



# Sidewinder

Operating Instructions Manual

SDW25



# Table of Contents

Introduction.....2

Installation and Assembly.....3

Sidewinder Drawing & Parts List.....4-7

Maintence Schedule.....8-9

Troubleshooting Tips.....9

Notes & Warranty.....10-11



## Introduction

Thank you for purchasing a Kurt Sidewinder 2nd Op vise.

The Sidewinder is a versatile, quick mounting vise that will work on the left or right side of any Kurt 6 inch vise. The sidewinder mounts vertically to the back stationary jaw and uses an integral bracket and a stabilization leg for support. A workstop is also included for part height positioning. This Kurt vise permits fast, accurate positioning on repetitive vertical work. It can be used with your AngLock precision vise for accurate parts production.

# Installation & Assembly Guide

The SideWinder vise is a precision tool and must be handled carefully. You will need a set of socket wrenches to install it properly.

## Begin by following the steps listed.

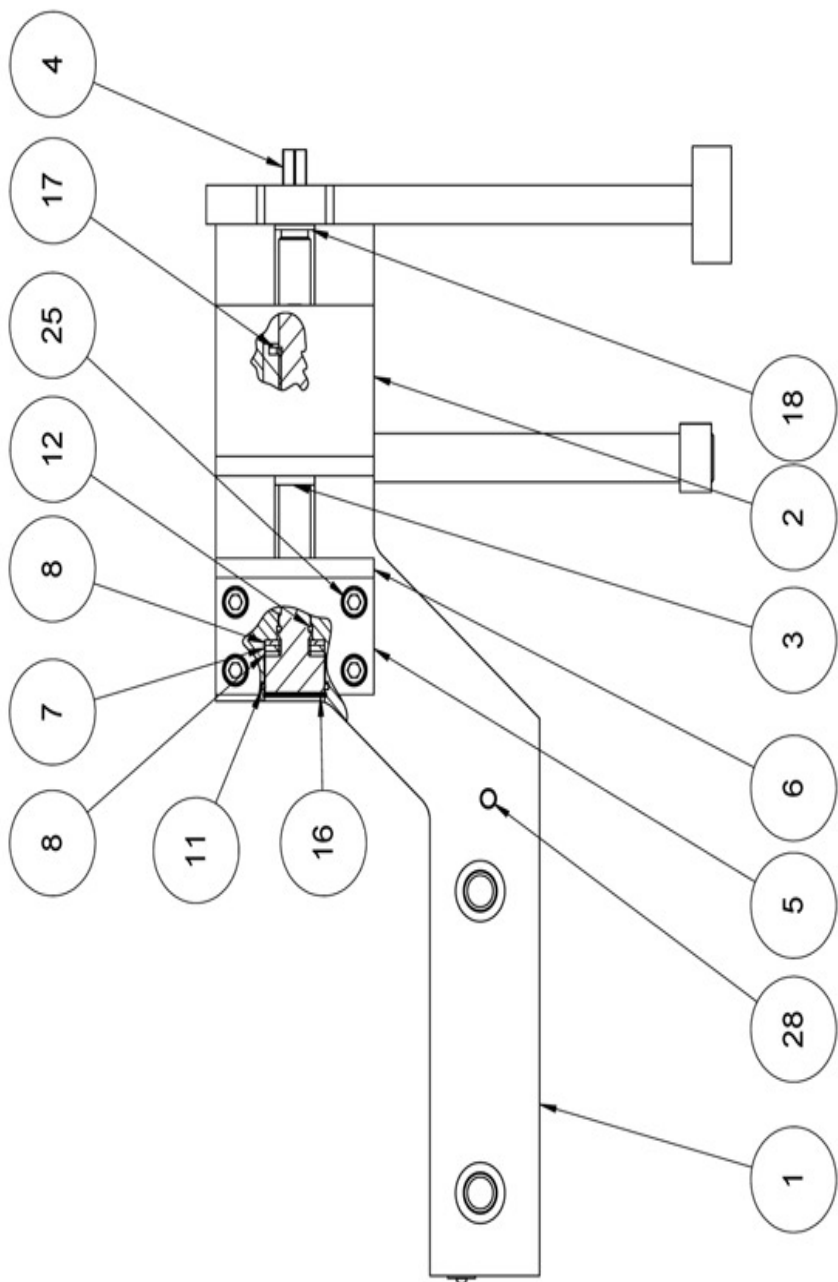
1. Clean the back of the vise hone if needed.
2. Using the two 1/2-13 SHCS provided mount the Siderwinder vise on the back lip of the vise with the 1/4 pin stopping off the left or right side of the vise as you are looking at the back of the vise (opposite the handle).
3. Attach the support bracket to end of the sideWinder and be sure that the foot rests on the machine table. Use two "T" nuts and bolts to fasten the foot to the machine table. Finger tighten only.
4. Once the SideWinder is installed and you are sure that it is square, tighten all the fasteners as required.
5. Do not over torque the vise. Use our reccomended torque setting to tighten your vise.

