

Precision V Blocks

V Blocks with Clamp(Cast Iron)

Instruction Manual

To ensure correct use, please read this instruction manual carefully before use. After reading, keep it in a safe place where the user can always refer to it.



OBISHI KEIKI SEISAKUSHO Co., Ltd.

Safety Precautions

- ※Before use, please read this instruction manual carefully and use the product correctly.
- ※The precautions shown here are intended to ensure the safe and proper use of the product and to prevent any potential hazards to the user.
- ※The precautions are categorized into three levels — **Danger, Warning, and Caution** — to clearly indicate the severity and urgency of potential harm or damage that may occur if the product is mishandled.

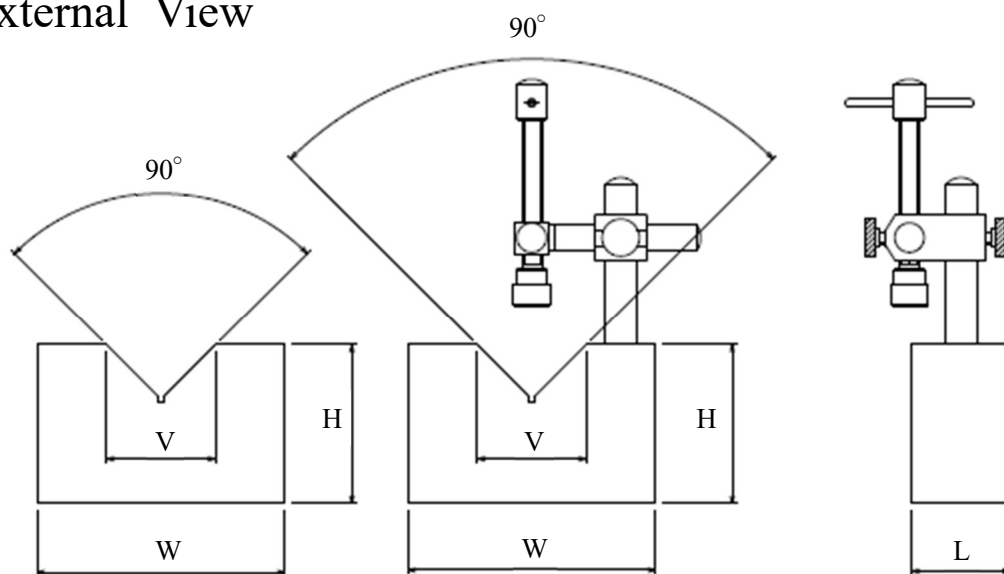
For Safe and Proper Use		
This instruction manual includes various symbols and pictograms throughout the text to ensure correct use of the product and to prevent harm or damage to the user. The symbols and their meanings are as follows. ● Please read the text after fully understanding the symbols and their meanings. ● After reading, be sure to keep this manual in a place where anyone using the product can easily refer to it at any time. ● All of these are safety-related instructions, so please be sure to follow them.		
	Danger	This indicates situations where incorrect handling could result in imminent risk of death or serious injury.
	Warning	This indicates situations where incorrect handling could potentially result in death or serious injury.
	Caution	This indicates situations where incorrect handling may result in injury to persons or only property damage.
Examples of symbols		The △ symbol indicates the presence of danger, warning, or caution messages, with specific precautions described within the figure. (The left figure is used to indicate general danger, warning, or caution without specifying details.)
		The ○ symbol indicates prohibited actions, with specific precautions described within or below the figure. (The figure on the left is used for general prohibition notices without specifying particular actions.)
		The ● symbol indicates mandatory actions, with specific instructions detailed within the figure. (The figure on the left is used for general mandatory actions or instructions without specifying details.)

V Blocks with Clamp(Cast Iron) Instruction Manual

1. Product Features

- They are manufactured as a set of two, with the parallelism between the two base surfaces and the V-grooves ensured.
- A clamp (one piece) is included for securing the workpiece.
- They are used for measuring cylindrical workpieces and as holding fixtures during machining operations.
- The V-groove angle is 90 degrees.

