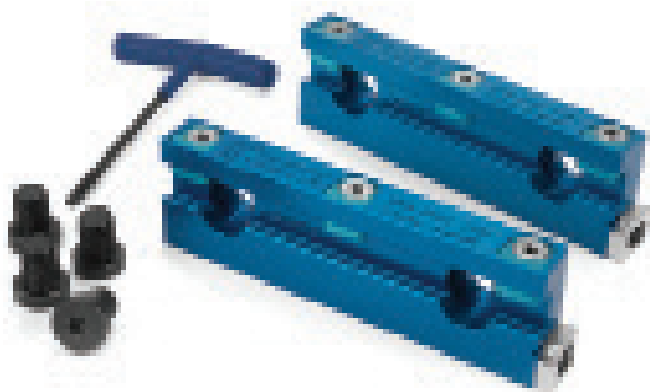




DL6(M) DoveLock Quick Change Jaw System User Guide



Introduction

Thank you for purchasing the Kurt DoveLock Quick Change jaw system.

The following instruction will help you to install and use your new Kurt DJ6(M) Master Jaw Kit. This system is a quick change jaw plate system that allows you to change the jaws over in under a minute. Please follow dirrections carefully to set-up them up correctly

The jaw system has five components to it. You purchase the master jaws to install on your vise. The jaw kits themselves are optional. You must have dicided which of the four sizes you would need. See them listed below.

DL606AL-JawKit	6 inch wide jaws
DL607AL-JawKit	7 inch wide jaws
DL608AL-JawKit	8 inch wide jaws
DL610AL-JawKit	10 inch wide jaws

These jaw kits are an option to your master jaw kit . The jaw kits are purchased as a separate item.

DJ6(M) DoveLock Jaw System

Use this to fill out information about your product for quick reference.

Purchase Date: _____ - _____ - _____

Purchase Order: _____

Purchased From: _____

Delivery Date: _____

Serial No.: _____

Note:

Make sure to register your warranty online at kurtworkholding.com

Installation & Assembly Guide

The Kurt DoveLock Quick Change Jaw System is a precision tool and must be handled carefully and with respect. You will need two Hex wrenches to install them properly.

This workstop is a precision tool and must be handled carefully. You will need a set of Hex wrenches to install it properly.

NOTE: The installation is done by assembly the unit on the backside of the vise (the end opposite the handle).

Fig.1

D40 Parts List

D40 Drawing

Maintenance Schedule

It is very important to perform regularly maintenance on your Kurt vise to assure proper operation. Improper maintenance will result in poor vise performance and may void your warranty.

Daily / Weekly

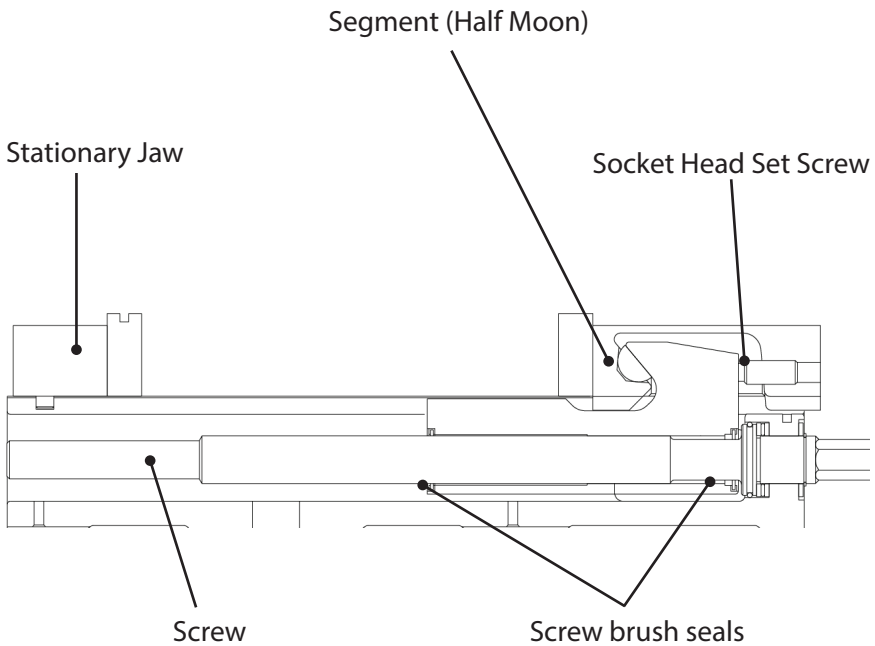
1. Remove chips from surface of vise.
2. Visually inspect for chips, seals for damage and cleanliness.
3. Visually inspect for chip entrapments and remove when necessary.
4. Air-dry and apply rust inhibiting oil to the machined surface of the vise.

Monthly

1. Open the vise to the maximum opening.
2. In the back of the movable jaw (handle end, center hole) loosen the socket head set screw (approx. 6 turns) With the hex key (Allen wrench) in the set-screw socket lift up and forward to pivot the Jaw off of the vise bed.
3. Slide the Jaw slightly toward the stationary jaw and lift up to remove the jaw from the "hook" of the nut. Note: A spherical segment (shaped as $\frac{1}{2}$ of a steel ball) is inside the cavity of the movable jaw and may fall out as the jaw is removed. Take care not to lose or misplace the spherical segment.
4. Turn the movable jaw over and clean the inside cavity. Also clean the spherical segment.
5. Remove chips, clean and apply a light coat of machine oil to the machined surface of the following items:
 - a. Nut & Screw assembly (clean exposed threads on the screw)
 - b. Bed of vise (top of "rails")
 - c. Inside of the vise between the center ways.
6. To re-assemble the movable jaw, apply a "glob" of grease to the under side of the movable jaw in the pocket. Place the spherical segment in the mating pocket and push into the grease. The grease will hold the segment in place when the jaw is turned over to replace.
7. Tip the jaw so the front of the jaw (the side with the jaw plate) is on the vise bed. Lower the jaw on to the bed so that the segment contact the hook part of the nut and rest the jaw on to the vise bed.

8. Tighten the setscrew to firmly contact the nut. Back off the setparallel, sawed, or cast parts.
9. Your vise is now ready for use. Open and close your vise to check for proper operation. Center the part to be clamped in the vise and close. Your parts should be centered from side to side to insure proper clamping. (See Fig. 2 below)

Fig.2



Troubleshooting Tips

The Kurt D-Series vise will operate mostly trouble free for many years. If properly maintained, this product is indestructible. In some cases it will be necessary to troubleshoot. Use the information below to help in the process.

Problem: My vise turns hard.

Tip: As a new vise the brush seal could be stiff. Allow for break in of vise.

Tip: As a used vise, it could be filed with chips and threads could be jammed. Properly clean and grease vise.

Problem: My vise will not turn in either direction.

Tip: The vise is jammed with debris. Disassemble and clean as needed.

Problem: My vise won't hold tolerance.

Tip: You may be experiencing jaw lift from clamping too high or on one side of the jaw. Lower the part in the vise jaw and clamp more material.

Maintenance Log/Notes:

This image shows a single sheet of white paper with horizontal blue ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

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