

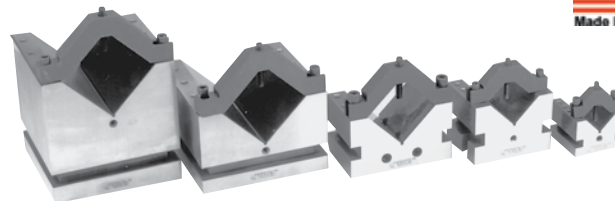
V-BLOCKS AND CLAMPS

SERIES 255:



V-BLOCKS

SERIES 641: SUBURBAN - USA
SERIES 794: MEDA - SUPERIOR IMPORT



Made of hardened steel and precision ground. Matched and numbered in pairs. Blocks can be used on sides since clamps do not protrude.

All vee blocks are parallel, square and central within .0002". Each block comes with one clamp and blocks are available in matched pairs. All models are made of hardened steel. Sizes other than those listed are available by special order.

Capacity	Size (L x W x H)	Order No.	Price
2 dia.	2-3/8 x 2-3/4 x 2	1725005	

V-BLOCK AND CLAMPS

SERIES 255:



Made of tool steel, hardened and precision ground. Matched and numbered in pairs to an accuracy of .0002". Models 003 and 004 can be used on their sides since clamps do not protrude.

Capacity	L x W x H Size	Order No.	Price
1 dia.	1-5/8 x 1-1/4 x 1-1/4	1725000	
1 dia.	1-3/8 x 1-5/8 x 1-3/4	1725001	
1-1/2 dia.*	2 x 1-1/2 x 1-1/2	1725007	
1-1/2 dia.	1-5/8 x 1-3/4 x 2-3/4	1725002	
1-1/2 dia.	1-3/4 x 2-1/2 x 2-3/4	1725003	
2-1/8 dia.	2-3/4 x 3-1/2 x 4-7/8	1725004	

*One clamp per set.

V-BLOCK AND CLAMP

SERIES 255:



Made of hardened steel and precision ground. Block can be used on its base, end, or sides. Block has 4 tapped clamping holes with 3/8"-16 thread. Clamp has adjustable side screw for support.



90° SUPER DUTY V-BLOCK SETS

SERIES 255:



All V-blocks are parallel, square and centered within 0.0002". Completely hardened and ground tool steel, fitted case. One reversible swing away clamp supplied with each block.



INDIVIDUAL BLOCKS							
Model No.	Dim.	"V" Cap	Lbs.	Suburban		MEDA	
				Order No.	Price	Order No.	Price
90° V Blocks							
VB-222-S0	2-1/2 x 2-1/2x 2	1-5/8	3 lbs.	6410049		7940015	
VB-334-S1	3 x 4 x 3	2-7/8	9 lbs.	6410050		7940016	
VB-466-S2	6 x 6 x 4	4-3/8	33 lbs.	6410051			
VB-666	6 x 6 x 6	4-3/8	50 lbs.	6410052			

MATCHED PAIRS 90° V Blocks				
Model No.	Suburban		MEDA	
	Order No.	Price	Order No.	Price
VB-222-M-S0	6410053		7940017	
VB-334-M-S1	6410054		7940018	
VB-466-M-S2	6410055			
VB-666-M	6410056			

Quality Precision Tools



The Choice Is Yours!!!

Capacity	Size	Order No.	Price
1-5/16 dia.	1-7/8 square x 3-5/8 long	1725006	

Dimensions	Vee Capacity	Order No.	Price
2-3/8x2-3/8x2"	1-3/16"	2550000	
4-1/8x4-1/8x3-1/16"	2-9/16"	2550001	

PRECISION V-BLOCK AND CLAMP - FOR LARGER CAPACITY WORK
STARRETT SERIES 578:



V-block will handle round work up to a diameter of 4" (100mm). The block can be used on its side or on its end for machining or inspection, with no interference from the clamp. A reversible swing-away style clamp is furnished with the unit. The three tapped hole positions in the V-block for the clamp allow the clamp to be positioned at either end or at the center. Two tapped holes in one end of the V-block provide for mounting it perpendicular to a face plate. Clearance holes in the bottom provide for mounting the V-block to angle plates or other fixtures. The block is 5-1/4" wide, 3" high and 3-3/8" long (133 x 75 x 86mm) and made of hardened steel, precision ground.



Description	Capacity Diameter	Catalog No.	EDP No.	Price
V-block and clamp	Max 4" (100mm) Min. 9/16" (14mm)	578	64960	

V-BLOCK AND CLAMP
STARRETT SERIES 567:



Can be used on base, end, and flat on either side as clamp is within outside width of block. Clamp is provided with an adjustable side screw with caps to support block and prevent tilting. Groove at stepped end at right angle to base and is handy for holding shouldered studs, round pins, etc. Hole clearance for drilling and removing dowel pins is provided. Block has four 3/8" -16 tapped holes, two in base and one on each side to attach angle iron. Angle iron holding block can then be attached to lathe faceplate or held by magnetic chuck. Block made of hardened steel. Sides are ground parallel and the groove central and parallel to sides and base. Size 1-7/8" (48mm) square, base length about 3-1/2" (89mm).

