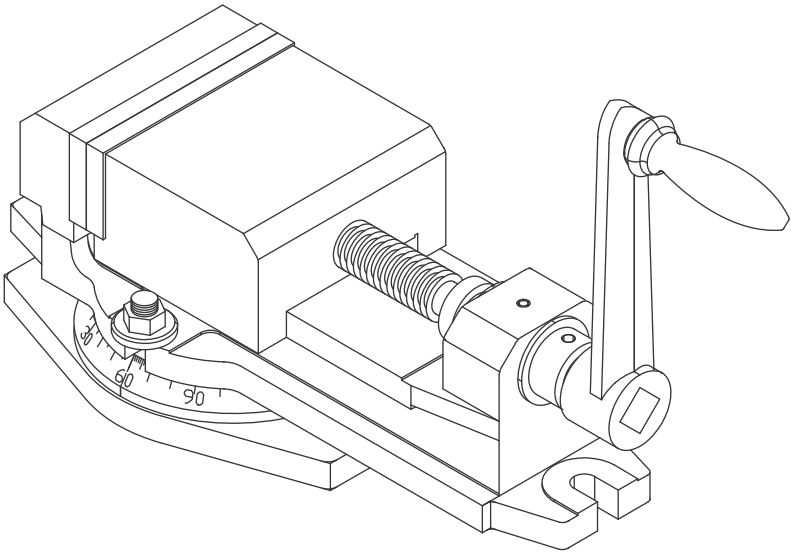
ENGLISH

ESPAÑOL

PALMGREN®

# 4" AND 6" MILLING VISE




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

963157700 - 0522

## DESCRIPTION

Palmgren 4" and 6" Milling Vises are used for heavy duty milling and machining operations. Precision ground surfaces include vise base, swivel base, jaw mounting surfaces and all sliding surfaces of body and movable jaw. The body, swivel base and movable jaw are made of annealed high tensile strength cast iron. Jaw plates and bed are made of hardened steel and cast iron. A graduated swivel base allows vise to be rotated 360° and locked at any desired angle. Swivel base and clamping handle are removable.

## 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 mounting flanges provided on base.
- 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.

## DIMENSIONS

Refer to Figure 1.

| Stock No. **9625404A** | | |
|---|---|---|
| Swivel Base Bolt Centers | A | 7 7/8" |
| Jaw Width | B | 4" |
| Bolt Centers, Widthwise | C | 4 13/32" |
| Bolt Centers, Lengthwise | D | 13 9/16" |
| Overall Body Length | E | 16 3/8" |
| Maximum Jaw Opening | F | 4 1/8" |
| Jaw Height | G | 1 9/16" |
| Height without Swivel Base | H | 3 3/4" |
| Overall Height with Swivel Base | I | 4 15/16" |
| Key Slot | J | 5/8" |

| Stock No. **9626603A** | | |
|---|---|---|
| Swivel Base Bolt Centers | A | 9 7/8" |
| Jaw Width | B | 6" |
| Bolt Centers, Widthwise | C | 6 5/16" |
| Bolt Centers, Lengthwise | D | 18 11/16" |
| Overall Body Length | E | 21 9/16" |
| Maximum Jaw Opening | F | 6" |
| Jaw Height | G | 2 3/16" |
| Height without Swivel Base | H | 4 15/16" |
| Overall Height with Swivel Base | I | 6 3/8" |
| Key Slot | J | 11/16" |

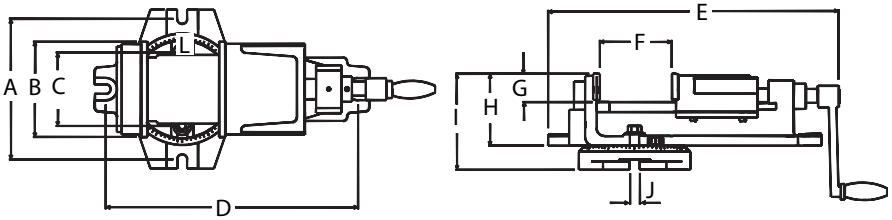



**Figure 1 - Dimensions**

## OPERATION

Refer to Figure 2.

