



KURT MANUFACTURING COMPANY

INDUSTRIAL PRODUCTS DIVISION

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PRECISION MACHINING, SPECIAL MACHINES, DIE CASTING & INDUSTRIAL PRODUCTS

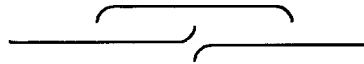
KURT W. KUBAN, FOUNDER

W.G. (BILL) KUBAN, PRESIDENT

DL430 & DL640 ASSEMBLY INSTRUCTIONS FOR THE NUT AND SCREW ASSEMBLY

(Watch how everything comes apart, the tag is at the front end.)

1. Remove the button head cap screw (#30) at handle end of vise.
2. Remove front movable jaw (#34, at handle end of vise) and stationary jaw (#42).
3. With rear movable jaw (#34) located near center of vise firmly tighten set screw (#33).
4. Turn vise screw counterclockwise until friction block (#31) located in holding block (#17) slides clear of vise.
5. Remove rear movable jaw. Slide out nut and screw assembly.
6. Slide the new assembly in until back of front nut is flush with end of body. Holding block (#17) and screw hex will remain outside body.
7. Put the rear movable (#34) on and firmly tighten the set screw (#33).
8. Assemble friction clamp (#31) and pre-load spring (#32) in holding block (#17).
9. Align holding block (#17) with opening in body while turning screw clockwise until holding block is flush with body.
10. Replace button head cap screw (#30)
11. Loosen set screw (#33) in rear movable jaw (#34) and adjust to snug.
12. Replace rear chip guard (#39). Chip guards must engage pin in movable jaws.
13. Assemble front movable jaw (#34) and chip guard (#39) (see sketch below). A small bend is put in nose of chip guard to prevent jamming.
14. Crank vise until chip guards overlap 1/8".
15. Replace center chip guard shield (#40) (see sketch below)
16. Replace stationary jaw (#42).

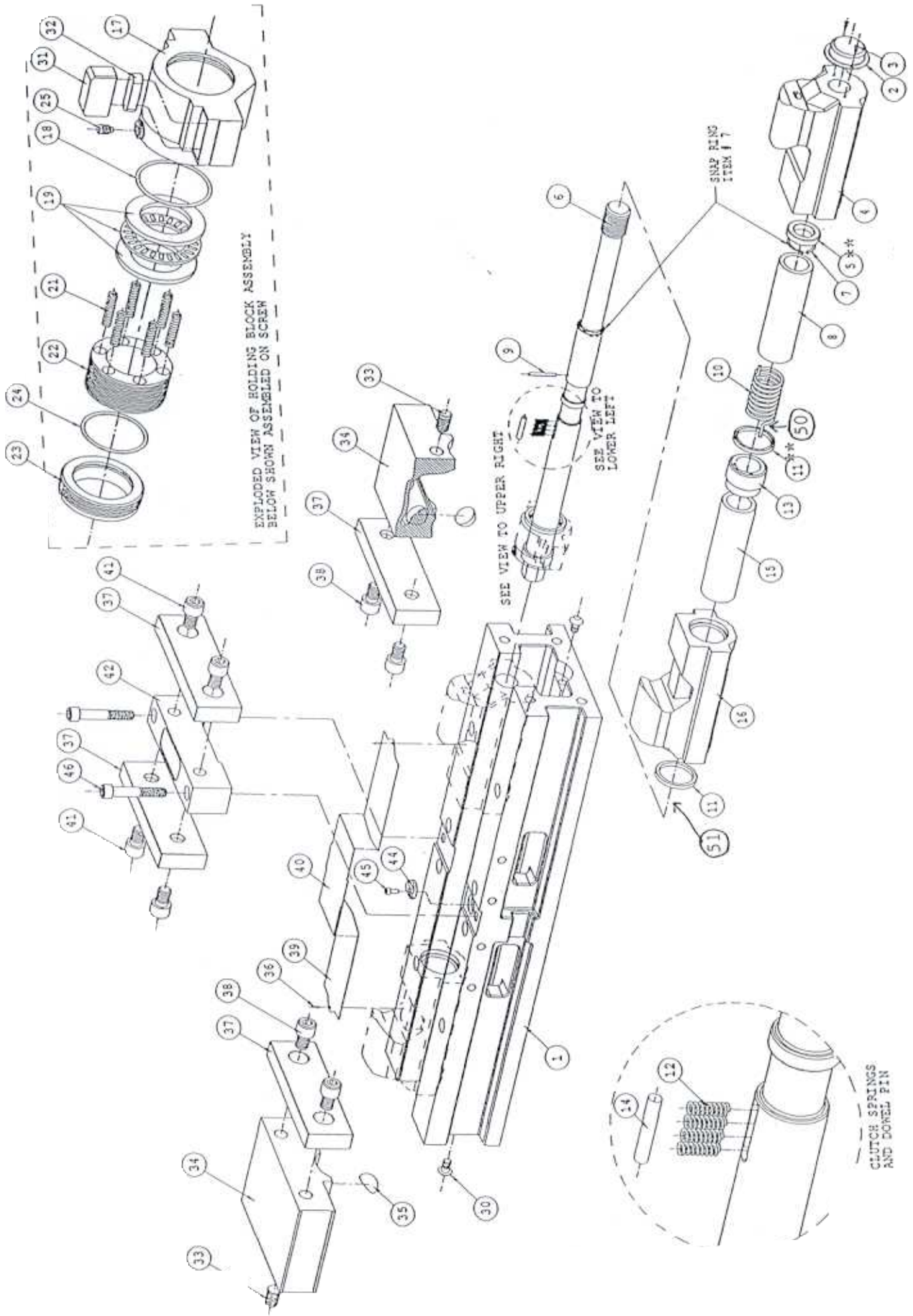


Chip Guard Placement

Center guard has slight arc that
must point down

ONE STOP WORKHOLDING

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!! * !! THESE ITEMS CHANGE FOR METRIC VISE.

