KLUTCH

8in. Capacity Heavy-Duty Bench Vise

Owner's Manual



WARNING: Read carefully and understand all ASSEMBLY AND OPERATION INSTRUCTIONS before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.

Item #77597

READ & SAVE THESE INSTRUCTIONS

Thank you very much for choosing a Klutch™ product!

For future reference, please complete the owner's record below:

Serial Number/Lot Date Code (if applicable): _____

Purchase Date: _____

Save the receipt, warranty, and this manual. It is important that you read the entire manual to become familiar with this product before you begin using it.

This bench vise is designed for certain applications only. Northern Tool & Equipment is not responsible for issues arising from modification or improper use of this product such as an application for which it was not designed. We strongly recommend that this product not be modified and/or used for any application other than that for which it was designed.

For technical questions, please call **1-800-222-5381**.

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Intended Use

The Klutch 8in. Capacity Heavy-Duty Bench Vise can hold a variety of work pieces. It features:

- High-quality, heavy-duty, cast iron construction
- Swivel base rotates 360°
- Replaceable, hardened, steel serrated jaws
- Shot blasted, pre-coated finish for increased durability
- Large, built-in anvil

Note: Nuts and bolts for attaching the vise to a table are not provided and should be purchased separately.

Packaging Contents

- Bench Vise
- Handle
- Owner's Manual

Technical Specifications

Property	Specification
Opening of Vise	8"
Jaw Width	8"
Hardness	40+ HRC
Construction	Cast Iron
Tensile Strength	30,000 PSI
Swivel Base	360°

Important Safety Information

⚠WARNING

- Read and understand all instructions. Failure to follow all instructions may result in serious injury or property damage.
- The warnings, cautions, and instructions in this manual cannot cover all possible conditions or situations that could occur. Exercise common sense and caution when using this tool. Always be aware of the environment and ensure that the tool is used in a safe and responsible manner.
- Do not allow persons to operate or assemble the product until they have read this manual and have developed a thorough understanding of how it works.
- Do not modify this product in any way. Unauthorized modification may impair the function and/or safety and could affect the life of the product. There are specific applications for which the product was designed.
- Use the right tool for the job. DO NOT attempt to force small equipment to do the work of larger industrial equipment. There are certain applications for which this equipment was designed. It will be a safer experience and do the job better at the capacity for which it was intended. DO NOT use this equipment for a purpose for which it was not intended.
- Industrial or commercial applications must follow OSHA requirements.

⚠WARNING

PROP 65

- This product can expose you to chemicals including lead, which is known to the State of California to cause cancer. For more information, go to www.p65warnings.ca.gov.

⚠WARNING

WORK AREA SAFETY

- Inspect the work area before each use. Keep work area clean, dry, free of clutter, and well-lit. Cluttered, wet, or dark work areas can result in injury. Using the product in confined work areas may put you dangerously close to cutting tools and rotating parts.
- Keep children and bystanders away from the work area while operating the tool. Do not allow children to handle the product.

⚠WARNING

PERSONAL SAFETY

- Stay alert, watch what you are doing, and use common sense when operating the tool. Do not use the tool while you are tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating the tool may result in serious personal injury.
- Dress properly. Do not wear loose clothing, dangling objects, or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts. Air vents on the tool often cover moving parts and should be avoided.
- Wear the proper personal protective equipment when necessary. Use ANSI Z87.1 compliant safety goggles (not safety glasses) with side shields, or when needed, a face shield. Use a dust mask in dusty work conditions. Also use non-skid safety shoes, hardhat, gloves, dust collection systems, and hearing protection when appropriate. This applies to all persons in the work area.
- Do not overreach. Keep proper footing and balance at all times.

⚠CAUTION

BENCH VISE USE AND CARE

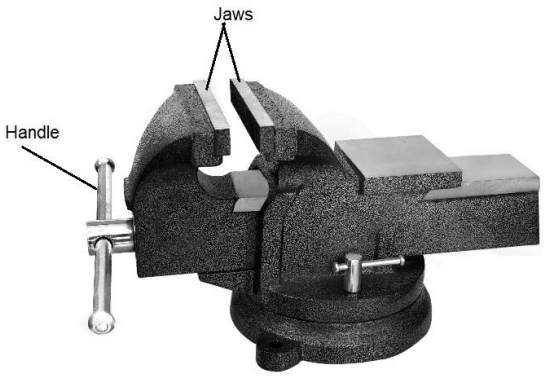
- Do not force the bench vise. Products are safer and do a better job when used in the manner for which they are designed. Plan your work and use the correct product for the job.
- Check for damaged parts before each use. Carefully check that the product will operate properly and perform its intended function. Replace damaged or worn parts immediately. Never operate the product with a damaged part.

