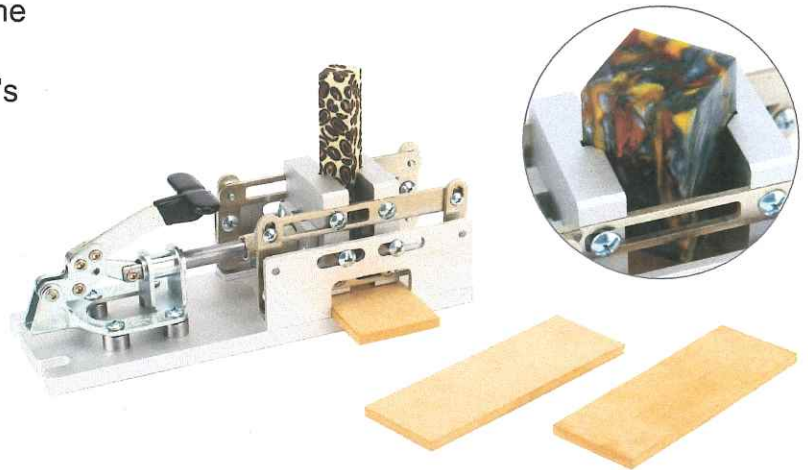


SELF CENTERING PEN DRILLING VISE INSTRUCTION MANUAL

PDV1

The self centering pen drilling vise is simply the best and easiest-to-use vise available today. Made from heavy-duty aluminum and steel, it's built to last a lifetime. Adjustment for different size blanks is fast and needs no tools. It securely holds square stock up to 1-1/2" and round stock to 1-1/2" diameter.



Safety:

For safe operation, the pen blank drilling vise should be secured to the drill press table. If you don't have clamps large enough to secure the vise to your drill press table, the vise can be mounted on a large board to facilitate easier clamping.

Setup And Use:

1. Find the center of your blank by marking the diagonals from corner to corner on a square blank, or by using center-finder on a round blank.
2. Insert a piece of 1/4" thick, 2" wide, by 3" or longer piece of scrap wood or plywood through the "tunnel" under the vise jaws. This piece serves as a backup for the blank to prevent breakout upon the drill's exit through the work piece.
3. With the clamp lever down, position the corners of the blank so they fit into the cutouts in the jaws, then turn the knurled portion of the toggle clamp shaft until the vise jaws contact the blank. Turning the shaft clockwise will move the jaws in; turning it counter-clockwise will move the jaws out.
4. Lift the clamp lever up and turn the clamp adjustment clockwise one or two turns. Push the clamp lever down. The clamp should lock without applying excessive force, but still provide enough pressure to lock the blank securely in place. Adjust as necessary.
5. Set the drill press depth stop so the bit will not make contact with the drill press table.
6. Line the center point of the drill bit up with the center of the blank.
7. Clamp the vise to the drill press table.
8. Drill your blank. If drilling multiple blanks of the same size, do not change the position of the vise.

