

Owner's Manual & Safety Instructions

Save This Manual Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's serial number in the back of the manual near the assembly diagram (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference.

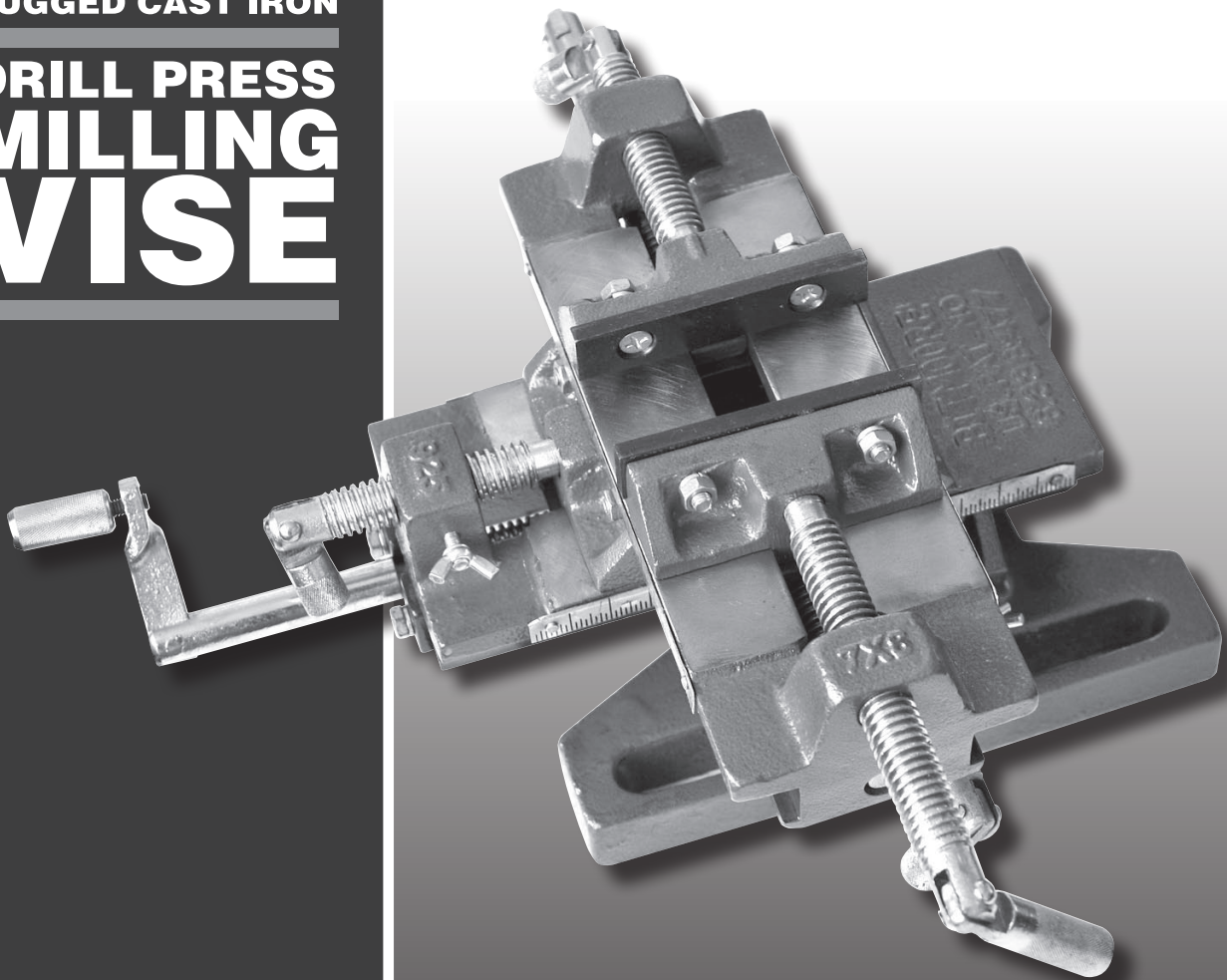
**CENTRAL
Forge**

5In.

RUGGED CAST IRON

**DRILL PRESS
MILLING
VISE**

ITEM 69159



Visit our website at: <http://www.harborfreight.com>
Email our technical support at: tech@harborfreight.com

When unpacking, make sure that the product is intact and undamaged. If any parts are missing or broken, please call 1-800-444-3353 as soon as possible.

