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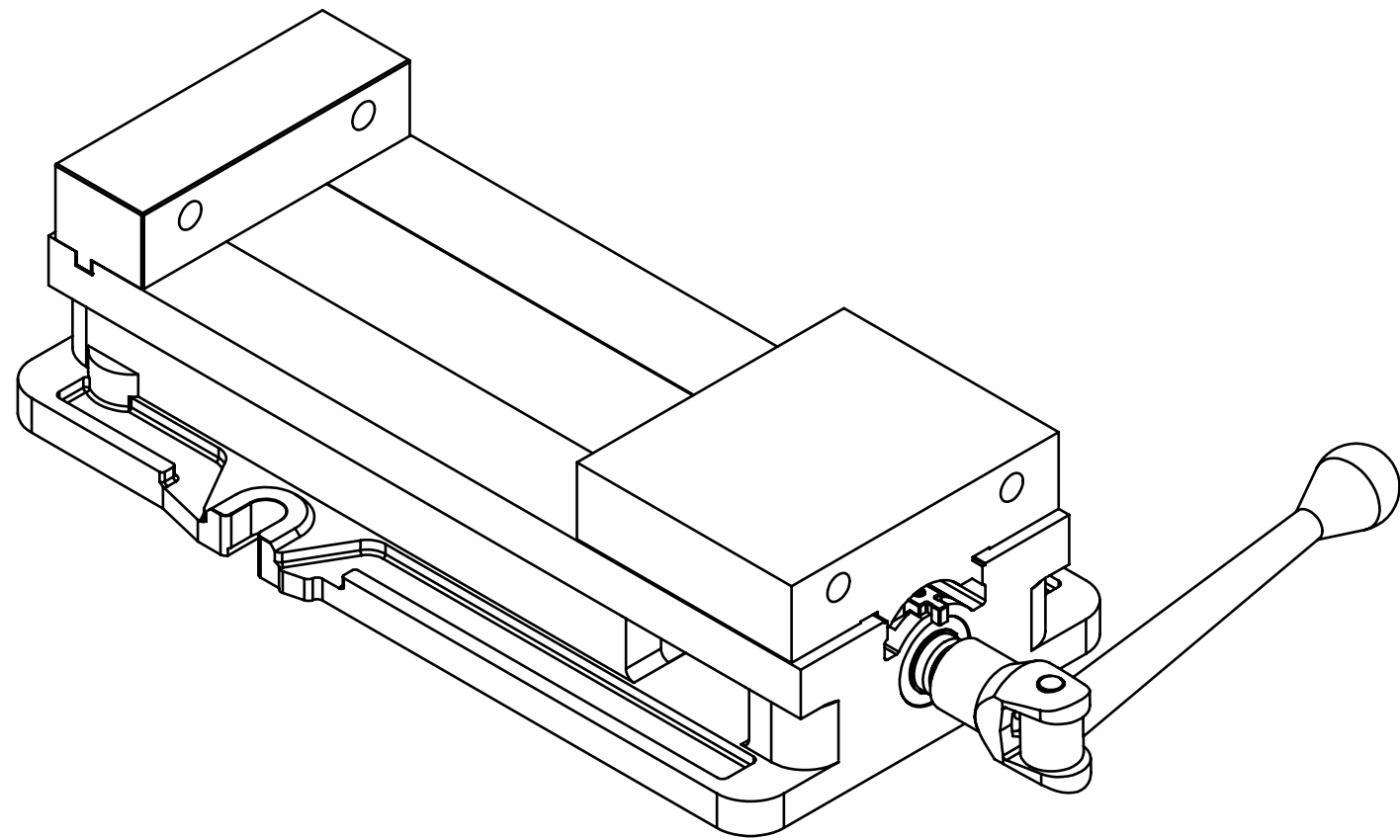
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STEP 1.

