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SCMX250 SCMX425

Operating Instructions Manual



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Vise Data

(Use this to fill out information about your vise for quick reference)

Purchase Date: _____

Purchase Order: _____

Purchased From: _____

Delivery Date: _____

Serial No.: _____

NOTE:

Make sure to register your warranty online at www.kurtworkholding.com to receive the full benefits of the Kurt Manufacturing Lifetime Ironclad™ Warranty.



Thank you!

If you have any feedback or questions,

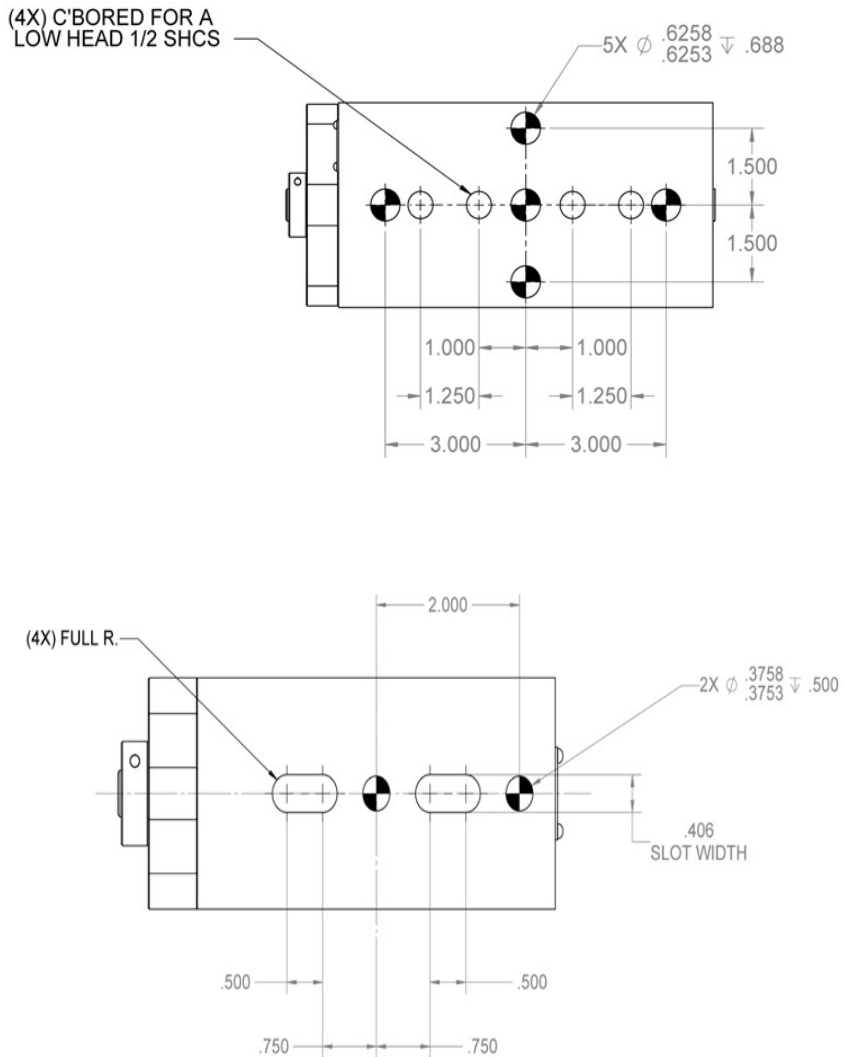
Please contact us at:
workholding@kurt.com

or

877-226-7823

Installation & Assembly Guide

Both of the SCMX vises can be mounted thru the inside of the vise and located from the bottom using dowels. They are designed with c'bored holes for low head cap screw as well as dowel holes for precise locating.



3 to 6 months

1. Open vise to maximum opening.
2. Loosen and remove the movable jaw. See pg. 10
3. Remove the 3 SHCS from the screw support and remove the nut & screw assembly.
4. Remove the screw support from the screw by loosening the front collar from the screw.
5. Remove the thrust bearing assembly consisting of (4) thrust washers and (2) thrust bearing from each side of the screw support.
6. Clean and inspect the thrust washers and thrust bearing.
7. Apply water resistant grease to the thrust washer (i.e. marine grade grease)
8. Install thrust bearing assemblies on the screw in the reverse manner.
9. Install the screw support and collar assemblies in the reverse manner by spinning on the screw.

