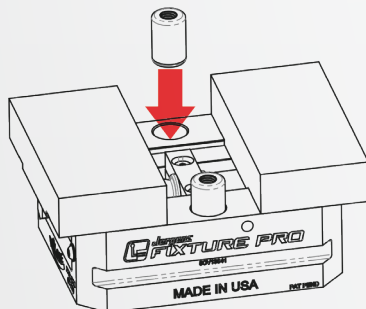


Centering

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

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QUICK-CHANGE FIXTURING



Self-Centering Visers

INSTRUCTION MANUAL

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For further information and accessories for your Jergens Self-Centering Vise visit our website at www.jergensinc.com

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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.	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	

