

# VERSA-LOK™

Innovative Assembly  
& Mounting Device  
for V-Flange Tool  
Holders



Patent Pending

Bench mounting hardware  
not included

## Owners Manual

### Model: VERSA-LOK-CAT40

### Part Number: 101996

To download a copy of this manual, please visit our website: [www.experienceamt.com](http://www.experienceamt.com)

Document: Versa-LOK-CAT40-OM-REV1.pdf  
Manual Part Number: 102541

# Contents:

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- Mounting / Installation
- Operation
- Limited Warranty and Registration Policy

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# Nomenclature:



# Safety Precautions:

Versa-LOK™ has been designed and is intended to be used with Toolholders that conform to ANSI/JIS standards. In extremely limited cases, like competitive products, Versa-LOK™ may not accommodate Toolholders where manufactures deviate from ANSI/JIS standards.

When tightening collets, retention studs or other Toolholder features, always adhere to torque specifications provided by the manufacture of the respective Toolholder or accessory.

Always use care when handling tools with sharp edges and wear safety glasses where appropriate.

Mount Versa-LOK™ rigidly as outlined in the section titled “Mounting/Installation”

Be sure to verify that the Toolholder is inserted and locked as described in the section titled “Operation”

# Mounting/Installation:

Versa-LOK™ can be mounted to tool carts, work benches, machine frames, building columns, or other rigid structures.

See page 7 for a full size mounting template.

Three clearance holes sized for 3/8" fasteners are provided in the Riser Base of Versa-LOK™. It is recommended that all three fasteners be used and that they be a minimum of grade 8.

The use of wood lag screws is not recommended due to the torque applied when tightening Toolholders, collets, and retention studs. When mounting Versa-LOK™ to a wood bench top, drill 7/16" clearance holes thru the thickness of the bench and use long bolts with washers and locknuts on the bottom of the bench (See Figure 1).

When mounting to metal surfaces, with a minimum thickness of 0.50 inches, it is recommended that the mounting surface be drilled and tapped for 3/8" fasteners or the same procedure as for wood bench mounting may be used.

Be sure to mount Versa-LOK™ with the Tool Pot cantilevered (or overhung) from the bench or other mounting surface. This will allow the Toolholder to be rotated to any of the eight indexing positions and will allow the maximum diameter tool to fully rotate 360 degrees with no interference.