2. External View



3. Specifications

Code No.	Nominal	Size (W×H×L×V mm)	Base and V-groove Parallelism (μ m)	Range (Φ)	Mass (kg/Set)
JG101	125	125×80×50×55	10	8~50	6.5
JG102	150	150×90×65×65		8~80	9.0
JG104	200	200×140×100×85	15	10~110	20.0

4. Instructions for Use

【Measurement of cylindrical workpieces (Figure 1)】

Example 1)

Place the product on a Reference Surface Plate and position the workpiece in the V-groove.

Bring the contact point of a dial gauge into contact with the workpiece to measure parallelism or eccentricity.

Note: When measuring, move the stand with the dial gauge by sliding it on the Reference Surface Plate.

【Use as a Parallel Block (Figure2)】

Example 2)

Place this product on a Reference Surface Plate with the top surface facing upward.

Place the workpiece on top, and use the measuring tip of the dial gauge to measure parallelism and straightness.

Note: During measurement, move the stand holding the dial gauge smoothly by sliding it on the Reference Surface Plate.

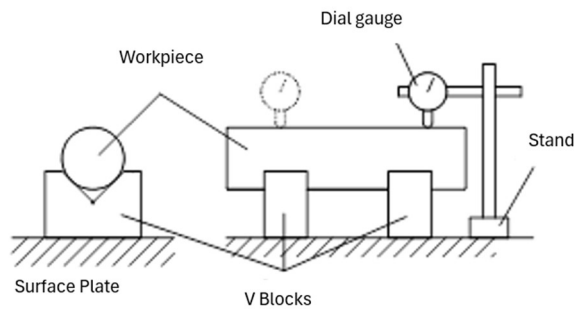


Figure 1

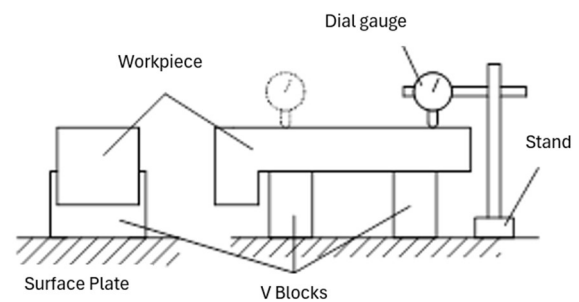


Figure 2

5. Precautions for Use

- ① Clean the Precision Surface and the measurement surface of the workpiece before use.
- ② Handle the instrument carefully during use and storage to avoid impact or shock.
- ③ Allow the instrument to acclimate to the ambient temperature before use.
- ④ Do not use or store the instrument in places with drastic temperature changes.
- ⑤ After use, always apply rust prevention treatment and store the instrument in its storage case.
- ⑥ Check the instrument for abnormalities before use in the following cases:
 - When the instrument has been dropped.
 - When an object has been dropped onto the instrument.
- ⑦ If there are scratches or damage, have the instrument repaired and inspected. Remove minor scratches on the Precision Surface locally with an Arkansas stone or similar before use.
- ⑧ Check the accuracy regularly before using the product.
- △ ⑨ If the product has sharp edges, handle it carefully to avoid injuring your fingers or other parts of your body.
- △ ⑩ Wear protective gloves and safety glasses as necessary to prevent injury while working.
- △ ⑪ Do not use this product if it is damaged or deteriorated, as it may cause injury or accidents.
- △ ⑫ If an injury occurs, give first aid immediately and seek medical attention if necessary.

Contact Information



JIS Certified Factory

OBISHI KEIKI SEISAKUSHO Co., Ltd.

Head Office: 1-1216-1 Nanyo, Nagaoka City, Niigata 940-1164

TEL: (0258)22-1100 FAX: (0258)22-0014

Tokyo Office: 3-5, Kanda Surugadai, Chiyoda-ku, Tokyo 101-0062

TEL: (03)3293-8881 FAX: (03)3293-8884

Nagoya Office: 2F Nichiju Bldg., 3-15 Oimachi, Naka-ku, Nagoya City, Aichi 460-0015

TEL: (052)322-4031 FAX: (052)322-5647



ISO9001 Certified (JQA-QMA11294)

Head Office and Factory

ISO9001
JQA-QMA11294

Design, development, manufacturing, and calibration services for precision measuring instruments (levels, surface plates, straight edges, reference measuring instruments, square rulers, blocks, dial gauge stands, comparators, angle measuring instruments, bench centers, squareness measuring instruments).