- Mount vise to work surface in desired location. Secure vise using mounting flanges provided on swivel base (Ref. No. 1). Be sure to bolt or clamp vise to work surface using both swivel base flanges.
- Rotate vise to desired position. A scale and indicator are provided for reference. Tighten hex nuts (Ref. No. 15) to secure body to swivel base.
- Open jaws of vise and place workpiece between jaws in desired position. Secure workpiece between jaws by rotating handle. Be sure workpiece is held securely in vise before starting machining operation.
- Swivel base can be removed to allow body to be mounted directly to work surface or table. Be sure to bolt or clamp body to work surface or table in at least two mounting locations.

## 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 leadscrews lubricated with medium weight machine oil.

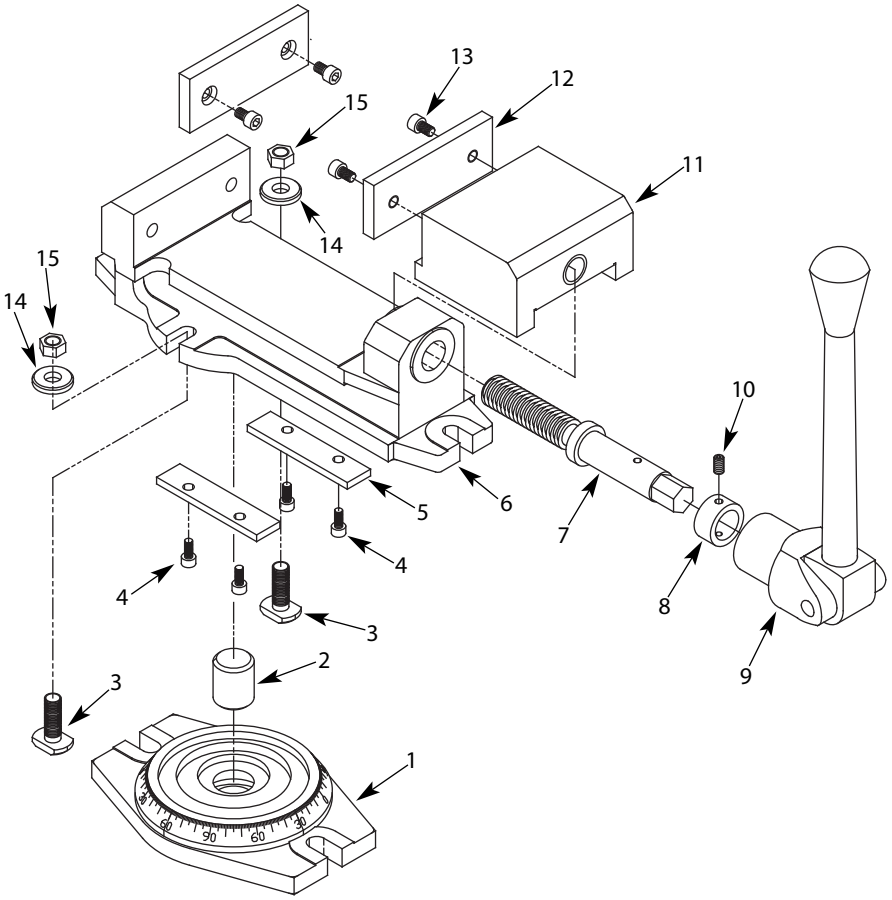



**Figure 2 - Replacement Parts Illustration for 4" and 6" Milling Vise**

# REPLACEMENT PARTS LIST FOR MILLING VISES

| Ref. No. | Description | Part Number for: 4" 9625404A | 6" 9626603A | Qty. |
|---|---|---|---|---|
| 1 | Swivel base | 963142600 | 963143700 | 1 |
| 2 | Center Pin | 963142500 | 963142500 | 1 |
| 3 | T-bolt | 963142400 | 963143600 | 2 |
| 4 | 8-1.25 x 15mm Hex head bolt | – | * | 4 |
| 4 | 6-1.0 x 15mm Socket head bolt | * | – | 4 |
| 5 | Guide plate | 963156100 | 963156800 | 2 |
| 6 | Body | 963156200 | 963456900 | 1 |
| 7 | Leadscrew | 963156300 | 963157000 | 1 |
| 8 | Collar | 963156400 | 963157100 | 1 |
| 9 | Handle | 963156500 | 963157200 | 1 |
| 10 | 6-1.0 x 10mm Set screw | – | * | 1 |
| 10 | 6-1.0 x 8mm Set screw | * | – | 1 |
| 11 | Movable jaw | 963156600 | 963157300 | 1 |
| 12 | Jaw plate | 963156700 | 963157400 | 2 |
| 13 | 10-1.5 x 15mm Socket head bolt | – | * | 4 |
| 13 | 6-1.0 x 15mm Socket head bolt | * | – | 4 |
| 14 | Spacer | 963142300 | 963143500 | 2 |
| 15 | 16-2.0mm Hex nut | – | * | 2 |
| 15 | 12-1.75mm Hex nut | * | – | 2 |
