and workpiece to cylinder.
Clean organizer back and bench surface with isopropyl alcohol according to manufacturer's instructions.

Place organizer where desired and press firmly for 60 seconds.