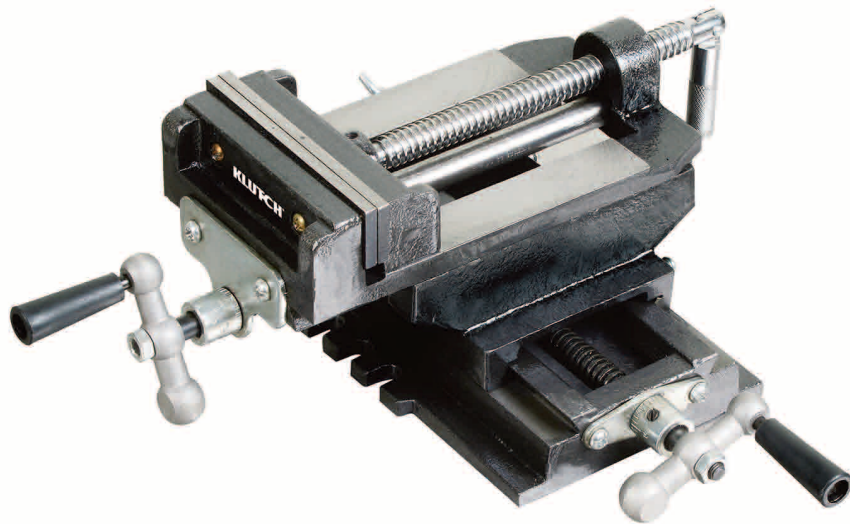




# 5" Cross Slide Drill Press Vise

## OWNER'S MANUAL



**⚠ WARNING:**  
Read carefully and understand all ASSEMBLY AND OPERATION INSTRUCTIONS before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.

**Item#s 49463**



# 5" Cross Slide Drill Press Vise

## OWNER'S MANUAL

Thank you very much for choosing a Klutch product. For future reference, please complete the owner's record below:  
Serial Number/Lot Date Code: \_\_\_\_\_ Purchase Date: \_\_\_\_\_  
Save the receipt, warranty and these instructions. It is important that you read the entire manual to become familiar with this product before you begin using it.

This 5" Cross Slide Drill Press Vise is designed for certain applications only. The distributor cannot be responsible for issues arising from modification or use of this product in an application for which it was not designed. We strongly recommend that this product not be modified and/or used for any application other than that for which it was designed.

For technical questions please call 1-800-222-5381.

### Table of Contents

Intended Use.....1  
Technical Specifications.....1  
Important Safety Information.....1  
Specific Operation Warnings.....3  
Assembly.....3  
Operating Instructions.....3  
Maintenance.....3  
Parts Diagram.....4  
Parts List .....4  
Troubleshooting.....4  
Replacement Parts.....5  
Limited Warranty.....5

### Intended Use

This Heavy-duty cast iron cross slide vise has replaceable serrated 4in. jaws that open to 3 1/4in. Two swivel crank handles adjust both forward and sideways for versatile clamping and precise drilling capabilities. Set screws hold positioning tightly for drilling. Longitudinal movement of 6in. with cross travel of 4in. Vise is secured to drill press by 3 slots on 2 sides and 1 slot on one end.

### Technical Specifications

Property	Specification
Jaw Capacity	3 1/4 in.
Jaw Length	4 in.
Material	Heavy-duty cast iron
Handles (qty.)	2
Longitudinal Travel	6 in.

### Important Safety Information

- ⚠ WARNING:**
- Read and understand all instructions. Failure to follow all instructions may result in serious injury or property damage.
  - The warnings, cautions, and instructions in this manual cannot cover all possible conditions or situations that could occur. Exercise common sense and caution when using this tool. Always be aware of the environment and ensure that the tool is used in a safe and responsible manner.
  - Do not allow persons to operate or assemble the product until they have read this manual and have developed a thorough understanding of how it works.

- Do not modify this product in any way. Unauthorized modification may impair the function and/or safety and could affect the life of the product. There are specific applications for which the product was designed.
- Use the right tool for the job. DO NOT attempt to force small equipment to do the work of larger industrial equipment. There are certain applications for which this equipment was designed. It will do the job better and more safely at the capacity for which it was intended. DO NOT use this equipment for a purpose for which it was not intended.
- Industrial or commercial applications must follow OSHA requirements.

**WARNING:**

- This product may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

**WARNING:****WORK AREA SAFETY**

- Inspect the work area before each use. Keep work area clean, dry, free of clutter, and well lit. Cluttered, wet, or dark work areas can result in injury. Using the tool in confined work areas may put you dangerously close to other cutting tools and rotating parts.
- Do not allow the product to come into contact with an electrical source. The tool is not insulated and contact will cause electrical shock.
- Keep children and bystanders away from the work area while operating the tool. Do not allow children to handle the tool.
- Be aware of all power lines, electrical circuits, water pipes, and other mechanical hazards in your work area. Some of these hazards may be hidden from your view and may cause personal injury and/or property damage if contacted.

