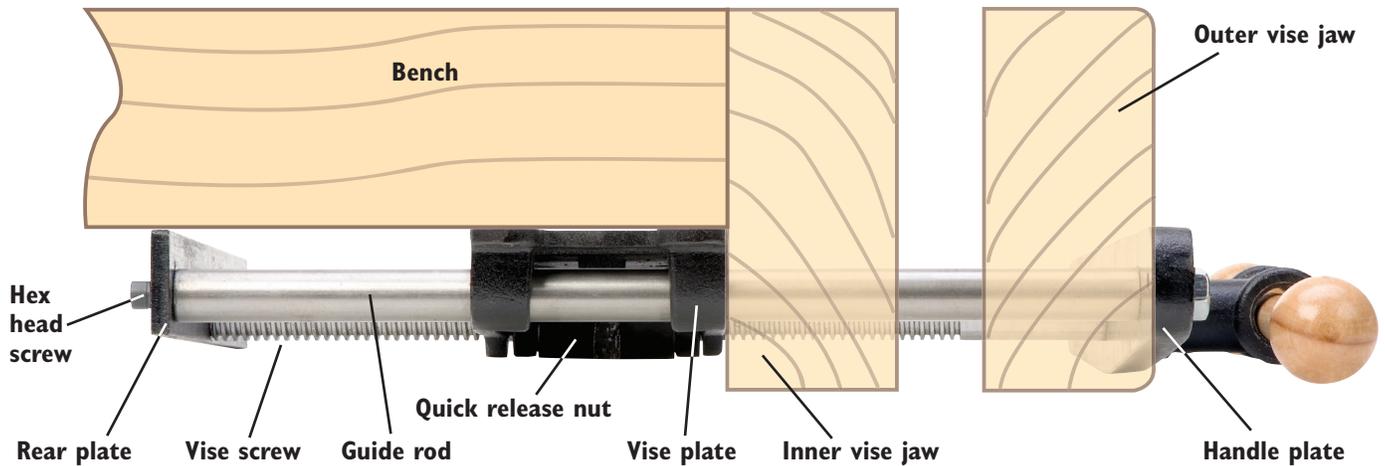


# Heavy Duty Quick Release Front Vise Instructions



1. Mill the wooden vise jaws oversized in height to allow extra wood for fitting. Once the vise is assembled, the top surfaces can be planed flush with the benchtop.
2. Clamp the inner vise jaw against the bench edge. It should extend approx. 1/4" above the benchtop surface and 2½" to 3" below the bottom edge. These dimensions may vary, but it is important that enough stock is below the bench for drilling and mounting the handle assembly.
3. Unscrew the vise so it is in two sections. The handle, handle plate, guide rods and vise screw make up one part, and the cast-iron vise plate makes up the other part. Remove the two hex head screws and rear plate. Slide off the vise plate with the two-part quick-release nut.
4. To determine drilling locations for the vise screw and guide rods, clamp the vise plate in position under the benchtop and flush against the inner vise jaw. Use spacers or shims if the underside of the benchtop is not milled yet. Mark the locations of the holes for the guide rods and vise screw on the inner vise jaw.
5. Unclamp the inner vise jaw from the bench. Repeat Steps 2-4 for the outer vise jaw.
6. Use a drill press to bore the holes for the vise parts in each vise jaw. The holes should be drilled slightly larger than the diameter of the guide rods and vise screw to eliminate any binding when the wood expands. Once the vise jaws have been drilled, you may set the handle assembly into them.
7. Secure the handle plate to the outer vise jaw with wood screws.
8. Mount the vise plate to the underside of the bench with 1/4" lag screws (not included).
9. Insert the vise screw and guide rods through the front vise plate holes and slide the two parts of the quick-release nut onto the screw. Viewed from the bench front, the major nut part with the holes that receive the vise screw will have its tab pointing toward the right side.
10. Slide the vise screw and guide rods through the rear set of vise plate holes and test the mechanism for proper fit and assembly of quick-release components.
11. Attach the rear retaining plate to the back ends of the guide rods and vise screw with the hex screws.
12. Open the vise and position the inner vise jaw against the edge of the bench; drill and countersink pilot holes and attach with wood screws.
13. Lubricate the vise screw and guide rods with a light grease and lightly oil all other metal parts to inhibit rust formation.

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