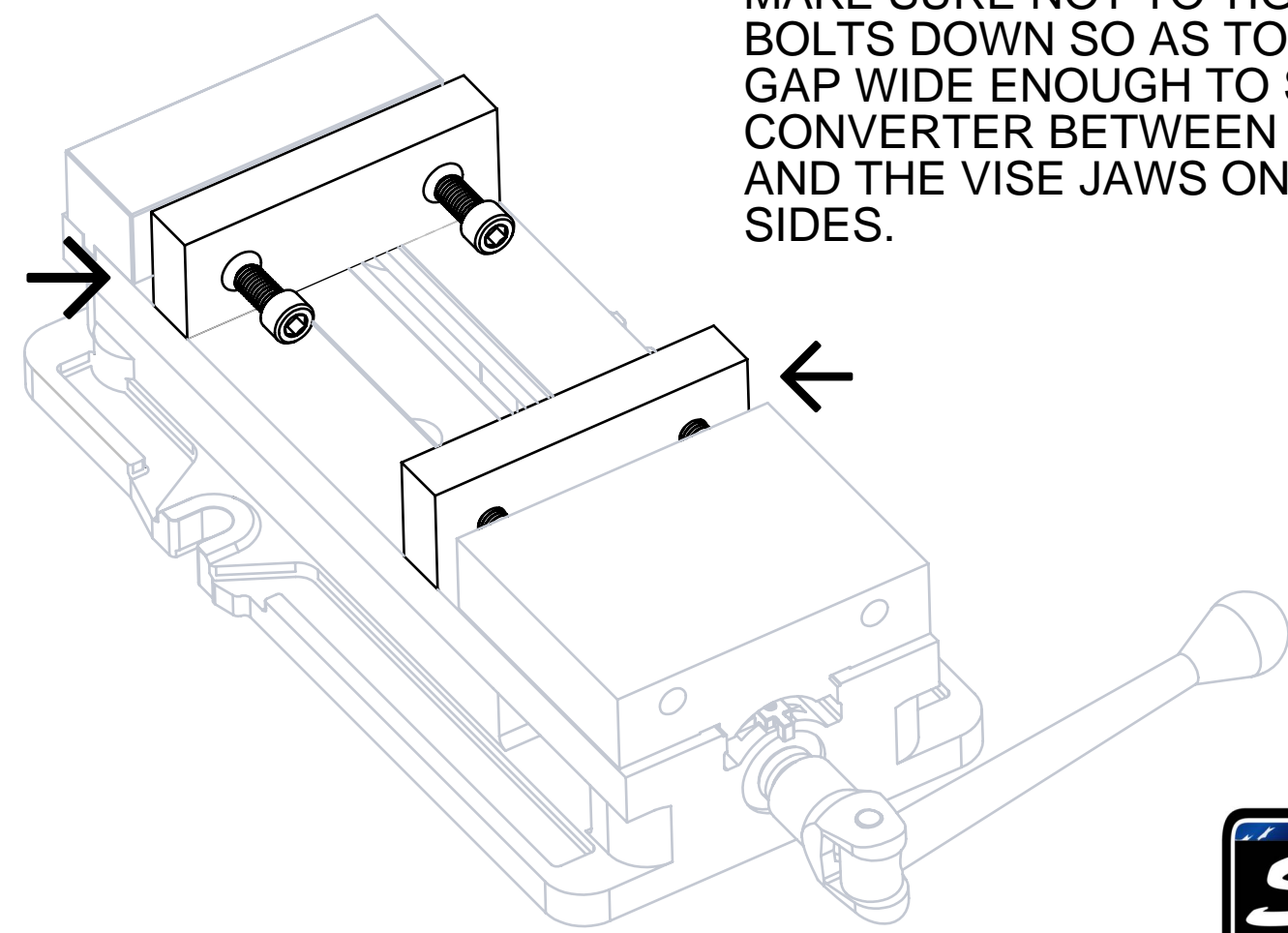
OPEN YOUR 4" VISE WIDE ENOUGH TO ACCEPT THE DOUBLE VISE CONVERTER (APPROXIMATELY 7 1/2").



STEP 2.

