

Please read and save these instructions. Read carefully before attempting to assemble, install, operate or maintain the product described. Protect yourself and others by observing all safety information. Failure to comply with instructions could result in personal injury and/or property damage! Retain instructions for future reference.

Dayton® 6" Precision Milling Vise

Description

Dayton 6" Precision Milling Vise is used for heavy duty milling and drilling operations. Precision ground surfaces include top and bottom of body, swivel base, and all surfaces of movable and stationary jaws. Body, swivel base and movable jaw are made of annealed high tensile strength cast iron. A spherical segment located in movable jaw provides 1/2 pound of down force on movable jaw for each pound of clamping force. This eliminates any tilting of movable jaw or workpiece. Hardened steel lead screw ensures smooth operation and is enclosed to keep it free of any chips. Graduated swivel base allows vise to be rotated 360°. Other features include removable swivel base, removable pivot handle and coolant trough.

Dimensions

Refer to Figure 1.

- A Swivel base bolt center 11 1/8"
- B Body bolt centers 7 1/4"
- C Jaw width 6"
- D Body length 18"
- E Maximum jaw opening 8"
- F Jaw height 1 3/4"
- G Overall height without swivel base 4 3/8"
- H Overall height with swivel base 6 1/4"

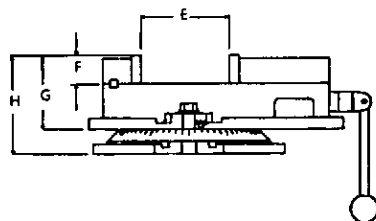
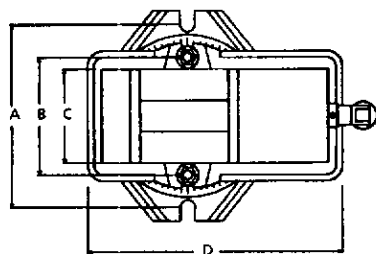


Figure 1 - Dimensions

General Safety Information

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

Operation

Refer to Figure 2.

1. 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.

2. Rotate vise to desired position, scale and indicator are provided for reference. Tighten hex nuts (Ref. No. 23) to secure body to swivel base.
3. 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.
4. 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.

1. Keep machined surfaces and all moving parts clean and free of dirt, chips and foreign materials.
2. Keep machined surfaces and lead-screw lubricated with medium weight machine oil.

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For Replacement Parts, call 1-800-323-0620

24 hours a day - 365 days a year

Please provide following information:

- Model number
- Serial number (if any)
- Part description and number as shown in parts list

Address parts correspondence to:

Grainger Parts
P.O. Box 3074
1657 Shermer Road
Northbrook, IL 60065-3074 U.S.A.

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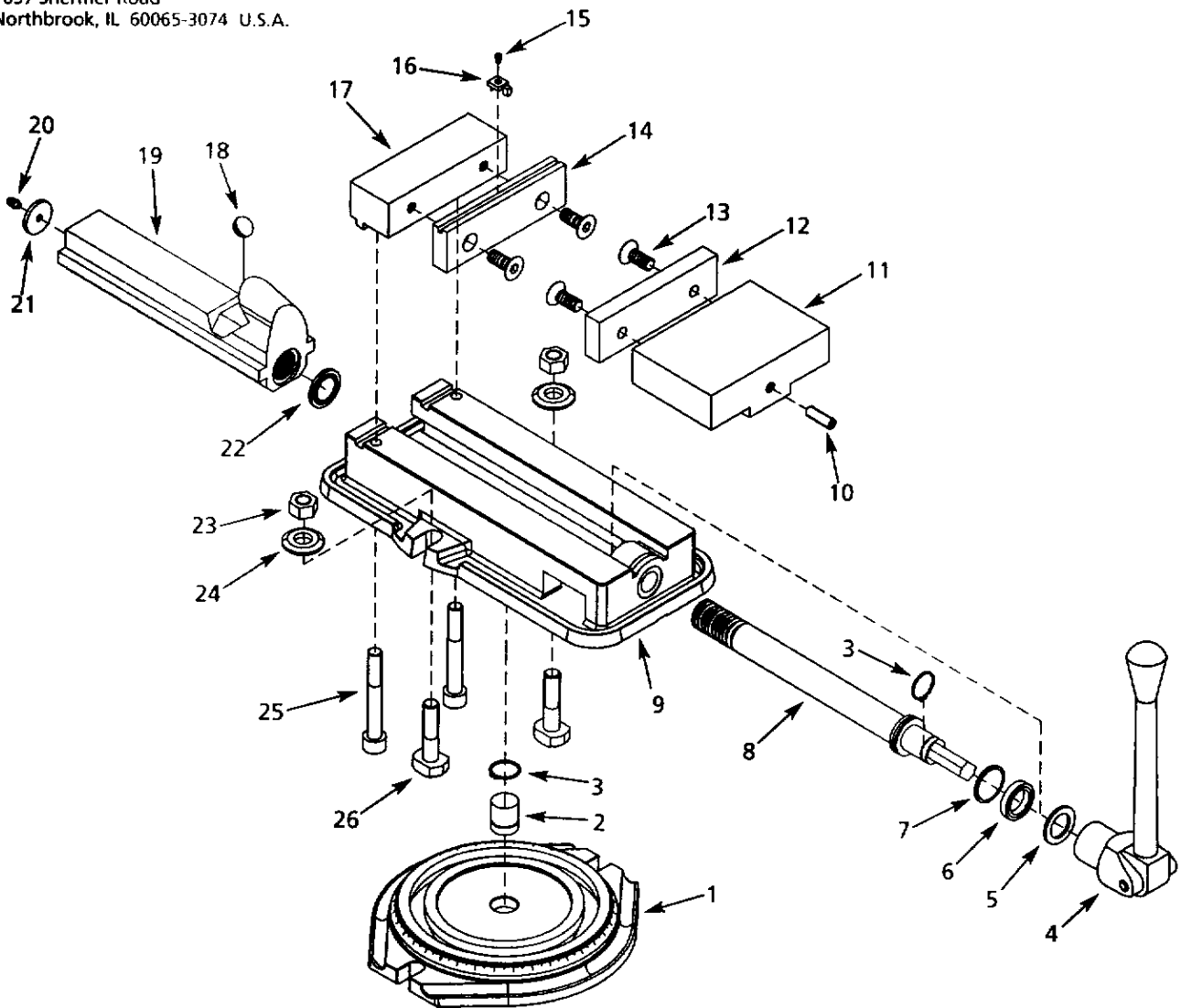


