

PALMGREN®

TRADITIONAL DRILL PRESS VISES



MODELS:

9612152

9612251

9612253

9612301

9612401

9612602

Read carefully and follow all safety rules and operating instructions before first use of this product.



DESCRIPTION

Palmgren Traditional Drill Press Vises are assembled in the U.S, and are constructed from fine grain cast iron with replaceable steel jaw plates. Lead screws on Models 9612152, 9612251 and 9612253 are precision cut V-thread. Lead screws on Models 9612301, 9612401 and 9612602 have a rugged Acme thread. All vises can be used when placed on end or either side. Models 9612301, 9612401 and 9612602 have grooves in the body for clamping. Center of base is open for holding work through body of vise. Base and bed are parallel to 0.001" on all vises.

SAFETY RULES

- Understand and obey all safety instructions supplied with drill press, mill or other machines on which vise is used.
- Bolt or clamp vise to work surface in at least two mounting locations using clamping kit (not supplied).
- Be sure workpiece is clamped securely between jaws before starting machining operation.
- Do not over tighten—vise can develop a large clamping force. Use only force which is needed.
- Do not pound or hammer on workpiece. This vise is designed to clamp the workpiece in a desired position for machining operations only.

Model	A	B	C	D	E	F	G	Weight
9612152	1-1/2"	5-1/8"	1-13/16"	1"	1-1/2"	-	-	2 lbs
9612251	2-7/16"	7-1/2"	2-9/16"	1-1/2"	3"	-	-	6 lbs
9612253	2-7/16"	8"	2-9/16"	1-1/2"	2-1/2"	-	-	6 lbs
9612301	3"	9"	3"	1-3/4"	3"	7/16"	3/8"	11 lbs
9612401	4"	10-3/4"	3-1/4"	1-3/4"	4"	7/16"	3/8"	19 lbs
9612602	6"	13-3/4"	4"	2"	6"	5/8"	1/2"	39 lbs

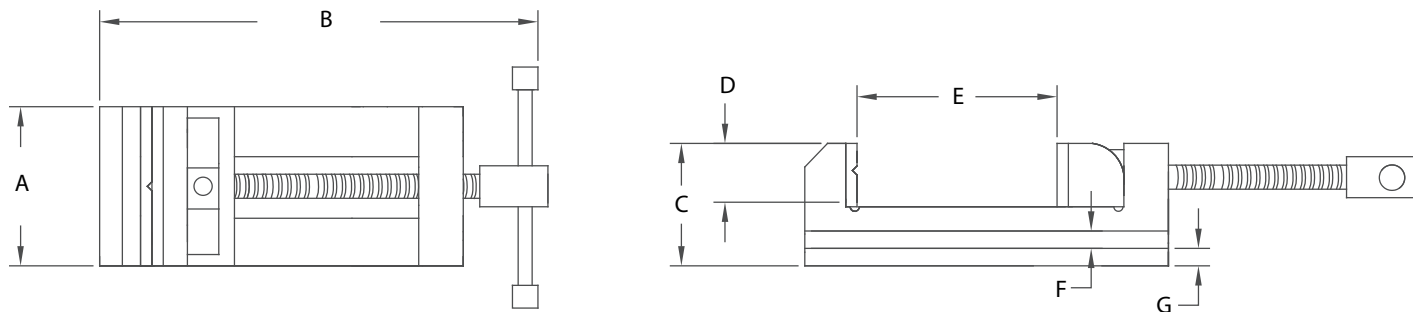


Figure 1 - Dimensions

DIMENSIONS

Refer to Figure 1.

OPERATION

Refer to Figure 2.

- Mount vise to work surface in desired location.
- Open jaws of vise and place workpiece between jaws in desired position. Secure workpiece between jaws by rotating leadscrew with handle (Ref. No. 3). Be sure workpiece is held securely in vise before starting machining operation.

MAINTENANCE

Particles of metal or wood can damage machined surfaces, causing difficult or inaccurate operation.

- The vise is shipped with a protective coating. This coating should be removed before operation. Use penetrating oil to remove protective coating.
- Keep machined surfaces and all moving parts clean and free of dirt, chips and foreign materials.
- Keep machined surfaces and lead screws lubricated with medium weight machine oil.

