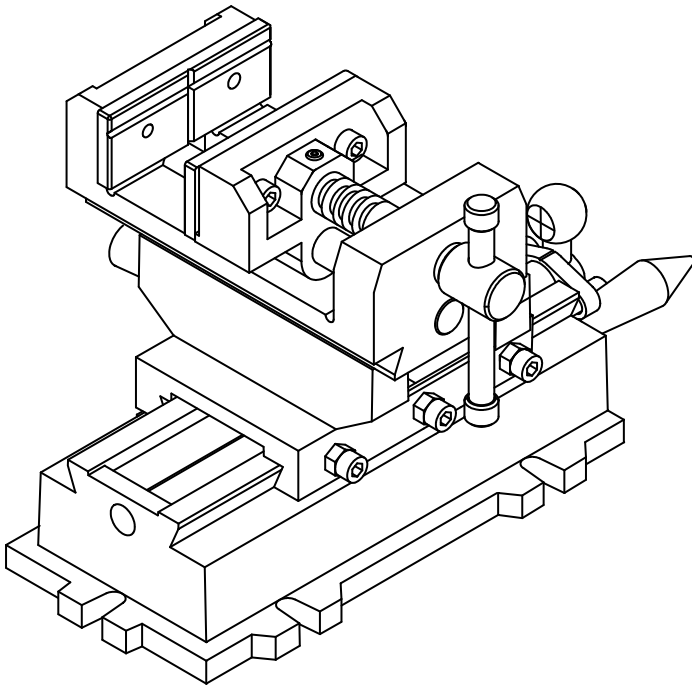


# PALMGREN®

3", 6" & 8"  
CROSS VISE



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

**DESCRIPTION**

Palmgren 3", 6" and 8" Cross Vises travel on two separate axes, longitudinal and cross , to permit accurate positioning of work-piece. Body, saddle, base and jaws are made of high strength cast iron. Vise leadscrew, longitudinal and cross feed screws are precision ground carbon steel.

**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 work-piece. This vise is designed to clamp the workpiece in a desired position for machining operations only.

**DIMENSIONS**

Refer to Figure 1.

Stock No.		9630303C	9630601C	9630801C
Jaw Width	A	3"	6"	8"
Throat Depth	B	1 <sup>1</sup> / <sub>8</sub> "	2"	2"
Jaw Opening	C	3"	6"	8"
Overall Height	H	5 <sup>5</sup> / <sub>8</sub> "	7 <sup>1</sup> / <sub>4</sub> "	7 <sup>1</sup> / <sub>4</sub> "
Base Length	L	8 <sup>1</sup> / <sub>4</sub> "	12 <sup>1</sup> / <sub>4</sub> "	12 <sup>1</sup> / <sub>4</sub> "
Base Width	W	4 <sup>1</sup> / <sub>2</sub> "	7 <sup>1</sup> / <sub>2</sub> "	7 <sup>1</sup> / <sub>2</sub> "
Longitudinal Travel		5"	8"	8"
Cross Travel		5"	8"	8"
Value of One Division		0.002"	0.001"	0.001"
Cross Travel per One Revolution		0.100"	0.100"	0.100"
Longitudinal Travel per One Revolution		0.100"	0.100"	0.100"

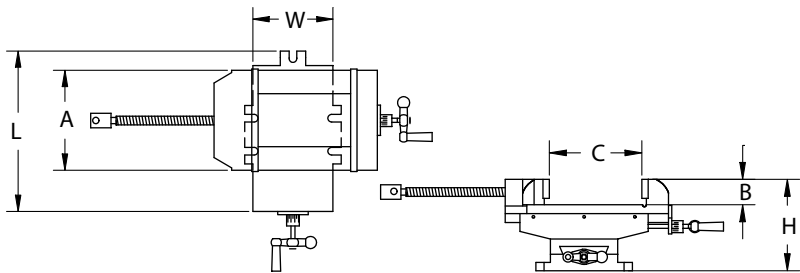


Figure 1 - Dimensions

## ASSEMBLY

Refer to Figure 2.

