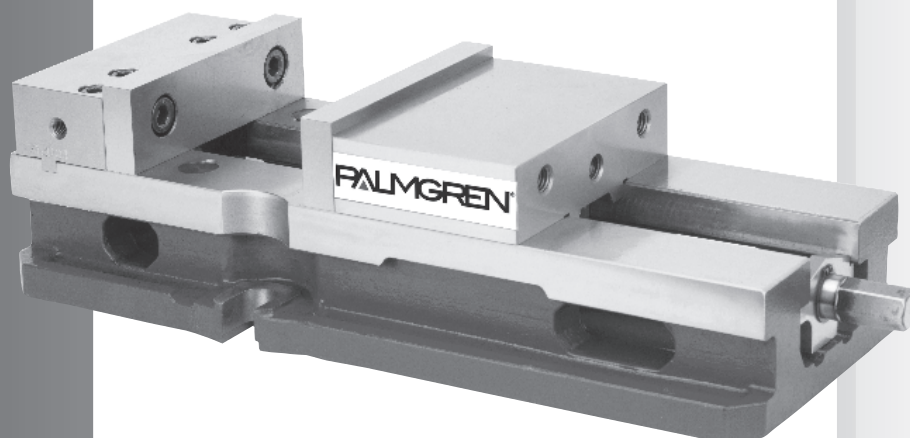


PALMGREN[®]
a CH Hanson brand



6" Machine Vise

Model 9625937

PALMGREN[®]
a CH Hanson brand

**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.**

**PLEASE REFER TO BACK COVER
FOR INFORMATION REGARDING
DAYTON'S WARRANTY
AND OTHER IMPORTANT
INFORMATION.**

Model #: _____

Serial #: _____

Purch. Date: _____

GETTING STARTED

Save this manual

Thank you for purchasing the Model 9625937 Machine Vise. Please read this manual carefully before using this product. You will need this manual for the safety warnings and precautions, assembly instructions, operating and maintenance procedures, parts list and diagrams. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep this manual and invoice in a safe and dry place for future reference.

UNPACKING

Open the shipping and product carton. After unpacking your machine vise, inspect it carefully for any damage that may have occurred during transit. Check for loose, missing or damaged parts. If any damage or loss has occurred, claim must be filed with the carrier immediately. Check for completeness. Immediately report missing parts to dealer.

IMPORTANT: The machine vise is shipped with a protective coating to prevent rust. Use penetrating oil to remove the coating. Do not use flammable or volatile solvents.

Contents:

- 6" Machine Vise
- Operating Instructions and Parts Manual

Inspect:



- All tools should be visually inspected before use, in addition to regular periodic maintenance inspections.



- See **General Safety Instructions, Cautions and Warnings as shown.**

DESCRIPTION

Palmgren's premium CNC vises combines quality, high precision and wide clamping capacities at an affordable price. Ideal for everyday use from high production environments to rapid prototyping machine shops.

- Equipped with Dual Force anti-lift mechanism.
- Sealed friction reducing needle thrust bearing help increase clamping pressure and reduce drag.
- Vise nut does not extend beyond the end of the vise body.
- Hardened jaw plates and vise bed.
- Repeatability to within 0.001".
- Bed heights matched to within +/- 0.0004".
- Parallelism of keyways on the bottom of the vise bed to the jaw face are within +/- 0.0008".
- 80,000 PSI stress relieved ductile iron castings.

SAFETY RULES

▲ WARNING *For your own safety, read all of the instructions and precautions before operating tool.*

▲ WARNING *Always follow proper operating procedures as defined in this manual even if you are familiar with the use of this or similar tools. Remember that being careless for even a fraction of a second can result in severe personal injury.*



PROPOSITION 65 WARNING: Some dust created by using power tools contain chemicals known to the state of California to cause cancer, birth defects or other reproductive harm.

Some examples of these chemicals are:

- Lead from lead-based paints
- Crystalline silica from bricks and cement and other masonry products
- Arsenic and chromium from chemically-treated lumber

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area and work with approved safety equipment. Always wear **OSHA/NIOSH** approved, properly fitting face mask or respirator when using such tools.

Machine vise safety rules

- Wear safety glasses complying with United States ANSI Z87.1 when using the machine vise in machining operations. Everyday glasses have only impact resistant lenses. They are not safety glasses.
- Understand and obey all safety instructions supplied with your drill press, mill or any other machines on which the vise is being used.
- Bolt or clamp the vise to the work surface in at least two mounting locations using the mounting flanges provided on the base.
- Be sure the workpiece is clamped securely between the jaws of the vise before beginning any machining operations.
- Do not over tighten – the vise can develop a large amount of clamping force. Use only the force that is needed to securely hold the workpiece.
- Do not hammer or pound on the workpiece. This vise is designed to clamp the workpiece in a desired location for machining operations only.

OPERATION

⚠ WARNING *Always wear safety goggles complying with United States ANSI Z87.1 when using the vise during any machining operations.*

⚠ CAUTION *The machine vise must be properly and securely mounted to a work surface. Workpieces must be securely held in the vise before beginning any machining operations.*