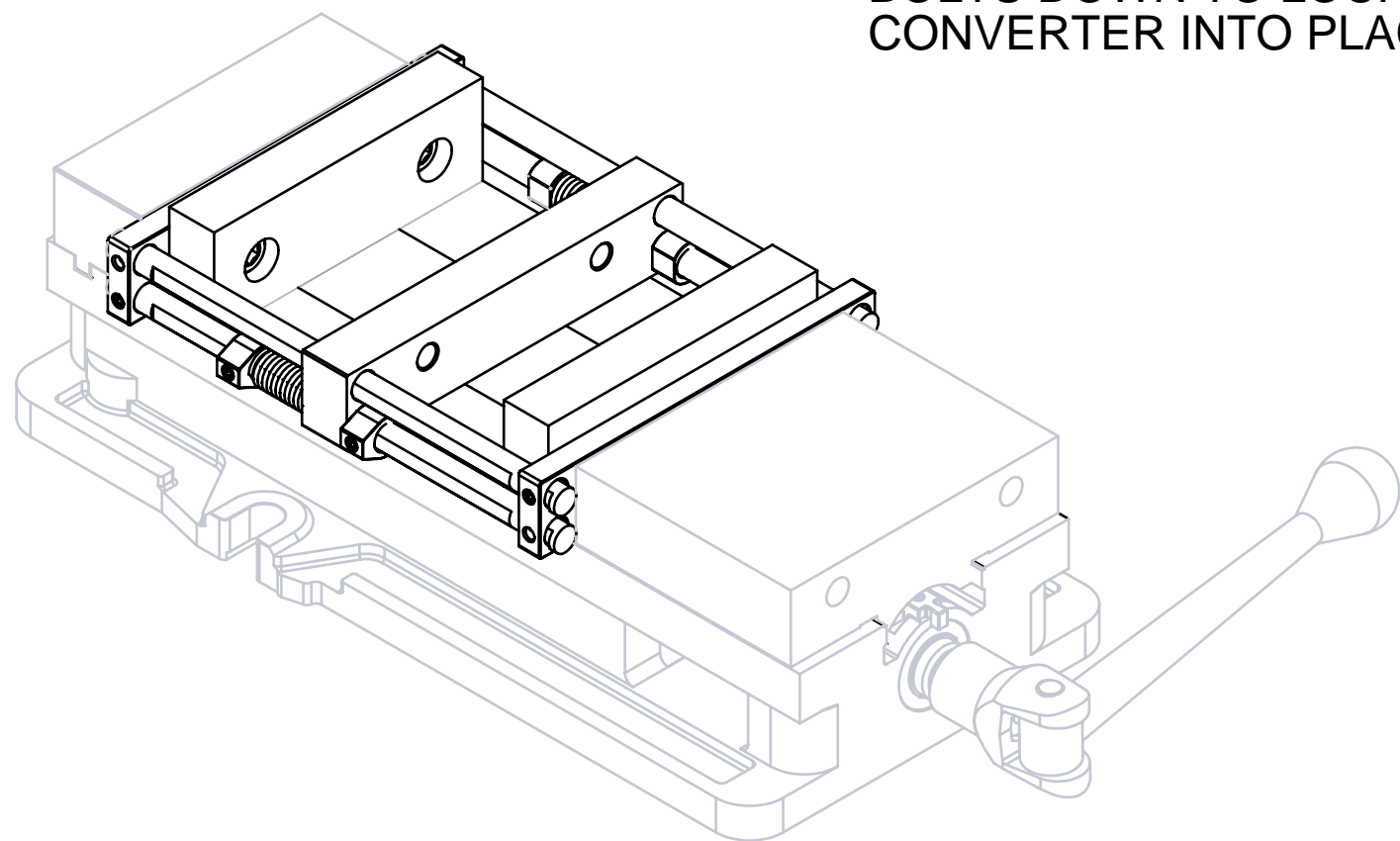
INSTALL YOUR OUTSIDE SET OF JAWS USING 3/8-16 X 1 1/2 BOLTS.

MAKE SURE NOT TO TIGHTEN THE BOLTS DOWN SO AS TO LEAVE A GAP WIDE ENOUGH TO SLIP THE CONVERTER BETWEEN THE VISE AND THE VISE JAWS ON BOTH SIDES.



