

**Specifications:**

Pipe Capacity: .....1/8" - 2 1/2"

Vise:

Weight .....32 lbs.

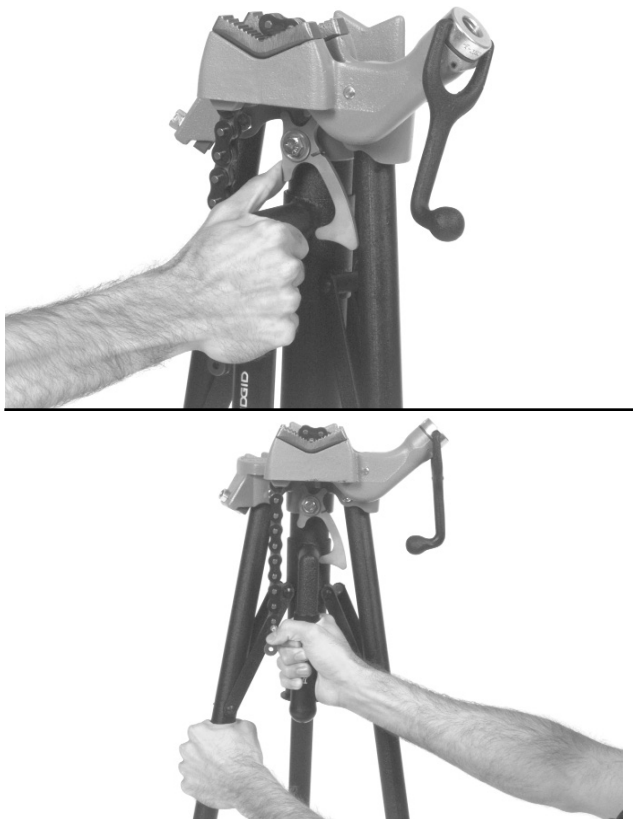
Height .....36.8 inches

**▲ WARNING** Do not use 425 Chain Vise with geared threaders. May result in vise tipping, causing serious injury.

**Operating Instructions:**

1. From folded, transport position, set the vise stand with legs touching the floor or ground surface.
2. Using thumb, rotate spring-loaded automatic-locking latch so carrying handle is free to move down center tube. Simultaneously, push down on horizontal portion of handle with one hand and pull on one of the three legs to facilitate opening of legs (*Figure 1*).

**▲ WARNING** Keep fingers clear of links and other moving parts.



**Figure 1 – Opening Vise Legs**

3. Continue pushing down on carrying handle until it locks over-center.

**NOTE!** Locking over-center requires more force than when simply opening the legs. Reference the maintenance section for adjusting this locking force.

4. Make sure pipe vise stand is stable and located on a level and firm surface. Ensure adequate space to freely move around stand.

5. Load pipe into vise and tighten chain around pipe using clamp lever. Do not use a handle extension to tighten chain. Use one or more pipe supports if pipe extends more than three (3) feet beyond base.

**▲ WARNING** Failure to properly support pipe can result in vise tipping or pipe falling.

6. End of pipe should be positioned so that it is not more than (9) inches from the front jaw of the vise. Do not use handle extensions on tools used to work the pipe.

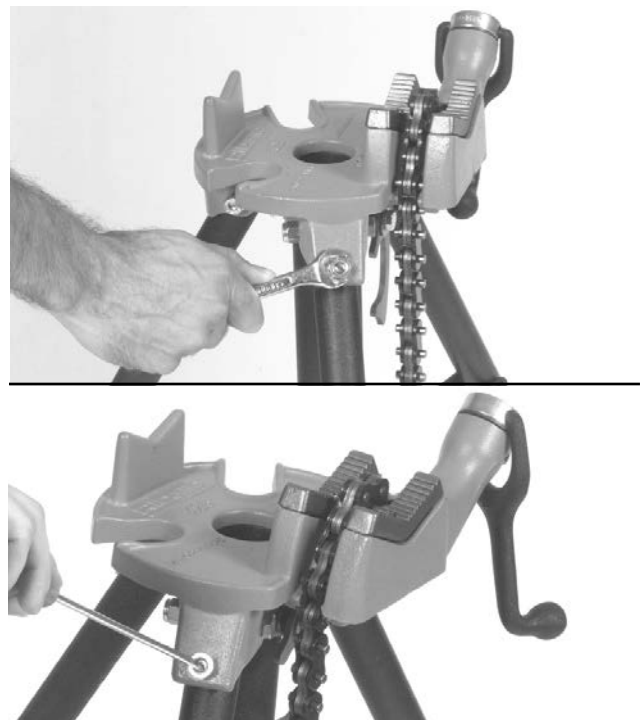
**▲ WARNING** Failure to follow these instructions may result in the vise tipping or the chain breaking resulting in serious injury.

**Maintenance:**

1. Keep all moving parts well lubricated and free from rust and other foreign matter that may cause binding.
2. Inspect vise stand on a routine basis for any broken or damaged parts. Clean the teeth of the jaw with a wire brush to remove dirt. Replace jaw if teeth are worn to prevent pipe slippage. Inspect chain for separation of the links or any other damage. This indicates the chain has been over-stressed and should be replaced.

**▲ WARNING** Failure to replace the chain can result in chain failure and serious injury.

3. If stands legs become loose (over-center locking force of carrying handle diminishes), adjust by performing the following:
  - (A) Loosen lock-nut located on leg (*Figure 2 - left of chain vise when looking at front of base*).
  - (B) Turn screw clockwise in increments of 1/8 turn until desired over-center locking force is achieved.
  - (C) Tighten lock-nut.



**Figure 2 – Adjusting Leg Stiffness**

**Transporting:**

1. With workpiece removed from the vise, lift up on carrying handle (releasing over-center locking mechanism) until spring-loaded, automatic-locking latch engages boss carrying handle (*Figure 3*).

NOTE! The legs simultaneously fold-up as carrying handle is lifted.

2. Position hand on carrying handle to achieve optimum balance during transport.

**▲ WARNING** Keep fingers clear of links and other moving parts.



Figure 3 – Transporting Vise

