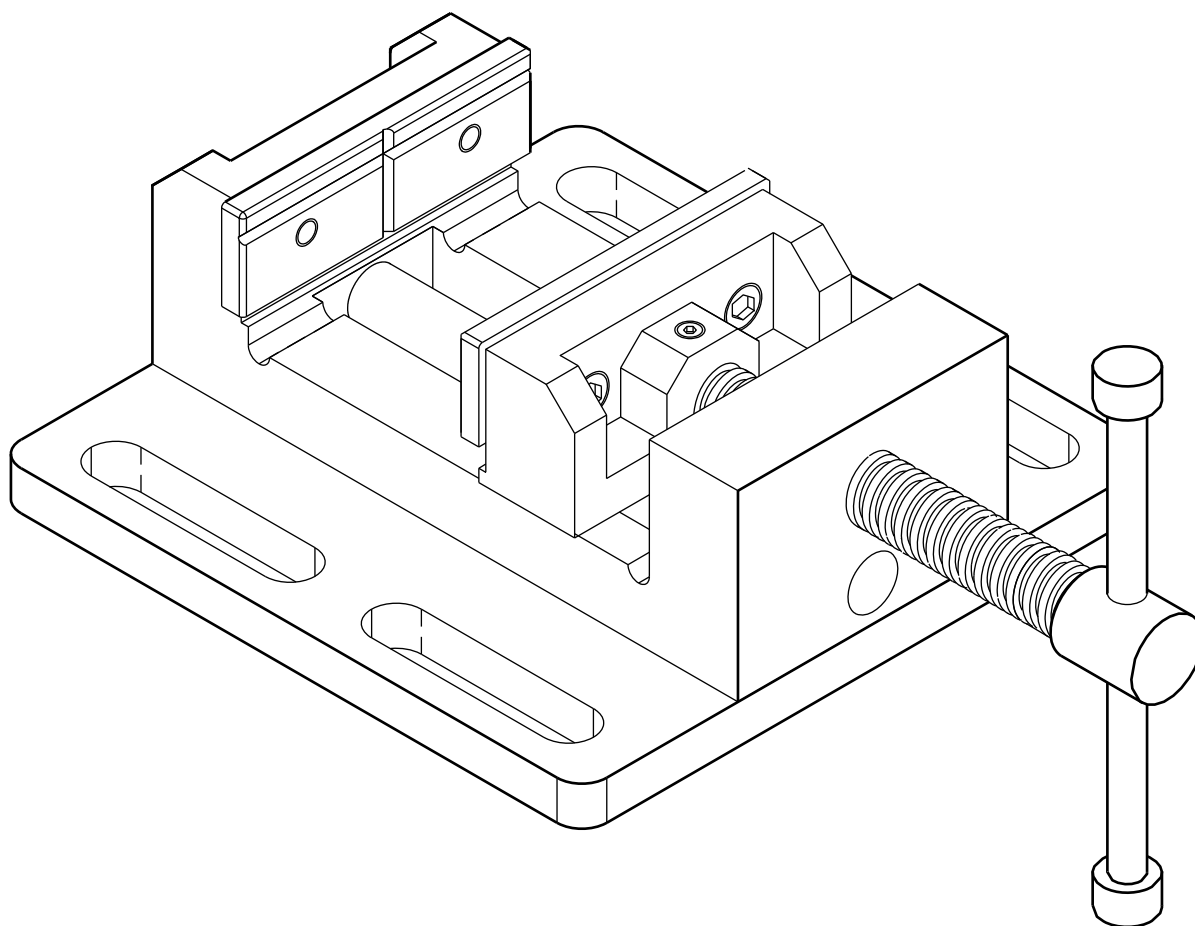


# PALMGREN

3", 4", 6" & 8"

## LOW PROFILE DRILL PRESS VISE



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

**DESCRIPTION**

Palmgren 3", 4", 6" and 8" Low-Profile Drill Press Vises are made of durable cast iron and steel. Vises are provided with four mounting slots for securing vise to work surface.

