



# Instruction Sheet

## Model SB1215, SB1216, SB1217

### Precision Drill Press Vise



## ⚠ WARNING

Models SB1216 and SB1217 are heavy! Get the assistance of a second person when lifting or placing the vise. Wear heavy duty leather boots for foot and toe protection, and keep hands and fingers away from all pinch points. Ignoring this warning can lead to a severe crushing injury or finger amputation!



## Specifications

Hardened Steel Jaws .....	Yes
Hand-Scraped Ways.....	Yes
Leadscrew Type.....	Acme Thread
Epoxy Paint .....	Yes
Net Weight (SB1215) .....	18.5 lbs.
Net Weight (SB1216) .....	39.05 lbs.
Net Weight (SB1217) .....	75.05 lbs.

## Operation

- Place the vise on a clean and lightly-oiled drill press table. Rub the vise base in a circular motion once or twice on the table to fully seat the vise with the table.
- Clamp or bolt the vise to the table. Do not overtighten the clamps or fasteners.
- Position the workpiece between the jaws and tighten the jaws with the handle. Never use a cheater pipe to increase leverage, or you may damage the vise. If you like, unthread the knob and remove the handle (**Figure 1**), so that a socket and ratchet can be used on the end of the leadscrew drive hex. However, never use any type of impact wrench to tighten the leadscrew.

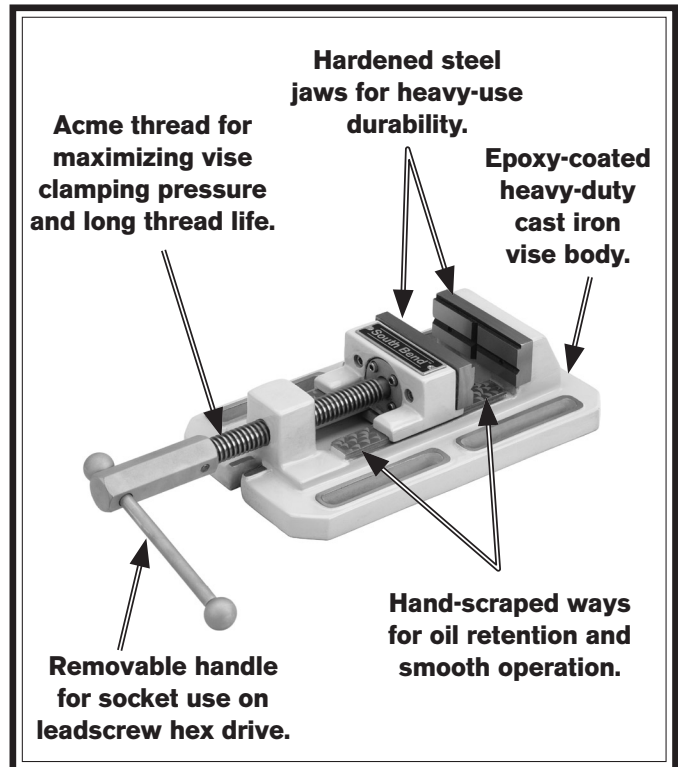


Figure 1. Features.

## Care & Maintenance

- Keep leadscrew and ways clean and oiled.
- Avoid leaving the vise clamped to a cast iron table—moisture may get trapped and rust between mating surfaces.
- Stone away any burrs in the jaws or leadscrew threads.
- Never hammer on vise or a workpiece clamped in vise.
- Never subject vise to flame or water.

