

Model D2524/D2525 Quick Release Wood Vise Instruction Sheet



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Introduction

Your new Model D2524/D2525 Quick Release Wood Vise (**Figure 1**) is designed to fit on workbenches $2\frac{1}{4}$ " and thicker, but can be adapted to workbenches down to $1\frac{1}{2}$ " thick by using a shim. Holes are pre-drilled in the jaw faces to attach aftermarket or shop-built wood clamping vise jaw pads.

D2524 Specifications

- Jaw Width7"
- Mounting Height (Workbench Thickness) $2\frac{1}{4}$ "
- Maximum Jaw Opening8"
- Weight.....21 lbs.

D2525 Specifications

- Jaw Width9"
- Mounting Height (Workbench Thickness) $2\frac{1}{4}$ "
- Maximum Jaw Opening 10"
- Weight.....25 lbs.

Installation

1. Have another person hold the vise up against the workbench in the desired mounting location. If the workbench has holes for bench dogs, make sure the bench dog on the vise is aligned with those holes.

Note: If the workbench is less than $2\frac{1}{4}$ " thick, use a piece of scrap wood (**Figure 2**) between the vise and workbench as a shim. Cut the shim to the necessary thickness so the vise does not protrude above the workbench after mounting.

2. Pencil mark the workbench through the mounting holes to establish locations to drill pilot holes.
3. Use a $\frac{1}{8}$ " drill bit to drill pilot holes approximately $1\frac{1}{2}$ " deep in the face of the workbench, where the wood screws will be used (see **Figure 3**).

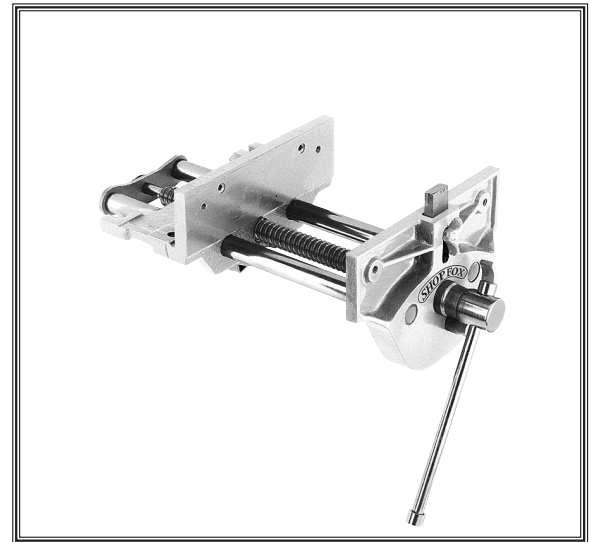


Figure 1. Quick release wood vise.

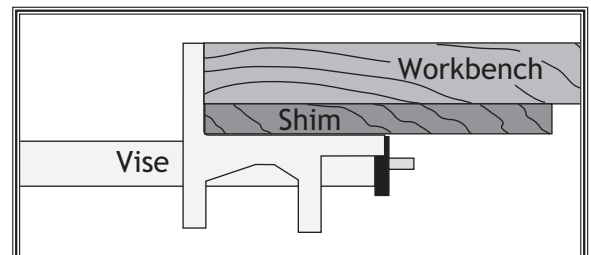


Figure 2. Shim placed between workbench and vise for workbenches under $2\frac{1}{4}$ ".

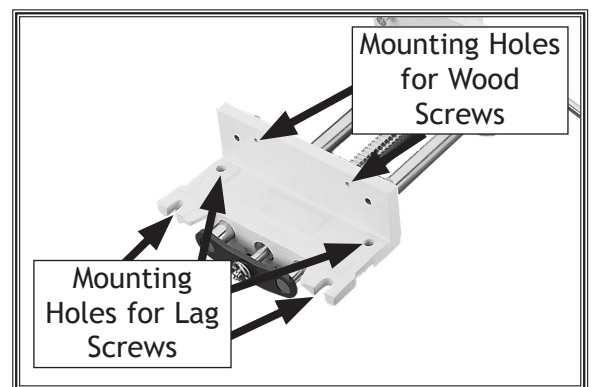


Figure 3. Mounting hole locations.

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4. Use a $\frac{1}{4}$ " drill bit to drill pilot holes approximately 1" deep in the underside of the workbench, where the lag screws will be used.
5. Attach the vise to the workbench with two #10 x 2" wood screws through the face of the vise jaw, as shown in **Figure 4**.
6. Secure the vise to the underside of the workbench with four $\frac{5}{16}$ " x $1\frac{3}{4}$ " lag screws and $\frac{5}{16}$ " flat washers as shown in **Figure 4**.

Note: If you're using a shim, make sure the lag screws pass completely through the shim and secure at least halfway into the workbench thickness, as shown in **Figure 5**.