Description	Capacity	Catalog No.	EDP No.	Price
Set complete: One V-block and one clamp	1-5/16" (33mm)	567	52588	

V-BLOCKS AND CLAMP
STARRETT SERIES 271:



- Complete set with 2 V-blocks and 1 clamp.
- Case hardened steel.
- Used singly or in pairs.
- Includes steel rod which keeps blocks in alignment.
- Hold work up to 1-1/4" (32 mm) diameter.

Catalog No.	EDP No.	Price
271C	51295	

V-BLOCKS AND CLAMPS FOR ROUND OR SQUARE WORK
STARRETT SERIES 568:



- Clamps have screw holes at 45° and 90° for holding either round or square work.
- Clamp can be mounted on V-block in low or high position for small or large work.
- 3/8"-16 Tapped holes for mounting the V-block on face plates or angle irons.
- V-blocks are hardened steel precision ground, parallel, and square on all sides.
- V-groove is ground central and parallel to sides and base for perfect alignment in matched pairs.
- Each block is 2-1/2" long x 3" wide x 2" high (63 x 75 x 50 mm).

V-BLOCKS AND CLAMPS SET
STARRETT SERIES 278:



V's are ground central, parallel and square with ends and sides. Made of tool steel and hardened. Manufactured and numbered in pairs, so that V's in each block are always in alignment. Tapped hole 1/4"-20 through sides. Angle iron and blocks can then be attached to lathe faceplate or held by magnetic chuck. Each block 1-1/4" (32mm) square and 1-5/8"(40mm) long.



Description	Capacity	Catalog No.	EDP No.	Price
Set complete: Two V-blocks (one pair) and two clamps	1"/25mm	278	51312	

Description	Catalog No.	EDP No.	Price
Two V-blocks (matched pair) and two clamps 2" (50mm) round - 1-7/16" (36mm) square capacity	568C	52592	

SUPER WEE BLOCKS

SERIES 986:



(Smallest Vee Blocks in the World)

Ideal for: holding and indexing pins and punches while grinding-drilling-milling-EDM work (electrodes, etc.). Inspecting parts on optical comparators. Used in conjunction with large V-Blocks or Magnetic V-Blocks. Provides maximum bearing surface. It's a complete holding fixture system with bridges to straddle longer parts and yet the top hold-down screw of grinding fixture is utilized efficiently. Work area is clearly visible. Grind or machine miniature or intricate parts.

- Precision hardened and ground, Wee Blocks are within .0002" in both squareness and parallelism.
- Clamps are reversible.
- Blocks and clamping bars are hardened



Complete in Fitted Case, set includes:

- 1- Super Wee Block "A" capacity .030"-5/32"
- 1- Bridge A (for above)
- 1-Super Wee Block "B" capacity .050"-9/32"
- 1-Bridge B (for above)
- 1-Ring Clamp with thumb screw for Block "A"
- 1-Ring Clamp with thumb screw for Block "B"
- 2-Top Clamping Bar - 1/8"
- 2-Top Clamping Bar -5/32"
- 1-Top Clamping Bar -3/16"



Model No. 16096	
Order No. 8616096	Price



While we show only the most popular **FLEXBAR** items we can supply their entire range of products. Please inquire for a complete **FLEXBAR** catalog.

MICRO-RISE HIGH PRECISION ADJUSTABLE "V" BLOCKS

SERIES 986:



High Precision Adjustable V-Blocks Use for inspection, production milling, work staging, spin grinding, or any operation requiring precision adjustable support.

FEATURES:

- Hardened and ground anvils support up to 1,000 lbs.
- Wide angle "V" accepts 3/16" to 5" diameters.
- Top flats ground parallel to base. Can hold wide, flat parts. Narrow flats may be held on a parallel across top.
- Vibration lock, (position lock), prevents creeping.
- Insures solid support without deflection
- 1/2" total rise of "V", .050" per revolution.
- Dial graduated in increments of .001".
- Available in metric screw and dial.

Dimensions	
• Base.....	1-3/4 x 4"
• "V" Section.....	13/16" Wide
• Height Closed	3"
• Height Open	3-1/2"
• Standard "V" Angle.....	120°
• Special "V" Angle.....	90° on request

Model No.	Description	Order No.	Price
16505	Std. 2 pc. set	8616505	
16507	Std. 2 pc. set w/clamps	8616507	

BALL BEARING "V" BLOCK

Enables you to inspect and detect out-of-round conditions and lobes with no damage to parts and no damage to blocks.

