

Please read and save these instructions. Read carefully before attempting to assemble, install, operate or maintain the product described. Protect yourself and others by observing all safety information. Failure to comply with instructions could result in personal injury and/or property damage! Retain instructions for future reference.

Dayton® 3, 6 and 8" Cross Visés

Description

Dayton 3, 6 and 8" Cross Visés travel on two separate axes, longitudinal and cross, to permit accurate positioning of workpiece. Body, saddle, base and jaws are made of high strength cast iron. Vise leadscrew, longitudinal and cross feed screws are precision ground carbon steel.

Specifications

Refer to Figure 2.

3" CROSS VISE - MODEL 4YG28A

- A Longitudinal travel (left to right) 5"
- B Cross travel (forward-rearward) 5"
- Value of one division 0.0039"
- Cross travel per one revolution 0.1181"
- Longitudinal travel per one revolution 0.1181"

6" AND 8" CROSS VISÉS MODEL 6Z848D AND 3W766C

- A Longitudinal travel (left to right) 8"
- B Cross travel (forward-rearward) 8"
- Value of one division 0.0039"
- Cross travel per one revolution 0.1575"
- Longitudinal travel per one revolution 0.1575"

Dimensions

Refer to Figure 1.

3" CROSS VISE - MODEL 4YG28A

- A Jaw width 3"
- B Throat depth 1 1/8"
- C Jaw opening 3"
- D Base width 4 1/2"
- E Base length 8 1/4"
- F Overall height 5 5/8"

6" CROSS VISE - MODEL 6Z848D

- A Jaw width 6"
- B Throat depth 2"
- C Jaw opening 6"
- D Base width 7"
- E Base length 12"
- F Overall height 7 1/4"

8" CROSS VISE - MODEL 3W766C

- A Jaw width 8"
- B Throat depth 2"
- C Jaw opening 6"
- D Base width 7"
- E Base length 12"
- F Overall height 7 1/4"

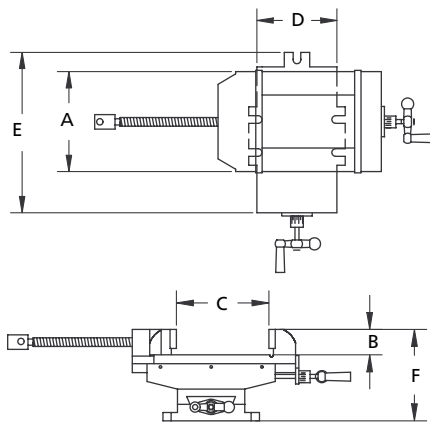


Figure 1 - Dimensions

WORKPIECE TRAVEL LIMITS

Refer to Figure 2.

Figure 2 shows vise stationary jaw in centered position.

For model 4YG28A, the vise stationary jaw can be moved 2 1/2" to the left and right, and 2 1/2" forward and rearward from the position shown in Figure 2.

For models 6Z848D and 3W766C, the vise stationary jaw can be moved 4" to the left and right, and 4" forward and rearward from the position shown in Figure 2.

Refer to Figure 2 to mount cross vise base to machine table in desired location. Be sure to secure vise using at least two mounting flanges on base.

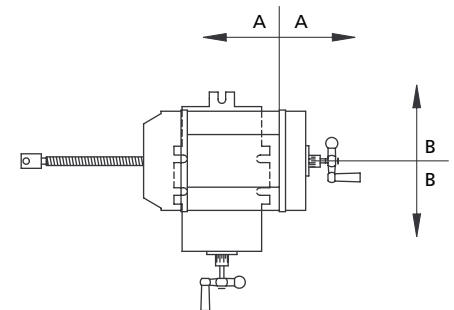


Figure 2 - Centered Position of Vise
General Safety Information

1. Understand and obey all safety instructions supplied with drill press, mill, or other machines on which vise is used.
2. Bolt or clamp vise to work surface in at least two mounting locations using mounting flanges provided on base.
3. Be sure workpiece is clamped securely between jaws before starting machining operation.
4. Do not over tighten—vise can develop a large clamping force. Use only force which is needed.
5. Do not pound or hammer on workpiece. This vise is designed to clamp the workpiece in a desired position for machining operations only.

