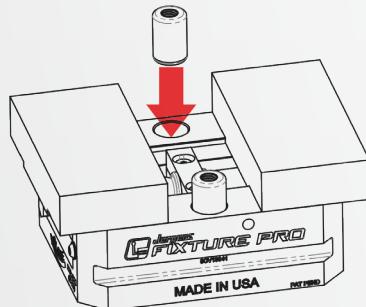


Centering

Vises will come pre-centered from Jergens. In the event that the jaws need to be re centered. Please use the following procedure:

1. Loosen pillow block shoulder screws (DO NOT REMOVE) such that Pillow Block can freely move
2. Insert (2) 20mm (10mm for 75mm CV Series Vise) dowels in vise as shown
3. Lightly clamp dowel pins
4. Tighten Pillow Block Shoulder Screws to 7 N·m (5.5lbs·ft)
5. Loosen vise
6. Remove 20mm (10mm) dowels



Additional Information

For model file downloads and compatibility information, please visit our website at:
www.jergensinc.com

See our products in action at: www.youtube.com/jergensinc

WORLD HEADQUARTERS

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QUICK-CHANGE FIXTURING



Self- Centering Vises

INSTRUCTION MANUAL

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Usage and Maintenance

Do's and Don'ts

- **Keep the lead screw clean and clear of debris and chips.** Use a nylon or soft wire brush to clean chips and debris off the leadscrew
- Do NOT over torque. Observe max torque marked on vise body.
- Do NOT use impact gun or other power tools to operate vise.
- Do NOT strike vise or handle with a mallet.
- When machining soft jaws, clamp on a small spacer block with desired operating torque. This will stabilize the jaws during the modification process.
- If vise is to be stored for an extended period of time, clean all chips and debris from vise and coat entire vise with rust inhibitor.
- Keep lead screw well lubricated with anti-seize. Use Loctite LB C5-A or equivalent.

Jaw Installation

1. Turn lead screw so trucks are approximately half closed
2. Align the jaw such that the tail fits within the base opening
3. Snap the jaw into place with forward and down pressure

Jaw Removal

1. Turn lead screw so jaws are approximately half closed
2. Push forward and lift jaw

Replacement Parts:

| | Vise Width | 130mm | 130mm | 75mm |
|----------|----------------------|-----------------|-----------------|-----------------|
| | Vise Length | 160mm | 250mm | 100mm |
| Item No. | Description | Part No. | Part No. | Part No. |
| 1 | Truck - LH | 774081 | 774081 | 774099 |
| 2 | Truck - RH | 774082 | 774082 | 774100 |
| 3 | Spring Plunger | 26853 | 26853 | 26853 |
| 4 | Lead Screw | 774080 | 774086 | 774098 |
| 5 | Pillow Block - Lower | 774079 | 774079 | 774097 |
| 6 | Pillow Block - Upper | 774078 | 774078 | 774096 |
| 7 | Pillow Block Screw | 774083 | 774083 | 774095 |
| 8 | Stop Screw | 770149 | 770149 | 770149 |
| 9 | Insert Jaw Set | 5CV13041 - INSJ | 5CV13041 - INSJ | 5CV13049 - INSJ |
| | Alum. Soft Jaw Set | 5CV13041 - ASJ | 5CV13041 - ASJ | 5CV13049 - ASJ |
| | Steel Soft Jaw Set | 5CV13041 - SSJ | 5CV13041 - SSJ | 5CV13049 - SSJ |
| | Hard Step Jaw Set | 5CV13041 - HSJ | 5CV13041 - HSJ | 5CV13049 - HSJ |
| 10 | Handle | 49456 | 49456 | 49457 |

