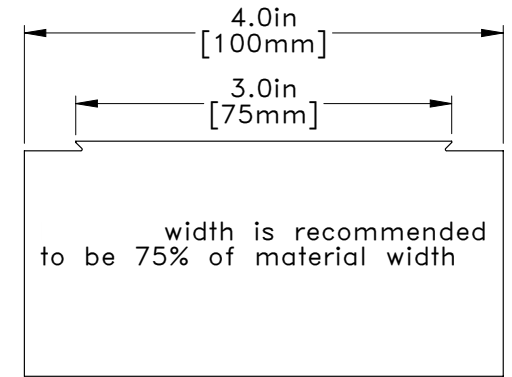
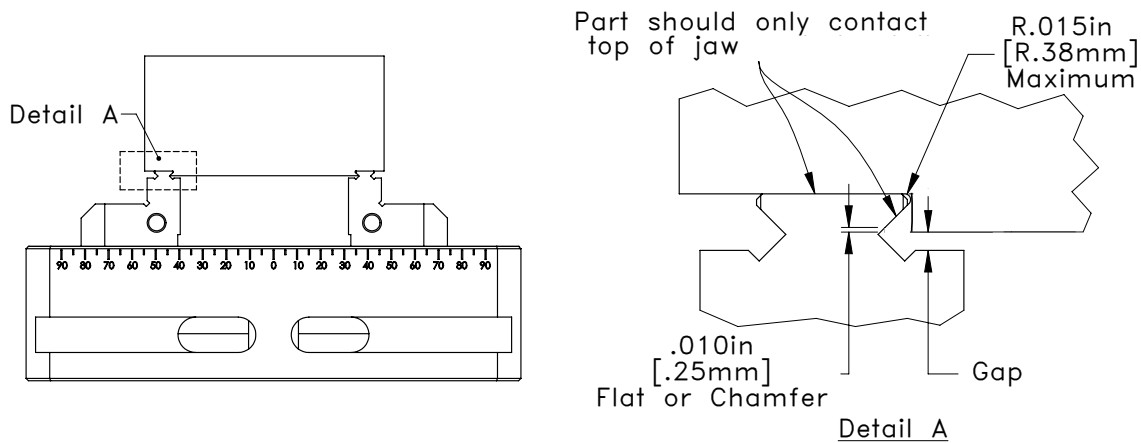
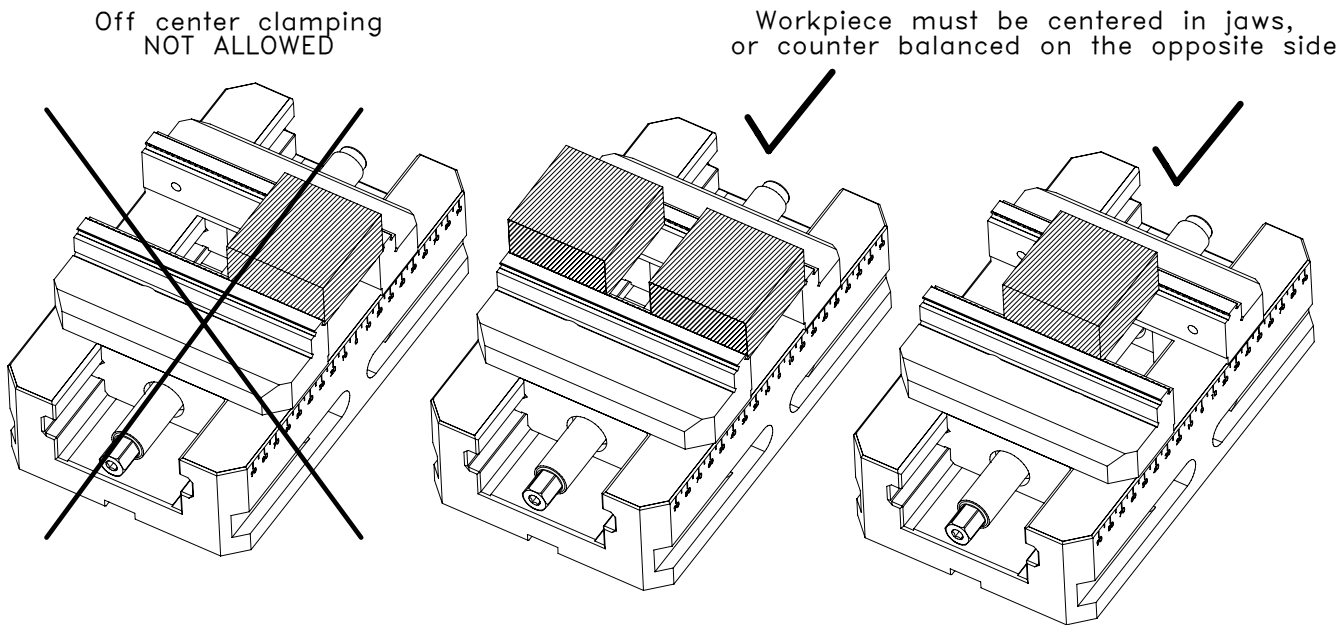