### MODEL 9630303C, 3" VISE

- Mount crank handles (Ref. No. 12) to longitudinal and cross feed screws (Ref. Nos. 8 and 9) using acorn nuts (Ref. No. 13).
- This vise is shipped with a protective coating. This coating should be removed before operation. Remove protective coating with penetrating oil.

### MODELS 9630601C AND 9630801C, 6" AND 8" VISES

- Thread movable jaw leadscrew (Ref. No. 14) through end of body (Ref. No. 16) and into hole in movable jaw (Ref. No. 18).
- Secure with dog point set screw (Ref. No. 19)
- Mount crank handles (Ref. No. 12) to longitudinal and cross feed screws (Ref. Nos. 8 and 9) using acorn nuts (Ref. No. 13).
- This vise is shipped with a protective coating. This coating should be removed before operation. Remove protective coating with penetrating oil.

## 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).
- Move saddle (Ref. No. 3) by rotating longitudinal crank handle (Ref. No. 12). Tighten center set screw (Ref. No. 6) to secure position.

- Move vise body (Ref. No. 16) to desired position by rotating crossfeed crank handle (Ref. No. 12). Tighten center set screw (Ref. No. 6) to secure position.
- Open jaws of vise. Place workpiece between jaws in desired position. Rotate vise handle to secure workpiece between vise jaws. Be sure workpiece is secure in vise before starting machining operation.

## GIB ADJUSTMENT

- Adjust gibs (Ref. No. 4) by tightening the set screws (Ref. Nos. 6 and 23) at each end of the gibs.
- Adjust the screws until a slight drag is felt when rotating the crank handles (Ref. No. 12). Tighten nuts (Ref. No. 5) to secure screws.