NOTE: When re-installing your collars & bearings be careful to get them in their proper position. The collar should only be finger tight or less. The vise should have a smooth operation. If not check to make sure that the washers & bearing have been installed correctly.

10. Install the three SHCS back in the screw support and make tight.
11. Your vise is now ready to use.

Maintenance Schedule

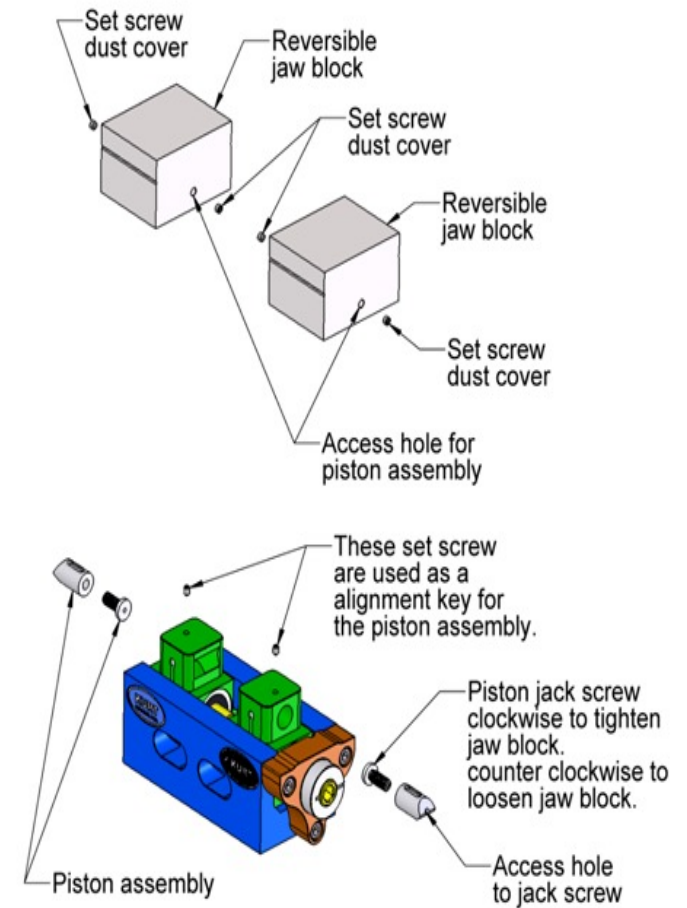
It is very important to perform regularly maintenance on your Kurt vise to assure proper operation. Improper maintenance will result in poor vise performance and may void your warranty.

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. Remove the moveable jaws using the procedure on page 10.
3. Turn the movable jaw over and clean the inside cavity.
4. Remove any chips, clean and apply a light coat of machine oil to the machined surface of the following item
 - a. Nut and Screw assembly (clean exposed threads on the screw)
 - b. Bed of vise (top of “rails”)
 - c. Inside of the vise between the center ways.
5. 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.1 below)