Specific Operation Warnings

⚠WARNING

- Never use a hammer, pipe extension, or cheater bar on the spindle handle of a vise.

Main Parts of Bench Vise



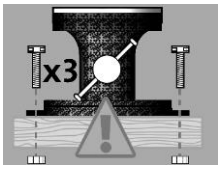
Assembly Instructions

⚠WARNING

- Only hand-tighten swivel base lock-down nuts at the sides of the vise.
- Never use a pipe extension to tighten lock nut handles.

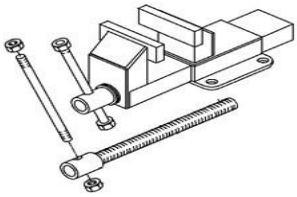
Note: Nuts and bolts for attaching the vise to a table are not provided and should be purchased separately.

- The vise must be mounted on a solid, level surface capable of supporting the combined weight of the vise, the intended work pieces, and applicable forces.



- Use the holes in the base of the vise as a template to mark the bench surface. Verify that the installation surface does not have hidden utility lines before drilling or driving screws. Drill holes and attach the vise firmly to the work surface with the use of the proper size bolts, nuts, lock, and flat washers. Never weld the base of a vise to any metal object.

- Place the handle into the hole of the spindle bar and screw in the open end.

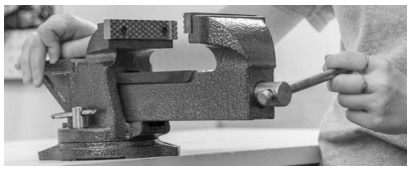


Operating Instructions

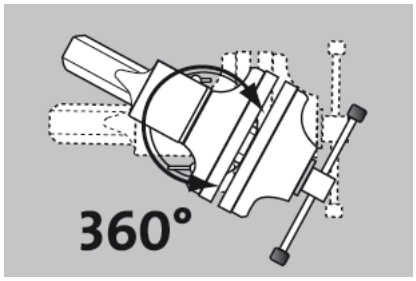
⚠WARNING

- Never use a hammer, pipe extension, or cheater bar on spindle handle of vise.
- Never unscrew moveable jaw beyond the maximum specified opening of the vise.
- Never use a vise as a press for assembly or disassembly of objects.

1. Turn the spindle screw by rotating counter-clockwise to open the jaws and place the work piece between them.



2. Loosen the lock-down nuts and rotate the vise to the best orientation for the job. A choice of three jaws are available: straight jaws, pipe jaws, or V-jaws. Tighten the locking bolt to secure the vise before starting any work.



3. Close the jaws until the work piece is held securely. Do not overtighten the jaws. Overtightening the jaws could damage the work piece. The position of the jaws will lock after the handle is tightened.



Before Each Use

⚠WARNING

To reduce risk of injury always wear eye and face protection with striking vise-held objects or when using power tools to a vise.

- Verify that the vise is tightly mounted on the bench; tighten if loose.
- Tighten the swivel base using the lock-down nuts attached to it.
- Check the movement of the vise using the handle. Lubricate the spindle if needed.
- Inspect the general condition of the vise. Check for misalignment or any binding of moving parts.

After Each Use

- Clean the external surfaces of the vise with a clean cloth.
- Always close the vise after using it.