Operation

Rotating the handle (**Figure 6**) clockwise moves the sliding jaw toward the fixed jaw; rotating handle counter-clockwise moves the sliding jaw away from the fixed jaw.

Moving the quick release lever (**Figure 6**) towards the vise handle disengages the leadscrew so the sliding jaw can be freely moved by pushing or pulling it.

Tightening/loosening the wing bolt (**Figure 6**) allows for adjustment the height of the bench dog.

! WARNING

This vise is not a toy. DO NOT use as a crushing tool. Never clamp containers with compressed or explosive contents. Using incorrectly may cause serious injury.

Accessories

Ask your Shop Fox dealer for the wood-faced magnetic jaw pads shown in **Figure 7**.

Maintenance

The painted parts of the vise can be cleaned with a damp rag. If wood pitch has built up on the components, clean this with a pitch dissolver or blade and bit cleaner.

Lubricate the leadscrew with dry lubrication, such as silicone or graphite, that will not cause sawdust to stick to the threads.

If material becomes built up on the threads, clean thoroughly with a pitch dissolver.

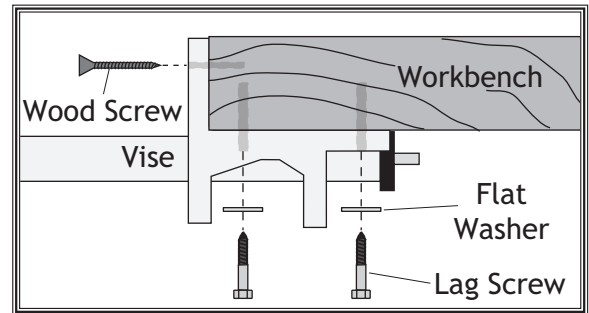


Figure 4. Attaching vise to workbench.

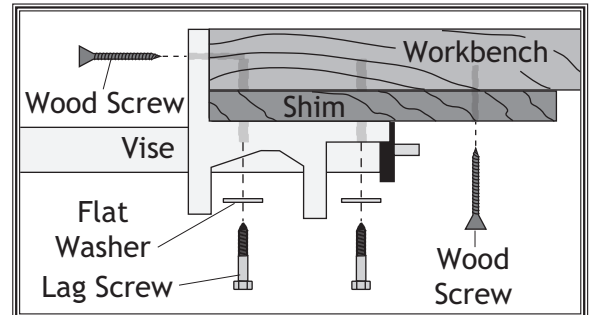


Figure 5. Attaching vise to workbench with shim between vise and workbench.

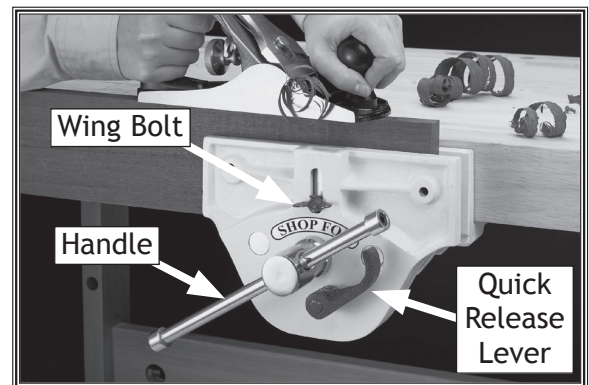


Figure 6. Operation controls of vise.