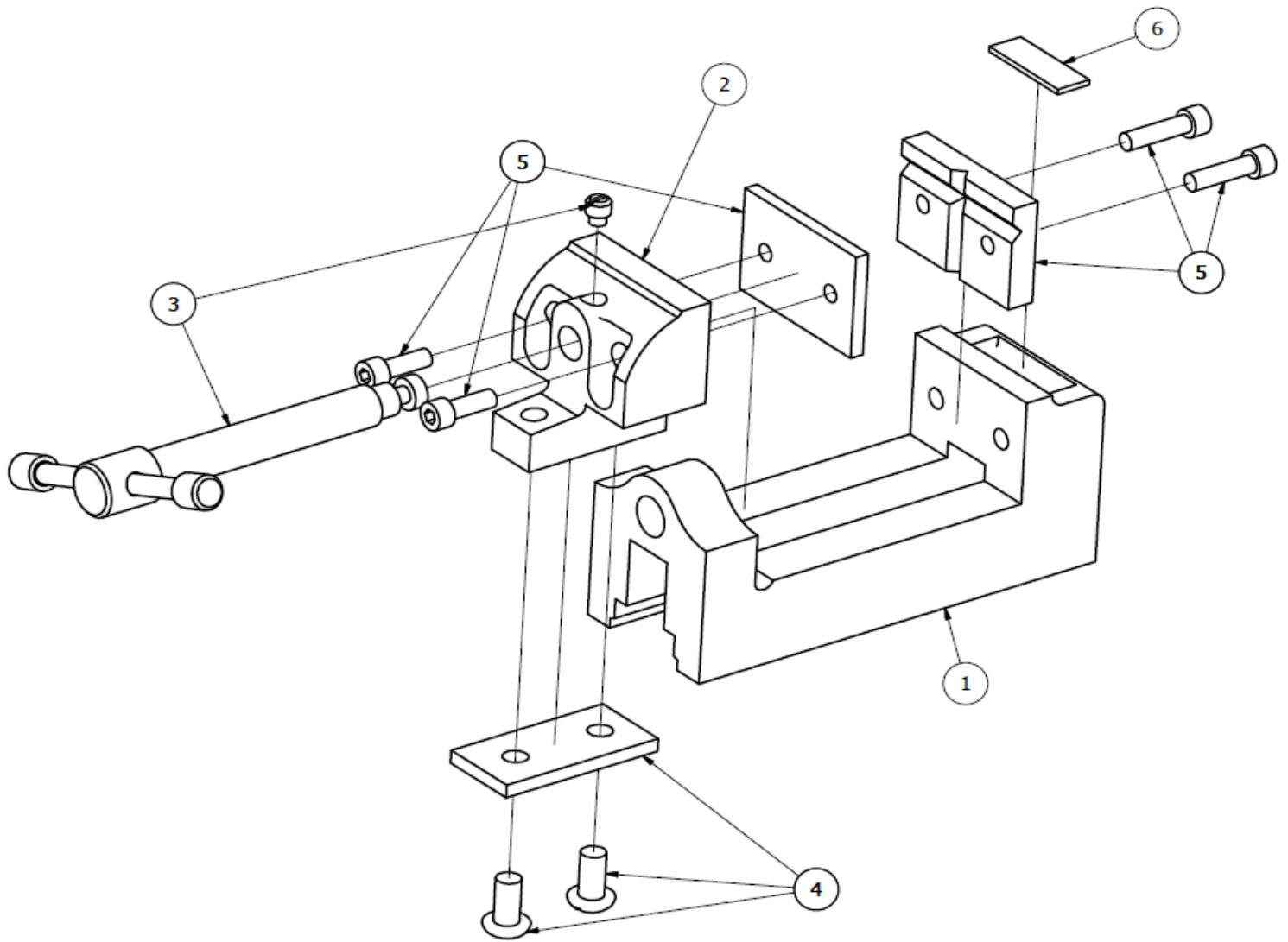


Figure 2 - Replacement Parts Illustration for Traditional Drill Press Vises

REPLACEMENT PARTS LIST FOR TRADITIONAL DRILL PRESS VISES

Ref. No.	Description	Model 9612152	Model 9612251	Model 9612253	Model 9612301	Model 9612401	Model 9612602
1	Body	N/A	N/A	N/A	N/A	N/A	N/A
2	Follower	N/A	N/A	N/A	N/A	N/A	N/A
3	Lead Screw Assembly	9610009.00	9610010.00	9610010.00	9610011.00	9610012.00	9610013.00
4	Bottom Plate Kit	9610024.00	9610025.00	9610025.00	9610025.00	9610026.00	9610027.00
5	Jaw Plate Kit	9610014.00	9610015.00	9610015.00	9610016.00	9610017.00	9610018.00
6	Palmgren Nameplate	N/A	N/A	N/A	N/A	N/A	N/A

(N/A) - Not available as a replacement part.

WARRANTY

Palmgren warrants their products to be free of defects in material or workmanship. This warranty does not cover defects due directly or indirectly to misuse, abuse, normal wear and tear, failure to properly maintain the product, heated, ground or otherwise altered, or used for a purpose other than that for which it was intended. The warranty does not cover expendable and/or wear parts (i.e. v-belts, coated screws, abrasives), damage to tools arising from alteration, abuse or use other than their intended purpose, packing and freight. The duration of this warranty is expressly limited to the terms noted below beginning from the date of delivery to the original user. Palmgren products carry the following warranties on parts with a 1 year warranty on labor:

- USA Machine vises – Lifetime
- IQ Machine vises – Lifetime
- Bench vises – Lifetime
- Positioning tables – Lifetime
- Bench grinders, buffers and belt grinders – 3 years
- Tapping machines – 3 years
- Drilling machines – 3 years
- Finishing machines – 3 years
- Band saws – 3 years
- Work stands – 3 years
- Arbor presses – 3 years
- Milling machines – 3 years
- Lathes – 3 years
- Accessories – 1 year

The obligation of Palmgren is limited solely to the repair or replacement, at our option, at its factory or authorized repair agent of any part that should prove deficient. Purchaser must lubricate and maintain the product under normal operating conditions at all times. Prior to operation become familiar with product and the included materials, i.e. warnings, cautions and manuals. **Failure to follow these instructions will void the warranty.**

This warranty is the purchaser's exclusive remedy against Palmgren for any deficiency in its products. Under no circumstances is Palmgren liable for any direct, indirect, incidental, special or consequential damages including lost profits in any way related to the use or inability to use our products. This warranty gives you specific legal rights which may vary from state to state.

SERVICE & REPAIR

1. If a Palmgren product requires a repair or warranty service **DO NOT** return the product to the place of purchase.
2. All warranty related work must be evaluated and approved by Palmgren/C.H. Hanson.
3. Prior to returning any item the user must obtain factory approval and a valid RGA number.
4. For instructions and RGA number call toll free (800) 827-3398.