**PERSONAL SAFETY**

- Stay alert, watch what you are doing, and use common sense when operating the tool. Do not use the tool while you are tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating the tool may result in serious personal injury.
- Dress properly. Do not wear loose clothing, dangling objects, or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts. Air vents on the tool often cover moving parts and should be avoided.
- Wear the proper personal protective equipment when necessary. Use ANSI Z87.1 compliant safety goggles (not safety glasses) with side shields, or when needed, a face shield. Use a dust mask in dusty work conditions. Also use non-skid safety shoes, hardhat, gloves, dust collection systems, and hearing protection when appropriate. This applies to all persons in the work area.
- Do not overreach. Keep proper footing and balance at all times.
- Remove keys or wrenches before connecting the tool to an air supply, power supply, or turning on the tool. A wrench or key that is left attached to a rotating part of the tool may cause personal injury.
- Secure the work with clamps or a vise instead of your hand when practical. This safety precaution allows for proper tool operation using both hands.

**CAUTION:****PRODUCT USE AND CARE**

- Do not force the tool. Tools do a better and safer job when used in the manner for which they are designed. Plan your work, and use the correct tool for the job.
- Check for damaged parts before each use. Carefully check that the tool will operate properly and perform its intended function. Replace damaged or worn parts immediately. Never operate the tool with a damaged part.
- Store the tool when it is not in use. Store it in a dry, secure place out of the reach of children. Inspect the tool for good working condition prior to storage and before re-use.

- Use only accessories that are recommended by the manufacturer for use with your tool. Accessories that may be suitable for one tool may create a risk of injury when used with another tool. Never use an accessory that has a lower operating speed or operating pressure than the tool itself.
- Keep guards in place and in working order. Never operate the product without the guards in place.
- Inspect the tool for damage or excessive wear before each use. If you find damage do not use the tool.

**Specific Operation Warnings****WARNING:**

- Keep the Vise clean for best and safest performance.
- DO NOT exceed this rated capacity. Never apply excessive force to a work piece.
- Only use this Vise on a surface that is stable, level, dry, and capable of sustaining the load. Keep the surface clean, tidy and free from unrelated materials and ensure that there is adequate lighting.
- Inspect the Vise before each use. DO NOT use if bent, broken, cracked or otherwise damaged.
- Check to ensure that all applicable bolts and nuts are firmly tightened.
- Ensure that work piece is center-loaded and secure.
- DO NOT use the Vise to compress springs or any other item that could disengage and cause a potential hazard. Never stand directly in front of a loaded Vise.
- DO NOT operate the Vise when you are tired or under the influence of alcohol, drugs or medication.
- DO NOT expose the Vise to rain or wet or damp conditions.
- If the Vise needs repairing and/or there are any parts that need to be replaced, have it repaired by authorized technicians and only use the replacement parts supplied by the manufacturer.
- Use caution when hammering anything in or on this Vise as the workpiece can be dislodged from the vise causing injury or property damage. Hammering can also cause metal chips to become airborne, causing injury.
- Wear ANSI Z 87.1 compliant goggles.
- KEEP ALL BYSTANDERS AWAY FROM THE WORK AREA.

**Assembly**

The vise is fully assembled.

**Operating Instructions**

Please make sure the jaws are fixed on the body securely and the body (#1) fixed on a suitable stand firmly before using this tool; The dies with teeth should maintain sharp, each die should be ensured can open or close when handle (#13) depressed, and can recover when handle lift up; Put the metal in the middle of jaw box, and press down the handle when you forming.

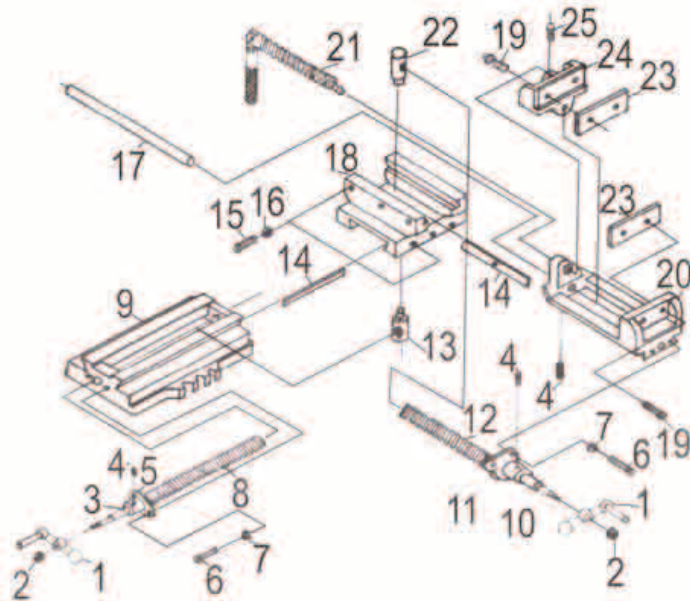
Notice: Any work should within its max. Capacity.