**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.		12303	12403	12601	12801
Jaw Width	A	3"	4"	6"	8"
Throat Depth	B	1 <sup>5</sup> / <sub>16</sub> "	1 <sup>3</sup> / <sub>4</sub> "	2"	2"
Jaw Opening	C	3"	4"	6"	8"
Overall Height	H	2 <sup>7</sup> / <sub>16</sub> "	2 <sup>7</sup> / <sub>8</sub> "	3 <sup>9</sup> / <sub>16</sub> "	3 <sup>9</sup> / <sub>16</sub> "
Base Length	L	6 <sup>1</sup> / <sub>2</sub> "	7 <sup>3</sup> / <sub>8</sub> "	10 <sup>15</sup> / <sub>16</sub> "	15 <sup>7</sup> / <sub>16</sub> "
Base Width	W	5 <sup>7</sup> / <sub>16</sub> "	6 <sup>3</sup> / <sub>8</sub> "	9 <sup>3</sup> / <sub>8</sub> "	11 <sup>1</sup> / <sub>16</sub> "

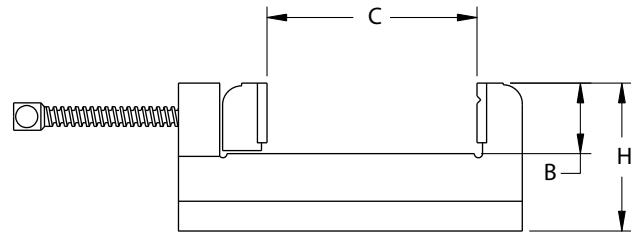
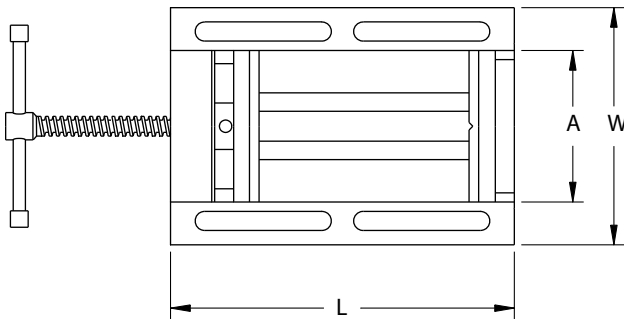


Figure 1 - Dimensions

**OPERATION**

Refer to Figure 2.

- Mount vise to work surface in desired location by securing at least two mounting flanges located on base (Ref. No. 1).
- 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.