## Detail



Note – Dovetail clamping is not required, but can be utilized for more secure clamping as needed

## Clamping Guidelines



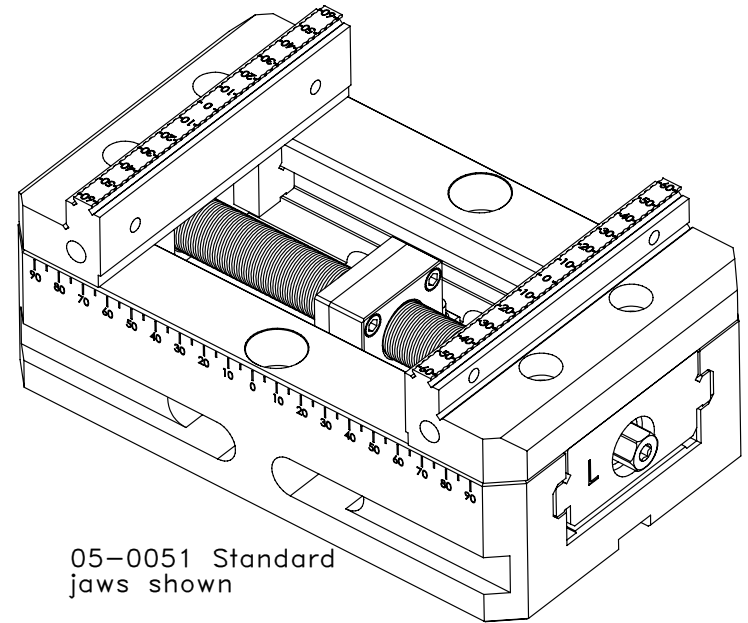
## Vise Operation and Maintenance

1. Keep lead screw well lubricated with Copper based Anti-Seize lubricant
2. Keep the lead screw clean and free of chips and other debris. Use a soft wire or nylon brush to clean the screw regularly
3. Do NOT over torque. Stay below the maximum torque marked on vise. Excess torque may result in damage not covered under warranty
4. Never use power tools to operate the vise
5. Never strike the vise handle with a mallet
6. If machining soft jaws, clamp a spacer block between the jaws at the desired operating torque for maximum precision and repeatability
7. If the vise will not be used for an extended period of time, clean thoroughly and liberally apply rust inhibitor to all surfaces

05-0004 Assembly		
PN	Description	Qty
05-0004	HSCV-5-05	1
	Red and Black Colored Ratchet Wrench	1
	<b>Jaws:</b>	
05-0051	Jaws	1 PR
	<b>Clamping:</b>	
05-0106	Toe Clamps	2
05-0092	Stud Bolt	2
05-0094	Flange Nut	2
05-0096	T-Slot Nuts	2
	<b>Ways Fasteners:</b>	
05-0101	SHCS	2
05-0096	T-nuts	2
	<b>Locating Kit:</b>	
05-0093	Dowel Pin	2
05-0100	SHCS	2
05-0099	BHCS	2
05-0095	Alignment Key: 16mm	2
	<b>Keyways Set:</b>	
05-0095	Alignment Key: 16mm	2
05-0099	BHCS	2