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No portion of this manual or any artwork contained herein may be reproduced in any shape or form without the express written consent of Harbor Freight Tools. Diagrams within this manual may not be drawn proportionally. Due to continuing improvements, actual product may differ slightly from the product described herein. Tools required for assembly and service may not be included.

⚠ WARNING

**Read this material before using this product.
Failure to do so can result in serious injury.
SAVE THIS MANUAL.**

IMPORTANT SAFETY INFORMATION

WARNING

Read all safety warnings and instructions.

Failure to follow the warnings and instructions may result in serious injury.

Save all warnings and instructions for future reference.

Setup Safety

1. **Mount this item securely before use.** The forces exerted on this vise during use may cause a poorly mounted or unmounted vise or workpiece to come loose; causing SEVERE PERSONAL INJURY or property damage.
2. **Carefully follow all warnings and operation instructions, including accessory mounting instructions, provided with the equipment you will mount this vise on.**

Operation Safety

1. **Stay alert, watch what you are doing and use common sense when operating a tool. Do not use while you are tired or under the influence of drugs, alcohol or medication.** *A moment of inattention may result in serious personal injury.*
2. **Use personal protective equipment. Always wear ANSI-approved safety goggles.** *Safety equipment used for appropriate conditions will reduce personal injuries.*
3. **Dress properly. Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts.** *Loose clothes, jewelry or long hair can be caught in moving parts.*
4. **Do not force the tool. Use the correct tool for your application.** *The correct tool will do the job better and safer at the rate for which it was designed.*
5. **Make sure that the equipment's bit does not come in contact with this vise.** Damage to the vise may damage the workpiece or cause a piece to fly off causing personal injury.
6. **This product is not a toy.** Keep it out of reach of children.

Maintenance and Storage Safety

1. **Store idle tools out of the reach of children and do not allow persons unfamiliar with the tool or these instructions to operate the power tool.** *Power tools are dangerous in the hands of untrained users.*
2. **Maintain tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the tool's operation. If damaged, have the tool repaired before use.** *Many accidents are caused by poorly maintained tools.*
3. **Maintain labels and nameplates on the tool.** These carry important safety information. If unreadable or missing, contact Harbor Freight Tools for a replacement.



SAVE THESE INSTRUCTIONS.

Specifications

Overall Base Dimensions	7 IN. X 8-1/2 IN. X 6 IN. High
Maximum Jaw Opening	4-3/4"
Cross Travel	7-1/8"
Jaw Depth	1"
Longitudinal Travel	6-1/8"
Features	56 Square Inch X and Y Movement Calibrated to Scales

Setup - Before Use:



Read the **ENTIRE IMPORTANT SAFETY INFORMATION** section at the beginning of this manual including all text under subheadings therein before set up or use of this product.

Note: For additional information regarding the parts listed in the following pages, refer to *Parts List and Diagram* on page 7.

Assembly/Mounting

1. Make sure the power-head of your drill press is fastened securely to the column of the drill press. Lock the worktable into place.
2. Secure the Lower Base (1) of the Vise in the center of the drill press worktable, using appropriate hardware, as provided with or explained in the manual for the drill press machine (hardware not included). Make sure that the hardware used solidly secures the vise and does not interfere with the X/Y adjustment of the vise. **See Figure 1.**

