



KURT MANUFACTURING COMPANY

INDUSTRIAL PRODUCTS DIVISION

1325 N. E. Quincy Street, Minneapolis, Minnesota 55413-1540
Phone (763) 572-4424 Toll Free 800-328-2565 Fax (612) 623-3902

PRECISION MACHINING, SPECIAL MACHINES, DIE CASTING & INDUSTRIAL PRODUCTS

KURT W. KUBAN, FOUNDER

W.G. (BILL) KUBAN, PRESIDENT

DL400 & DL600 CLUTCH TROUBLESHOOTING GUIDE

If the vise feels as though it is clamping your part tight and it really is not:

1. Tighten part in the front jaw set only (handle end). Pre-load block will move out to it's maximum travel.
2. When maximum travel is reached, reverse screw direction. The clutch should now be back "in time".
3. Vise should now function properly.

If when clamping parts of same size the snap ring comes off:

1. Unclamp the pre-load block.
2. Replace the snap ring.
3. Load a part in the rear jaw set with a shim, .030/.125 thick, and clamp lightly.
4. Load second part in the front jaw set without a shim and clamp lightly.
5. Tighten pre-load block and remove the shim.
6. Unclamp parts and remove shim.
7. Rotate the handle until both parts are clamped.
8. Pre-load block should now move out slightly with no pressure on the snap ring.

ONE STOP WORKHOLDING

www.kurt.com