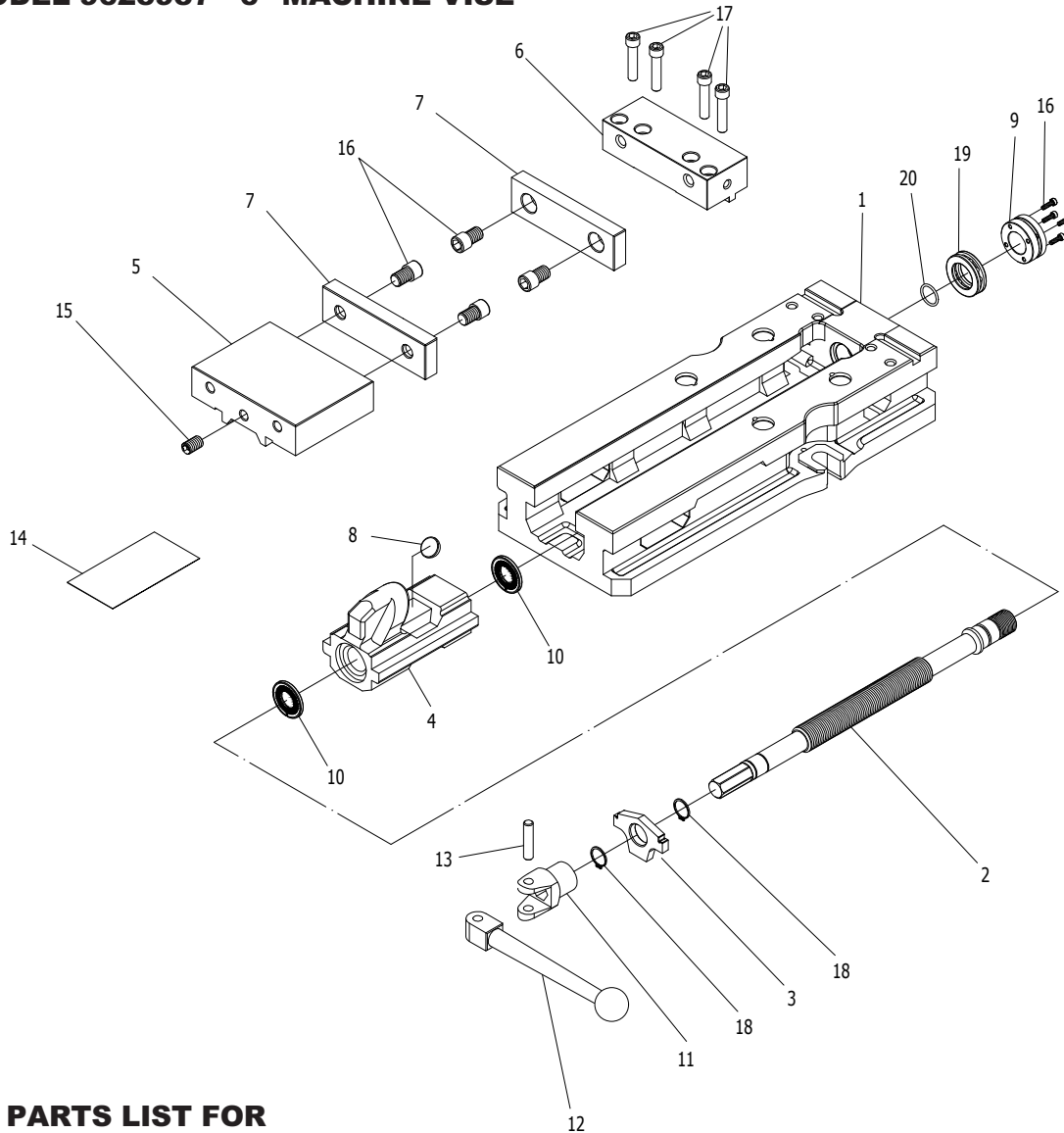
- Mount the vise to a work surface in a desired location. Secure the vise using the provided flanges.
- Be sure to bolt or clamp the vise to the work surface using both base flanges.
- Tighten the hex nuts to secure the body.
- Open the jaws of the vise and place the workpiece between the jaws in a desired position. Secure the workpiece by rotating the vise handle clockwise. Be sure the workpiece is secure in the vise before beginning any machining operations.

MAINTENANCE

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

- The vise is shipped with a protective coating to prevent rust. Use penetrating oil to remove the coating. Do not use flammable or volatile solvents.
- Keep the machined surfaces and all moving parts of your vise clean and free of dirt, chips and foreign materials.
- Keep the machined surfaces and lead screws lubricated with medium weight machine oil.

**REPAIR PARTS ILLUSTRATION
FOR MODEL 9625937 - 6" MACHINE VISE**



**REPAIR PARTS LIST FOR
MODEL 9625937 - 6" MACHINE VISE**

Ref. No.	Description	Part No.	Qty.
1	Body	N/A	1
2	Main Screw	N/A	1
3	Spindle Case	N/A	1
4	Spindle Nut	N/A	1
5	Movable Jaw	N/A	1
6	Fixed Jaw	N/A	1
7	Jaw	9643290.01	2
8	Semi-sphere Segment	9643291.01	1
9	Lock Nuts	N/A	1
10	Brush	9643292.01	2

Ref. No.	Description	Part No.	Qty.
11	Handle Socket	N/A	1
12	Handle Bar	N/A	1
13	Pin 10mm Dia., 42mm Length	*	1
14	Slide Cover	N/A	1
15	Adjustable Screw 1/2" x 1-3/4"L - 13UNC	*	1
16	Bolts 1/2" x 1"L - 13UNC	*	4
17	Bolts 3/8" x 1-3/4"L - 16UNC	*	4
18	C-rings S22	*	2
19	Ball Bearing 51105	9643293.01	1
20	O-ring P20	9643294.01	1

For Repair Parts, call 1-800-827-3398

Please provide following information:

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

(Δ) Not Shown (*) Standard hardware item available locally (N/A) Not available as replacement part

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 it 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, tombstones, jack screws and vise accessories - LIFETIME.

All bench grinders, drill presses, tapping machines, band saws, lathes, milling machines, arbor presses, 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 related to the use or inability to use our products. This warranty gives you specific legal rights which may vary from state to state.



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