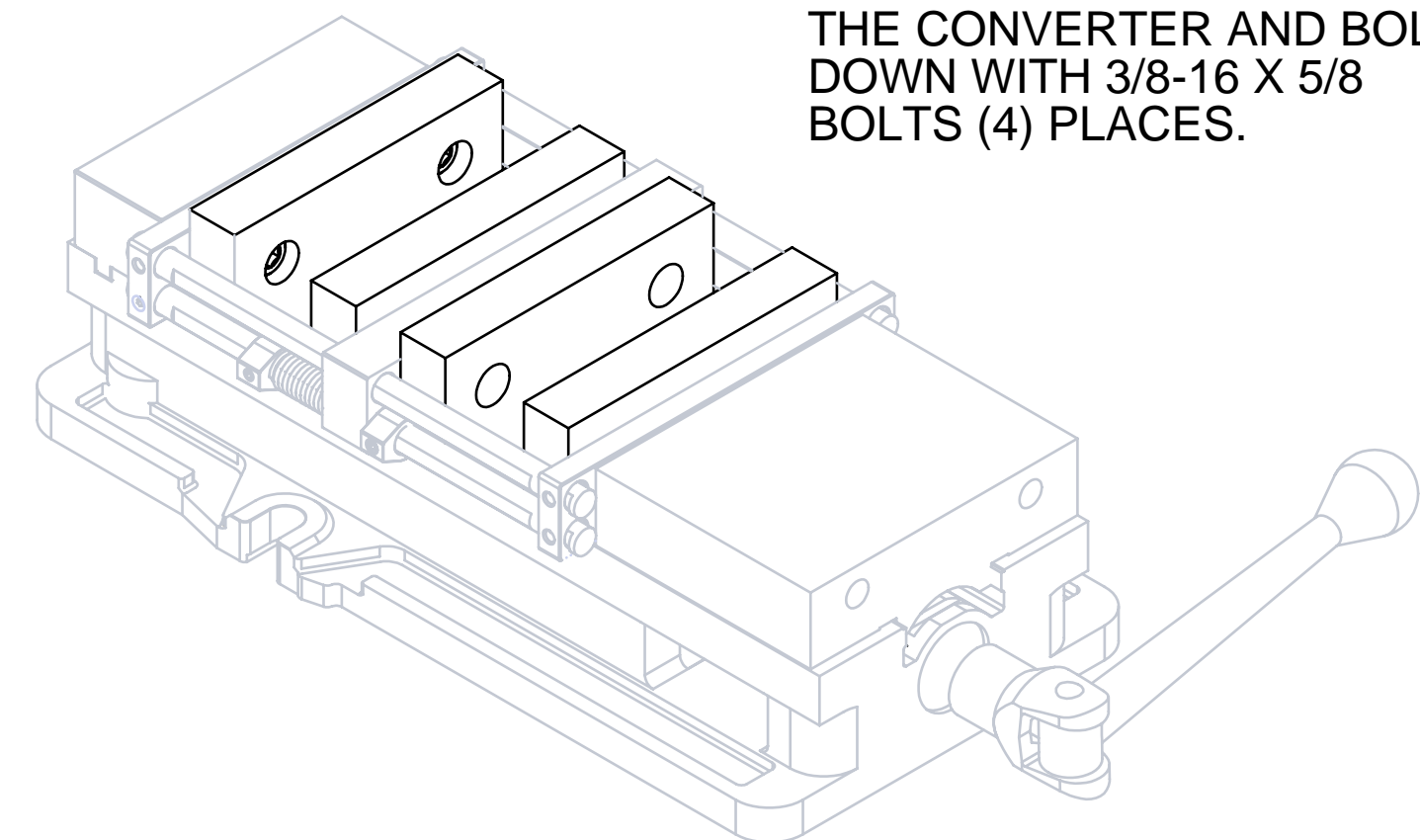
STEP 3.

TIGHTEN ALL (4) 3/8-16 X 1 1/2 BOLTS DOWN TO LOCK THE CONVERTER INTO PLACE



STEP 4.

