

Precision V Blocks

Box V Block 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.

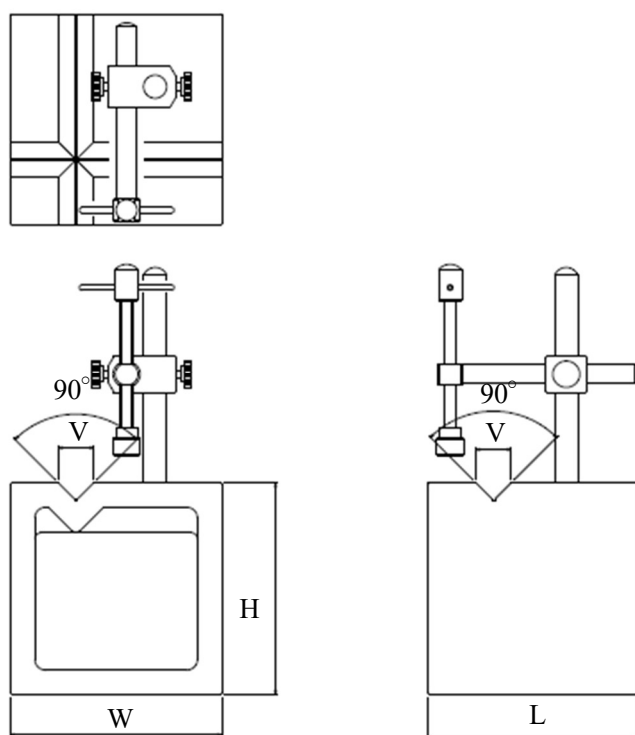
For Safe and Proper Use		
This instruction manual includes various symbols and pictograms throughout the text to ensure correct use of the product and to prevent harm or damage to the user. The symbols and their meanings are as follows. ● Please read the text after fully understanding the symbols and 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.)

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1. Product Features

- The parallelism and squareness of all six faces are maintained with high precision.
- A clamp (one piece) is included for securing the workpiece.
- It is very convenient for measuring cylindrical workpieces and for use as a parallel block.
- The V-groove angle is 90 degrees.

2. External View



3. Specifications

Nominal	Size (W × H × L × V mm)	Special Grade		Grade A		Grade B		Range (Φ)	Mass (kg)
		Code No.	Parallel Square- ness(μm)	Code No.	Parallel Square- ness(μm)	Code No.	Parallel Square- ness(μm)		
100	100 × 100 × 100 × 15	JK101	4.0	JK201	7.0	JK301	14	7~18	4

150	$150 \times 150 \times 150 \times 22$	JK103	4.5	JK203	8.0	JK303	16	10~30	11
200	$200 \times 200 \times 200 \times 33$	JK105	5.0	JK205	9.0	JK305	18	11~45	22
250	$250 \times 250 \times 250 \times 35$	JK106	5.5	JK206	10.0	JK306	20	12~48	37
300	$300 \times 300 \times 300 \times 45$	JK107	6.0	JK207	11.0	JK307	22	14~60	69
350	$350 \times 350 \times 350 \times 50$	JK108	6.5	JK208	12.0	JK308	24	14~68	109
400	$400 \times 400 \times 400 \times 55$	JK109	7.0	JK209	13.0	JK309	26	14~75	133
500	$500 \times 500 \times 500 \times 60$	JK110	8.0	JK210	15.0	JK310	30	14~82	267

4. Instructions for Use

【Measurement of cylindrical workpieces (Figure 1)】

Example 1)

Place the product on a Reference Surface Plate, position the workpiece in the V-groove, and secure it with the clamp.

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

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

【Use as a Parallel Block (Figure2)】

Example 2)

Place the product on a Reference Surface Plate with its top face upward.

Place the workpiece on top and secure it with the clamp.

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

Note: During measurement, move the stand with the dial gauge smoothly across the Reference Surface Plate.

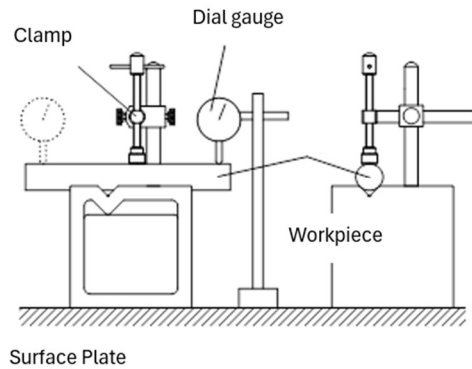


Figure 1

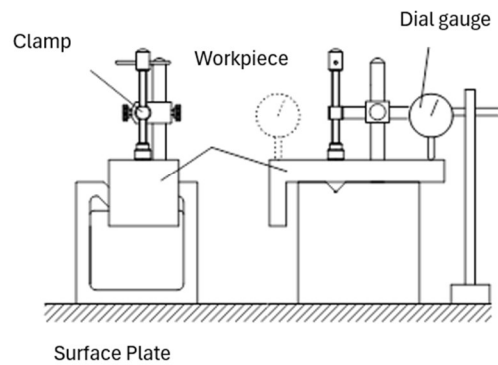


Figure 2

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

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Head Office and Factory

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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).