| Δ | Operator's Manual | 963157700 | 963157700 | 1 |

Δ Not shown.

* Standard hardware item available locally.

# TORNILLO DE BANCO PARA FRESADO

## No. de Existencia

## 9625404 – 102 mm
## 9626603 – 152 mm

***Antes de utilizar este producto por primera vez, lea cuidadosamente todas las normas de seguridad y las instrucciones de operación y cumpla con las mismas.***

## DESCRIPCION

Las Prensas de Tornillo Fresadoras de 102 y 152 mm Palmgren se usan para las operaciones de tipo pesado de fresado y maquinado. Las superficies esmeriladas de precisión incluyen la base del tornillo de banco, la base giratoria, las superficies de montaje de las mordazas y todas las superficies deslizantes del cuerpo y de la mordaza movible. El cuerpo, la base giratoria y la mordaza movible están fabricados de hierro fundido, de alta resistencia a la tensión, recocido. Las placas de mordaza y la bancada están fabricadas de acero endurecido y hierro fundido. La base giratoria graduada permite que el tornillo de banco rote 360º y se asegure a cualquier ángulo deseado. La base giratoria y el mango de agarramiento son removibles.

## REGLAS DE SEGURIDAD

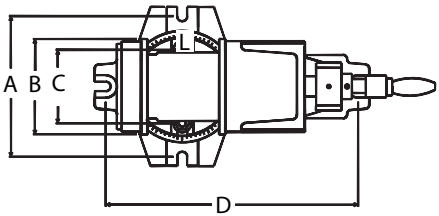
- Entienda y obedezca todas las instrucciones de seguridad que se proporcionan con la prensa taladradora, la fresadora o con otras máquinas en las cuales se usa el tornillo de banco.
- Aperne o agarre el tornillo de banco a la superficie de trabajo en dos lugares de montaje, por lo menos, usando las pestañas de montaje que se proporcionan en la base.
- Asegúrese que la pieza de trabajo esté firmemente agarrada entre las mordazas antes de empezar la operación de maquinado.
- No lo apriete demasiado — el tornillo de banco puede desarrollar una gran fuerza de agarre. Use solamente la fuerza que se necesita.
- No golpee ni martille la pieza de trabajo. Este tornillo de banco ha sido diseñado para agarrar la pieza de trabajo en la posición que se desea solamente para las operaciones de maquinado.