Functions

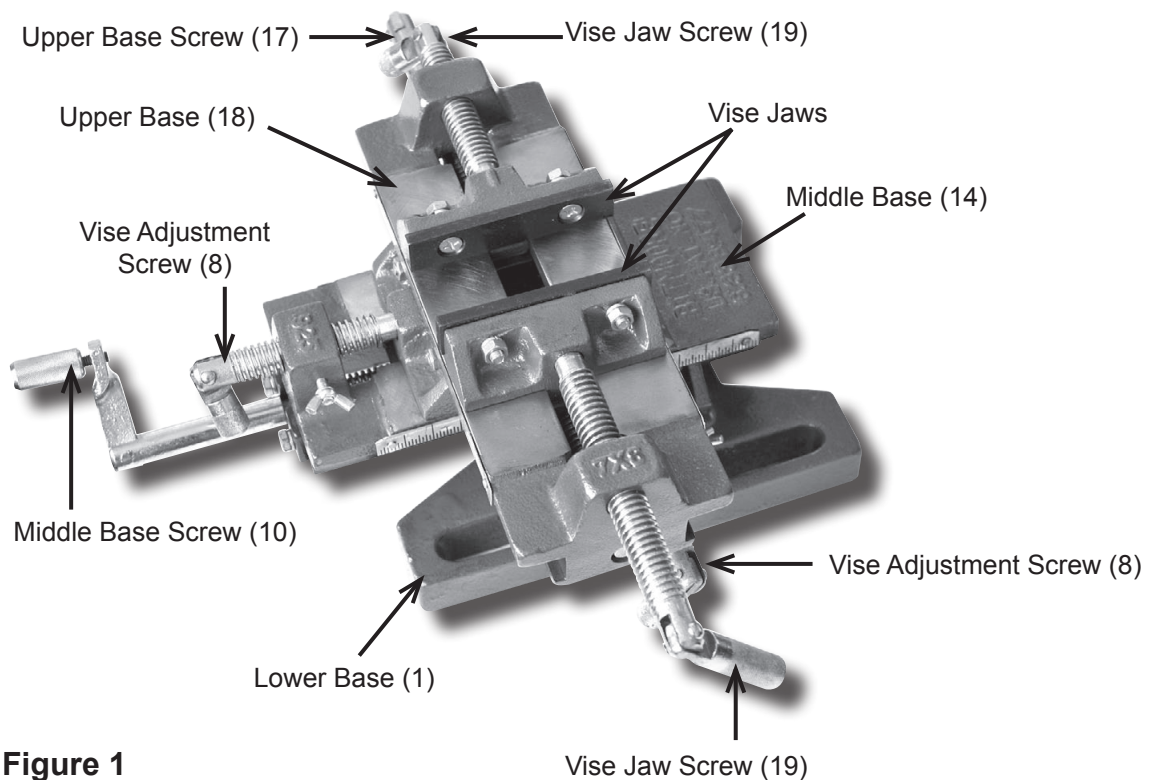


Figure 1

Operating Instructions



Read the **ENTIRE IMPORTANT SAFETY INFORMATION** section at the beginning of this manual including all text under subheadings therein before set up or use of this product.

Work Piece and Work Area Set Up

Designate a work area that is clean and well-lit. The work area must not allow access by children or pets to prevent distraction and injury.

General Operating Instructions

1. The Vise Adjustment Screws (8) and Middle Base Screw (10) are for adjusting the tension on X/Y movement of the workpiece secured in the Vise Jaws. Use the handles to hold the Adjustment Screws (8 & 10) at the desired tension. **See Figure 2 and Parts Diagram, page 7.**