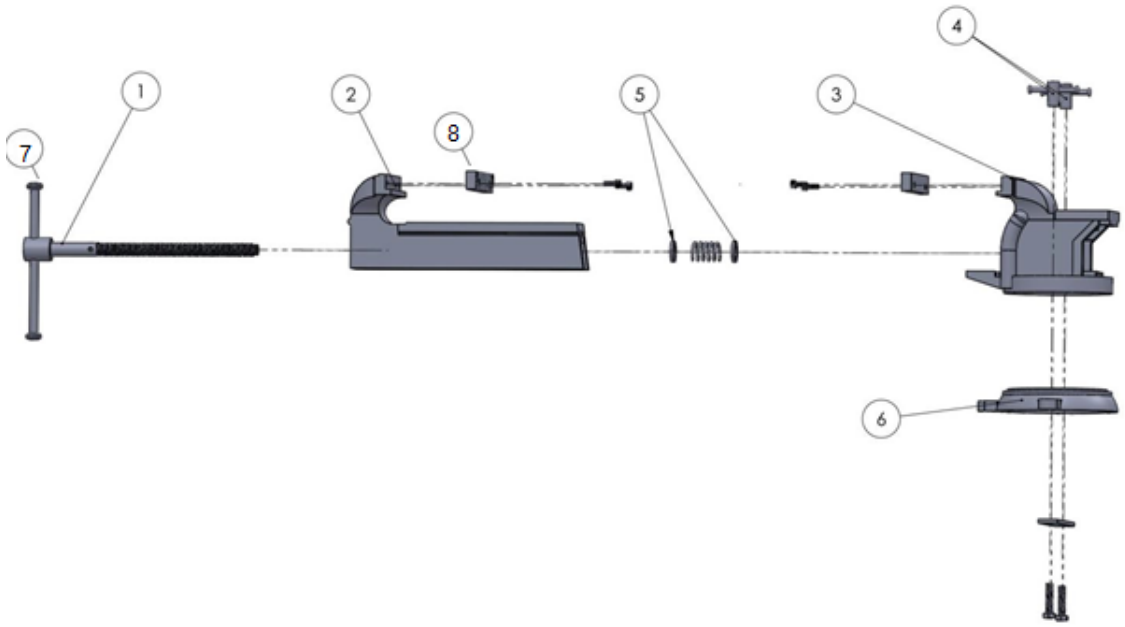
Maintenance

- Keep the vise clean and dry, and moving parts lightly lubricated for better performance.
- Keep the handle dry, clean, and free from oil, grease, and solvents. An oily handle can cause an accident during use.

Troubleshooting

Failure	Corrective Action
Loosened jaw.	Tighten the screws with a screwdriver or Hex driver.
Excessive play in swivel base.	Adjust the lock-down bolts equally on both sides.
Handle is falling off.	1. Place a steel block at the bottom of the handle. 2. Place the handle end at the steel block and strike lightly with a hammer.
Anvil no longer has a sharp or square edge; it has rounded.	Re-sharpen the anvil edges with a rough file, as needed and chamfer it manually.

Parts Diagram



Parts List

Replaceable Parts

Part No.	Description
7	Handle
8	Jaws

Non-replaceable Parts

Part No.	Description
1	Spindle Screw Bar
2	Moving Slide
3	Vise Body
4	Lock-down Bolt
5	Spring and Washers
6	Swivel Base with Screws and Strip

Replacement Parts

- For replacement parts and technical questions, please call Customer Service at **1-800-222-5381**.
- Not all product components are available for replacement. The illustrations provided are a convenient reference to the location and position of parts in the assembly sequence.
- When ordering parts, the following information will be required: item description, item model number, item serial number/item lot date code, and the replacement part reference number.
- The distributor reserves the rights to make design changes and improvements to product lines and manuals without notice.

Limited Warranty

Northern Tool and Equipment Company, Inc. ("We" or "Us") warrants to the original purchaser only ("You" or "Your") that the Klutch product purchased will be free from material defects in both materials and workmanship, normal wear and tear excepted, for a period of **one year** from date of purchase. The foregoing warranty is valid only if the installation and use of the product is strictly in accordance with product instructions. There are no other warranties, express or implied, including the warranty of merchantability or fitness for a particular purpose. If the product does not comply with this limited warranty, Your sole and exclusive remedy is that We will, at our sole option and within a commercially reasonable time, either replace the product or product component without charge to You or refund the purchase price (less shipping). This limited warranty is not transferable.

Limitations on the Warranty

This limited warranty does not cover: (a) normal wear and tear; (b) damage through abuse, neglect, misuse, or as a result of any accident or in any other manner; (c) damage from misapplication, overloading, or improper installation; (d) improper maintenance and repair; and (e) product alteration in any manner by anyone other than Us, with the sole exception of alterations made pursuant to product instructions and in a workmanlike manner.

Obligations of Purchaser

You must retain Your product purchase receipt to verify date of purchase and that You are the original purchaser. To make a warranty claim, contact Us at 1-800-222-5381, identify the product by make and model number, and follow the claim instructions that will be provided. The product and the purchase receipt must be provided to Us in order to process Your warranty claim. Any returned product that is replaced or refunded by Us becomes our property. You will be responsible for return shipping costs or costs related to Your return visit to a retail store.

Remedy Limits

Product replacement or a refund of the purchase price is Your sole remedy under this limited warranty or any other warranty related to the product. We shall not be liable for: service or labor charges or damage to Your property incurred in removing or replacing the product; any damages, including, without limitation, damages to tangible personal property or personal injury, related to Your improper use, installation, or maintenance of the product or product component; or any indirect, incidental or consequential damages of any kind for any reason.

Assumption of Risk

You acknowledge and agree that any use of the product for any purpose other than the specified use(s) stated in the product instructions is at Your own risk.

Governing Law

This limited warranty gives You specific legal rights, and You also may have other rights which vary from state to state. Some states do not allow limitations or exclusions on implied warranties or incidental or consequential damages, so the above limitations may not apply to You. This limited warranty is governed by the laws of the State of Minnesota, without regard to rules pertaining to conflicts of law. The state courts located in Dakota County, Minnesota shall have exclusive jurisdiction for any disputes relating to this warranty.

KLUTCH

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Made in India