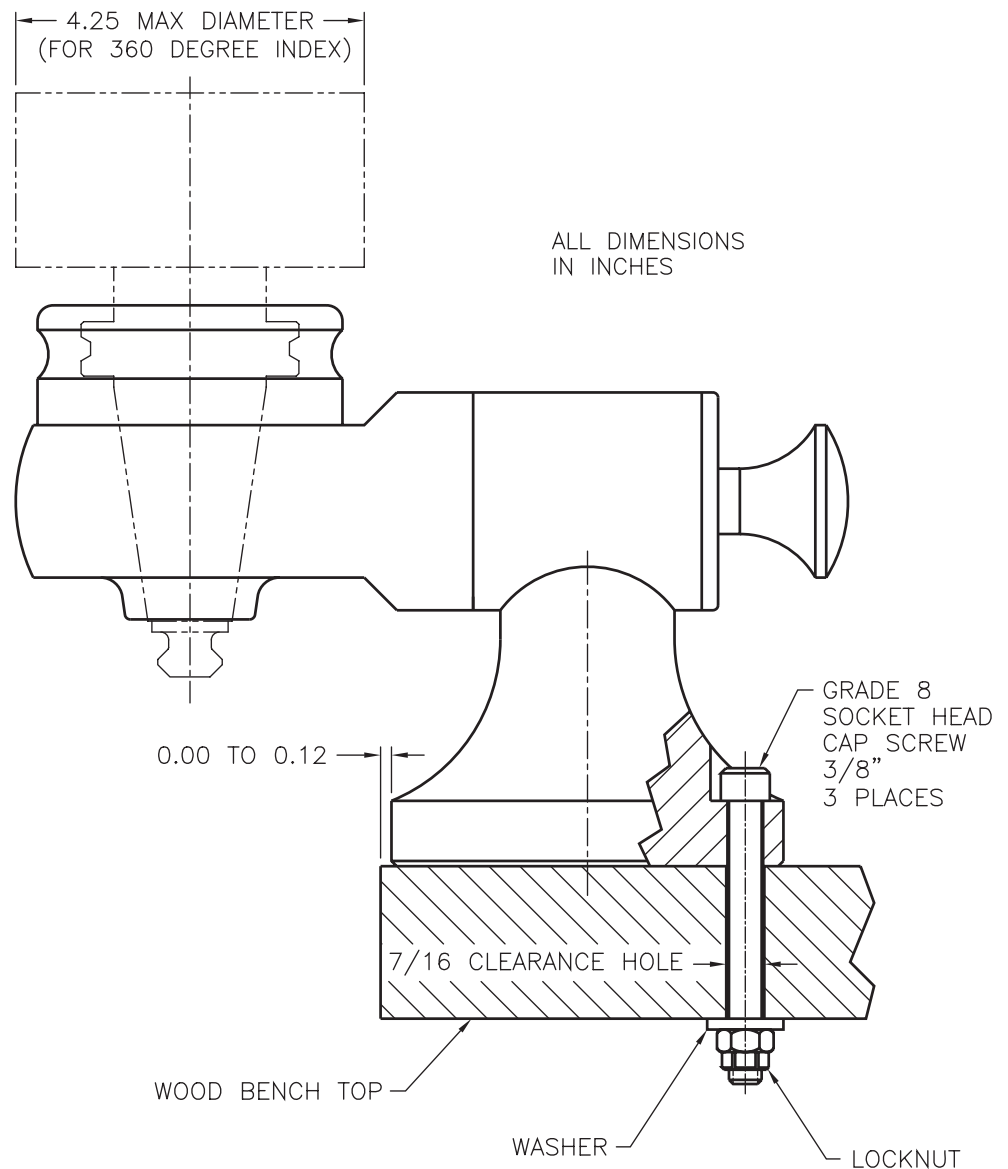


FIGURE 1

# Operation:

## Tool Insertion / Removal Procedure: (See Figure 2)

### Insertion:

- 1) With the Tool Pot in the upright position (0 degrees), use one hand to slide and hold the Lock Collar downward.
- 2) Using your opposite hand, place the Toolholder into the Lock Housing, aligning one of the Toolholder key notches with the Versa-LOK™ Lock Key.
- 3) Release the Lock Collar to clamp the Toolholder in place.

### Warning!

To assure that the Lock Collar is returned to the normal position and the Toolholder has been clamped, verify by pulling upward on the Toolholder and visually inspecting the Lock Collar position. Failure to properly lock and verify the assembly may cause the Toolholder to fall out of the Tool Pot during indexing, which may damage the Tool / Toolholder and may cause personal injury.

### Caution:

Using compressed shop air, be sure to frequently blow out the inside area of the Tool Pot to remove any chips or other debris. Contamination in this area may cause interference when inserting Toolholders and may cause the Toolholder to not fully lock into position.

### Removal:

- 1) With the Tool Pot in the upright position (0 degrees), use one hand to slide and hold the Lock Collar downward.
- 2) Using your opposite hand remove the Toolholder from the Lock Housing.
- 3) Release the Lock Collar.

### Caution:

Only insert or remove Toolholders with the Tool Pot in the upright position (0 degrees)



FIGURE 2

# Operation:

## Rotating the Tool Pot to one of the eight indexing positions: (See Figure 3)

- 1) Use one hand to firmly hold the Tool Pot.
- 2) Use the opposite hand to pull and hold the Release Knob outward.
- 3) Rotate the Tool Pot to the desired index position.
- 4) Release the Release Knob and verify that it snaps into position and locks the Tool Pot from rotation.



