

# KURT SIDEWINDER VISE FOR 2ND OP WORK HOLDING

Operating Instruction Manual  
Model No. SDW35



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## INTRODUCTION

Thank you for purchasing a Kurt Sidewinder 2nd Op vise.

The SideWinder is a versatile, quick mounting vise that will work on SDW35 the left or right side of any Kurt 6 inch vise. The sidewinder mounts SDW35 vertically to the back stationary jaw and uses an integral bracket and SDW35 a stabilization leg for support. A workstop is also included for part SDW35 height positioning. This Kurt vise permits fast, accurate positioning on SDW35 repetitive vertical work. It can be used with your AngLock precisionSDW35vise for accurate parts production.

# INSTALLATION & ASSEMBLY GUIDE

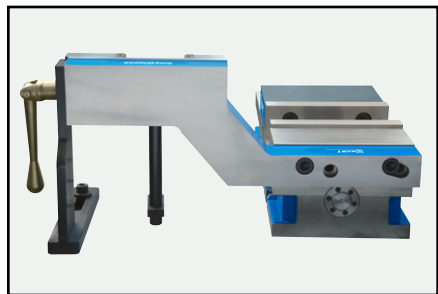
The Kurt SideWinder vise is a precision tool and must be handled carefully. You will need a set of socket wrenches to install it properly.

## Begin by following the steps listed.

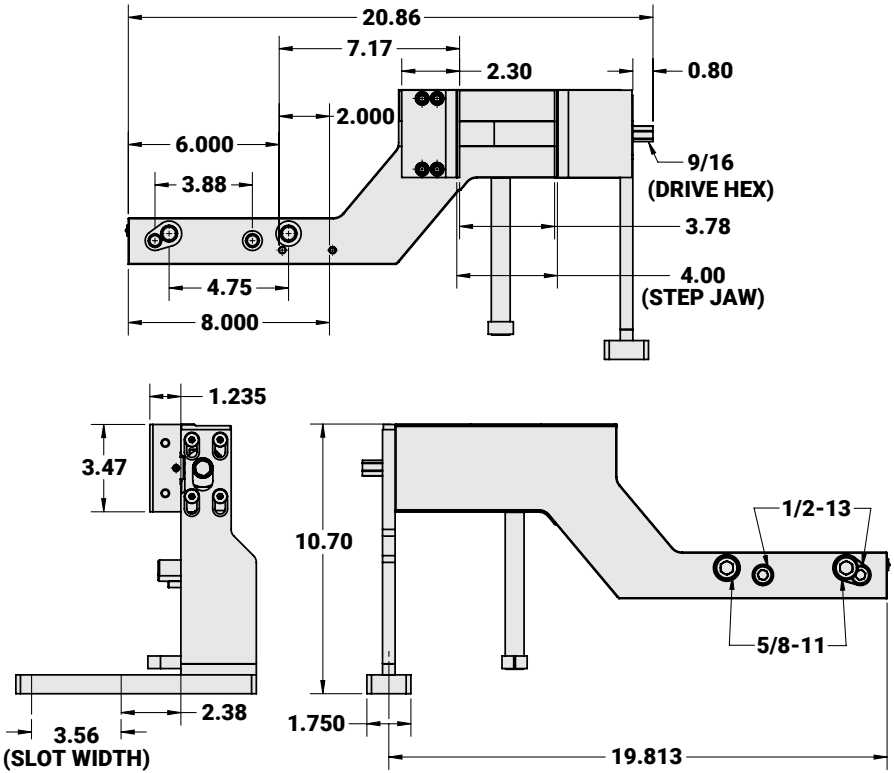
1. Clean the back of the vise hone if needed.
2. Using the two 1/2-13 SHCS provided mount the Sidewinder vise on the back lip of the vise with the 1/4 pin stopping off the left or right side of the vise as you are looking at the back of the vise (opposite the handle).
3. Attach the support bracket to end of the SideWinder and be sure that the foot rests on the machine table. Use two "T" nuts and bolts to fasten the foot to the machine table. Finger tighten only.
4. Once the SideWinder is installed and you are sure that it is square, tighten all the fasteners as required.
5. Do not over torque the vise. Use our recommended torque setting to tighten your vise.