Figure 2 - Replacement Parts Illustration for 6" Precision Milling Vise

Replacement Parts List for 6" Precision Milling Vise

Reference Number	Description	Part Number	Quantity
1	Swivel base	10420.01	1
2	Center pin	10421.00	1
3	3AMI-25 Retaining ring	1900.00	2
4	Handle	10422.01	1
5	Spacer	10423.00	1
6	6805ZZ Bearing	10424.00	1
7	Oil Seal	10425.00	1
8	Leadscrew	10426.00	1
9	Body	10427.01	1
10	12-1.75 x 35mm Dog point set screw	10428.00	1
11	Movable jaw	10429.00	1
12	Flat jaw plate	10430.00	1
13	10-1.5 x 30mm Flat head screw	*	4
14	Grooved jaw plate	10432.00	1
15	3-0.5 x 6mm Socket head bolt	*	1
16	Work stop	10434.00	1
17	Stationary jaw	10435.00	1
18	Spherical segment	10436.00	1
19	Leadscrew nut	10437.01	1
20	Oil fitting	10438.00	1
21	Cap	10439.00	1
22	Wiper	10165.00	1
23	16-2.0mm Hex nut	*	2
24	Spacer	10166.00	2
25	16-2.0 x 75mm Socket head bolt	10167.00	2
26	16-2.0 x 50mm T-bolt	10168.00	2

(*) Standard hardware item, available locally.

Dayton® 6" Precision Milling Vice

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LIMITED WARRANTY

DAYTON ONE-YEAR LIMITED WARRANTY. Dayton® 6" Precision Milling Vice, Models covered in this manual, are warranted by Dayton Electric Mfg. Co. (Dayton) to the original user against defects in workmanship or materials under normal use for one year after date of purchase. Any part which is determined to be defective in material or workmanship and returned to an authorized service location, as Dayton designates, shipping costs prepaid, will be, as the exclusive remedy, repaired or replaced at Dayton's option. For limited warranty claim procedures, see PROMPT DISPOSITION below. This limited warranty gives purchasers specific legal rights which vary from jurisdiction to jurisdiction.

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PROMPT DISPOSITION. Dayton will make a good faith effort for prompt correction or other adjustment with respect to any product which proves to be defective within limited warranty. For any product believed to be defective within limited warranty, first write or call dealer from whom the product was purchased. Dealer will give additional directions. If unable to resolve satisfactorily, write to Dayton at address below, giving dealer's name, address, date, and number of dealer's invoice, and describing the nature of the defect. Title and risk of loss pass to buyer on delivery to common carrier. If product was damaged in transit to you, file claim with carrier.

Manufactured for Dayton Electric Mfg. Co., 5959 W. Howard St., Niles, Illinois 60714 U.S.A.