

Conversion Kit Assembly – CT430 & CT640 Tower Versions

Refer to the Conversion Kit Assemble Sketch at the bottom of this page.

USE CAUTION WHEN HARDENING CHIP GUARD MATERIAL. EDGES AND CORNERS ARE SHARP AND MAY CAUSE PERSONAL INJURY IF NOT HANDLED PROPERLY.

To convert the double station vise over to a single station follow these instructions.

1. Close vise far enough to allow mounting the conversion plate to the underside of the lower movable jaw using ½-13 cap screws. Wipe all surfaces clean prior to assembly.
2. Now open the vise until the convertible plate mounted to the movable jaw makes contact with the base plate. Install bolts to fasten the convertible plate to the base plate. This jaw is now stationary.
3. Loosen cap screws holding the stationary jaw in place and remove the stationary jaw from the vise body. Note that the stationary jaws and the body are stamped with a letter code witch denotes a matched fit condition. When reinstalling the stationary jaws make certain that the letter on the jaw matches the letter stamped in the body slot. This marking is in the bottom of the stationary slot on the tower body.
4. Remove the standard chip guards and keep with stationary jaw. Depending on the desired vise opening, cut the supplied chip guard to desired length and install.

Note: This type of vise setup should not be used as a self centering vise.