### Caution:

The Versa-LOK™ Tool Pot will rotate extremely freely when the Release Knob is pulled outward. Heavy, long Toolholders will rotate/swing very fast due to gravity. Be sure to have a firm grip on the Tool Pot and/or the Toolholder when pulling the Release Knob.



### Hint:

Use the Indexing Indicators on the Tool Pot and the Pivot Lock Housing to help visually position the Tool Pot during indexing.



FIGURE 3

# Tightening/Loosening Collets, Retention Studs and Other Toolholder Features:

When tightening/loosening collets, retention studs and other Toolholder features, apply torque not shock load. Use a leverage bar. This method is safe and will not stress the Toolholder or Versa-LOK™ fixture (See Figure 4).

Do not strike wrenches with hammers to break loose retention studs or collets (See Figure 5).

## Caution

Failure to adhere to torque specifications provided by the manufacture of the Toolholder / accessory may damage the Toolholder, collet or Versa-LOK™ fixture.

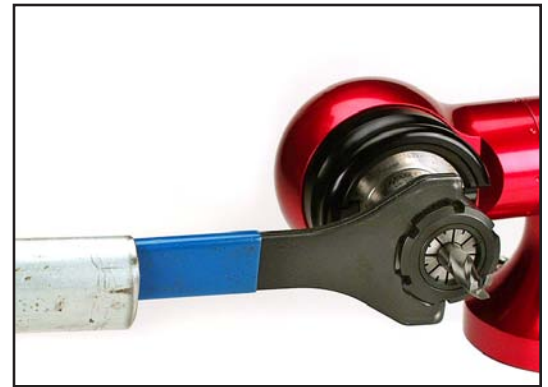
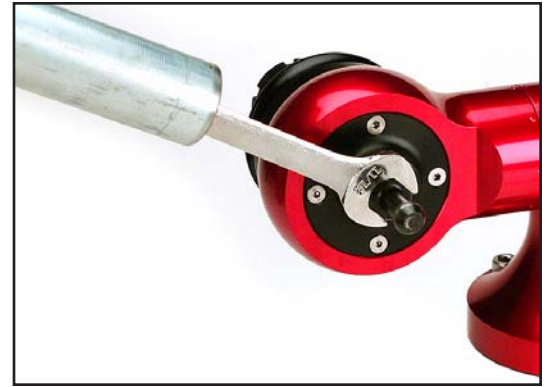
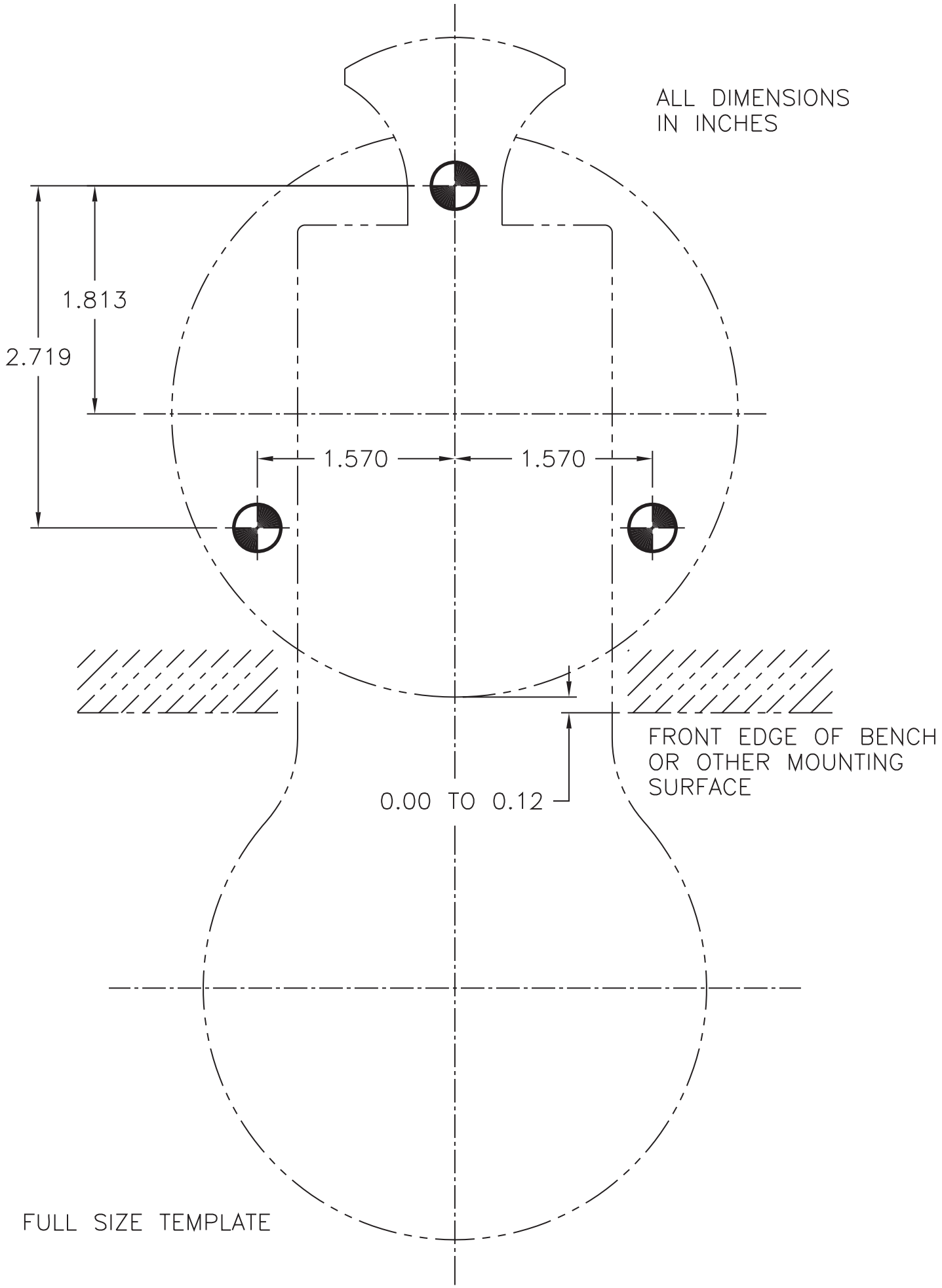