ADD YOUR SET OF JAWS TO THE CENTER HARD JAW OF THE CONVERTER AND BOLT DOWN WITH 3/8-16 X 5/8 BOLTS (4) PLACES.



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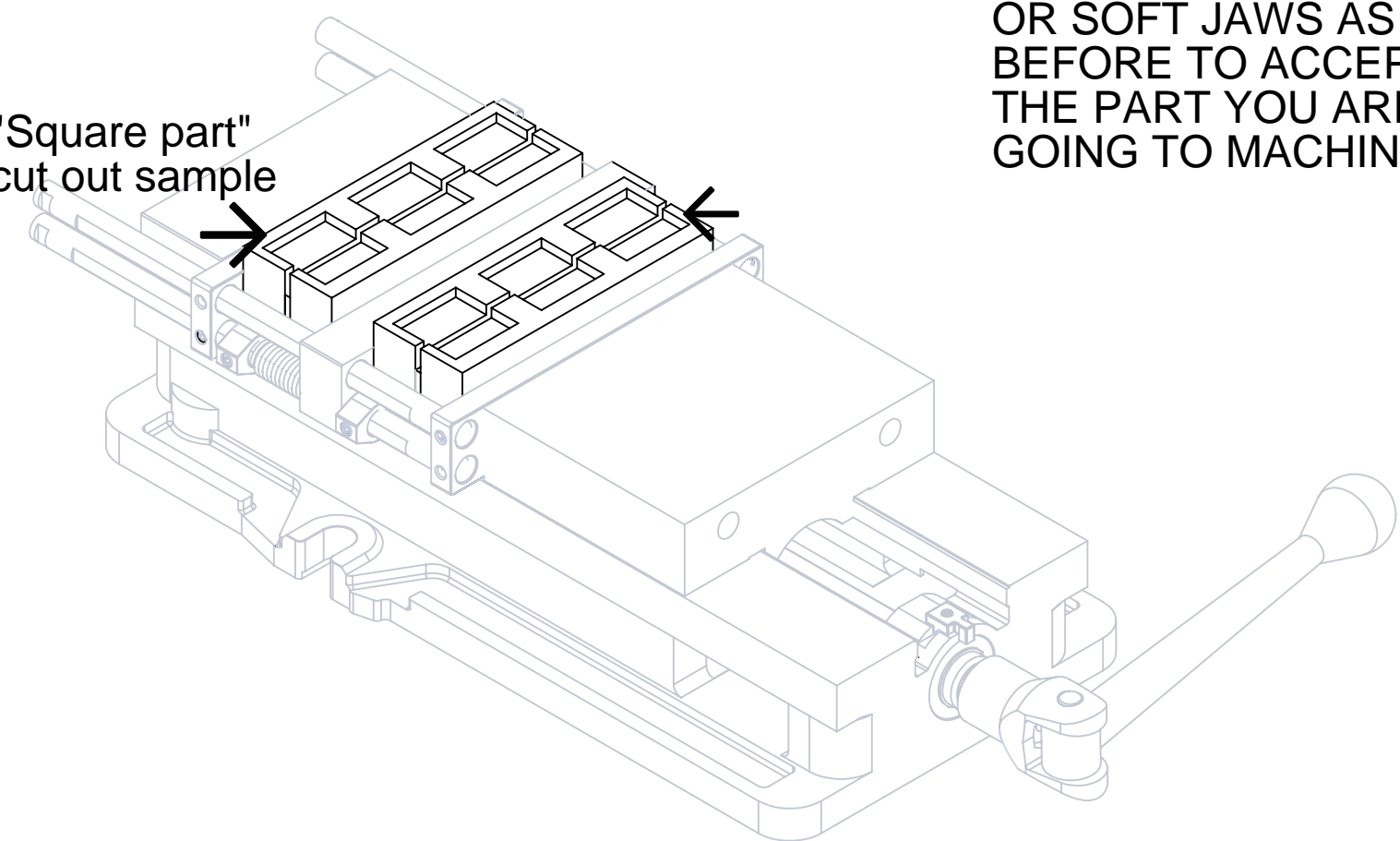
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STEP 5.

