



## BASES GIRATORIAS SERIES 30 SERIES 30 SWIVEL BASES



Manual de instrucciones  
*Manual instructions*



ES

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MIBG  
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Contacto: [ventas@forza.es](mailto:ventas@forza.es) / [www.forza.es](http://www.forza.es)

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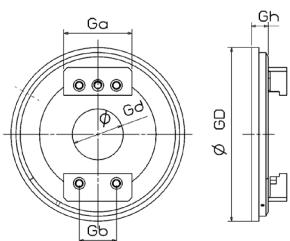
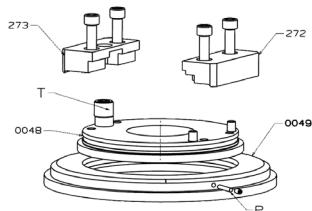
## Características técnicas / Technical features

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Las bases giratorias están fabricadas en acero al carbono. / These swivel bases are made in carbon steel.

Se componen de dos anillo (exterior e interior), dos bridas y un tornillo excéntrico (T) en las bases giratorias B/150 y B/200. / B/150 and B/200 include 2 rings (external and internal), two straps and an eccentric screws (T) B/100 and B/125 include two wedges.

El prisionero y varilla P se utilizan para bloquear el anillo interior. / The pin and the P bar are used to block the internal ring.

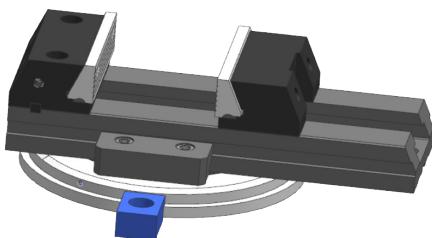


Ref.	Ga	Gb	Gd	GD	Gh	Bridas Clamps	Peso Wright
<b>B/100</b>	78	53	55	214	19	12560	6,5
<b>B/125</b>	90	58	55	236	24	12560	9,5
<b>B/150</b>	110	60	82	280	27	15060	14
<b>B/200</b>	140	85	90	325	30	15060	20

## Sujección de la mesa / Assembly to the working table

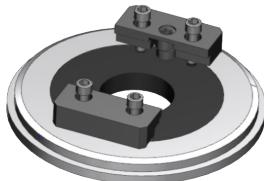
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Para sujetar las bases se utiliza un juego de dos bridas, que no están incluidas en las bases giratorias. / To fix the swivel base to the working table 2 straps are used. These straps are not included in the swivel bases.

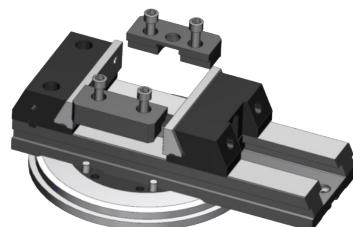


## Uso de las bases giratorias / Use of the swivel base

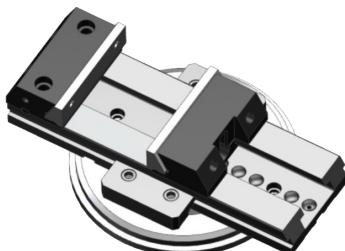
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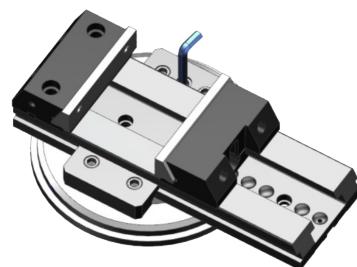
1. Amarre la base a la máquina y suelte las bridas de la base giratoria. / Fit the base on th machine and remove the straps of the swivel base.



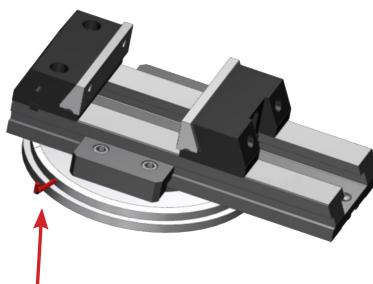
2. Coloque la mordaza, el cuerpo quedará entre los pasadores y el tornillo excéntrico. / Place the vice, the body will be place between the pins and the eccentric screw.



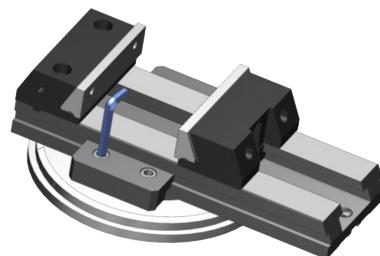
3. Con los 4 tornillos sin apretar desplace la mordaza para buscar el centro de giroque necesita. / Before tightening the 4 scews, move the vice unitl find the rotating centrt that is required.



4. Una vez localizado el centro bloquee la mordaza con el tornillo eexcéntrico. / Once the rotatinf centr in located, block the machine vice with the eccentric screw.



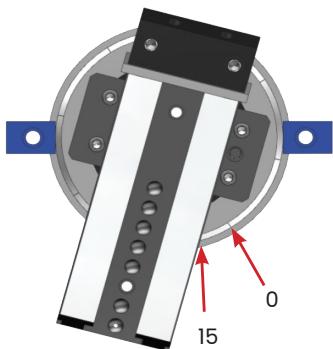
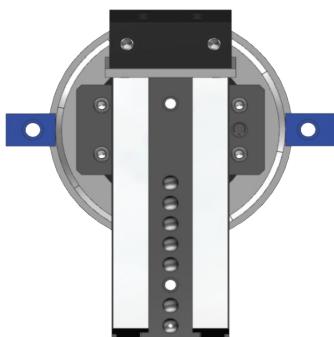
5. Gire la mordaza sobre la base giratoria hasta buscar la posición deseada. Cuando la tenga bloquee el anillo con el prisionero lateral. / Turn the vice on the swivel vice until get the desired position. Then, block the ring with the lateral pin.



6. Apriete los 4 tornillos para trabajar. / Tighten the 4 screws to work.

## Puesta a cero de la base / Zero setting of the swivel base

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1. Posicionar el cuerpo de la mordaza en el punto cero de la base giratoria. / Fix the body of the vice in the 0 reference of the swivel base.

2. Girar los grados necesarios utilizando el cuerpo como indicador de giro. / Turn body the necessary grades by using the body as rate indicator.

