



KURT MANUFACTURING COMPANY

INDUSTRIAL PRODUCTS DIVISION

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

Web site address: www.kurt.com

PRECISION MACHINING, SPECIAL MACHINES, DIE CASTING & INDUSTRIAL PRODUCTS
KURT W. KUBAN, FOUNDER W.G. (BILL) KUBAN, PRESIDENT

TO: _____ DATE: _____
COMPANY: _____ FAX #: _____
FROM: _____ PAGES SENT: _____
SUBJECT: ASSEMBLE NEW SCREW AND NUT ASSEMBLY INTO DL430 AND DL640 BODYS. CC: _____

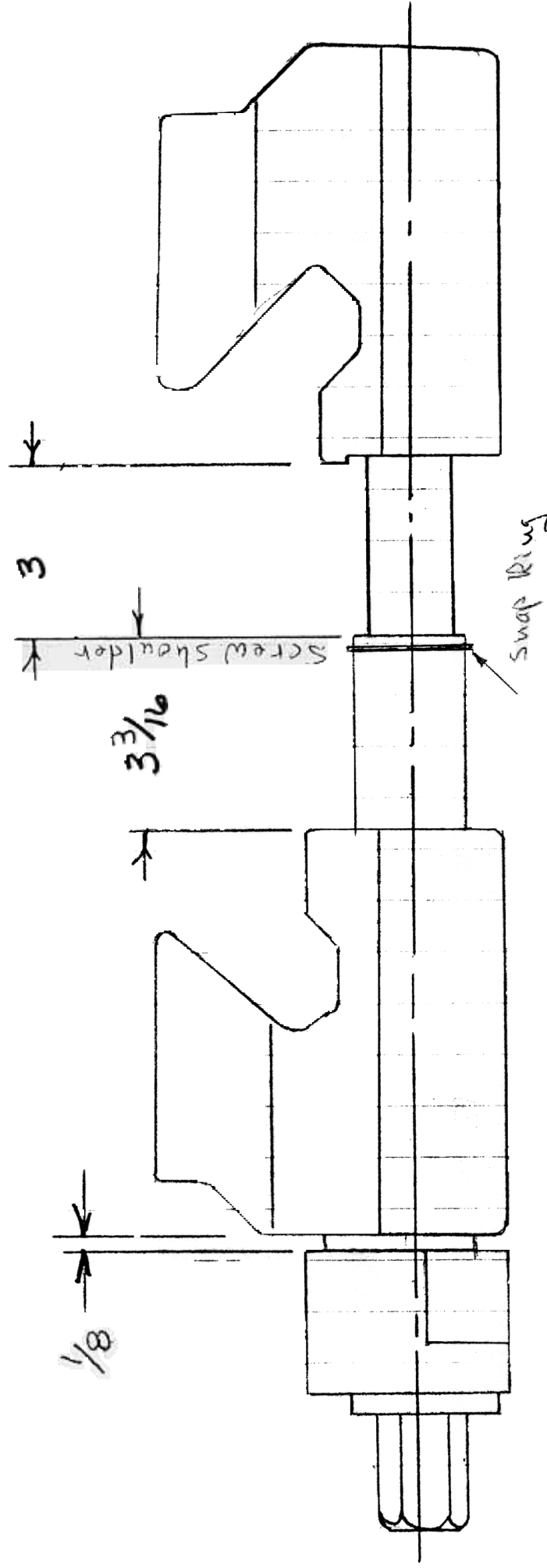
WATCH HOW THINGS ARE TAKEN APART
(TAG IS AT THE FRONT END)