Torque-Ft.Lbs.	Clamping Force-Lbs
4	580
6	880
8	1120
10	1540
12	2450

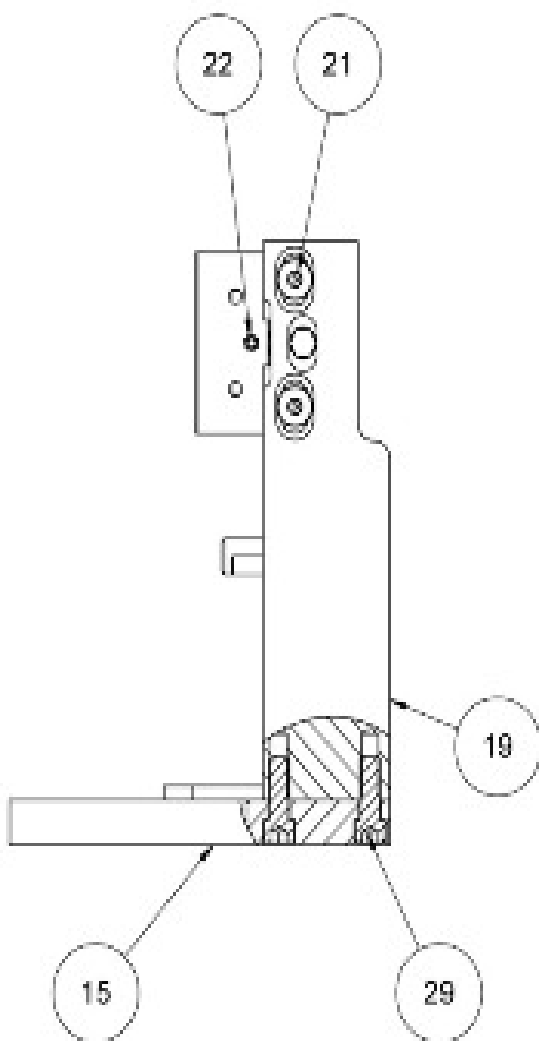
**NOTE:** The installation is done by assembling the unit on the backside of the vise (the end opposite the handle).