## DIMENSIONES

Refiérase a la Figura 1, la pagina 7.

| No. de Existencia **9625404A** | | |
|---|---|---|
| Centros del perno de la basa giratoria | A | 200 mm |
| Ancho de la mordaza | B | 102 mm |
| Centros del perno, en el sentido del ancho | C | 112 mm |
| Centros del perno, en el sentido de la longitud | D | 345 mm |
| Longitud del cuerpo total | E | 415 mm |
| Abertura de la mordaza maxima | F | 105 mm |
| Altura de la mordaza | G | 39 mm |
| Altura sin la base giratoria | H | 94 mm |
| Altura total con la base giratoria | I | 124 mm |
| Ranura de la chaveta | J | 15.9 mm |

| No. de Existencia **9625404A** | | |
|---|---|---|
| Centros del perno de la basa giratoria | A | 250 mm |
| Ancho de la mordaza | B | 152 mm |
| Centros del perno, en el sentido del ancho | C | 160 mm |
| Centros del perno, en el sentido de la longitud | D | 475 mm |
| Longitud del cuerpo total | E | 548 mm |
| Abertura de la mordaza máxima | F | 152 mm |
| Altura de la mordaza | G | 56 mm |
| Altura sin la base giratoria | H | 125 mm |
| Altura total con la base giratoria | I | 161 mm |
| Ranura de la chaveta | J | 17.46 mm |



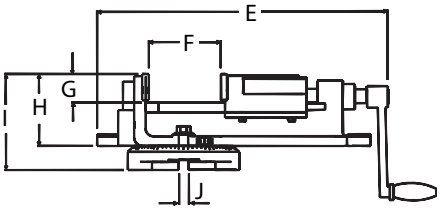




**Figure 1 - Dimensions**

- Abra las mordazas del tornillo de banco y coloque la pieza de trabajo entre ellas, en la posición que se desea. Asegure la superficie de trabajo entre las mordazas haciendo rotar el mango. Asegúrese que la pieza de trabajo esté sujeta firmemente en el tornillo de banco antes de empezar la operación de maquinado.
- La base giratoria se puede remover para permitir que el cuerpo se monte directamente en la superficie de trabajo o en la mesa. Asegúrese de apernar o agarrar el cuerpo en la superficie de trabajo o en la mesa en por lo menos dos lugares de montaje.

## OPERACION

Refiérase a la Figura 2.

- Monte el tornillo de banco en la superficie de trabajo en el lugar deseado. Asegúrelo con las pestañas de montaje que vienen en la base giratoria (Ref. No. 1). Asegúrese de apernar o agarrar el tornillo de banco en la superficie de trabajo usando ambas pestañas de la base giratoria.
- Rote el tornillo de banco a la posición deseada, la escala y el indicador se proporcionan para referencia. Apriete las tuercas hexagonales (Ref. No. 15) para asegurar el cuerpo a la base giratoria.

## MANTENIMIENTO

Las partículas de metal o de madera pueden dañar las superficies maquinadas, haciendo que la operación sea difícil o incorrecta.

- El tornillo de banco se envía con un revestimiento protector. Este revestimiento se debe remover antes de la operación. Use un aceite penetrante para removerlo.
- Mantenga las superficies maquinadas y todas las partes móviles limpias y sin polvo, astillas y materias extrañas.
- Mantenga las superficies maquinadas y el tornillo de entrada lubricados con aceite para máquinas de peso mediano.

ESPAÑOL

# PALMGREN WARRANTY

C.H. Hanson / 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 is was intended.

The warranty does not cover expendable and/or wear part (i.e. v-belts, screws, abrasives, jaws), 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.

***The Palmgren branded items carry the following warranties on parts:***

**All vises, clamps, positioning tables, arbor presses, tombstones, jack screws and vise accessories - LIFETIME.**

**All bench grinders, drill presses, tapping machines, band saws, lathes, milling machines, abrasive finishing machines and work stands - 3 YEARS.**

The obligation of C.H. Hanson / 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 inoperable. 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 C.H. Hanson for any inoperable parts in its product. Under no circumstances is C.H. Hanson liable for any direct, indirect, incidental , special or consequential damages including loss of profits in any way elated to the use or inability to use our products. This warranty gives you specific legal rights which may vary from state to state.

PALMGREN®

***Palmgren - a C.H. Hanson Company***
***2000 N. Aurora Rd., Naperville, IL 60563***
***U.S.A.*** *or call* ***1-800-827-3398***