1. REMOVE STATIONARY AND MOVEABLES.
2. REMOVE BUTTON HEAD CAP SCREW.
3. TAP THE TOP OF THE NUT WITH A RUBBER HAMMER TO REMOVE ASSEMBLY.
4. SLIDE NEW ASSEMBLY IN, FLUSH THE BACK OF THE NUT TO THE END OF THE BODY WITH JUST THE PRELOAD BLOCK STICKING OUT.
5. PUT REAR MOVEABLE ON AND TIGHTEN THE SET SCREW--TIGHT.
6. ASSEMBLE PAD AND FRICTION BLOCK--NUMBERS 32 & 31
7. HOLD BLOCK FROM TURNING WHILE CRANKING CLOCKWISE UNTIL BLOCK IS FLUSH TO BODY.
8. REPLACE BUTTONHEAD CAP SCREW.
9. LOOSEN SET SCREW, ADJUST TO SNUG (SEE NOTE 5) SET SCREW #33
10. REPLACE CHIP GUARD SHEILD (REAR)
11. ASSEMBLE FRONT MOVEABLE AND CHIP GUARD SHEILD (SEE SKETCH BELOW)
12. CRANK VISE TILL CHIP GUARDS OVERLAP 1/8"
13. ASSEMBLE CENTER CHIP GUARD SHEILD--SEE SKETCH BELOW FOR HUMP DIRECTION.
14. ASSEMBLE STATIONARY JAW AND JAW PLATES USE BRASS HAMMER TO ALIGN JAWS TOGETHER AND DOWN. THIS IS DONE IN THE CLOSED POSITION.

ONE STOP WORKHOLDING

The nuts should be posit.
to stalling into the body

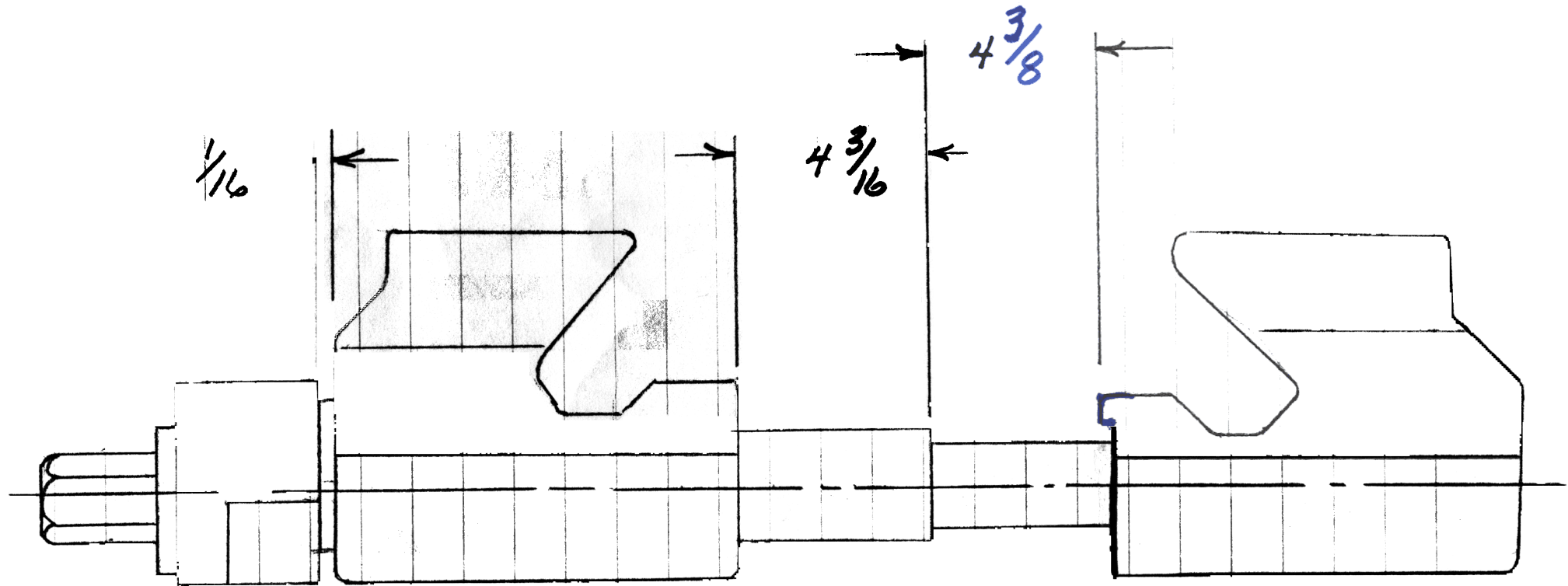
as such prior



DL430

"TIMING NUTS"
WHEN SCREW & NUT ASSEMBLY
ARE OUT OF THE VISE BODY

THE NUTS SHOULD BE POSITIONED AS SUCH
PRIOR TO INSTALLING INTO THE BODY.



DL640

"TIMING NUTS"

WHEN SCREW & NUT ASSY
ARE OUT OF THE VISE BODY