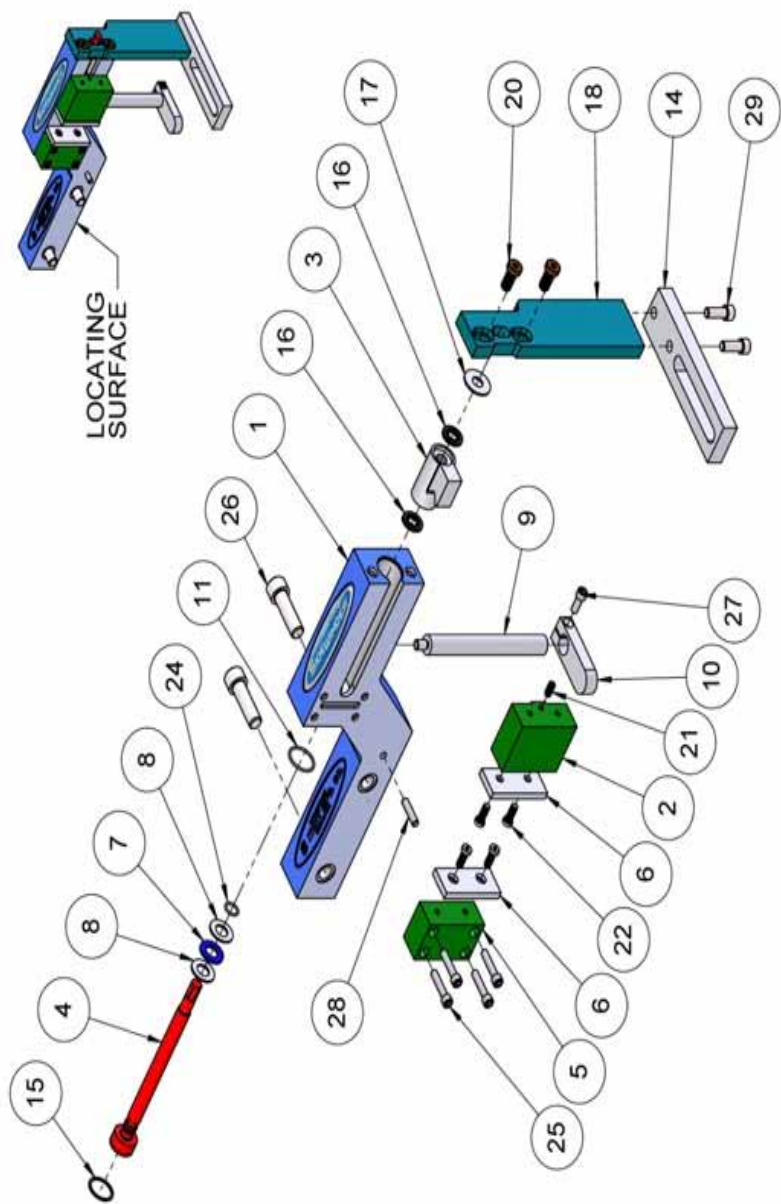


# SDW25 Front View



# SDW25 End View





## SDW25 Parts List

ITEM	PART NO.	DESCRIPTION	QTY.
1	SDW25-1	Body	1
2	SDW25-2	Movable Jaw	1
3	SDW25-3	Nut	1
4	SDW25-5	Screw	1
5	SDW25-6	Stationary Jaw	1
6	SDW25-7	Jaw Plate	2
7	SDW25-41	Thrust Bearing	1
8	SDW25-42	Thrust Washer	2
9	SWD25-58	Workstop Rod	1
10	SDW25-85	Workstop	1
11	DL430-128	O-ring	1
14	SDW25-126	Foot Adj.	1
15	SDW25-147	Retaining ring	1
16	SDW25-211	Brush Seal	2
17	SDW25-224	Screw Support	1
18	SDW25-227	Retainer Plate	1
20	00-3352	3/8-16x3/4 LHCS	2
21	01-3076	1/4-20x1/2 SHSS	1
22	00-3288	1/4-20x.63LHCS	4
24	MT4-96	O-ring	1
25	00-1294	1/4-20x1-1-1/4	2
26	00-14215	1/2-13x1-5/8	2
27	00-1288	1/4-20x5/8 SHCS	1

# Maintenance Schedule

It is very important to perform regular maintenance on your Kurt vise. Improper maintenance will result in poor vise performance and may void your warranty.

## Daily / Weekly

1. Remove chips from surface of vise.
2. Visually inspect for chips, seals for damage and cleanliness.
3. Visually inspect for chip entrapments and remove when necessary.
4. Air-dry and apply rust inhibiting oil to the machined surface of the vise.

## Monthly

1. Open the vise to the maximum opening.
2. In the back of the movable jaw (handle end, center hole) loosen the socket head set screw (approx. 6 turns) With the hex key (Allen wrench) in the set-screw socket, lift up and forward to pivot the Jaw off of the vise bed.
3. Slide the Jaw slightly toward the stationary jaw and lift up to remove the jaw from the "hook" of the nut. Note: A spherical segment (shaped as  $\frac{1}{2}$  of a steel ball) is inside the cavity of the movable jaw and may fall out as the jaw is removed. Take care not to lose or misplace the spherical segment.
4. Turn the movable jaw over and clean the inside cavity. Also clean the spherical segment.
5. Remove chips, clean and apply a light coat of machine oil to the machined surface of the following items:
  - a. Nut & Screw assembly (clean exposed threads on the screw)
  - b. Bed of vise (top of "rails")
  - c. Inside of the vise between the center ways.
6. Tip the jaw so the front of the jaw (the side with the jaw plate) is on the vise bed. Lower the jaw on to the nut so the jaw rests on the vise bed.
7. Tighten the setscrew to firmly contact the nut. Back off the setparallel, sawed, or cast parts.
8. Your vise is now ready for use. Open and close your vise to check for proper operation. Center the part to be clamped in the vise and close. Your parts should be centered from side to side to insure proper clamping. (See Fig. 2 below)