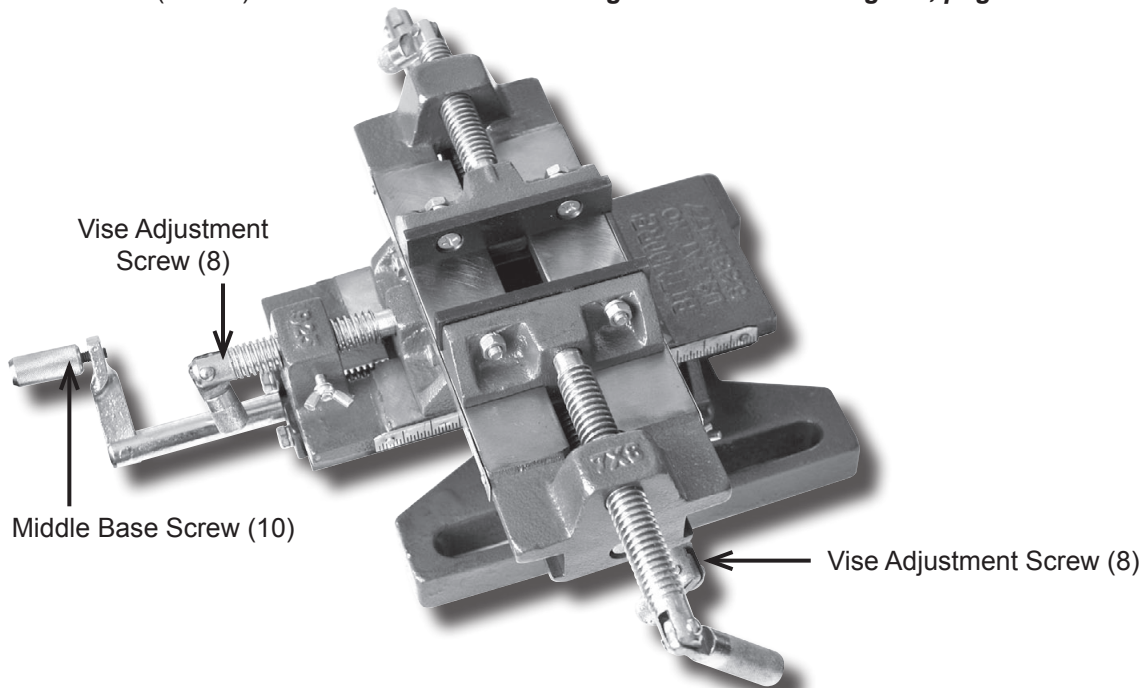


Figure 2

2. Turn the Handles on the Vise Jaw Screws (19) to hold the workpiece in place. The unit is calibrated to eight turns per inch (1/8" per turn). Match up with the visual aid reference scales (SAE) which are located on all four sides of the Vise.

See Figures 3 & 4.

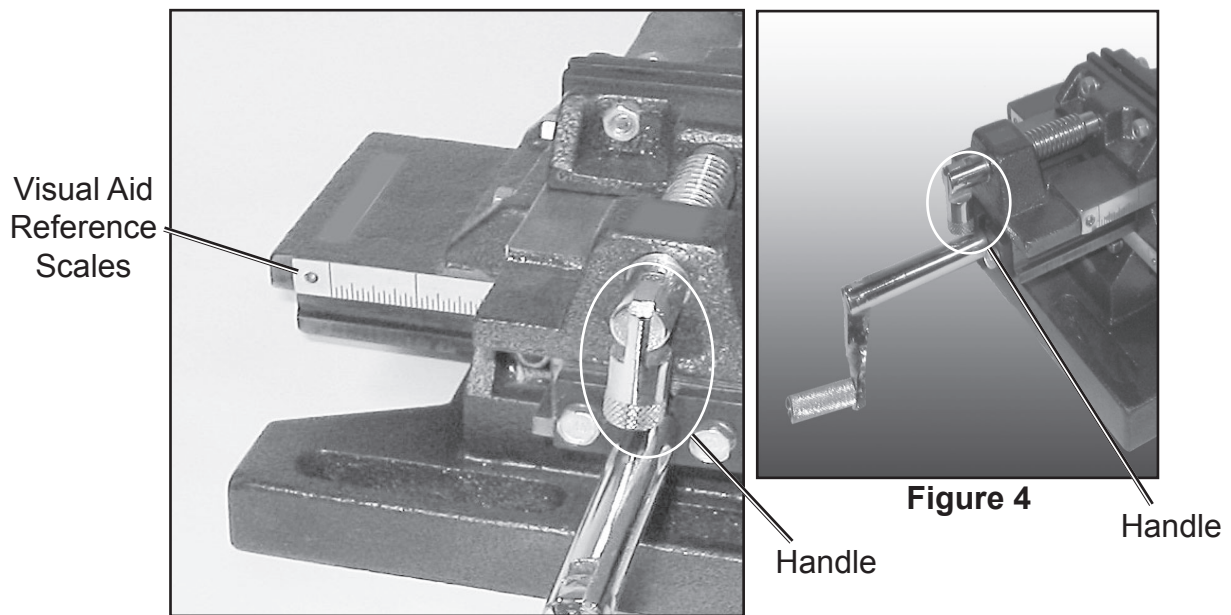


Figure 3

Figure 4

3. The opposing adjustable jaws enable the work piece to be firmly secured yet located in the middle of the X/Y movement.
4. To prevent accidents, clean when finished, then store the tool indoors out of children's reach.

Maintenance and Servicing



Procedures not specifically explained in this manual must be performed only by a qualified technician.

CAUTION

TO PREVENT INJURY FROM TOOL FAILURE:

Do not use damaged equipment. If damaged or loose parts are noted, have the problem corrected before further use.