## 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.

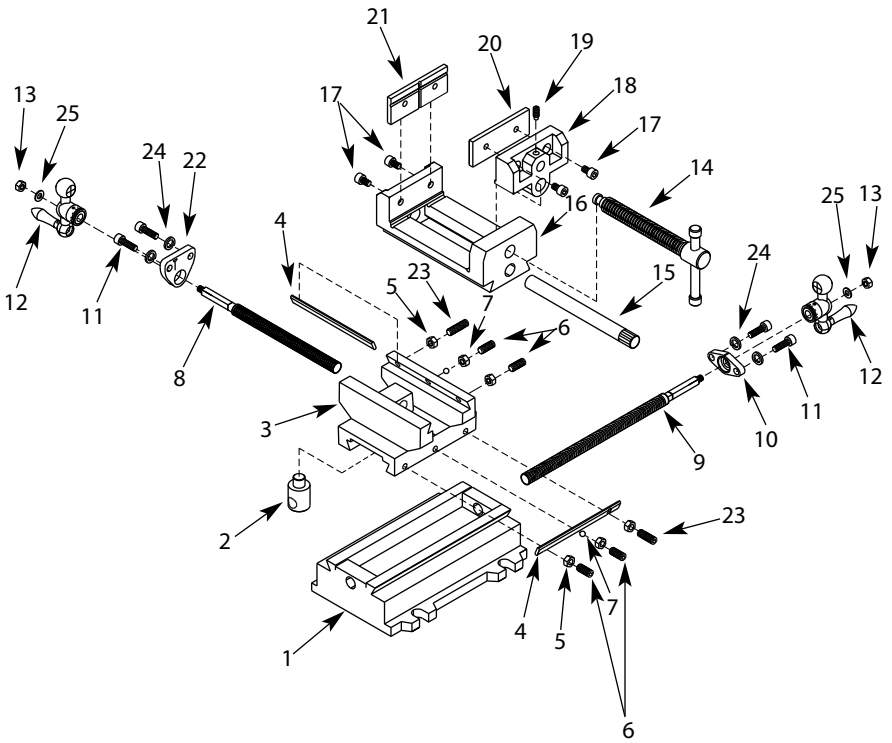


Figure 2 - Replacement Parts Illustration for 3" , 6" and 8" Cross Vise

**REPLACEMENT PARTS LIST FOR CROSS VISES**

Ref. No.	Description	Part Number for:			Qty.
		3" 9630303C	6" 9630601C	8" 9630801C	
1	Base	962886600	962888400	962888400	1
2	Nut	962886701	962888501	962888501	1
3	Saddle	962886801	962888601	962888601	1
4	Gib	962886900	962888700	962888700	2
5	6-1.0mm Hex Nut	*	*	*	6
6	6-1.0 x 16mm Set Screw	*	–	–	4
6	6-1.0 x 20mm Set Screw	–	*	*	4
7	1/8" Ball	962887000	962888800	962888800	2
8	Longitudinal Feed Screw	962887101	962888901	962888901	1
9	Cross Feed Screw	962887201	962889001	962889001	1
10	Retaining Plate	962887300	962889100	962889100	1
11	6-1.0 x 16mm Socket Head Bolt	*	–	–	4
11	8-1.25 x 25mm Socket Head Bolt	–	*	*	4
12	Crank Handle Assembly	962887401	962889201	962889201	2
13	6-1.0mm Acorn Nut	962887500	962889300	962889300	2
14	Leadscrew with Handle	962887600	962889400	962890100	1
15	Guide Rod	962887700	962889500	962890200	1
16	Body	962887800	962889600	962890300	1
17	6-1.0 x 10mm Socket Head Bolt	*	–	–	4
17	8-1.25 x 14mm Socket Head Bolt	–	*	–	4
17	8-1.25 x 25mm Socket Head Bolt	–	–	*	4
18	Movable Jaw	962887900	962891400	962890400	1
19	6-1.0 x 12mm Dog Point Set Screw	962888000	962889700	962889700	1
20	Jaw Plate	962888100	962889800	962890500	1
21	Grooved Jaw Plate	962888200	962889900	962890600	1
22	Retaining Plate	962888300	962890000	962890000	1
23	6-1.0 x 16mm Set Screw	*	–	–	2
23	6-1.0 x 25mm Set Screw	–	*	*	2
24	6mm Lock Washer	*	–	–	4
24	8mm Lock Washer	–	*	*	4
25	6mm Flat Washer	–	*	*	2
Δ	Operator's Manual	962886500	962886500	962886500	1

Δ Not shown.

\* Standard hardware item available locally.

# PRENSA DE TORNILLO TRANSVERSAL

## NO. DE EXISTENCIA

**30303B – 76 MM**

**30601B – 152 MM**

**30801B – 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 Transversales de 76, 152 y 203 mm Palmgren se mueven sobre dos ejes separados, uno longitudinal y otro transversal, para permitir la colocación precisa de la pieza de trabajo. El cuerpo, el caballete, la base y las mordazas están fabricados de hierro fundido de alta resistencia. El tornillo de entrada de la prensa de tornillo, así como los tornillos de avance longitudinal y transversal, son de acero al carbono esmerilados a precisión.

### 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.

- Aperse o agarre la prensa de tornillo a la superficie de trabajo en por lo menos dos lugares de montaje, 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.

