

**YASDA's precision Vice makes a significant contribution to the machining of precision parts, molds, and dies which require high-precision grinding**



# YPV PRECISION VICE

MULTIPLY POWER  
PRECISION CLAMP SYSTEM

**YPV - 80 . YPV - 100 . YPV - 125 . YPV - 180**

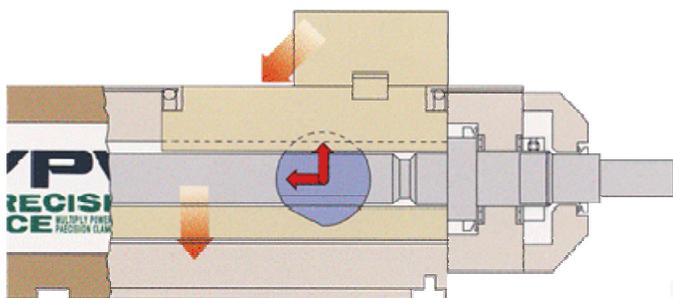
## «Advantages»

**YASDA's precision vice demonstrates the following effects of the wedge nuts function by clamping work pieces:**

- Preventing the work piece from moving up and keeping it fitted as downward force is given to the movable sleeve.
- Clamping the work piece with no more than appropriate force.
- Finally, clamping the work piece securely as the movable unit and the wedge nuts clamp the sliding face.

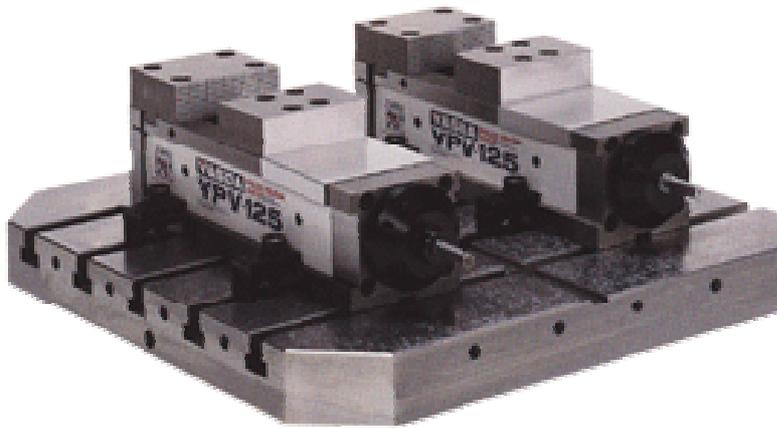
**Due to these:**

**Minimal strain to the work piece.  
Unnecessary to hit the work piece from the top as it is properly fitted.  
Therefore, the work piece is not damaged.**



**Wedge nut mechanism prevents the work pieces from moving up, and thus, further higher and more accurate clamping force can be created**

In proportion to the jaw clamping force, the wedge nuts built into the slider, which fastens the jaw, create downward force and pull down the jaw, so as to prevent the work piece from moving up completely and to maintain accurate clamping.

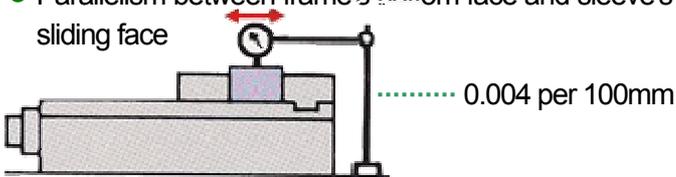


- The accuracy can be maintained even with parallel specification. Please specify the parallel specification when ordering.

## ACCURACY LIST

### ■ Static accuracy

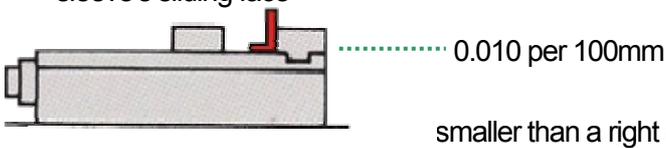
- Parallelism between frame's bottom face and sleeve's sliding face



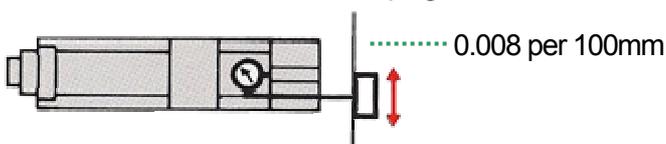
- Parallelism between both clamping faces of fixed sleeve



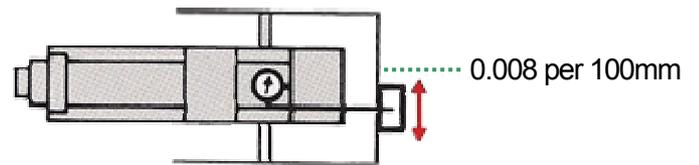
- Perpendicularity of fixed sleeve's clamping face and sleeve's sliding face