FIGURE 4



FIGURE 5

ALL DIMENSIONS  
IN INCHES



FULL SIZE TEMPLATE

# Limited Warranty:

Thank you for purchasing Versa-LOK™. Automated Machine Technologies, Inc. (AMT) manufactures of Versa-LOK™ products, warrants all parts to be free from manufacturing defects in materials and workmanship for a period of one year from the date of purchase.

This warranty is limited to the first retail purchaser, and is not transferable.

The liability of Automated Machine Technologies, Inc. shall not exceed the parts and labor required to repair or replace defective components. Transportation to or from the factory and any other materials required to make the repair are not included. This warranty does not cover failures or malfunctions resulting from the following:

- 1) Failure to properly install, operate or maintain the product(s) in accordance with our published Installation, Operation and Owners Manuals provided with the product(s).
- 2) Abuse, alteration, accident, fire, flood, lightning, negligence or acts of God.

Automated Machine Technologies reserves the right to inspect any product submitted for warranty claims and approve / disapprove warranty service based upon our investigation of the root cause of the defect. Defects that result from abuse or misuse will not be covered under this warranty.

## Limitation of Liability:

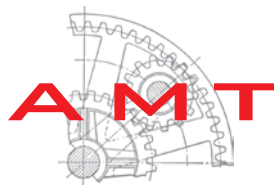
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## Registration:

AMT requires that you register your product(s) online (within 30 days of receipt) by visiting our website: [www.experienceamt.com](http://www.experienceamt.com). Products that have not been registered will not be entitled to warranty services.

## Warranty Claims:

For prompt warranty consideration, contact us for instructions regarding the claim and to obtain a Returned Material Authorization (RMA). All returned parts must have a RMA to be evaluated under the terms of this warranty.



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