ENGLISH

ESPAÑOL

Dayton® 3, 6 and 8" Cross Vises

Assembly

3" CROSS VISE - MODEL 4YG28A

1. Mount crank handles (Ref. No. 12) to longitudinal and cross feed screws (Ref. Nos. 8 and 9) using acorn nuts (Ref. No. 13).
2. This vise is shipped with a protective coating. This coating should be removed before operation. Remove protective coating with penetrating oil.

6" AND 8" CROSS VISES MODELS 6Z848D AND 3W766C

1. Thread movable jaw leadscrew (Ref. No. 14) through end of body (Ref. No. 16) and into hole in movable jaw (Ref. No. 18). Secure with dog point set screw (Ref. No. 19).
2. Mount crank handles (Ref. No. 12) to longitudinal and cross feed screws (Ref. Nos. 8 and 9) using acorn nuts (Ref. No. 13).
3. This vise is shipped with a protective coating. This coating should be removed before operation. Remove protective coating with penetrating oil.

Operation

Refer to Figure 3.

1. Mount vise to work surface in desired location by securing at least two mounting flanges located on base (Ref. No. 1).
2. Move saddle (Ref. No. 3) by rotating longitudinal crank handle (Ref. No. 12). Tighten center set screw (Ref. No. 6) to secure position.
3. Move vise body (Ref. No. 16) to desired position by rotating cross feed crank handle (Ref. No. 12). Tighten center set screw (Ref. No. 6) to secure position.
4. Open jaws of vise. Place workpiece between jaws in desired position. Rotate vise handle to secure workpiece between vise jaws. Be sure workpiece is secure in vise before starting machining operation.

Maintenance

Particles of metal or wood can damage machined surfaces, causing difficult or inaccurate operation.

1. Keep machined surfaces and all moving parts clean and free of dirt, chips and foreign materials.
2. Keep machined surfaces and leadscrews lubricated with medium weight machine oil.

GIB ADJUSTMENT

Refer to Figure 3.

Tighten saddle gibs (Ref. No. 4) by tightening the set screws (Ref. Nos. 6 and 23) at each end of the gibs.

Adjust the screws until a slight drag is felt when rotating the crank handles (Ref. No. 12). Tighten nuts (Ref. No. 5) to secure screws.

Models 4YG28A, 6Z848D and 3W766C

LIMITED WARRANTY

DAYTON ONE-YEAR LIMITED WARRANTY. Dayton® 3, 6 and 8" Cross Vises, Models covered in this manual, are warranted by Dayton Electric Mfg. Co. (Dayton) to the original user against defects in workmanship or materials under normal use for one year after date of purchase. Any part which is determined to be defective in material or workmanship and returned to an authorized service location, as Dayton designates, shipping costs prepaid, will be, as the exclusive remedy, repaired or replaced at Dayton's option. For limited warranty claim procedures, see PROMPT DISPOSITION below. This limited warranty gives purchasers specific legal rights which vary from jurisdiction to jurisdiction.

LIMITATION OF LIABILITY. To the extent allowable under applicable law, Dayton's liability for consequential and incidental damages is expressly disclaimed. Dayton's liability in all events is limited to and shall not exceed the purchase price paid.

WARRANTY DISCLAIMER. Dayton has made a diligent effort to provide product information and illustrate the products in this literature accurately; however, such information and illustrations are for the sole purpose of identification, and do not express or imply a warranty that the products are MERCHANTABLE, or FIT FOR A PARTICULAR PURPOSE, or that the products will necessarily conform to the illustrations or descriptions. Except as provided below, no warranty or affirmation of fact, expressed or implied, other than as stated in the "LIMITED WARRANTY" above is made or authorized by Dayton.

PRODUCT SUITABILITY. Many jurisdictions have codes and regulations governing sales, construction, installation, and/or use of products for certain purposes, which may vary from those in neighboring areas. While Dayton attempts to assure that its products comply with such codes, it cannot guarantee compliance, and cannot be responsible for how the product is installed or used. Before purchase and use of a product, review the product applications, and all applicable national and local codes and regulations, and be sure that the product, installation, and use will comply with them.