## 3 to 6 months

1. Open vise to maximum opening.
2. Remove spiral snap ring and washer from hex end of the vise screw.
3. Slide the movable jaw toward the stationary.
4. Remove the thrust bearing assembly consisting of (2) thrust washers and (1) thrust bearing from the counter bore in the end of the body.
5. Clean and inspect the counter bore, thrust washers and thrust bearing.
6. Apply water resistant grease to the thrust washer (i.e. marine grade grease)
7. Install thrust bearing assembly on the screw and slide movable jaw back.
8. Install washer and spiral retaining ring.
9. Your vise is now ready to use.

## Troubleshooting Tips

If properly maintained, the Kurt D-Series vise will operate trouble free for many years. In some cases it may be necessary to troubleshoot. Use the information below to help in the process.

**Problem:** My vise turns hard.

**Tip:** As a new vise the brush seal could be stiff. Allow for break in of vise.

**Tip:** As a used vise, it could be filed with chips and threads could be jammed. Properly clean and grease vise.

**Problem:** My vise will not turn in either direction.

**Tip:** The vise is jammed with debris. Disassemble and clean as needed.

**Problem:** My vise won't hold tolerance.

**Tip:** You may be experiencing jaw lift from clamping too high or on one side of the jaw. Lower the part in the vise jaw and clamp more material.





**LIFETIME WARRANTY**

**IRON CLAD™**

## On All Kurt® AngLock® Workholding Products

All Kurt Manufacturing Company industrial workholding products and parts with the exceptions noted below, are warranted against defects in material and workmanship for the life of the product or part. (The life of the product is defined as that point in time when such item no longer functions due to normal wear and tear.) Failure to properly maintain and/or properly operate the product or part that has been worn out, abused heated ground or otherwise altered, used for a purpose other than that for which it was intended, or used in a manner inconsistent with any instructions regarding its use. The sole obligation of Kurt Manufacturing Company, Inc. (Kurt) and the purchaser's SOLE AND EXCLUSIVE REMEDY hereunder, shall be limited to the replacement or repair of any Kurt product or part (by an authorized Kurt technician) which are returned to Kurt Manufacturing Company's place of business, transportation, shipping and postal charges prepaid, and there determined by Kurt Manufacturing Company to be covered by the warranty contained herein.

THE LIMITED WARRANTY DESCRIBED HEREIN IS MADE EXPRESSLY IN LIEU OF ANY OTHER EXPRESSED OR IMPLIED WARRANTIES, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. KURT MANUFACTURING COMPANY IS NOT RESPONSIBLE FOR THE IMPROPER USE OF ITS PRODUCTS. KURT SHALL NOT BE LIABLE FOR ANY DIRECT, INDIRECT, INCIDENTAL SPECIAL OR CONSEQUENTIAL DAMAGES, INCLUDING BUT NOT LIMITED TO, LOSS OF USE, REVENUE OR PROFIT.

KURT ASSUMES NO LIABILITY FOR, AND MAKES NO WARRANTY REGARDING ANY PURCHASE ITEMS WHERE THE MANUFACTURER OF SUCH ITEM EXTENDS A SEPARATE WARRANTY.



9445 East River Road NW  
Minneapolis, MN 55433

Phone: 877-226-7823  
Fax: 877-226-7828

[www.kurtworkholding.com](http://www.kurtworkholding.com)

Manual Revision: 12.18.2013



**Thank you for your purchase!  
If you have any feedback or questions.**

**Please contact us at:  
workholding@kurt.com  
or  
1-877-226-7823**

**Like, Tweet, and Subscribe to us!**

