QC ADVANCED SET
INCLUDING VISE

#500-517 • 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

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

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

FIG.1
FIG.2
FIG.3
FIG.4

✓ Included 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).

**INSTRUCTIONS AND PARTS LIST**

**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>
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</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>
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<tr>
<td>003-317</td>
<td>Jaw Screw</td>
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<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>
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<tr>
<td>022-382</td>
<td>Flat Nose Set Screw</td>
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<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>

**MICROBLOCK® WITHOUT JAWS**
SEATED QC FIXTURES
INSTRUCTIONS

Instructions apply to the following product(s):

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

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

Fixture Attachment
- BOTTOM
- SIDE
- ANGLE

Master Jaw Seat

Fixture Installation

FIG.1

FIG.2

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INSIDE RING HOLDER SCREW SET

Instructions apply to the following product(s):

500-011
SHELLAC CYLINDER
INSTRUCTIONS

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

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.
**Instruction apply to the following products:**

- 500-506
- 500-507

**Fixture Installation**

**FIG.1**

**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.

**FIG.3**

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.
Instructions apply to the following product(s):

- FIG.1
- FIG.2
- FIG.3
- FIG.4
- FIG.5
- FIG.6
- FIG.7

VERTICAL RING HOLDER

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.
Instructions apply to the following product(s):

523-021

Battery Installation

Divider Sharpening

Divider must be sharpened to use for marking metal. Use rotary handpiece diamond wheels (#023-123 and #023-120) to sharpen. With divider jaws closed, grind away excess metal to form point.

Unsharpened | Sharpened
--- | ---
TOP + BOTTOM | TOP + BOTTOM
SIDES | SIDES
TIP | TIP
ORGANIZERS WITH TAPE ATTACHMENT

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

Clean organizer back and bench surface with isopropyl alcohol according to manufacturer's instructions.

Place organizer where desired and press firmly for 60 seconds.
Instructions apply to the following product(s):

523-014

**FIG.1**

Hold the organizer where you would like it to be attached and mark where the screw holes will be.

**FIG.2**

Drill 7/64" diameter pilot holes, 5/8" deep in the spots you marked.

**FIG.3**

Place the screws in the holes.

**FIG.4**

Tighten the screws with a drill or screwdriver.