

Another remarkable feature of the Kurt Anglock Vise is the ease with which it can be restored to like new condition — in your own shop. Following these simple steps you can restore a worn or abused vise to original condition.



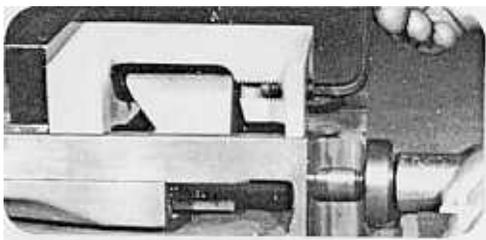
If your vise should become worn or abused where repairs are required, note the simplicity required to restore the vise to new condition even in your own shop. First, note that the jaw plate can easily be removed.



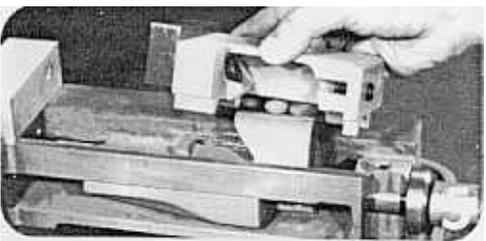
Remove the two socket head cap screws holding the stationary jaw to the bed.



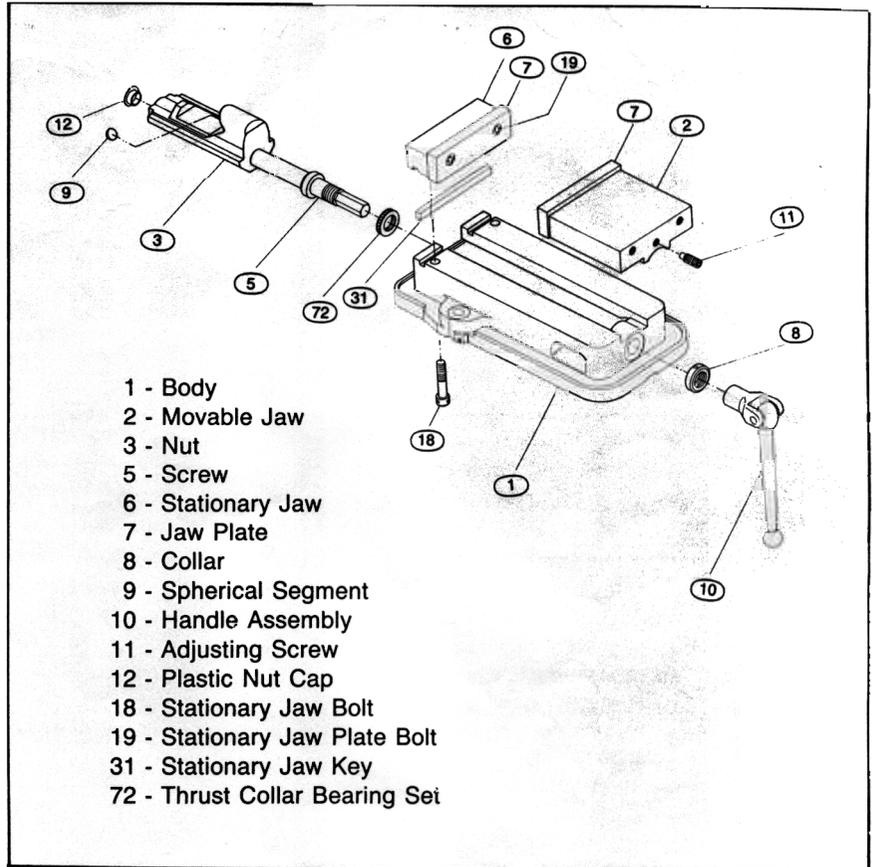
Lift the jaw from the bed.



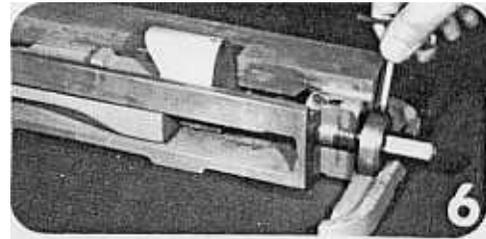
Loosen the adjusting screw and .