No. de Existencia		<b>30303C</b>	<b>30601C</b>	<b>30801C</b>
Ancho de la Mordaza	A	76 mm	152 mm	203 mm
Profundidad de la Garganta	B	29 mm	50 mm	50 mm
Abertura de la Mordaza	C	81 mm	152 mm	203 mm
Altura Total	H	143 mm	188 mm	188 mm
Longitud de la Base	L	210 mm	312 mm	312 mm
Ancho de la Base	W	114 mm	190 mm	190 mm
Recorrido Longitudinal		127 mm	203 mm	203 mm
Recorrido Transversal		127 mm	203 mm	203 mm
Valor de una División		0,05mm	0,025 mm	0,025 mm
Recorrido Transversal por Revolución		2,54 mm	2,54 mm	2,54 mm
Recorrido Longitudinal por Revolución		2,54 mm	2,54 mm	2,54 mm

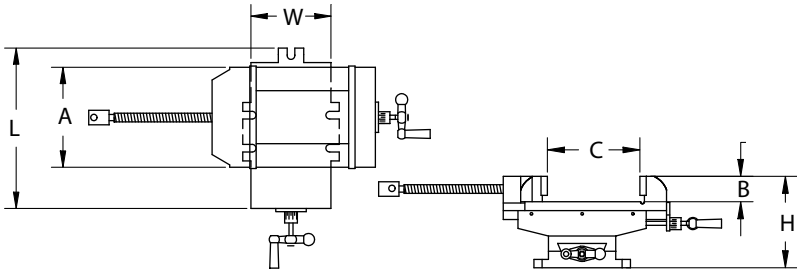


Figura 1 - Dimensiones

## MONTAJE

Refiérase a la Figura 2.

### MODELO 30303C

#### PRENSA DE TORNILLO DE 76 MM

- Monte los mangos de la manivela (Ref. No. 12) a los tornillos de avance longitudinal y transversal (Ref. Nos. 8 y 9) usando tuercas ciegas (Ref. No. 13).
- 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.

### MODELOS 30601C Y 30801C, PRENSAS DE TORNILLO DE 152 MM Y 203 MM

- Atornille el tornillo de entrada de la mordaza móvil (Ref. No. 14) hasta el extremo del cuerpo (Ref. No. 16) y en el agujero de la mordaza móvil (Ref. No. 18).
- Asegúrelo con un tornillo de fijación del punto de sujeción (Ref. No. 19).
- Monte los mangos de la manivela (Ref. No. 12) a los tornillos de avance longitudinal y transversal (Ref. Nos. 8 y 9) usando tuercas ciegas (Ref. No. 13).
- 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.

## OPERACION

Refiérase a la Figura 2.

- Monte la prensa de tornillo en la superficie de trabajo, en la ubicación que se desea, asegurando por lo menos dos pestañas de montaje ubicadas en la base (Ref. No. 1).

- Mueva el caballete (Ref. No. 3) haciendo rotar el mango de la manivela longitudinal (Ref. No. 12). Apriete el tornillo de fijación central (Ref. No. 6) para asegurar la posición.
- Mueva el cuerpo (Ref. No. 16) de la prensa de tornillo a la posición que se desea haciendo rotar el mango de la manivela de avance transversal (Ref. No. 12). Apriete el tornillo de fijación central (Ref. No. 6) para asegurar la posición.
- Abra las mordazas de la prensa de tornillo y coloque la pieza de trabajo entre ellas, en la posición que se desea. Haga rotar el mango de la prensa de tornillo para asegurar la pieza de trabajo entre las mordazas de la prensa de tornillo. Asegúrese que la pieza de trabajo esté sujeta firmemente en la prensa de tornillo antes de empezar la operación de maquinado.

## AJUSTE DE LA CHAVETA

Refiérase a la Figura 2.

- Ajuste las chavetas (Ref. No. 4) apretando los tornillos de fijación (Ref. Nos. 6 y 23) en cada extremo de las chavetas.
- Ajuste los tornillos hasta que se sienta una ligera resistencia al hacer rotar los mangos de la manivela (Ref. No. 12). Apriete las tuercas (Ref. No. 5) para asegurar los tornillos.

## MANTENIMIENTO

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

- 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.

# **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, arbor presses, tombstones, jack screws and vise accessories - LIFETIME.**

**All bench grinders, drill presses, tapping machines, band saws, lathes, milling machines, 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®**

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