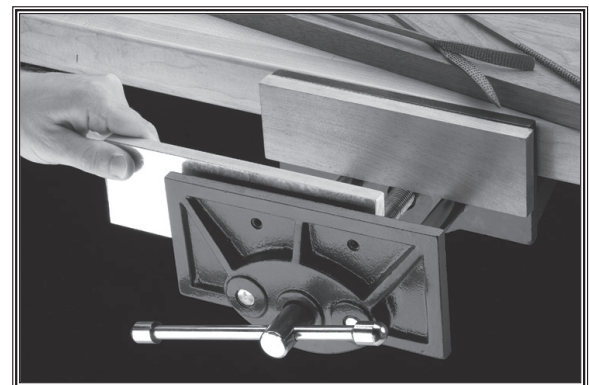
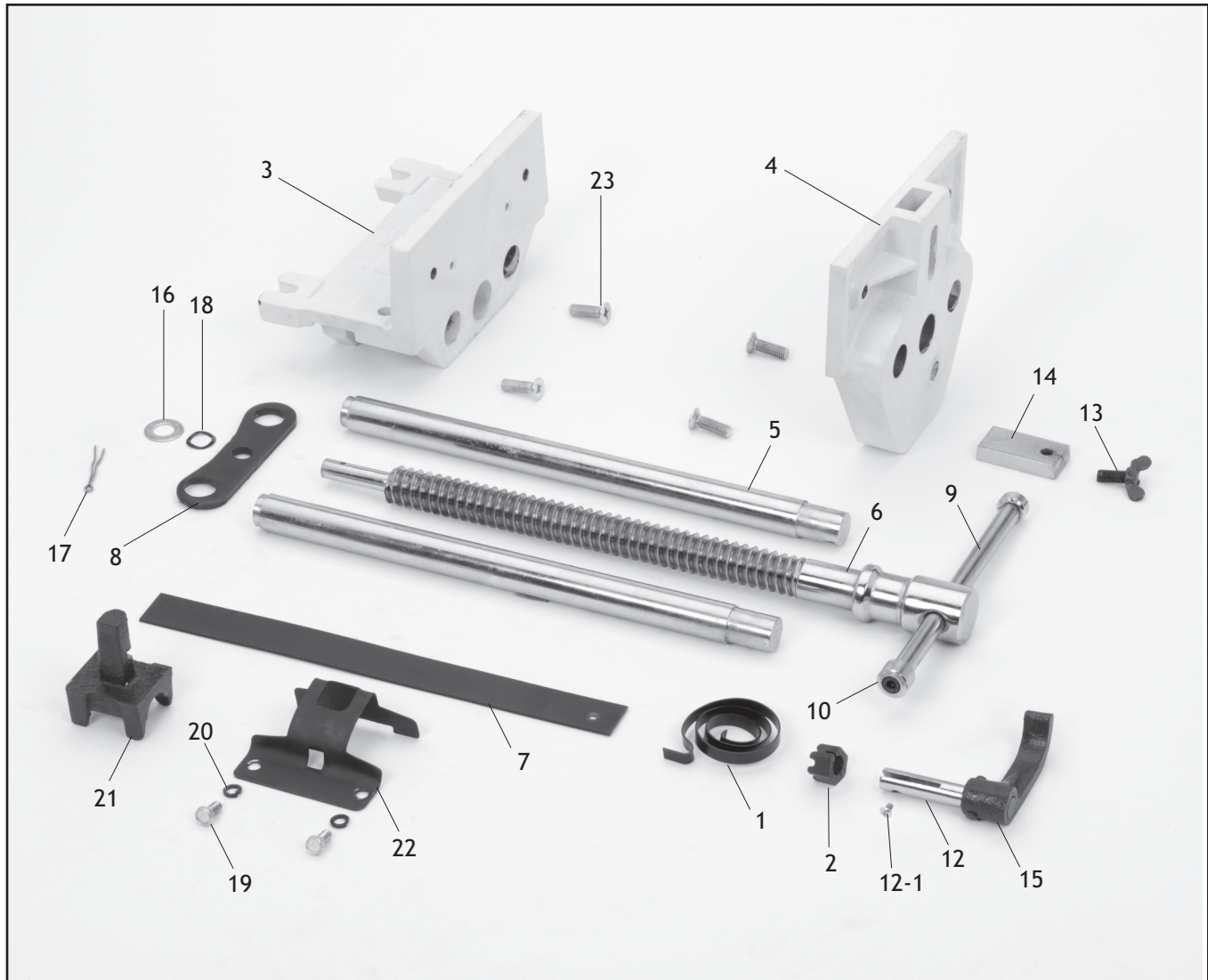


Figure 7. Shop Fox wood-faced magnetic jaw pads (Models D3127-D3133).