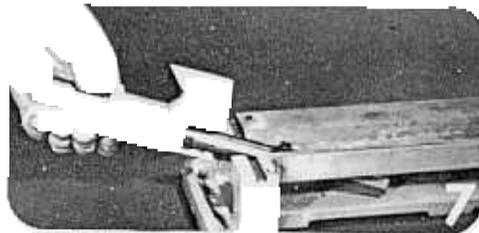
Lift the movable jaw off the bed.



- 1 - Body
- 2 - Movable Jaw
- 3 - Nut
- 5 - Screw
- 6 - Stationary Jaw
- 7 - Jaw Plate
- 8 - Collar
- 9 - Spherical Segment
- 10 - Handle Assembly
- 11 - Adjusting Screw
- 12 - Plastic Nut Cap
- 18 - Stationary Jaw Bolt
- 19 - Stationary Jaw Plate Bolt
- 31 - Stationary Jaw Key
- 72 - Thrust Collar Bearing Sei



Remove the set collar from the vise screw and . . .



Slide the screw assembly forward out of the body.

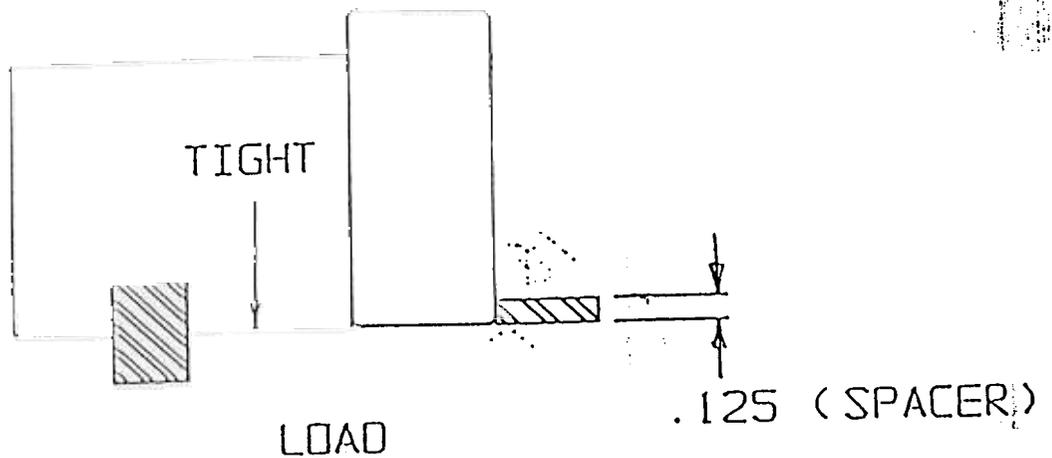


Regrind the body to restore flatness and remove blemishes, and reassemble.

#18 SHCS

D40 = 48 FT LBS.
D675 = 150 FT. LBS.
D688 = 150 FT. LBS.
D810 = 260 FT. LBS.
D100 = 360 FT. LBS.

6-1-92



NOTE: LOAD IS APPLIED TO SPACER BY CLAMPING OF VISE.

PRELOAD PROCEDURE:

- STEP #1: TIGHTEN BOLTS TO 5 FT/LB.
- STEP #2: APPLY LOAD WITH VISE JAWS OF 50 FT/LB
(NOTE: A SPACER WAS PLACED IN THE LOWER POSITION FOR THE PERLOAD PROCEDURE.)
- STEP #3: TIGHTEN BOLTS TO 50 FT/LB.
- STEP #4: APPLY LOAD WITH VISE JAWS OF 100 FT/LB.
- STEP #5: TIGHTEN BOLTS TO 100 FT/LB.
- STEP #6: APPLY LOAD WITH VISE JAWS OF 150 FT/LB.
- STEP #7: TIGHTEN BOLTS TO: (150 FT/LB)

FOR SMALLER VISES USE LESS TORQUE (SEE BOLT CHARTS)