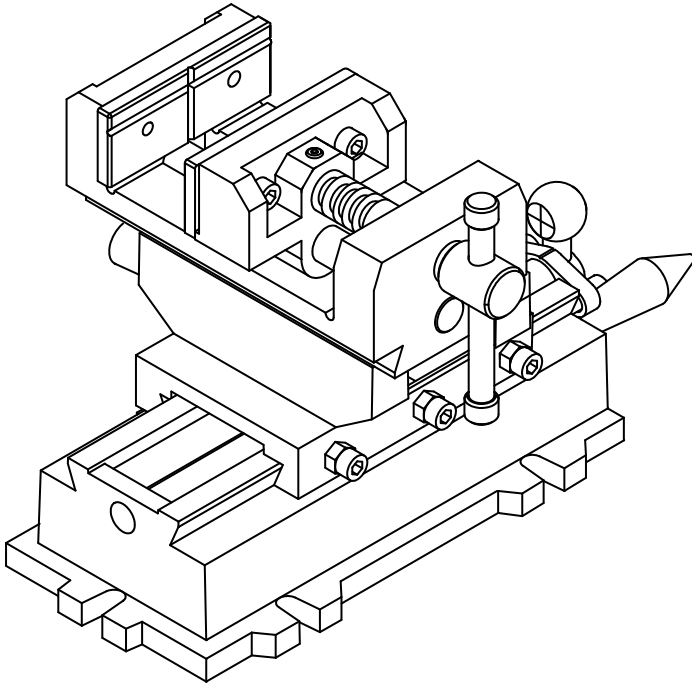


PALMGREN

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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.

- 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.

SAFETY RULES

- Understand and obey all safety instructions supplied with drill press, mill, or other machines on which vise is used.

DIMENSIONS

Refer to Figure 1.

Stock No.		30303B	30601B	30801B
Jaw Width	A	3"	6"	8"
Throat Depth	B	1 ¹ / ₈ "	2"	2"
Jaw Opening	C	3"	6"	8"
Overall Height	H	5 ⁵ / ₈ "	7 ¹ / ₄ "	7 ¹ / ₄ "
Base Length	L	8 ¹ / ₄ "	12 ¹ / ₄ "	12 ¹ / ₄ "
Base Width	W	4 ¹ / ₂ "	7 ¹ / ₂ "	7 ¹ / ₂ "
Longitudinal Travel		5"	8"	8"
Cross Travel		5"	8"	8"
Value of One Division		0.1mm	0.1mm	0.1mm
Cross Travel per One Revolution		3mm	4mm	4mm
Longitudinal Travel per One Revolution		3mm	4mm	4mm

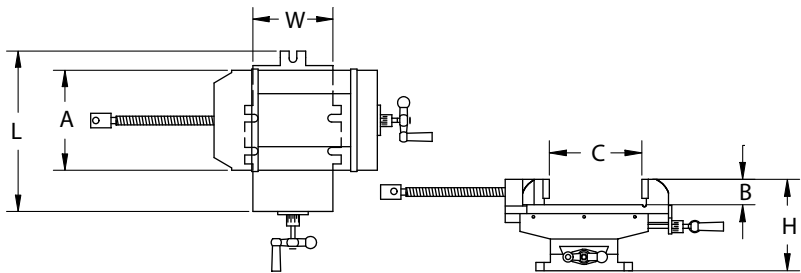


Figure 1 - Dimensions

ASSEMBLY

Refer to Figure 2.

MODEL 30303B, 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 30601B AND 30801B, 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.