1. **BEFORE EACH USE**, inspect the general condition of the tool. Check for loose hardware, misalignment or binding of moving parts, cracked or broken parts, and any other condition that may affect its safe operation.
2. **AFTER USE**, wipe external surfaces of the tool with clean cloth.
3. Keep the moving parts oiled, being sure to wipe off any excess oil off of the Handle and Jaws.
4. Check and tighten the mounting screws to be sure the Vise is secure.
5. **Replacing a Jaw Plate (2):**
 - a. Unscrew the Screws holding the Jaw and set aside.
 - b. Replace with a new Jaw and securing in place with the Screws. Tighten.
 - c. Repeat on the other Jaws if necessary. **See Figure 6.**

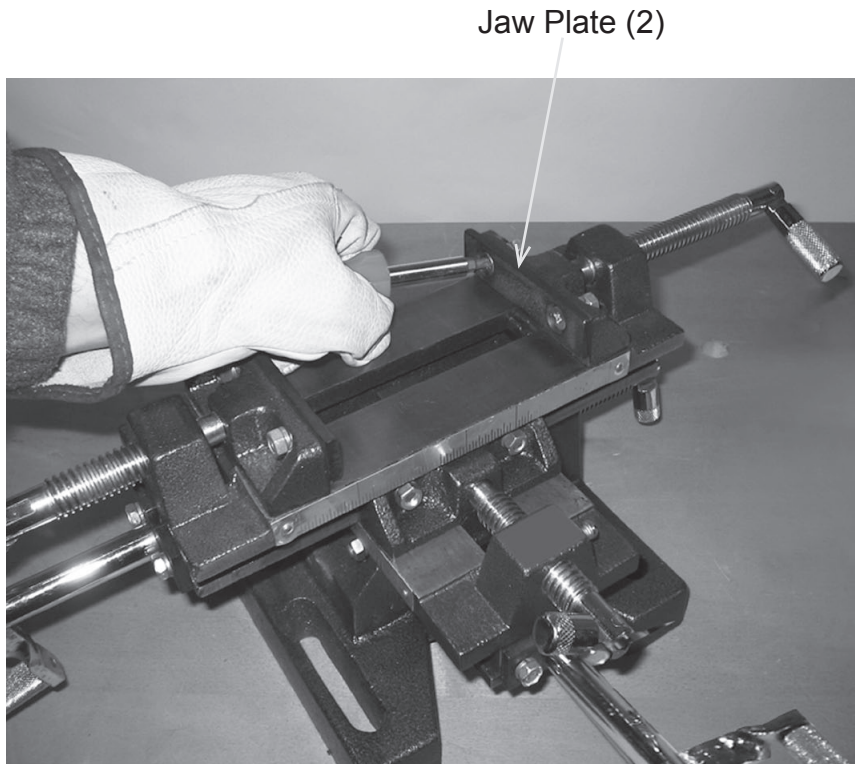


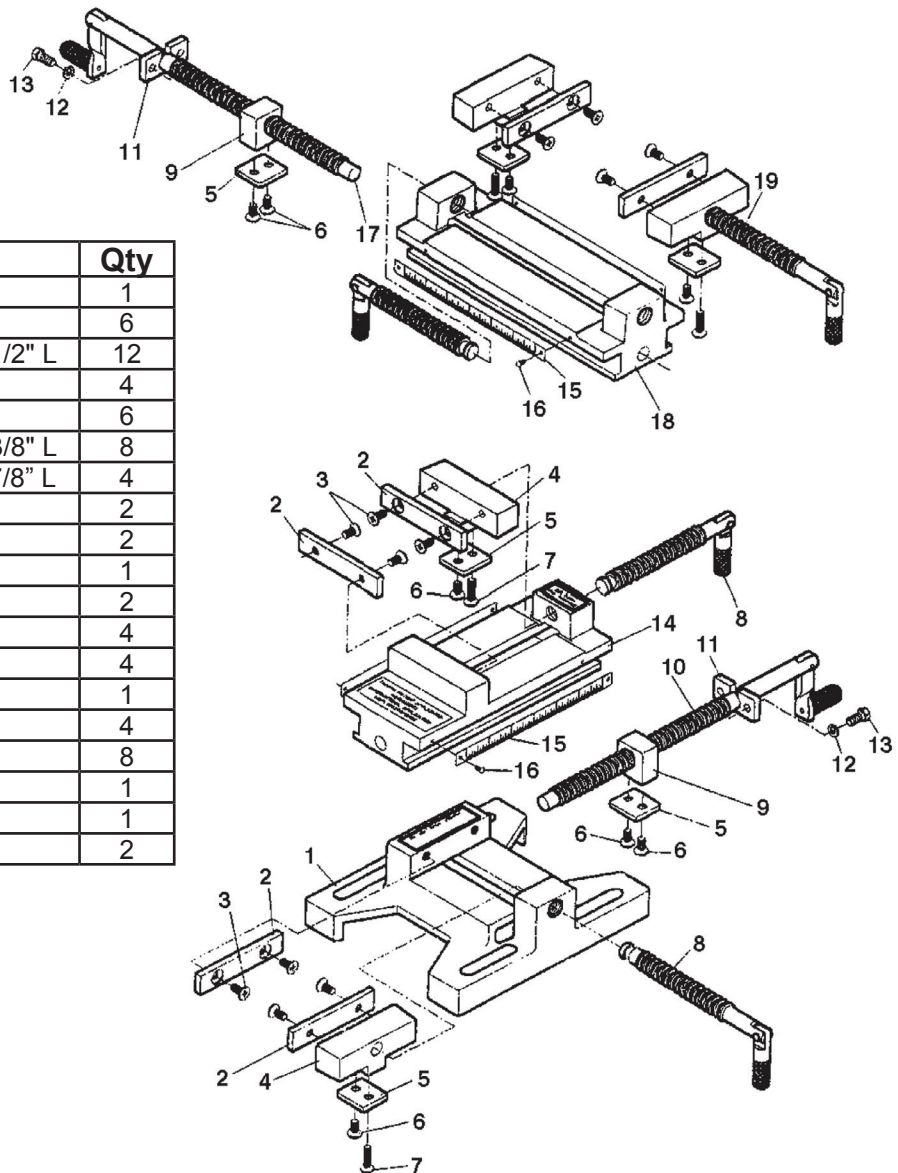
Figure 6

Parts List and Diagram

PLEASE READ THE FOLLOWING CAREFULLY

THE MANUFACTURER AND/OR DISTRIBUTOR HAS PROVIDED THE PARTS LIST AND ASSEMBLY DIAGRAM IN THIS MANUAL AS A REFERENCE TOOL ONLY. NEITHER THE MANUFACTURER OR DISTRIBUTOR MAKES ANY REPRESENTATION OR WARRANTY OF ANY KIND TO THE BUYER THAT HE OR SHE IS QUALIFIED TO MAKE ANY REPAIRS TO THE PRODUCT, OR THAT HE OR SHE IS QUALIFIED TO REPLACE ANY PARTS OF THE PRODUCT. IN FACT, THE MANUFACTURER AND/OR DISTRIBUTOR EXPRESSLY STATES THAT ALL REPAIRS AND PARTS REPLACEMENTS SHOULD BE UNDERTAKEN BY CERTIFIED AND LICENSED TECHNICIANS, AND NOT BY THE BUYER. THE BUYER ASSUMES ALL RISK AND LIABILITY ARISING OUT OF HIS OR HER REPAIRS TO THE ORIGINAL PRODUCT OR REPLACEMENT PARTS THERETO, OR ARISING OUT OF HIS OR HER INSTALLATION OF REPLACEMENT PARTS THERETO.

Part	Description	Qty
1	Lower Base	1
2	Jaw Plate	6
3	Flat Head Screw 1/4" - 20 x 1/2" L	12
4	Small Jaw	4
5	Bracket	6
6	Flat Head Screw 1/4" - 20 x 3/8" L	8
7	Flat Head Screw 1/4" - 20 x 7/8" L	4
8	Vise Adjustment Screw	2
9	Nut Block	2
10	Middle Base Screw	1
11	Retainer Plate	2
12	Spring Washer 1/4"	4
13	Hex Screw 1/4" - 20 x 5/8" L	4
14	Middle Base	1
15	Rule	4
16	Rivet 2 x 5 L	8
17	Upper Base Screw	1
18	Upper Base	1
19	Vise Jaw Screw	2



Record Product's Serial Number Here: _____

Note: If product has no serial number, record month and year of purchase instead.

Note: Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts.

Limited 90 Day Warranty

Harbor Freight Tools Co. makes every effort to assure that its products meet high quality and durability standards, and warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of 90 days from the date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities, criminal activity, improper installation, normal wear and tear, or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our product. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation of exclusion may not apply to you. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