TORQUE FT-LBS	CLAMPING FORCE - LBS
4	580
6	880
8	1,120
10	1,540
12	2,450

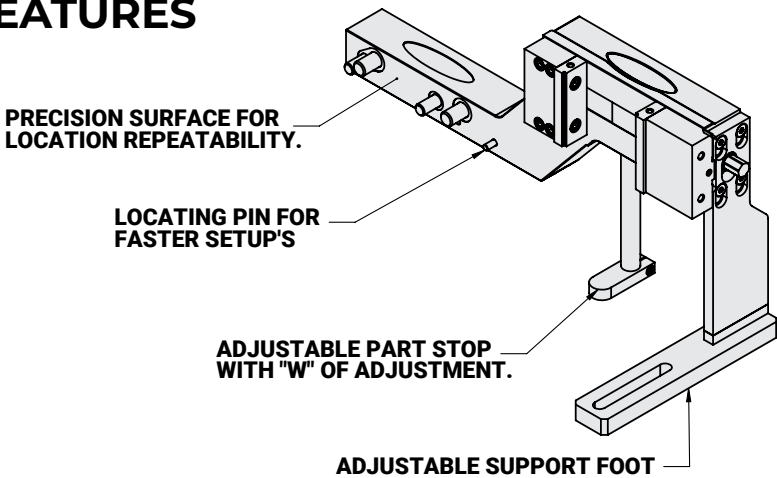
**NOTE:** The installation is done by assembling the unit on the backside of the vise (the end opposite the handle).



