SPECIFICATIONS

<table>
<thead>
<tr>
<th>Construction/Material</th>
<th>Cast iron, carbon steel, hardened-forged steel</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum Jaw Opening</td>
<td>5-3/8”</td>
</tr>
<tr>
<td>Base Swivel Capacity</td>
<td>360 degrees</td>
</tr>
<tr>
<td>Overall Dimensions</td>
<td>13-1/2” L x 8-3/8” W x 7-3/4” H</td>
</tr>
</tbody>
</table>

Save This Manual

You will need this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures, parts list and assembly diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Write the product’s serial number in the back of the manual near the assembly diagram, or write month and year of purchase if product has no number. Keep this manual and invoice in a safe and dry place for future reference.

GENERAL SAFETY RULES

**WARNING!**

READ AND UNDERSTAND ALL INSTRUCTIONS
Failure to follow all instructions listed below may result in electric shock, fire, and/or serious injury.

SAVE THESE INSTRUCTIONS

1. **Keep your work area clean and well lit.** Cluttered benches and dark areas invite accidents.

2. **Keep bystanders, children, and visitors away while using this product.** Distractions can cause you to lose control. Protect others in the work area from debris such as chips and sparks. Provide barriers or shields as needed. Keep children out of the work area.

3. **Stay alert. Watch what you are doing, and use common sense when operating the Bench Vise.** Do not use this product while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating this product may result in serious personal injury.

4. **Dress properly. Do not wear loose clothing or jewelry. Contain long hair. Keep your hair, clothing, and gloves out of the way of jaws and clamps.** Loose clothes, jewelry, or long hair can be caught in moving parts.

5. **Do not overreach. Keep proper footing and balance at all times.** Proper footing and balance enables better control of this product in unexpected situations.
6. **Use safety equipment. Always wear eye protection.** Dust mask, nonskid safety shoes, hard hat, or hearing protection must be used for appropriate conditions. Always wear ANSI-approved safety goggles when working with this tool.

7. **Use clamps (not included) or other practical ways to secure and support the workpiece to a stable platform.** Holding the work by hand or against your body is unstable and may lead to loss of control.

8. **Do not force the product. Use the correct product for your application.** The correct product will do the job better and safer at the rate for which it is designed. Do not force the product and do not use the product for a purpose for which it is not intended.

9. **Store idle products out of reach of children and other untrained persons.** This product is dangerous in the hands of untrained users.

10. **Maintain this product with care.** Keep the Vise clean of grease and metal filings. Do not use a damaged product. Tag damaged products “Do not use” until repaired.

11. **Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the product’s operation.** If damaged, **have the product serviced before using.** Many accidents are caused by poorly maintained products.

12. **Use only accessories that are recommended by the manufacturer for your model.** Accessories that may be suitable for one product may become hazardous when used on another product.

13. **When servicing a product, use only identical replacement parts.** Follow instructions in the “**Inspection, Maintenance, And Cleaning**” section of this manual. Use of unauthorized parts or failure to follow maintenance instructions may create a risk of electric shock or injury.

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**SPECIFIC SAFETY RULES**

1. **Maintain labels and nameplates on the product.** These carry important information. If unreadable or missing, contact Harbor Freight Tools for a replacement.

2. **Maintain a safe working environment.** Make sure there is adequate surrounding workspace. Do not use this product in a damp or wet location.

3. **Face of tool may chip if struck against another striking tool or hardened surface.** This will damage the tool and possibly result in eye or bodily injury. Always check tool before using; always discard a chipped tool.
UNPACKING

When unpacking, check to make sure that the item is intact and undamaged. If any parts are missing or broken, please call Harbor Freight Tools at the number shown on the cover of this manual as soon as possible.

ASSEMBLY INSTRUCTIONS

Note: For additional information regarding the parts listed in the following pages, refer to the Assembly Diagram near the end of this manual.

This product must be mounted to a solid surface capable of supporting the Bench Vise, workpiece and any clamps used to hold the workpiece in place.

1. Before initial use of the Vise, use a soft cloth to wipe off any protective coat of grease.

2. Use appropriate diameter bolts or lag bolts (not included) to fit 3/8” diameter mounting holes when mounting your vise.

3. Use the mounting holes on the Mounting Base (1) as a template. Set the Vise flat on the workbench or table. Using a pencil, mark the mounting hole points. Move the Vise out of the way.

4. Using the markings from Step 3 drill holes of the appropriate size through the table or workbench. Make certain that the drilling path is clear of electrical wires, cords or conduits.

5. Carefully set the Mounting Base (1) over the holes previously drilled. Insert hardened steel bolts (not included) of the appropriate diameter (to fit 3/8” mounting holes) down through the Mounting Base (1) and through the workbench. The length of the mounting bolts will be determined by the thickness of your workbench. Secure the mounting bolts in place with the appropriate washers and nuts (not included).

REPLACING THE JAWS

1. To remove the Jaws (4), unscrew the Inner Screws (7)-see Figure 1 on page 5.

2. Pull off the Jaws (4) and replace with a new set. Thread the Inner Screws (7) back into place-see Figure 1 on page 5.

OPERATION INSTRUCTIONS

Swivel the Bench Vise

1. Your Bench Vise will swivel 360 degrees for easier access to your workpiece.
2. Turn the two Swivel Levers (2) until they release the base of the Bench Vise. Turn the Vise to the desired position.

3. Tighten the Swivel Levers (2) in place until the Mounting Base (1) is firmly in position.

**FIGURE 1**

![Figure 1](image)

**INSTALLING THE WORKPIECE**

1. To open, turn Lever Handle (6) one turn to the left in vertical position.
2. Pull front jaw out.
3. Put workpiece into place.
4. Push front jaw back until it meets the workpiece.
5. Turn lever to the right to fasten.

Caution: Over-tightening the Jaws (4) may damage the workpiece. Soft materials may be marred by the jaws.

**INSPECTION, MAINTENANCE, AND CLEANING**

1. **BEFORE EACH USE**, inspect the general condition of the product. Check for loose screws, misalignment or binding of moving parts, cracked or broken parts and any other condition that may affect its safe operation. **Do not use damaged equipment.**
2. Remove dirt and debris from the vise using a clean, soft cloth. Do not use flammable corrosive or abrasive solvents to clean the Vise.

3. Lubricate all moving parts on a frequent and regular basis with a light machine oil.

**PARTS LIST**

<table>
<thead>
<tr>
<th>Part</th>
<th>Description</th>
<th>Q’ty</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Mounting Base</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>Swivel Lever</td>
<td>2</td>
</tr>
<tr>
<td>3</td>
<td>Moving Slide</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>Jaw</td>
<td>2</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Part</th>
<th>Description</th>
<th>Q’ty</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>Anvil</td>
<td>1</td>
</tr>
<tr>
<td>6</td>
<td>Handle</td>
<td>1</td>
</tr>
<tr>
<td>7</td>
<td>Inner Screw</td>
<td>2</td>
</tr>
</tbody>
</table>

**PARTS DIAGRAM**

2. Remove dirt and debris from the vise using a clean, soft cloth. Do not use flammable corrosive or abrasive solvents to clean the Vise.

3. Lubricate all moving parts on a frequent and regular basis with a light machine oil.
Harbor Freight Tools Co. makes every effort to assure that its products meet high quality and durability standards, and warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of ninety days from the date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities, or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our product. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation of exclusion may not apply to you. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

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PLEASE READ THE FOLLOWING CAREFULLY

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Record Product’s Serial Number Here:

Note: If product has no serial number, record month and year of purchase instead.

Note: Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts.