

# ASSEMBLING AND OPERATING INSTRUCTIONS

Speedy Air Vise comes to you ready to use. Connect one hose to the union on the hand end of the vise and to the Air Out on the foot pedal. Connect the other hose to the Air In on the foot pedal and to the air line. If application of the foot control does not activate air tool, loosen screws on air valve portion of the foot control and make slight adjustment of air valve to a different position.

Any pressure from 2lbs. per square inch to 150 lbs. per square inch may be applied. The total pressure on the jaw will be approximately fifteen times the per square inch pressure on the air line. Example: the total pressure on the jaw is approximately 1500 lbs. when the air line pressure is 100lbs. per square inch.

The pressure on the jaw can be reduced to permit the holding of light work without crushing by installing an air line regulator between the hose and the air pipe and adjusting the air line pressure to a safe working point. While water, dirt, oil and chips will not injure the vise or the diaphragm in the vise in any way, dirt oil and foreign particles should be kept out of the hose, regulator and the foot valve to secure untroubled service.

As a preventative against pipe line scale or other foreign matter getting into the valve and fouling the seats we advise the use of an air line filter between the hose and the air pipe.

The range of the jaw is adjustable by means of the knurled wheel between the movable jaw and the cylinder. The fillister head lock screw on the top of the movable jaw should be set up snugly after adjustment. After adjusting for jaw opening, the jam nut must be locked against the piston.

The movable jaw and slides should be oiled according to use and the cam on the foot pedal valve should be greased - other than that, the vise requires no maintenance and may be run submerged or submerged in cutting oil, water, soluble oil etc., without harm. When the vise is running in oil a short length of 1/8" or 1/4" pipe should be used to keep the air hose out of the oil.

Whenever practical, work should be held in the vertical and horizontal center of the jaws for maximum efficiency. To obtain greatest speed the jaws should be set to open the smallest practical amount.

## IMPORTANT - HOW TO REPLACE DIAPHRAM

Remove air line hose from head. Be sure jam nut is locked against piston. Remove the eight head screws, head and used diaphragm. Lay the new diaphragm in place being careful that the screw holes are lined up. Replace head and eight screws and tighten screws finger tight. Then tighten head screws tight, working across to opposite sides.

Should the head be removed for any reason it must be replaced according to above instructions.

**CAUTION: Keep hands and fingers clear from vise when in operation.**