Certain aspects of disclaimers are not applicable to consumer products; e.g., (a) some jurisdictions do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you; (b) also, some jurisdictions do not allow a limitation on how long an implied warranty lasts, consequentially the above limitation may not apply to you; and (c) by law, during the period of this Limited Warranty, any implied warranties of implied merchantability or fitness for a particular purpose applicable to consumer products purchased by consumers, may not be excluded or otherwise disclaimed.

PROMPT DISPOSITION. Dayton will make a good faith effort for prompt correction or other adjustment with respect to any product which proves to be defective within limited warranty. For any product believed to be defective within limited warranty, first write or call dealer from whom the product was purchased. Dealer will give additional directions. If unable to resolve satisfactorily, write to Dayton at address below, giving dealer's name, address, date, and number of dealer's invoice, and describing the nature of the defect. Title and risk of loss pass to buyer on delivery to common carrier. If product was damaged in transit to you, file claim with carrier.

Manufactured for Dayton Electric Mfg. Co., 5959 W. Howard St., Niles, Illinois 60714 U.S.A.

For Repair Parts, call 1-800-323-0620

24 hours a day – 365 days a year

Please provide following information:

- Model number
- Serial number (if any)
- Part description and number as shown in parts list

Address parts correspondence to:

Grainger Parts
 P.O. Box 3074
 1657 Shermer Road
 Northbrook, IL 60065-3074 U.S.A.

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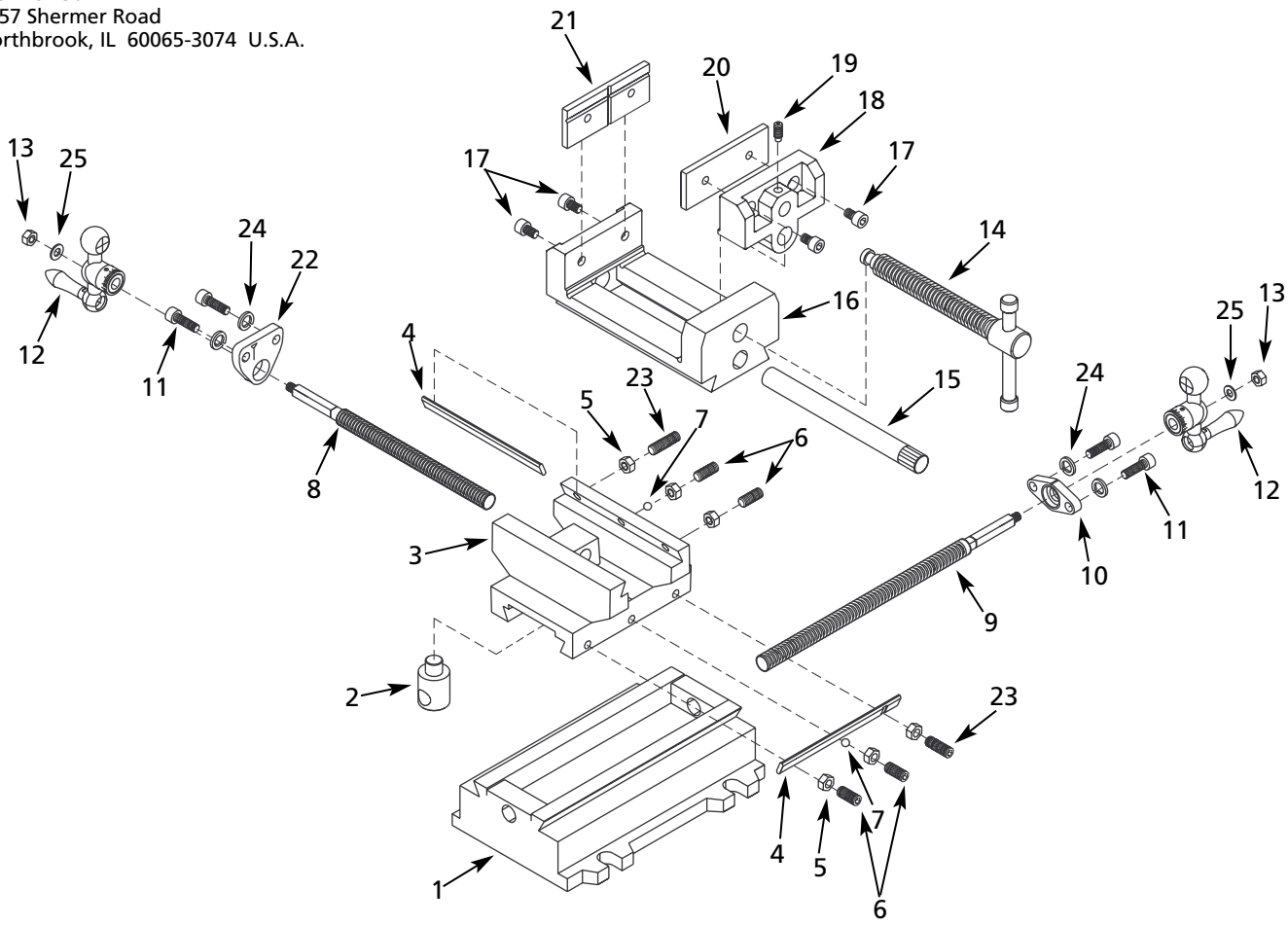