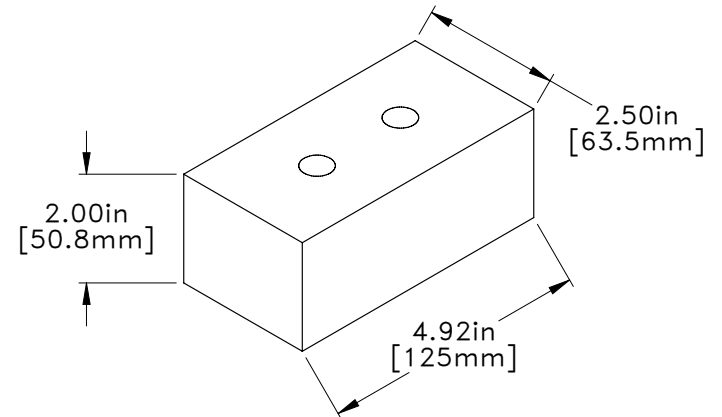
**05-0004 Optional Accessory Kits**

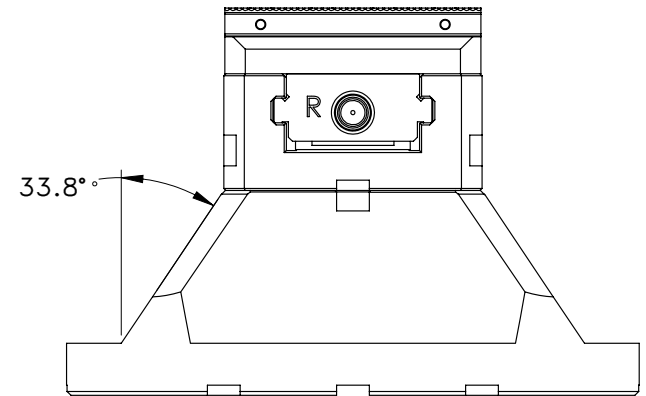
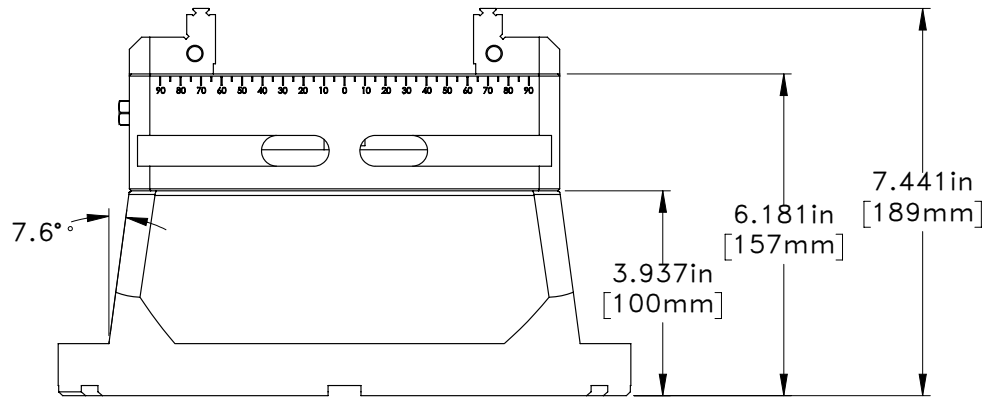
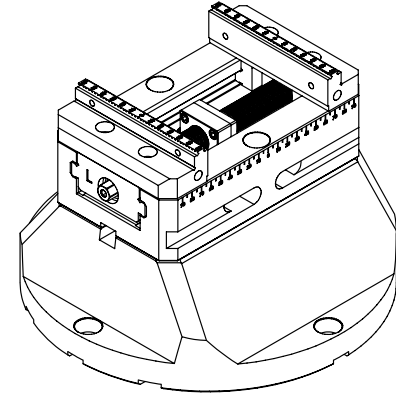
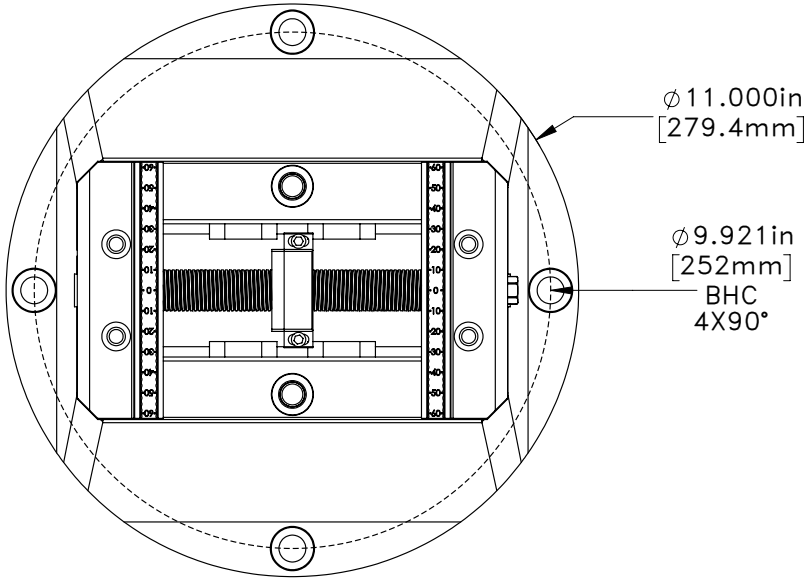
Item:	PN:	Product Name	Description	Qty
1	<b>Jaws:</b>			
	05-0049	HMVJ-5-2.5-A	5" LONG, 2.5" WIDTH, ALUMINUM	1 pr
	05-0050	HMVJ-5-2.5-S	5" LONG, 2.5" WIDTH, STEEL	1 pr
	05-0051	HMV-5-HS	5" LONG, SERRATED HARDENED STEEL	1 pr
2	<b>Riser Kit (05-0098):</b>			
	05-0097	SHCS	M12 X 35MM	4
	05-0096	T-Slot Nut	M12, 16MM	4
	05-0099	BHCS	M6 X 12MM	4
	05-0095	Alignment Key	16MM X 9.9MM X 25MM	4
3	<b>Clamping Kit (05-0042):</b>			
	05-0106	Toe Clamps	12mm	2
	05-0092	Stud Bolt	M12 X 1.75	2
	05-0094	Flange Nut	M12 X 1.75	2
	05-0096	T-Slot Nut	M12, 16MM	2
4	<b>Way Fasteners Kit (05-0074):</b>			
	05-0101	SHCS	M12 X 1.75 X 65MM	2
	05-0096	T-nuts	M12, 16MM	2
5	<b>Locating Kit (05-0075):</b>			
	05-0093	Dowel Pin	10MM X 10MM LONG	2