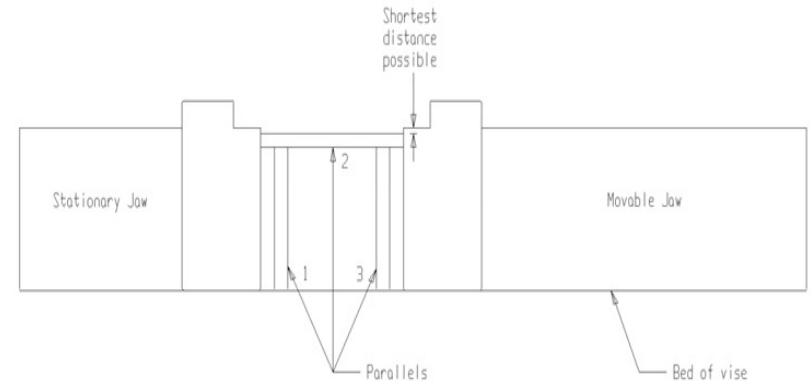
SCMX250 Parts List

SCMX 250 VISE			
ITEM #	PART #	DESCRIPTION	QTY
1	SCMX250-1	BODY	
2	MX350-211	INTERNAL BRUSH SEAL	
3	SCMX250-5	SCREW	1
4	SCMX250-8	FRONT COLLAR	2
5	SCMX250-42	THRUST WASHER	4
6	D30-41	THRUST BEARING	2
7	SCMX250-3F	FRONT NUT	1
8	SCMX250-3R	REAR NUT, RIGHT HAND THREADS	1
9	SCMX250-348	JAW BLOCK REVERSIBLE CARVABLE	2
11	SCMX250-142	PLUNGER	
12	01-1039	SHSS 6-32 X .188 LG	2
13	SCMX250-11	CUSTOM SCREW	2
14	01-1049	SHSS 8-32 X .125 LG, FLAT PT.	4
15	00-1291	SHCS 1/4-20 X .875 LG	2
16	SCMX250-224	SCREW SUPPORT	1
17	07-0230	U-TYPE DRIVE SCREW #2 X 1/4 LG	2
18	SCMX250-102	MODEL/SERIAL NUMBER TAG	1
19	SCMX250-313	WEBSITE STICKER	1
20	SCMX250-111	KURT LOGO STICKER	2
21	SCMX250-314	MAXLOCK STICKER	1
22	SCMX250-311	SCMX250 WIRE SPRING	2
23	SCMX250-355	SCMX250 .1875 STEEL BALL	4

Machining the carvable Jaws

To machine the jaws for the SCMX250 and SCMX425 use this simple standard procedure to do so.

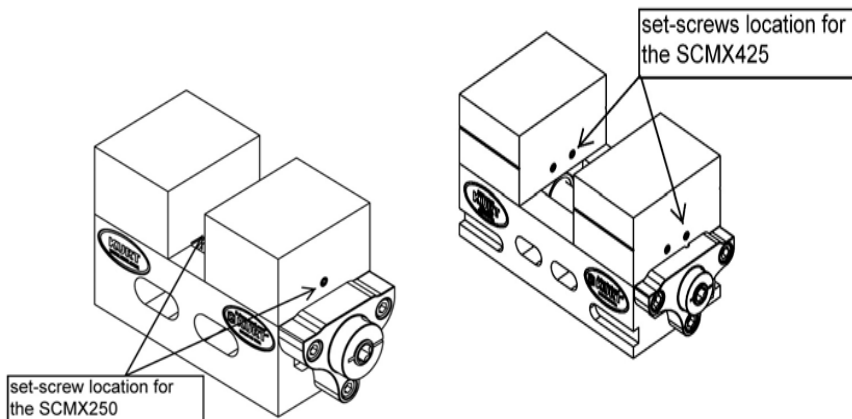
In order to get the best results when cutting the soft jaws, use parallels that are just below the cut surface. For better accuracy torque the vise to the same amount of torque you would be running production at when cutting your jaws.