# DIMENSIONAL DRAWINGS



# FEATURES

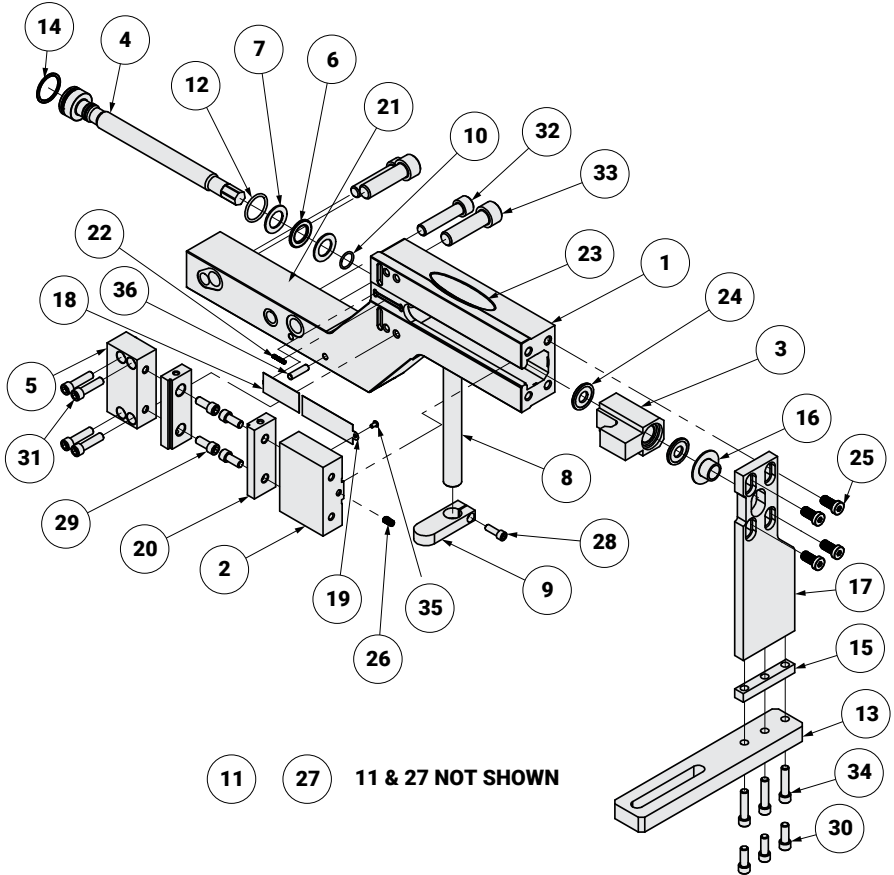


# SDW35 PARTS LIST

ITEM#	PART#	DESCRIPTION	QTY.
1	SDW35-1	BODY	1
2	SDW35-2	MOVABLE JAW	1
3	SDW35-3	NUT	1
4	SDW35-5	SCREW	1
5	SDW35-6	STATIONARY JAW	1
6	D40-41	THRUST BEARING	1
7	DL400-42A	THRUST WASHER	2
8	SDW35-58	ROD, WORK STOP	1
9	SDW35-85	WORK STOP	1
10	SDW35-96	O-RING #016	1
11	SDW35-102	MODEL/SERIAL NUMBER TAG	1
12	SDW35-119	O-RING #121	1
13	SDW35-126	FOOT ADJUSTMENT MOUNT	1
14	SDW35-147	RETAINING RING	1
15	SDW35-186	SPACER PLATE	1
16	SDW35-224	SCREW SUPPORT	1
17	SDW35-227	RETAINING PLATE	1
18	SDW35-248	CHIP GUARD SHORT	1
19	SDW35-249	CHIP GUARD LONG	1
20	ML35-32	STEP JAW PLATE	2
21	SDW25II-111	KURT LOGO STICKER	1
22	SDW35-311	SPRING 0.125 OD X 1.75 LG	1
23	SDW25II-314	SIDEWINDER STICKER	1
24	MX350-211	BRUSH SEAL	2
25	00-3352	LHSHCS 3/8-16 X 0.75 LG	4
26	01-3076	CP SHSS 1/4-20 X 0.50 LG W/ NYLOCK	1
27	07-0230	U-TYPE DRIVE SCREW #2 X 1/4 LG	2
28	00-1290	SHCS 1/4-20 X 0.75 LG.	1
29	00-1321	SHCS 5/16-18 X 0.75 LG	4
30	00-1322	SHCS 5/16-18 X 0.875 LG	3
31	00-1326	SHCS 5/16-18 X 1.25 LG	4
32	00-1424	SHCS 1/2-13 X 2.25 LG	2
33	00-1486	SHCS 5/8-11 X 2.25 LG	2
34	00-1327	SHCS 5/16-18 X 1.375 LG	3
35	03-0110	SBHCS 6-32 X 0.25 LG.	1
36	04-0043	DOWEL PIN 1/4 X 1.00 LG	1

# SDW35 MECHANICAL DRAWING

Fig.8



# MAINTENANCE SCHEDULE

It is very important to perform regular maintenance on your Kurt vise to ensure 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 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 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. 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 nut so the jaw rests on the vise bed.
7. Tighten the setscrew to firmly contact the nut. Back off the set parallel, sawed, or cast parts.
8. 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.

# MAINTENANCE SCHEDULE

## 3 to 6 months

1. Open vise to maximum opening.
2. Remove spiral snap ring and washer from hex end of the vise screw.
3. Slide the movable jaw toward the stationary.
4. Remove the thrust bearing assembly consisting of (2) thrust washers and (1) thrust bearing from the counter bore in the end of the body.
5. Clean and inspect the counter bore, thrust washers and thrust bearing.
6. Apply water resistant grease to the thrust washer (i.e. marine grade grease)
7. Install thrust bearing assembly on the screw and slide the movable jaw back.
8. Install washer and spiral retaining ring.
9. Your vise is now ready to use.

# TROUBLESHOOTING TIPS

If properly maintained, the Kurt SideWinder vise will operate trouble free for many years. In some cases it may 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.

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