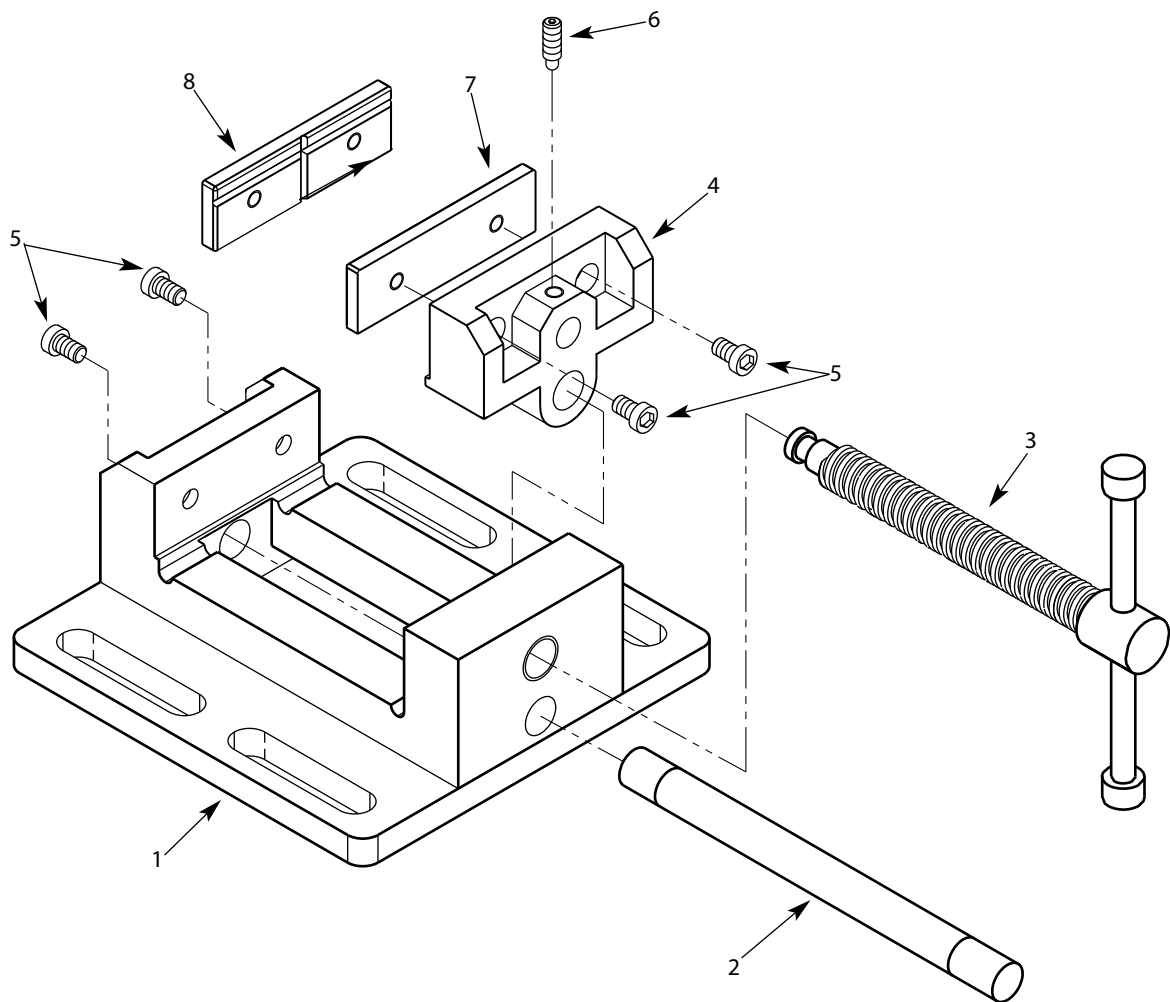


Figure 2 - Replacement Parts Illustration for 3", 4", 6" and 8" Low-Profile Drill Press Vises

**REPLACEMENT PARTS LIST FOR LOW-PROFILE DRILL PRESS VISES**

Ref. No.	Description	Part Number for:				Qty.
		3" 12303A	4" 12403A	6" 12601A	8" 12801A	
1	Base	†	†	†	†	1
2	Slide Bar	28530.00	28536.00	28542.00	28547.00	1
3	Lead Screw with Handle	28531.00	28537.00	28543.00	28548.00	1
4	Moving Jaw	28532.00	28538.00	28544.00	28549.00	1
5	6-1.0 x 12mm Socket Head Bolt	*	*	—	—	4
5	8-1.25 x 12mm Socket Head Bolt	—	—	*	—	4
5	8-1.25 x 25mm Socket Head Bolt	—	—	—	*	4
6	6-1.0 x 10mm Set Screw with Ball	28533.00	—	—	—	1
6	8-1.25 x 10mm Set Screw with Ball	—	28539.00	28539.00	28539.00	1
7	Flat Jaw Plate	28534.00	28540.00	28545.00	28550.00	1
8	Grooved Jaw Plate	28535.00	28541.00	28546.00	28551.00	1
Δ	Operator's Manual	28633.00	28633.00	28633.00	28633.00	1

Δ Not Shown.

\* Standard hardware item available locally.

† Not available as replacement part.

# PRENSA DE TORNILLO TALADRADORA DE BAJO PERFIL

## NO. DE EXISTENCIA

**12303A – 76 MM**

**12403A – 102 MM**

**12601A – 152 MM**

**12801A – 203 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 Taladradora de Bajo Perfil Palmgren de 76 mm, 102 mm, 152 mm y 203 mm han sido fabricadas de acero y hierro fundido durables. Se proporcionan con cuatro ranuras de montaje para asegurarlas a la superficie de trabajo.