MACHINE YOUR HARD OR SOFT JAWS AS BEFORE TO ACCEPT THE PART YOU ARE GOING TO MACHINE.

"Square part" cut out sample



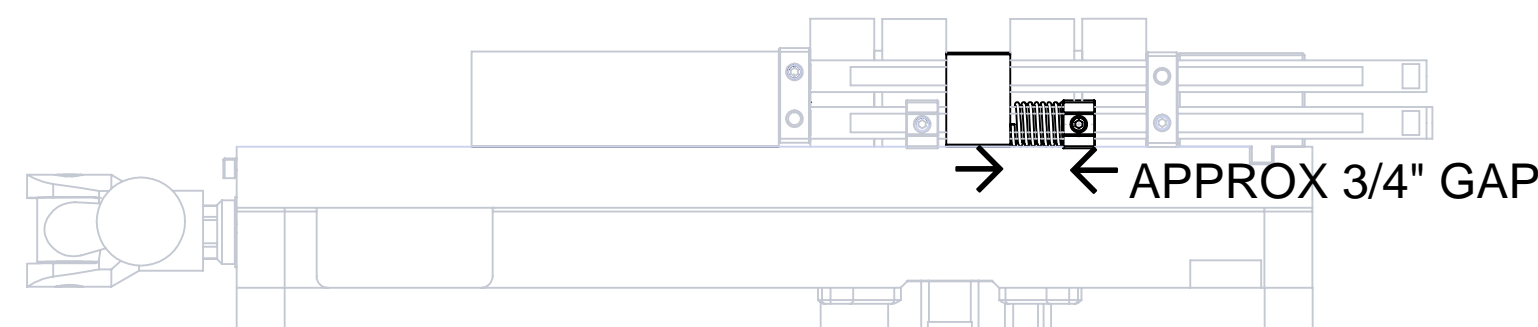
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STEP 6. SETTING THE STOPS ON THE DOUBLE VISE CONVERTER.

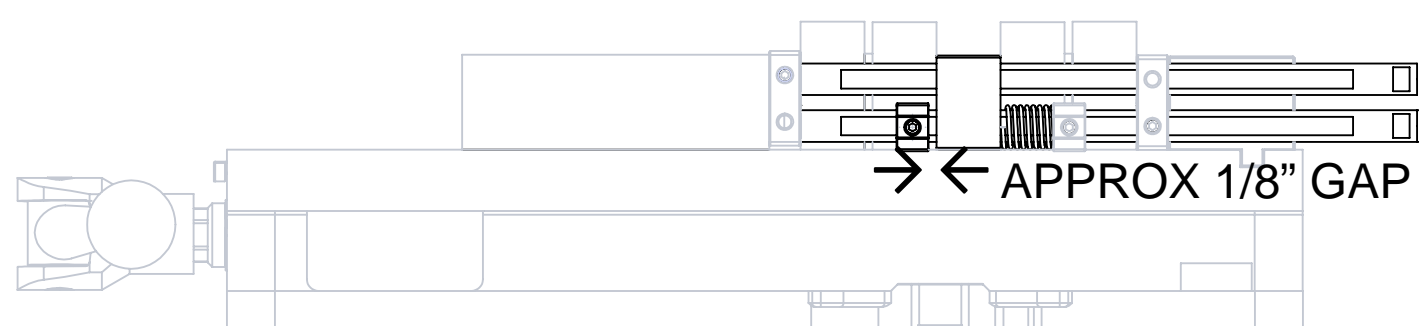
STEP 6A.

WITH THE VISE STILL CLOSED, SET THE (2) SPRING LOADED STOPS FIRST. MAKE SURE TO PUT TENSION ON THE SPRINGS BY PULLING THE STOPS TOWARD THE CENTER HARD JAW AND LEAVING APPROXIMATELY A 3/4" GAP BETWEEN THE STOP AND THE CENTER HARD JAW. LOCK DOWN THE SET SCREWS.