	05-0100	SHCS	M6 X 1.0 X 16MM	2
	05-0099	BHCS	M6 X 12MM	2
	05-0095	Alignment Key	16MM X 9.9MM X 25MM	2
6	<b>Screw Assembly (05-0076):</b>			
	05-0076	Screw Assembly	RISER KIT HSCV-5-05	1



05-0051 Standard jaws shown

Optional 05-0049 and 05-0050 jaw shape

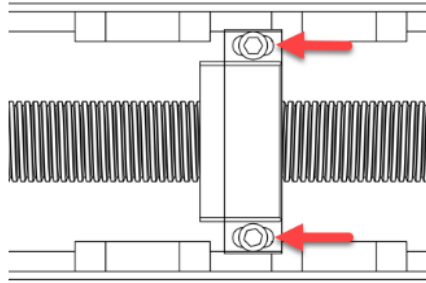




05-0090 100mm Riser Assembly shown with 05-0004 125mm Self Centering Manual Vise  
 Bolt pattern mounts directly to all UMC platters

## Re-Centering Vise Jaws

1. Check that both Vise Jaws are mounted securely and clean
2. Loosen (DO NOT REMOVE) the two center mounting block screws until the assembly can move freely



3. Insert (2) 3/4" diameter dowel pins into the vise as shown
4. Turn lead screw clockwise to lightly clamp the dowel pins between both jaws
5. Tighten the two center mounting block screws until snug, be careful not to over tighten
6. Turn lead screw counter-clockwise to unclamp jaws from dowel pins
7. Remove dowel pins