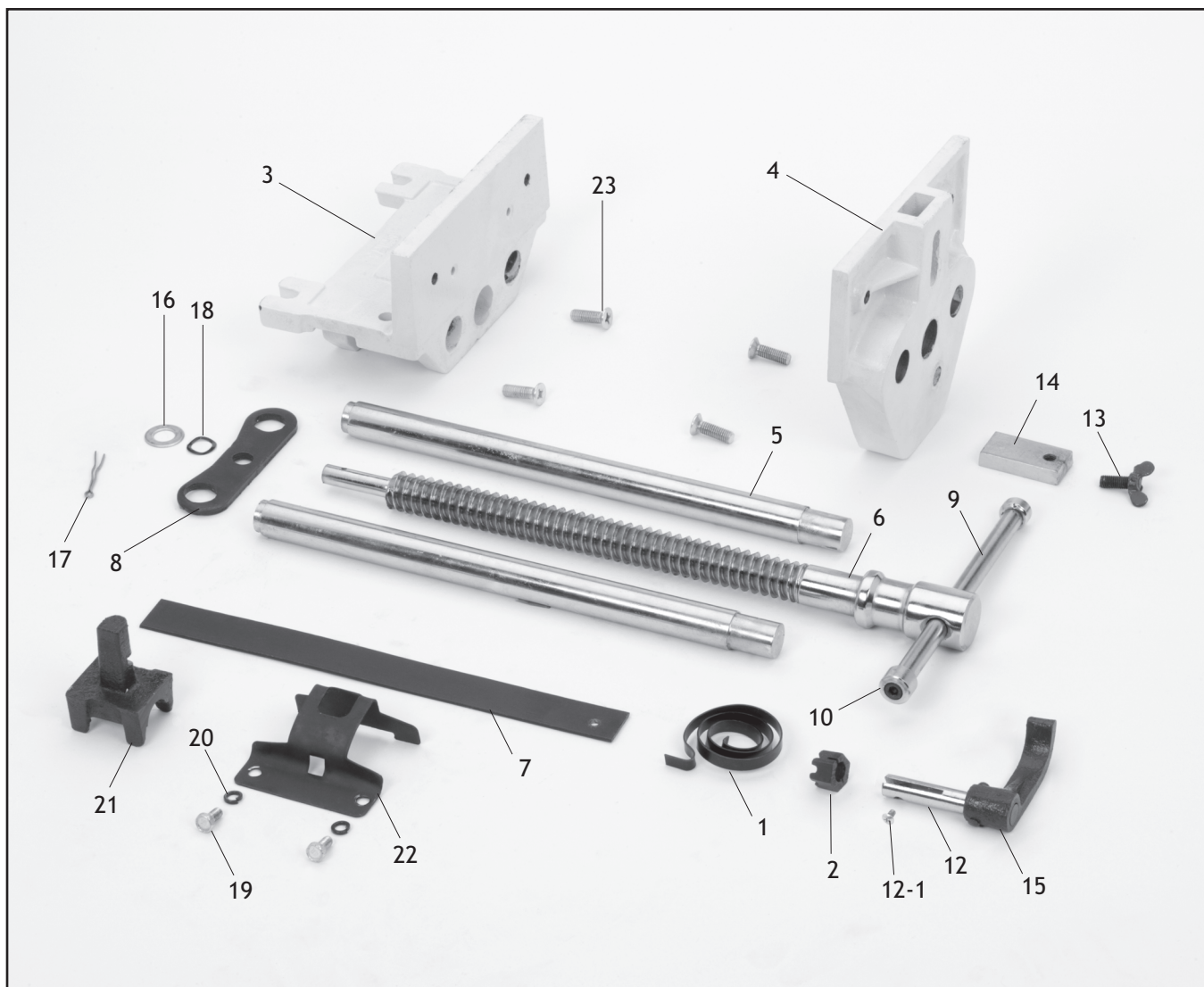
D2524 Parts



REF	PART #	DESCRIPTION
1	XD2524001	TORSION COIL SPRING 4 X 3
2	XD2524002	SLOTTED NUT M12-1.75
3	XD2524003	FIXED HOUSING 180 X 160 X 30
4	XD2524004	SLIDING HOUSING 110 X 110 X 180
5	XD2524005	GUIDE ROD 22 X 320
6	XD2524006	LEADSCREW 33 X 400
7	XD2524007	TORSION BAR 26 X 285 X 2
8	XD2524008	GUIDE ROD SUPPORT
9	XD2524009	HANDLE BAR W/KNOB
10	XD2524010	REMOVABLE HANDLE KNOB
12	XD2524012	RETAINER FORK
12-1	XP508M	PHLP HD SCR M5-.8 X 12

REF	PART #	DESCRIPTION
13	XD2524013	WING BOLT M8-1.25 X 20
14	XD2524014	LOCK DOG 50 X 25 X 10
15	XD2524015	QUICK RELEASE LEVER
16	XPW06M	FLAT WASHER 12MM
17	XD2524017	COTTER PIN 3 X 40
18	XD2524018	WAVY WASHER 12MM
19	XPB04M	HEX BOLT M6-1 X 10
20	XLW03M	LOCK WASHER 6MM
21	XD2524021	QUICK RELEASE HALF NUT
22	XD2524022	HALF NUT HOUSING BRACKET
23	XPFH21M	FLAT HD SCR M8-1.25 X 25

D2525 Parts



REF	PART #	DESCRIPTION
1	XD2524001	TORSION COIL SPRING 4 X 3
2	XD2524002	SLOTTED NUT M12-1.75
3	XD2525003	FIXED HOUSING 230 X 160 X 30
4	XD2525004	SLIDING HOUSING 230 X 110 X 110
5	XD2525005	GUIDE ROD 22 X 380
6	XD2525006	LEADSCREW 33 X 460
7	XD2525007	TORSION BAR 26 X 335 X 2
8	XD2525008	GUIDE ROD SUPPORT
9	XD2525009	HANDLE BAR W/KNOB
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