### 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 la prensa de tornillo.
- Aperne o agarre la prensa de tornillo 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 la apriete demasiado—la prensa de tornillo puede desarrollar una gran fuerza de agarre. Use solamente la fuerza que se necesita.
- No golpee ni martille la pieza de trabajo. Esta prensa de tornillo ha sido diseñada para agarrar la pieza de trabajo en la posición que se desea solamente para las operaciones de maquinado.

### DIMENSIONES

Refiérase a la Figura 1.

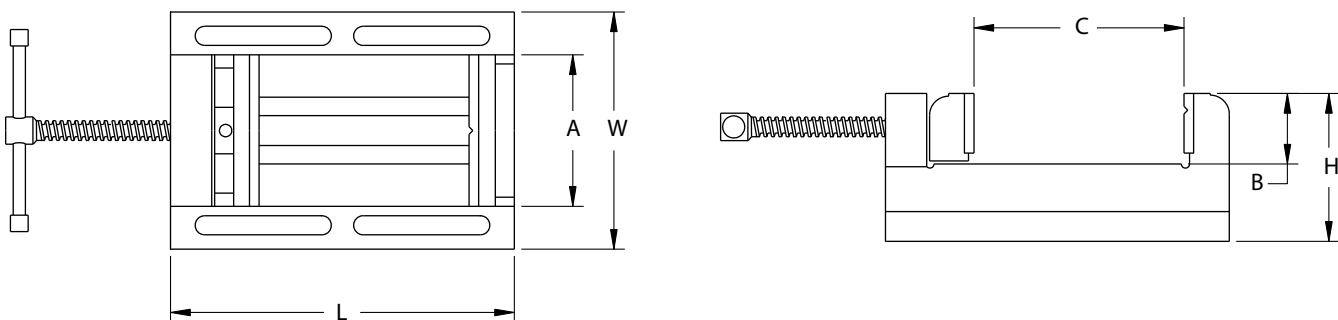


Figure 1 - Dimensiones

No. de Existencia		<b>12303</b>	<b>12403</b>	<b>12601</b>	<b>12801</b>
Ancho de la Mordaza	A	76 mm	102 mm	152 mm	203 mm
Profundidad de la Garganta	B	35 mm	44 mm	51 mm	51 mm
Abertura de la Mordaza	C	76 mm	102 mm	152 mm	203 mm
Altura Total	H	62 mm	73 mm	91 mm	91 mm
Longitud de la Base	L	165 mm	183 mm	278 mm	392 mm
Ancho de la Base	W	138 mm	157 mm	239 mm	281 mm

**OPERACION**

Refiérase a la Figura 2.

- Monte la prensa de tornillo en una superficie de trabajo en el lugar que se desea, asegurando por lo menos dos de las pestañas de montaje ubicadas en la base (Ref. No. 1).
- Abra las mordazas de la prensa de tornillo 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 tornillo de entrada con el mango (Ref. No. 3). Asegúrese que la pieza de trabajo esté sujeta firmemente en la prensa de tornillo antes de empezar la operación de maquinado.

**MAINTENIMIENTO**

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

- La prensa de tornillo 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.

## **NOTES/NOTAS**

# NOTES/NOTAS

## WARRANTY

Palmgren warrants their products to be free of deficiency in material or workmanship. The duration of this warranty is expressly limited to one year parts and labor unless otherwise noted beginning from the date of delivery to the original user. The following Palmgren products carry the following warranties on parts with a 1 year warranty on labor:

- USA Machine vises – Lifetime
- Imported Machine vises – 2 years
- Bench vises – 2 years
- Positioning tables – 2 years
- Bench grinders & buffers – 3 years
- Tapping machines – 2 years
- Drilling machines – 2 years
- Finishing machines – 2 years
- Band saws – 2 years
- Work stands – 2 years

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. The warranty does not cover expendable and/or wear parts (i.e. v-belts, coated abrasives), damage to tools arising from alteration, abuse or use other than their intended purpose, packing and freight. Purchaser must lubricate and maintain the product under normal operating conditions at all times. Proper use and care instructions are provided in the operator's manual. 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.
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) 621-6145.