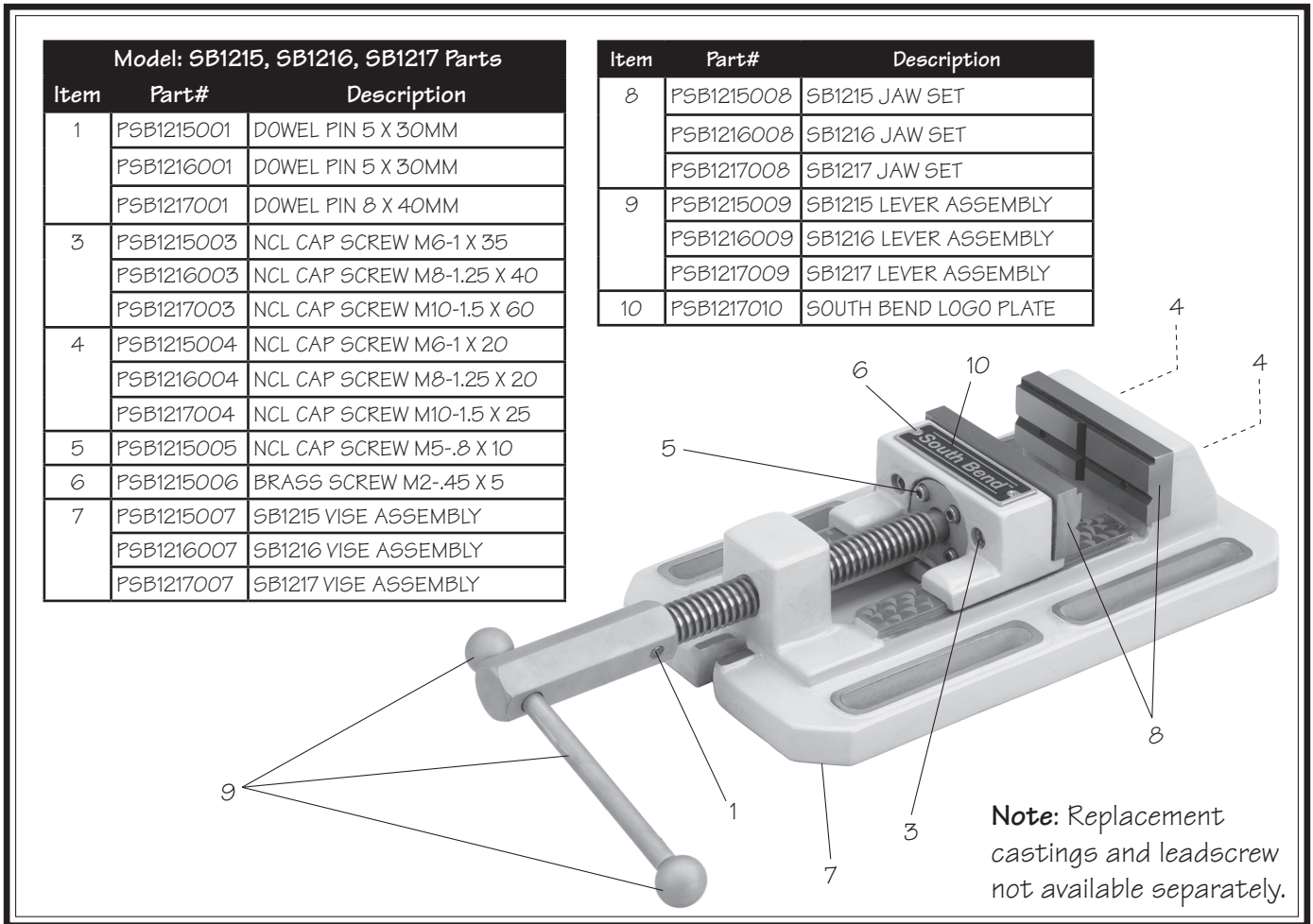
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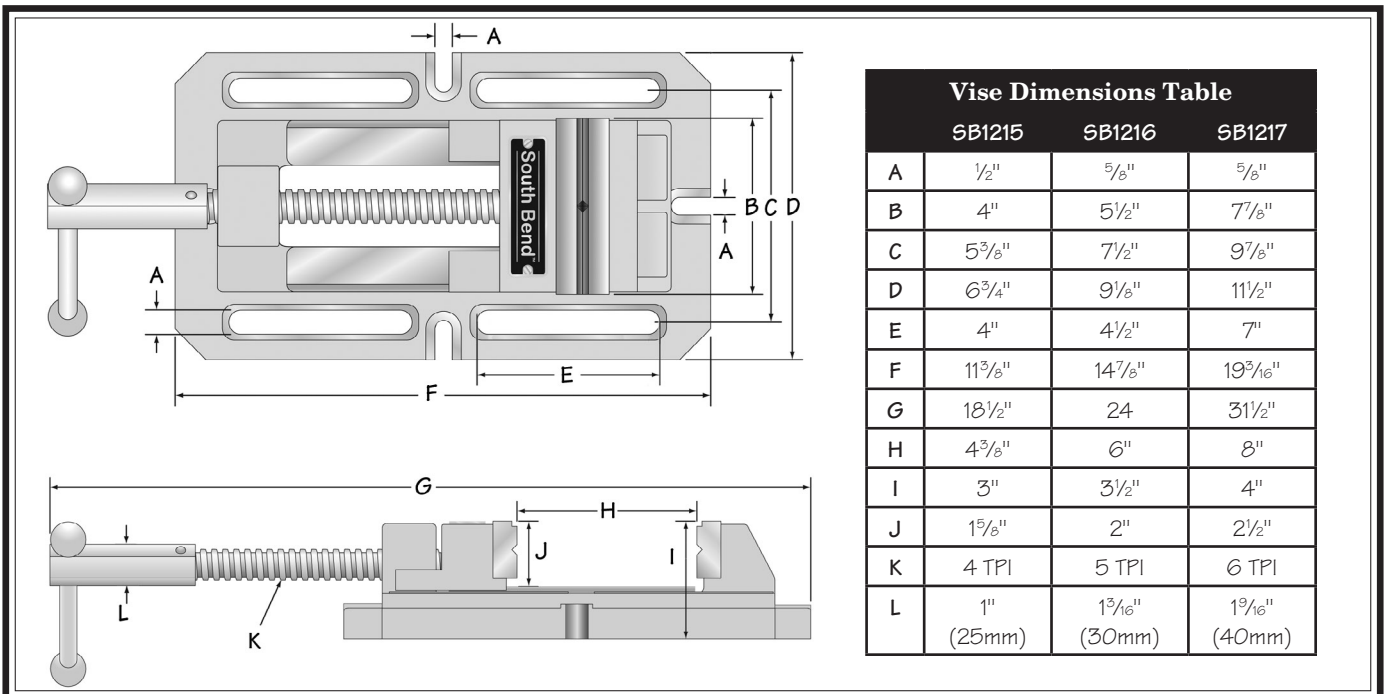
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**Figure 2. Parts list and diagram.**



**Figure 3. Vise dimensions.**

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