- Perpendicularity of side face of guide block of frame bottom and fixed sleeve's clamping face

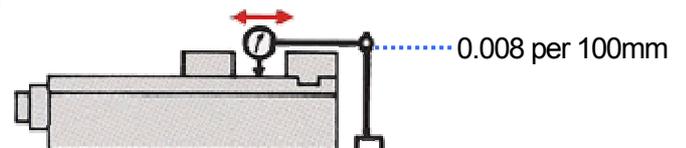


- Parallelism between side face of guide block of frame bottom face and fixed sleeve's clamping face

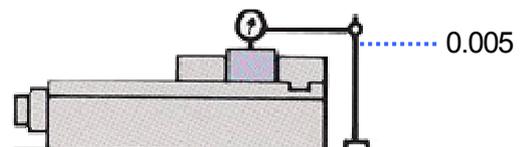


### ■ Dynamic accuracy

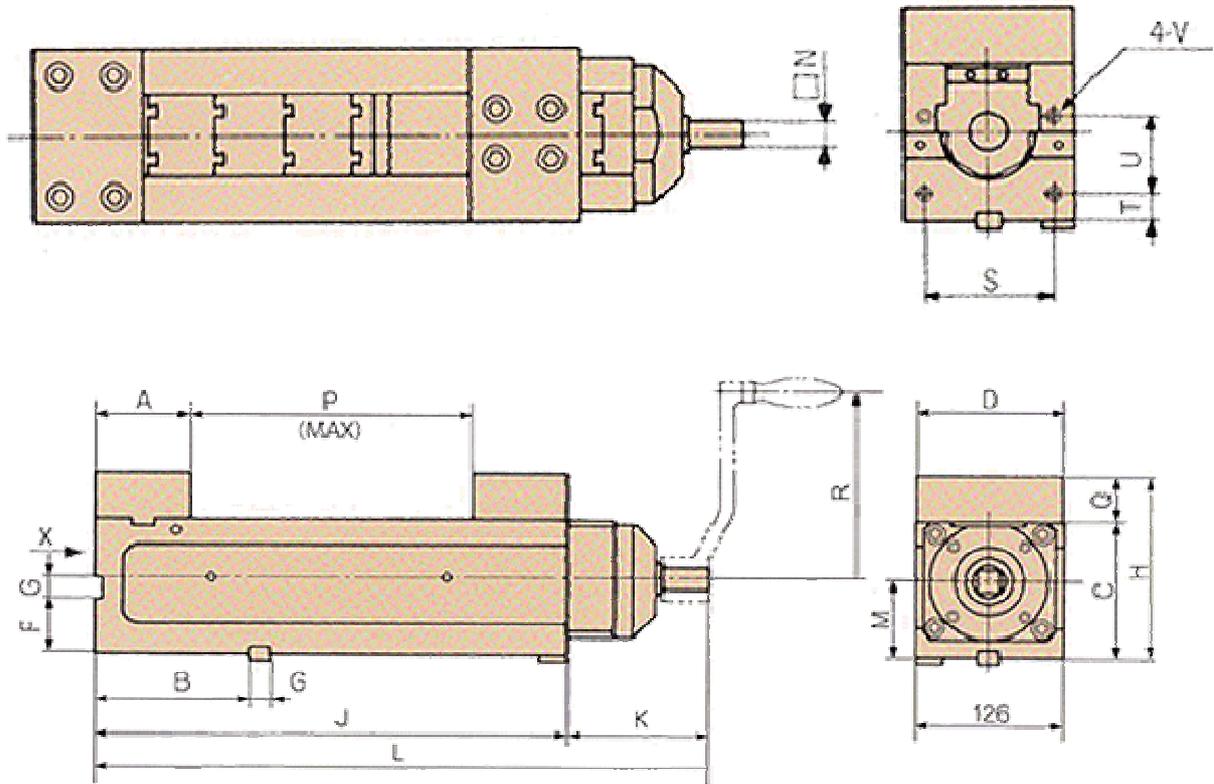
- Parallelism between upper face of clamped test block and frame bottom face



- Gap at the upper face of clamped test block



## YPV SERIES dimension table



Mark Model	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R	S	T	U	V	Weight
<b>YPV-80</b>	65	53	90	80	81	33	14	120	260	90	350	55	12	120	30	80	65	15	45	M8	14kg
<b>YPV-100</b>	75	93	100	100	101	43	14	135	300	100	400	60	14	145	35	100	83	15	55	M10	22kg
<b>YPV-125</b>	80	131	115	125	126	46	18	155	400	120	520	65	19	240	40	160	96	20	56	M12	40kg
<b>YPV-180</b>	100	191	155	180	181	66	18	205	500	150	650	85	24	300	50	250	130	25	75	M16	100kg

■ Please use this for the work finishing process as it is extremely precise.