The bolt (#16) can be adjusted to control the handle height and open spaces between upper and lower dies according to different conditions.

**Maintenance**

Maintain your tool. It is recommended that the general condition of any tool be examined before it is used. Keep your tool in good repair by adopting a program of conscientious repair and maintenance in accordance with the recommended procedures found in this manual. Keep all cutting tools sharp and clean. Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control. Keep handles dry, clean, and free from oil and grease.

### Parts Diagram



### Parts List

Part No.	Description	Q'ty	Part No.	Description	Q'ty
1	Handle	2	14	Gib	2
2	Nut	2	15	Screw	6
3	Bushing	1	16	Nut	6
4	Screw	3	17	Central Slide Bar	1
5	Bracket	1	18	Mid-Base	1
6	Lock Screw	4	19	Lock Screw	4
7	Spring Washer	4	20	Upper-Base	1
8	Lead Screw	1	21	Lead Screw	1
9	Base	1	22	Nut	1
10	Bushing	1	23	Jaw Plate	2
11	Bracket	1	24	Slide	1
12	Lead Screw	1	25	Wing Nut	2
13	Nut	1			

### Troubleshooting

#### Crushing and Marring:

Overtightening, using incorrect or dirty jaws can damage the work piece. Before clamping anything in this Vise, assure the Vise is clean and in working order. If the work piece is softer than the jaws, use shims or a softer material between the work piece and the jaws to prevent damage to the work piece.

### Replacement Parts

- For replacement parts and technical questions, please call Customer Service at 1-800-222-5381.
- Not all components are available for replacement. The illustrations provided are a convenient reference to the location and position of parts.
- The following are required when ordering parts: model number, serial number/lot date code, and description.
- The distributor reserves the rights to make design changes and/or improvements to product lines and manuals without notice.

### Limited Warranty

Northern Tool and Equipment Company, Inc. ("We" or "Us") warrants to the original purchaser only ("You" or "Your") that the Ironton Air Tool product purchased will be free from material defects in both materials and workmanship, normal wear and tear excepted, for a period of one year from date of purchase. The foregoing warranty is valid only if the installation and use of the product is strictly in accordance with product instructions. There are no other warranties, express or implied, including the warranty of merchantability or fitness for a particular purpose. If the product does not comply with this limited warranty, Your sole and exclusive remedy is that We will, at our sole option and within a commercially reasonable time, either replace the product without charge to You or refund the purchase price (less shipping). This limited warranty is not transferable.

### Limitations on the Warranty

This limited warranty does not cover: (a) normal wear and tear; (b) accessories both consumable and durable; (c) damage through abuse, neglect, misuse, or as a result of any accident or in any other manner; (d) damage from misapplication, overloading, or improper installation; (e) improper maintenance and repair; and (f) product alteration in any manner by anyone other than Us, with the sole exception of alterations made pursuant to product instructions and in a workmanlike manner.

### Obligations of Purchaser

You must retain Your product purchase receipt to verify date of purchase and that You are the original purchaser. To make a warranty claim, contact Us at 1-800-222-5381, identify the product by make and model number, and follow the claim instructions that will be provided. The product and the purchase receipt must be provided to Us in order to process Your warranty claim. Any returned product that is replaced or refunded by Us becomes our property. You will be responsible for return shipping costs or costs related to Your return visit to a retail store.

### Remedy Limits

Product replacement or a refund of the purchase price is Your sole remedy under this limited warranty or any other warranty related to the product. We shall not be liable for: service or labor charges or damage to Your property incurred in removing or replacing the product; any damages, including, without limitation, damages to tangible personal property or personal injury, related to Your improper use, installation, or maintenance of the product; or any indirect, incidental or consequential damages of any kind for any reason.

### Assumption of Risk

You acknowledge and agree that any use of the product for any purpose other than the specified use(s) stated in the product instructions is at Your own risk.



**5" Cross Slide Drill Press Vise  
OWNER'S MANUAL**

---

**Governing Law**

This limited warranty gives You specific legal rights, and You also may have other rights which vary from state to state. Some states do not allow limitations or exclusions on implied warranties or incidental or consequential damages, so the above limitations may not apply to You. This limited warranty is governed by the laws of the State of Minnesota, without regard to rules pertaining to conflicts of law. The state courts located in Dakota County, Minnesota shall have exclusive jurisdiction for any disputes relating to this warranty.



Distributed by  
Northern Tool and Equipment Company, Inc.  
Burnsville, Minnesota 55306  
NorthernTool.com  
Made in China