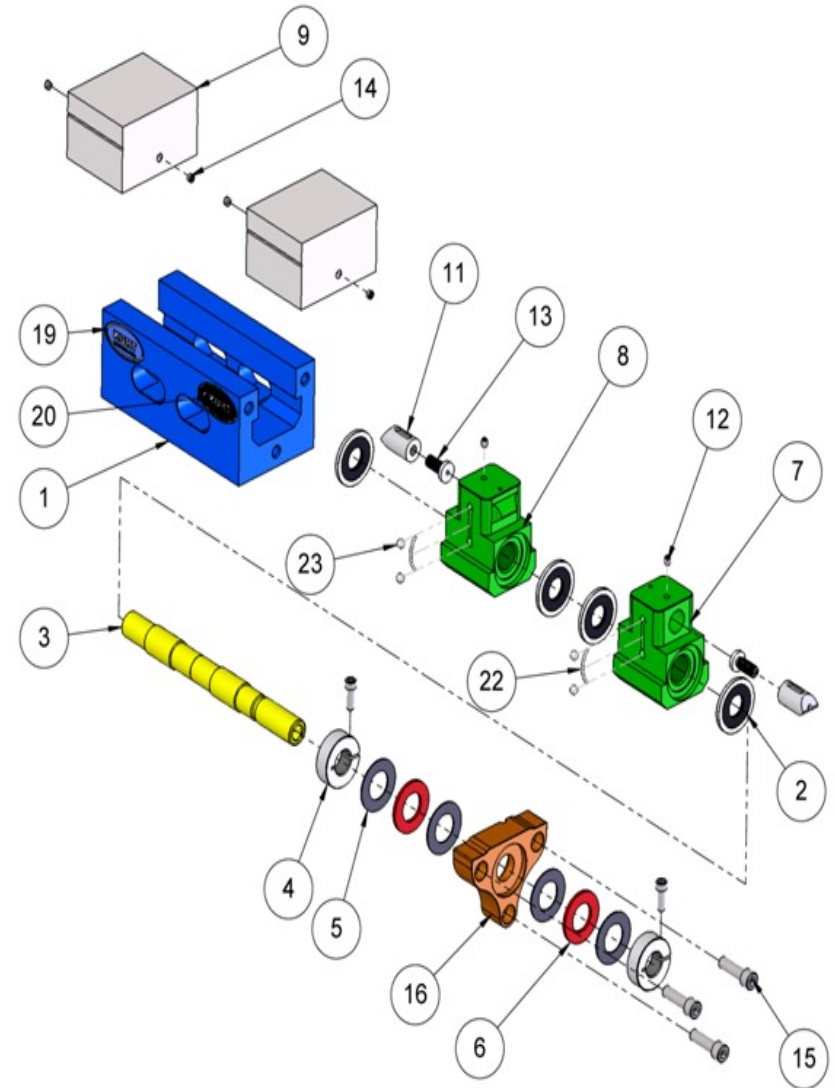
Jaw Removal

The machinable jaws on the SCM250 and SCM425 are easily removed. The following steps will help you to remove them for replacement or reversing them.

1. Using an allen wrench remove the first set screw (dust cover) in the front of the jaw. Use a 5/64 and a 3/32 for the SCM250 and a 3/32 and 1/8 for the SCM425 vises. The SCM250 has one in each jaw and the SCM425 has two in each jaw.
2. The next step is to screw in the internal plungers. The SCM250 Uses a 3/32 hex and the SCM425 uses a 1/8 hex allen wrench. This will release the jaw from the nut and allow you to lift off the jaw from the vise. Clockwise to lock, counter-clockwise to unlock.
3. Once the jaws are off of the vise they can be reserved and re-installed on the vise if needed.
4. When re-installing the jaws on the vise nut be sure that the Plungers are pushed all the way in. If not the jaw will not rest completely down on the nut.



SCM250 Mechanical Drawing



SCMX425 Parts List

SCMX 425 VISE			
ITEM #	PART #	DESCRIPTION	QTY
1	SCMX425-1	BODY	1
2	PT400-211	BRUSH SEAL	4
3	SCMX425-5	SCREW	1
4	SCMX425-8	FRONT COLLAR	2
5	TRA-1220	THRUST WASHER	4
6	D40-41	THRUST BEARING TORRINGTON	2
7	SCMX425-3F	FRONT NUT	1
8	SCMX425-3R	REAR NUT (RIGHT HAND THREADS)	1
9	SCMX425-348	JAW BLOCK REVERSIBLE CARVABLE	2
11	SCMX425-142	PLUNGER	4
12	01-1440	SHSS 6-32 X .25 LG, FLAT PT.	4
13	SCMX425-11	CUSTOM SCREW (5/16-24 X .875 LG)	4
14	01-0460	SHSS 10-32 X .188 LG, FLAT PT.	8
15	00-1353	SHCS 3/8-16 X .88 LG	3
16	SCMX425-224	SCREW SUPPORT	1
17	07-0230	U-TYPE DRIVE SCREW #2 X 1/4 LG	2
18	SCMX425-102	MODEL/SERIAL NUMBER TAG	1
19	SCMX425-313	WEBSITE STICKER	1
20	SCMX425-111	KURT LOGO STICKER	2
21	SCMX425-314	MAXLOCK STICKER	1
22	SCMX250-311	SCMX250 WIRE SPRING	4
23	SCMX250-355	SCMX250 .1875 STEEL BALL	2

SCMX425 Mechanical Drawing