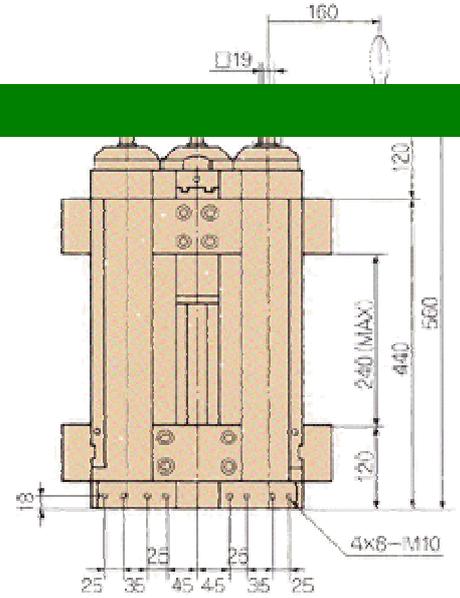
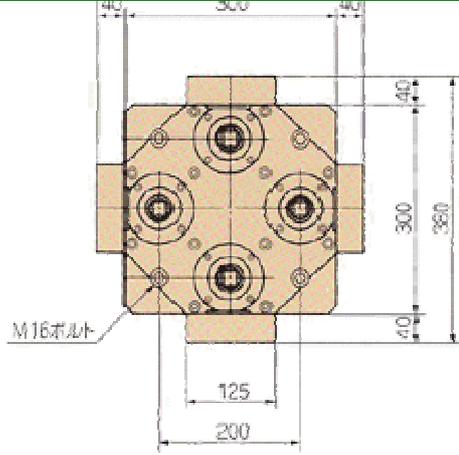
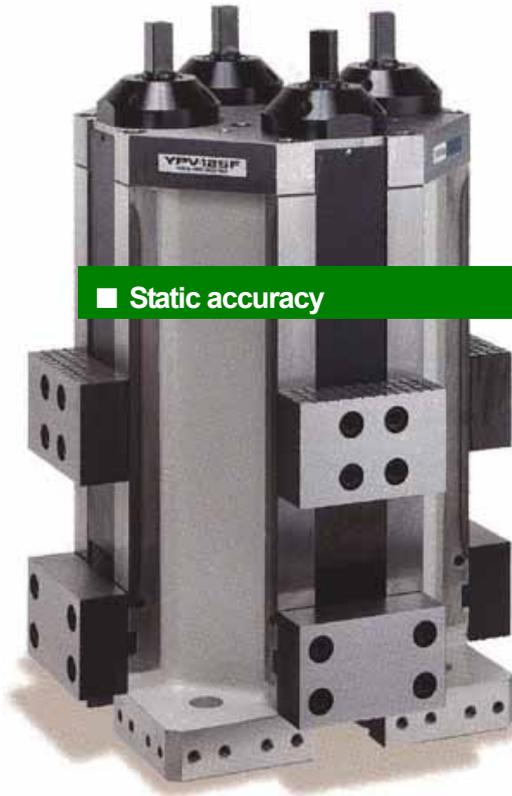
# YPV-125F

YASDA PRECISION VICE

YPV-125F, precise 4-face vice, is a user-friendly vice as the positions of fixed sleeves of four vices are precisely determined.

YPV-125F

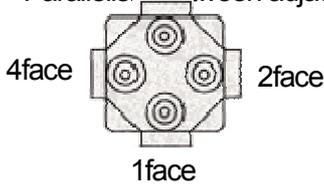
## Static accuracy



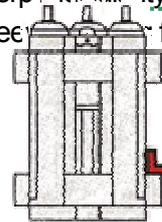
## ACCURACY table

- Parallelism between sliding faces in opposite direction ..... 0.005 per 125mm

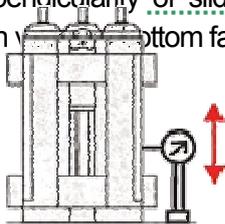
- Parallelism between adjacent sliding faces ..... 0.005 per 125mm



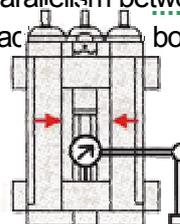
- Perpendicularity of fixed sleeve's clamping face and sleeve face ..... 0.010 per 100mm



- Perpendicularity of sliding faces of fixed sleeves of each vice bottom face ..... 0.004 per 100mm



- Parallelism between fixed sleeve's clamping face of each vice bottom face ..... 0.005 per 100mm



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