SERIES 986:

Sold in Matching Pairs:
±5 Microns
with Clamps & Test Ball



Model No.	Size	Inspection Capacity	Dia. of Balls	Wt. Capacity of Pair	Work Capacity w/ Clamps	Order No.	Price Per Pair
16093	Small (2"x2"x1")	3/64" to 2-1/2"	1/2"	220 lbs.	1-1/4"	8616093	
16094	Medium (3-3/8"x3-3/8"x1-3/8")	3/32" to 5"	15/16"	1,100 lbs.	2-1/2"	8616094	
16095	Large (4-3/4x4-3/8"x2-3/8")	3/16" to 15"	1-1/2"	2,000 lbs.	3"	8616095	

MAGNETIC V BLOCK-DUAL VEE  **SUPERIOR IMPORT**
 SERIES 509:

- All working surfaces are precision ground.
- Ideal for holding, inspection and light machining.
- Accuracy of Vee is within 0.0003" (0.007mm).
- Powerful, permanent magnet is controlled by rotary ON/OFF switch.
- Supplied in fine finished wooden box.
- 6" long V-block is 50% longer and 100% stronger than 4" V-blocks.



Order No.	Length	Width	Height
1726012	2-3/4"(70mm)	2-1/8"(54mm)	2-7/8"(73mm)
1726006	4"(100mm)	2-3/4"(70mm)	3-3/4"(95mm)
1726212	4"(100mm)	2-3/4"(70mm)	3-3/4"(95mm)
1726220	6"(150mm)	3"(75mm)	3-3/4"(95mm)

Order No.	V-Width		Price
	Big V	Small V	
1726012 (Single)	1-1/2"(38mm)	3/4" (19mm)	
1726006 (Single)	2"(50mm)	3/4" (19mm)	
1726212 (Pair)	2"(50mm)	3/4" (19mm)	
1726220 (Single)	2-1/4"(55mm)	1" (25mm)	

HIGH PRECISION TOOLMAKERS VISES  **SUPERIOR IMPORT**
 SERIES 256:



Made of hardened steel. All surfaces including jaws are precision ground with .0004" accuracy for flatness, parallelism and squareness. Can be used in any position. Models 1730001 and 1730002 have "V" grooved jaws for holding round work.

Width	Height	Depth of Jaw	Jaw Opening	Order No.	Price
2-3/8"	1-3/4"	15/16"	2-3/16"	1730001	
2-7/16"	2-7/16"	1-1/8"	3"	1730002	
3"	2-1/4"	1-1/4"	2-3/8"	1730003	

DUAL - VEE MAGNETIC V-BLOCK

STARRETT SERIES 271:



Magnetic V-blocks are designed for versatility and accuracy. All working surfaces are precision ground to provide convenient set-ups for inspection and light machining. Two precision vees will hold round stock sizes from 1/4" to 1-3/4" diameters. A powerful permanent magnet is controlled by a rotary switch. All working surfaces are heat treated for long wear and stability. Each block is 2-1/2" wide x 3" high x 3" (63 x 75 x 75mm) long. The top vee is 1-1/2" (38mm) wide at top, and 3/4" (19mm) wide at bottom with 90° included angles.

Capacity	Catalog No.	EDP No.	Price
1-3/4" (44mm)	566	63323	

QUICK ACTING PRECISION VISES

SERIES 256:



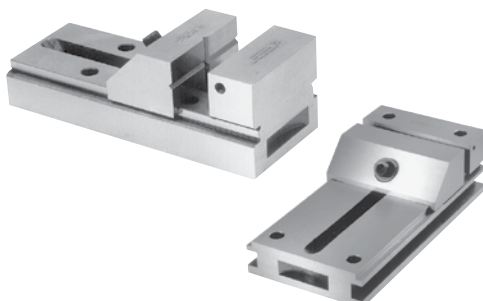
All surfaces hardened and precision ground to ± .0002". Base and stationary jaw are one solid piece. Horizontal and Vertical "V" on moveable jaw for holding round work. Up to 400 lbs. pressure at 45° downward angle keeps work rigid. Quick adjustment is made by pulling pin and pushing sliding jaw forward -then tightening with an Allen wrench.

Overall Length	Width	Height	Depth of Jaw	Jaw Opening	Order No.	Price
6"	2"	2"	1-3/16"	3"	1730206	
7"	3"	3"	1-1/2"	3-3/8"	1730307	

PRECISION VISES

SERIES 641: SUBURBAN - USA

SERIES 794: MEDA - SUPERIOR IMPORT



Angled channel provides extra jaw capacity. Jaw can be opened or closed without unbolting from work surface. Squareness and parallelism within .0002". V-237-S1 has recessed pockets at both ends for clamping. Vees machined in face of moveable jaw and 12 stepped channel which eliminates side holes are available on some models.

Model	Dimensions	Jaw Cap	Lbs.	Suburban		MEDA	
				Order No.	Price	Order No.	Price
V-225-S0	5-7/8 x 2 x 2	3-1/4	6 lbs.	6410036		7940006	
V-237-S1	7-1/2 x 3 x 2-5/8	4-3/4	11 lbs.	6410037		7940007	
V-411-S2	11 x 4 x 3	7	20 lbs.	6410038		7940008	
V-612-S2	12 x 6 x 3-7/16	8	40 lbs.	6410039		7940009	