



TSD 6208 B

PLANT STANDARD BHOPAL

BP 611 99 01

Rev. No. 02

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MACHINE VICE - FIXED BASE

 SUPERSEDES
BP 6119901(Rev.01)

1.0 SCOPE :

This standard covers the dimensions and other requirements for Machine Vice fixed base.

2.0 DESIGNATION :

A Machine vice with fixed base having nominal size 200 mm and with hand crank shall be designated as -

2.1 On Indents :

Machine Vice fixed base 200 - Hand Crank - BP 611 99 00.

2.2 For Issuing Enquiries and Purchase Orders :

Delete the Plant Standard No. from the above designation and add the information given under clause 6.

2.3 Abbreviated Description :

M/C VICE FXD BASE 200.

3.0 COMPLIANCE WITH STANDARDS :

3.1 Dimensions, Tolerances

& General Requirements

To conform to IS : 4502 - 1999 (Table-1)

3.2 MATERIAL :

3.2.1 Base Sliding and Fixed Jaws :

Shall be made of SG Iron, as specified in IS:1865.

3.2.2 Jaws Inserts :

Shall be made of suitable Tool Steel of T110W6Cr4 to IS : 3748.

3.2.3 Screws and Nuts :

Screws shall comply to property class 8.8 and Nuts of property class 8 as per IS : 1367(Pt.3) & (pt.6) respectively.

Revision : Reviewed & Updated

Issued by :

 STANDARDS AND MATERIALS GROUP
TECHNICAL SERVICES DEPARTMENT

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3.3 HARDNESS :

Jaws Inserts - 56 ± 2 HRC.

3.4 FINISH :

3.4.1 Jaw Insert faces shall be smooth and ground flat.

3.4.2 All non-Machined portion should be painted with a priming and finishing coat of Light Grey paint to shade No.631.

3.5 Marking :

Machine vice shall be marked with the nominal size and manufacturer's name or trade mark.

3.6 Packing :

Machine vice shall be coated with a suitable rust preventive and packed in such a way as not to be affected by the exposure to atmosphere.



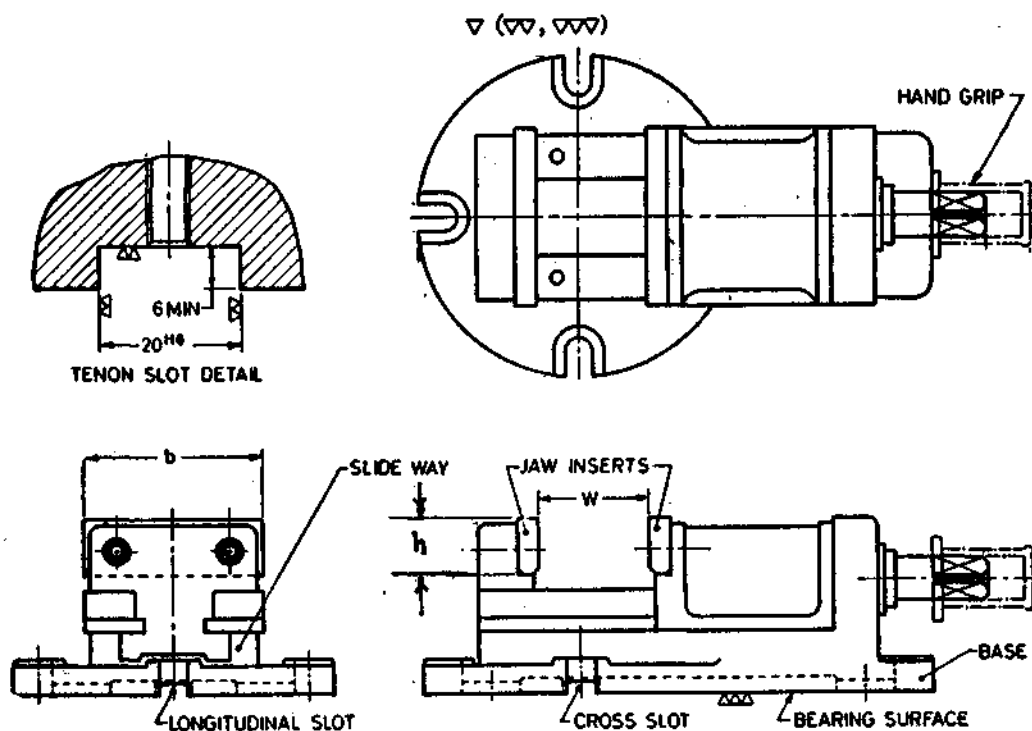
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**STOCKING/USER DEPARTMENTS IS
SHOWN AGAINST EACH SIZE.**

- ⊗ Denotes proposed stock size.
● Denotes stock size.
△ Denotes non-preferred size,
stocked for the time being
only.

ALL DIMENSIONS ARE IN MM.

NOM. SIZE b	CLAMPING RANGE(W) (MIN)	DEPTH OF JAWS h	CODE NO.	PREF./ STOCK SIZE.	STOCKING/ USER DEPT.
200	0 - 125	63	BP 6119901990	●	SCR
200*	0 - 200	63	BP 6119901981	●	SCR

* The size is not as per IS : 4502, other requirements like material, hardness and testing etc will be as per IS : 4502.