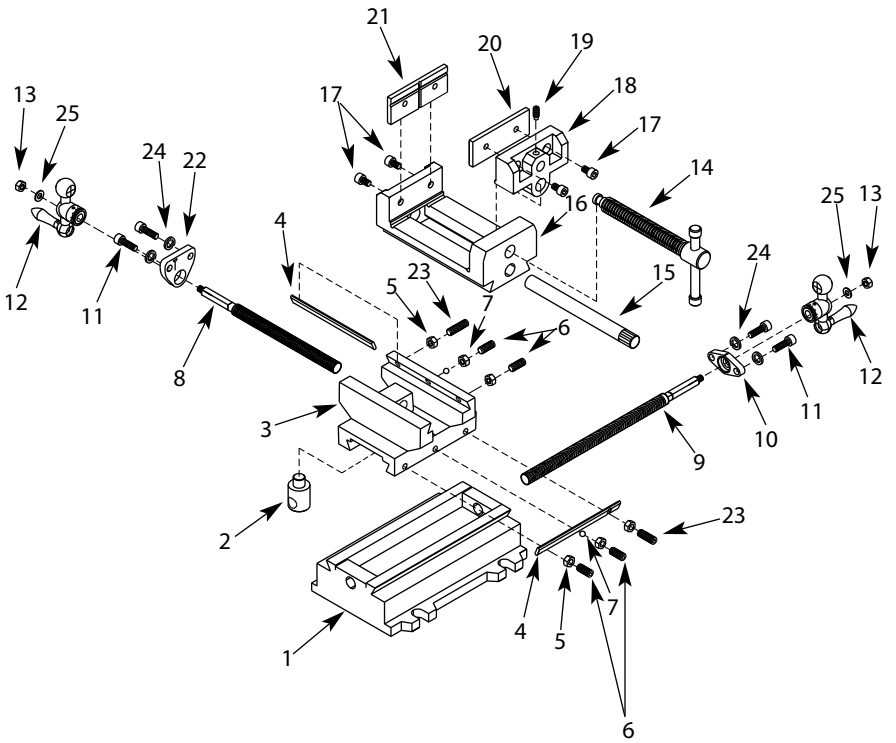


Figure 2 - Replacement Parts Illustration for 3" , 6" and 8" Cross Vise

REPLACEMENT PARTS LIST FOR CROSS VISES

Ref. No.	Description	Part Number for:			Qty.
		3" 30303B	6" 30601B	8" 30801B	
1	Base	28866.00	28884.00	28884.00	1
2	Nut	28867.00	28885.00	28885.00	1
3	Saddle	28868.00	28886.00	28886.00	1
4	Gib	28869.00	28887.00	28887.00	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	28870.00	28888.00	28888.00	2
8	Longitudinal Feed Screw	28871.00	28889.00	28889.00	1
9	Cross Feed Screw	28872.00	28890.00	28890.00	1
10	Retaining Plate	28873.00	28891.00	28891.00	1
11	6-1.0 x 16mm Socket Head Bolt	*	-	-	4
11	8-1.25 x 25mm Socket Head Bolt	-	*	*	4
12	Crank Handle Assmely	28874.00	28892.00	28892.00	2
13	6-1.0mm Acorn Nut	28875.00	28893.00	28893.00	2
14	Leadscrew with Handle	28876.00	28894.00	28901.00	1
15	Guide Rod	28877.00	28895.00	28902.00	1
16	Body	28878.00	28896.00	28903.00	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	28879.00	28914.00	28904.00	1
19	6-1.0 x 12mm Dog Point Set Screw	28880.00	28897.00	28897.00	1
20	Jaw Plate	28881.00	28898.00	28905.00	1
21	Grooved Jaw Plate	28882.00	28899.00	28906.00	1
22	Retaining Plate	28883.00	28900.00	28900.00	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	28865.00	28865.00	28865.00	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		30303B	30601B	30801B
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		0,1 mm	0,1 mm	0,1 mm
Recorrido Transversal por Revolución		3,0 mm	4,0 mm	4,0 mm
Recorrido Longitudinal por Revolución		3,0 mm	4,0 mm	4,0 mm

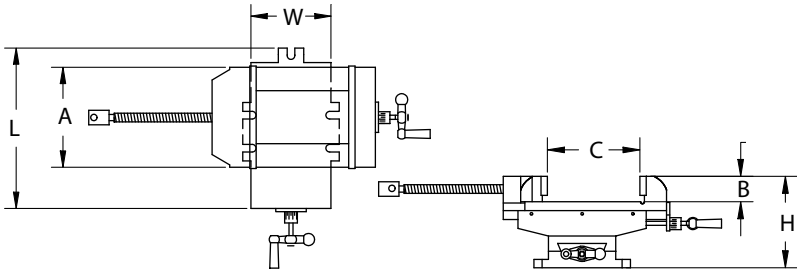


Figura 1 - Dimensiones

MONTAJE

Refiérase a la Figura 2.

MODELO 30303B

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 30601B Y 30801B, 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.

WARRANTY

Palmgren warrants their products to be free of deficiency in material or workmanship. The duration of this warranty is expressly limited to one year parts and labor unless otherwise noted beginning from the date of delivery to the original user. The following Palmgren products carry the following warranties on parts with a 1 year warranty on labor:

- USA Machine vises – Lifetime
- Imported Machine vises – 2 years
- Bench vises – 2 years
- Positioning tables – 2 years
- Bench grinders & buffers – 3 years
- Tapping machines – 2 years
- Drilling machines – 2 years
- Finishing machines – 2 years
- Band saws – 2 years
- Work stands – 2 years

The obligation of 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 deficient. The warranty does not cover expendable and/or wear parts (i.e. v-belts, coated abrasives), damage to tools arising from alteration, abuse or use other than their intended purpose, packing and freight. Purchaser must lubricate and maintain the product under normal operating conditions at all times. Proper use and care instructions are provided in the operator's manual. Failure to follow these instructions will void the warranty.

This warranty is the purchaser's exclusive remedy against Palmgren for any deficiency in its products. Under no circumstances is Palmgren liable for any direct, indirect, incidental, special or consequential damages including lost 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.

SERVICE & REPAIR

1. If a Palmgren product requires a repair or warranty service **DO NOT** return the product to the place of purchase.
2. All warranty related work must be evaluated and approved by Palmgren.
3. Prior to returning any item the user must obtain factory approval and a valid RGA number.
4. For instructions and RGA number call toll free (800) 621-6145.