Figure 3 – Repair Parts Illustration for 3, 6 and 8" Cross Vises

Repair Parts List for 3, 6 and 8" Cross Vises

Reference Number	Description	Part Number for Models:			Quantity
		4YG28A	6Z848D	3W766C	
1	Base	9880.01	9900.01	9900.01	1
2	Nut	9881.00	9901.00	9901.00	1
3	Saddle	9882.01	9902.01	9902.01	1
4	Gib	9883.00	9903.00	9903.00	2
5	6-1.0mm Hex nut	*	*	*	6
6	6-1.0 x 16mm Set screw	*	–	–	4
6	6-1.0 x 20mm Set screw	–	*	*	4
7	1/8" Ball	9884.00	9884.00	9884.00	2
8	Longitudinal feed screw	9898.00	2658.00	2658.00	1
9	Cross feed screw	9886.00	9906.00	9906.00	1
10	Retaining plate	9887.00	9907.00	9907.00	1
11	6-1.0 x 16mm Socket head bolt	*	–	–	4
11	8-1.25 x 25mm Socket head bolt	–	*	*	4
12	Crank handle assembly	15068.00	15069.00	15069.00	2
13	6-1.0mm Acorn nut	15017.00	15017.00	15017.00	2
14	Leadscrew with handle	6861.00	6877.00	9742.00	1
15	Guide rod	6860.00	6876.00	9743.00	1
16	Body	15013.00	9913.00	9745.00	1
17	6-1.0 x 10mm Socket head bolt	*	–	–	4
17	8-1.25 x 14mm Socket head bolt	–	*	–	4
17	8-1.25 x 25mm Socket head bolt	–	–	*	4
18	Movable jaw	6862.01	6879.01	9747.01	1
19	6-1.0 x 12mm Dog point set screw	9458.00	9458.00	9458.00	1
20	Jaw plate	6863.00	6882.00	9748.00	1
21	Grooved jaw plate	6864.00	6883.00	9749.00	1
22	Retaining plate	9897.00	9918.00	9918.00	1
23	6-1.0 x 16mm Set screw	*	–	–	2
23	6-1.0 x 25mm Set screw	–	*	*	2
24	6mm Lock washer	*	–	–	4
24	8mm Lock washer	–	*	*	4
25	6mm Flat washer	–	*	*	2
Recommended Accessories					
Δ	3" Prismatic jaw	7094.00	–	–	1
Δ	6" Prismatic jaw	–	6884.00	–	1
Δ	8" Prismatic jaw	–	–	2659.00	1

(Δ) Not shown.

(*) Standard hardware item, available locally.

Service Record

Dayton® 3, 6 and 8" Cross Vises

Date	Maintenance performed	Replacement components required

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