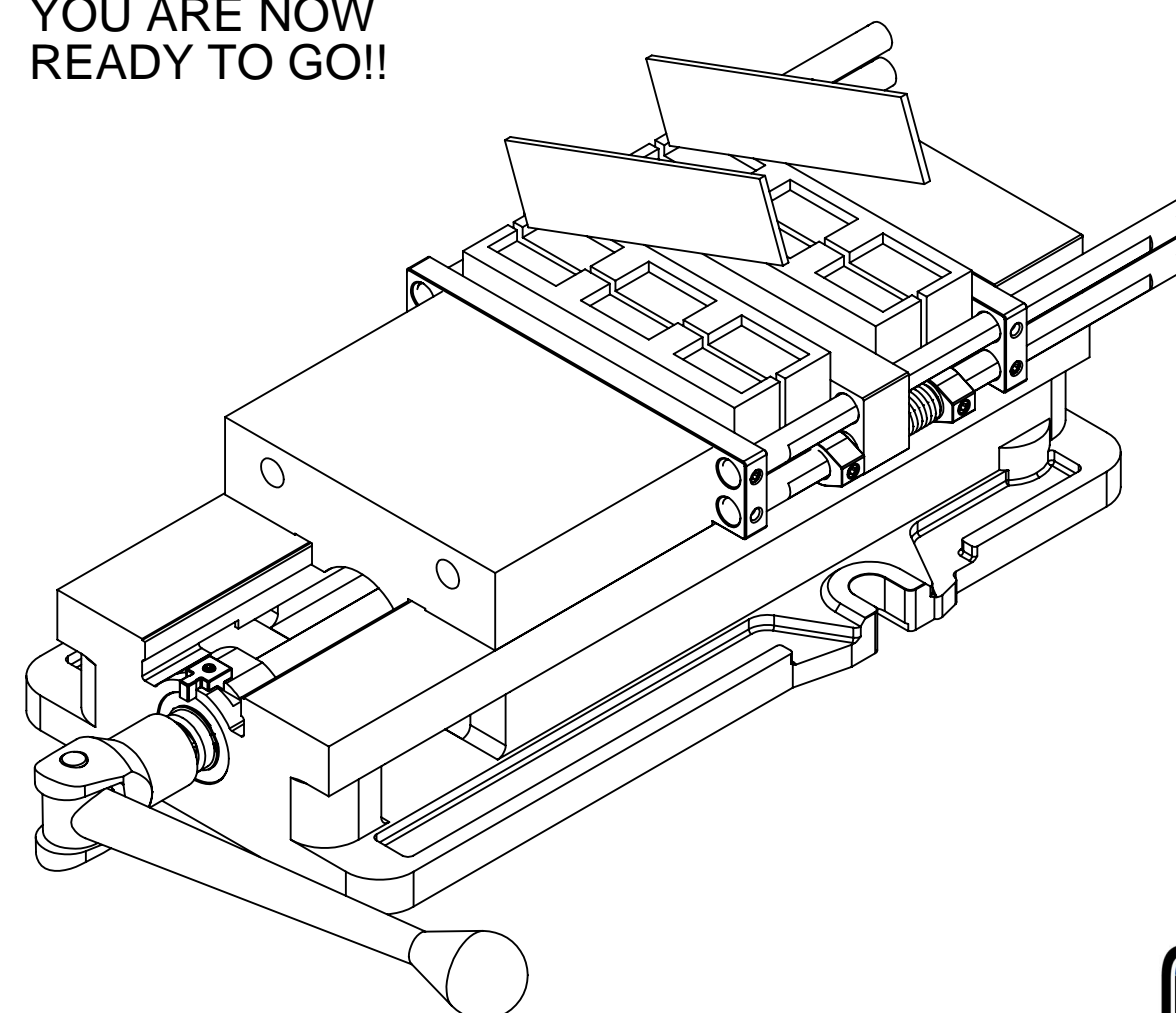
STEP 6B.

SET THE OTHER (2) STOPS BY LEAVING APPROXIMATELY A 1/8" GAP BETWEEN THE STOPS AND THE CENTER HARD JAW. LOCK DOWN THE SET SCREWS.



UNCLAMP YOUR VISE TO RELEASE YOUR PARTS OR PARALLELS AND YOU ARE NOW READY TO GO!!

STEP 7.



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