49	DL640-10-SA	C19718	OPTIONAL HANDLE ASSEMBY(FOR INT HEX)	1	M
48	DL640-313R	B19401	VISE BODY STICKER (LEFT REAR)	1	P
*47	DL640-313F	B19400	VISE BODY STICKER (LEFT FRONT)	1	P
*46	00-1361	NO DWG	SHCS 3/8-16NC X 2 LG	2	P
45	00-1191	NO DWG	SHCS #8-32NC X 3/8 LG	1	P
44	DL640-278	A19399	SECONDARY LOCATOR	1	M
43	D60-10A-SA	C10231	HANDLE ASSEMBLY	1	P
*42	DL640-6	C19398	STATIONARY JAW	1	M
*41	00-1414	NO DWG	SHCS 1/2-13NC X 3/4 LG	4	P
40	DL640-248	A19397	STATIONARY CHIP GUARD	1	P/M
39	DL640-249	B19396	MOVABLE CHIP GUARD	2	P/M
*38	00-1419	NO DWG	SHCS 1/2-13NC X 1 1/4 LG	4	P
37	D60-7	B1339	JAW PLATE	4	M
36	04-4008	NO DWG	ROLL PIN .062Ø X 5/16 LG	2	P
35	D60-9	B10671	SEGMENT	2	M
*34	DL640-2	D19395	MOVABLE JAW	2	M
*33	01-3334	NO DWG	80% SET SCR, CONE POINT, LONG LOCK, NYLON STRIP ONLY 1/2-13NC X 1" LG	2	P

** PART #5 CHANGED TO DL640-97 WIPER
 ** PART# 11 CHANGED TO DL640-331 WIPER RING

ADDED PART #50 DL640-217 SMALLEY RING
 ADDED PART #51 DL640-231 SMALLEY RING

DL640

33	01-3334	NO DWG	1/2-13NC X 1" LG	2	P	
32	DL640-311A	A19536	SPRING (PRE-LOAD)	1	M	
31	DL640-225A-P	A19535	FRICTION CLAMP	1	M	
30	03-0141	NO DWG	BHCS 5/16-18NC X 1/2 LG	2	P	
29	DL640-223	A19509	CAUTION STICKER	1	P	
28	DL640-314R	B19402	VISE BODY STICKER (RIGHT REAR)	1	P	
*27	DL640-314F	B19402	VISE BODY STICKER (RIGHT FRONT)	1	P	
26	DL600-111	A18984		4	P	
*25	01-7861	NO DWG	SOC SET SCREW (BRASS TIPS) #10-32 X 1/4 LG	1	P	
24	DL640-128	NO DWG	O-RING 1 3/16 I.D. X 1 5/16 O.D. X 1/16 C.S. #025 TO DIMENSION	1	P	
23	DL640-91	B19450	THREADED COLLAR	1	M	
22	DL640-8-P	B19389	COLLAR	1	M	
21	DL640-197	NO DWG	LEE COMPRESSION SPRING (SEE ILC-038C-13-9) 7.249 O.D. X .9280 X 1.125 FREE LGTH RATE 23#	6	P	
20	D60-41	NO DWG	THRUST BEARING TOPRINGTOR #HTA-1625	1	P	
19	D60-42	NO DWG	THRUST WASHER TOPRINGTOR #TRC-1625	2	P	
18	DL640-68	NO DWG	O-RING 1 3/8 I.D. X 1 1/2 O.D. X 1/16 C.S. #028 TO DIMENSION	1	P	
*17	DL640-212	C19452	HOLDING BLOCK	1	M	
16	DL640-3F	C19387	FRONT NUT	1	M	
15	DL640-274	B19386	CLUTCH SPACER	1	M	
14	04-0031	NO DWG	DOWEL PIN 3/16Ø X 7/8 LG	1	P	
13	DL640-273	C19385	CLUTCH	1	M	
12	DL600-215A	NO DWG	CLUTCH SPRING (STAINLESS STEEL) .0328 X .188 O.D. X .690 FREE LENGTH	4	P	
** 11	DL640-180	NO DWG	O-RING SEAL #624-50131 OR #664-50131 (80 DIAMETER) 1 3/16 I.D. X 1 5/8 O.D. X 5/32 C.S.	2	P	
10	DL640-177	A19384	RELEASE SPRING (TORSION)	1	P	
9	04-4144	NO DWG	ROLL PIN .125Ø X 1 1/4 LG	1	P	
8	DL640-53A-P	B19383	SPRING COVER	1	M	
7	DL640-147	NO DWG	SMALLEY W/OUT DUFF SPIRAL RETAINING RING #RC-38 (L384 SHANT DEAN)	1	P	
** 6	DL640-5	D19382	SCREW	1	M	
5	DL06J-146	NO DWG	O-RING SEAL #622-17 (80 DIAMETER) 13/16 I.D. X 1 3/16 O.D. X 1/4 C.S.	1	P	
4	DL640-3R	C19381	REAR NUT	1	M	
3	07-0230	NO DWG	U-TYPE DRIVE SCREW #2 X 1/4 LG	2	P	
2	DL600-218	B10951	END CAP	1	P	
* 1	DL640-1	D19380	BODY MACHINED	1	M	
ITEM	PART NO.	DWG. NO.	DESCRIPTION	QTY	MFR	PUR/