



Instructional Video

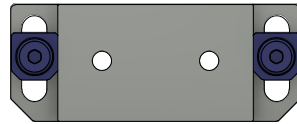
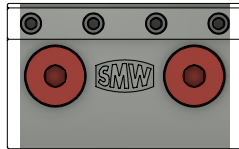
Gen3 Modular Vise

Use Instructions

Recommended Torque Specs

Clamping Bolts

Mounting Bolts



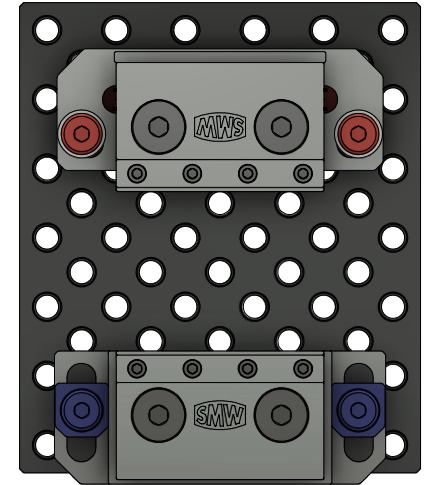
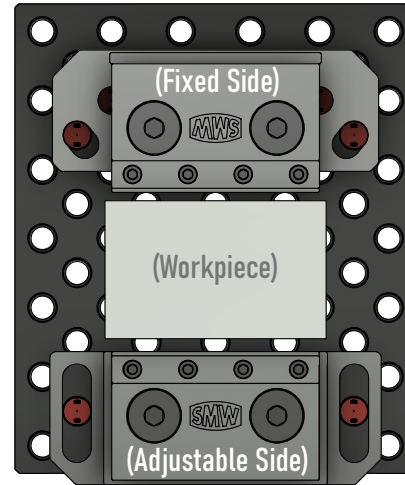
General Use

Do Not Exceed

Steel Fixture Plate

Alu. Fixture Plate

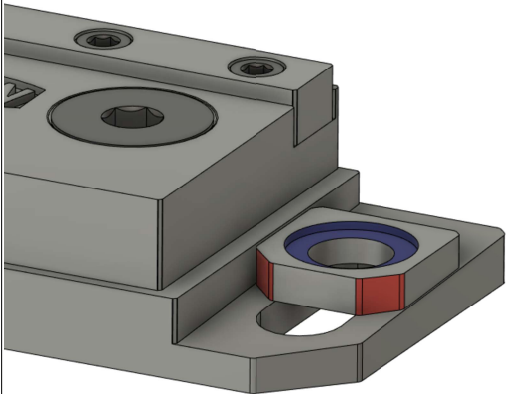
	General Use	Do Not Exceed	Steel Fixture Plate	Alu. Fixture Plate
Inch Vise (1/2")	10-30 ft-lbs [27-40 N-m]	35 ft-lbs [47 N-m]	≤50 ft-lbs [67 N-m]	≤45 ft-lbs [61 N-m]
Metric Vise (M12)	10-30 ft-lbs [27-40 N-m]	35 ft-lbs [47 N-m]	≤50 ft-lbs [67 N-m]	≤40 ft-lbs [54 N-m]



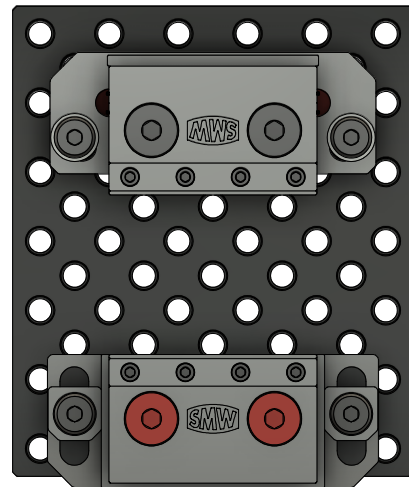
1. Place vise and workpiece on your fixture plate to determine hole placement. (Tip: use **colored fixture plate plugs** to mark repeat setups)

2. Install **fixed side bolts*** to fixture plate. Install **adjustable side bolts and angle washers**, but leave adjustable base loose.

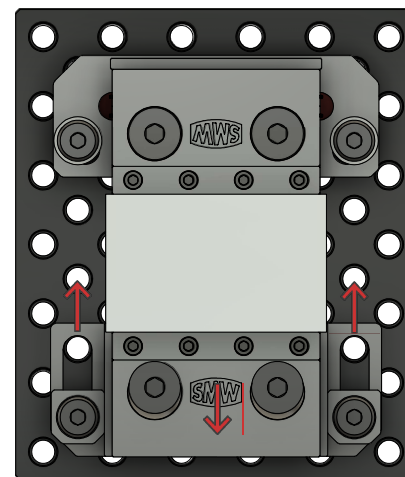
*we recommend tightening the *right* bolt first, which helps to seat alignment pins against the back of fixture plate bores as the bolt tightens



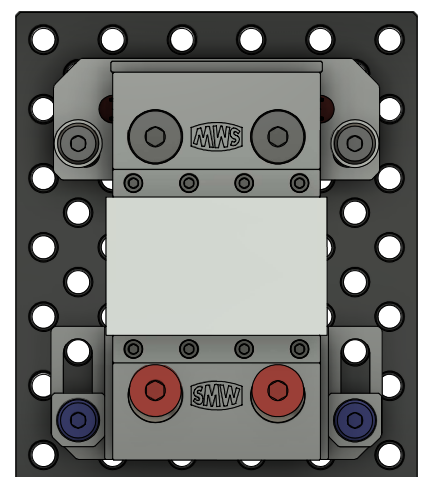
2a. Note that for proper angle washer function, the **large chamfers** must be at the back with the **counterbore** facing up.



3. Back out **adjustable clamping screws** (2) full turns (from the tightened position)



4. Using the workpiece as a spacer, push the adjustable side towards the fixed side (this pushes the adjustable side jaw rearwards, preloading the vise).



6. Tighten the **adjustable side mounting bolts**. The **clamping bolts** can now be used to clamp & unclamp the workpiece.

