

The following procedure explains how to replace the plastic chain cover on a twin-screw vise purchased prior to 2001 with this aluminum one.

Note: If you have purchased a twin-screw vise with an aluminum cover, please ignore these instructions. Follow instead the instructions contained with the complete vise.

- 1. Remove the plastic cover** – Use a #2 Phillips screwdriver to remove the screws holding the plastic cover in place. Discard the plastic cover and screws as these will no longer be needed.
- 2. Check jaw height** – To accommodate the aluminum cover, the thrust plates must be oriented vertically as shown in **Figure 1**. If they are not, remove the screws holding them in place, rotate the thrust plates as required and reinstall the securing screws. There must be at least $\frac{3}{8}$ " from the bottom edge of the thrust plates to the bottom of the front vise jaw. If there is, skip ahead to step 7. If not, the bottom surface of the front jaw will need to have a $\frac{3}{8}$ " thick extension piece added as explained in steps 3 to 6. Though not necessary, adding a second strip to the bottom surface of the rear jaw will leave a deeper and constant jaw height.

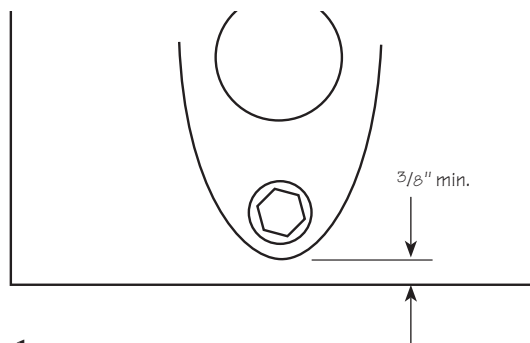


Figure 1

- 3. Make extension piece(s)** – If you are fitting the aluminum cover to a Veritas workbench (that does not have side skirts), mill one (or two) pieces of maple (or other similar hardwood) to the size shown in **Figure 2**. If you are fitting the cover to a vise with jaws **not** made by Veritas, measure the jaws and mill the piece(s) $\frac{3}{8}$ " thick and $\frac{1}{4}$ " larger in each horizontal dimension.

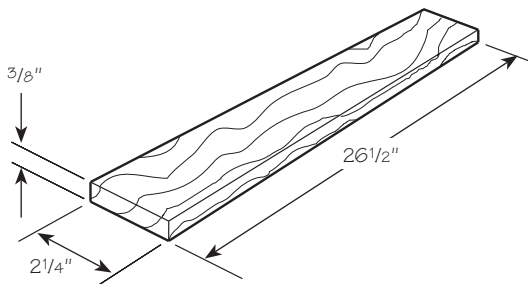


Figure 2

- 4. Drill dog clearance holes** – For jaws containing dog holes, it is much easier to transfer these to the extension piece(s) before being fastened to the jaw. Transfer the hole locations to the extension piece(s) you have just milled to size and drill $\frac{7}{8}$ " to 1" clearance holes as required. Keep in mind that these holes are oversized so their exact position is not critical.
- 5. Laminate extension piece(s) into place** – Before gluing the extension piece(s) into place, be sure to prepare the bottom edge(s) of the jaw(s). If there is an applied finish, or dirty or rough surface, scrape or plane the bottom edge clean and smooth. With the extension piece(s) oriented so the dog holes remain clear, glue and clamp them into place with a one-part white or yellow glue (PVA type I or II).
- 6. Trim to size** – Allow the glue to set, then cut the extension piece(s) flush with the jaw(s). The ends are easily trimmed with a flush-cut saw, and a block plane can be used for the long grain. Alternatively, a router set up with a flush-trimming bit, such as commonly used on countertop laminate, may be used to trim all overhanging edges. Sand the edge of the new piece(s) smooth and finish to match the main portion of each jaw.
- 7. Install the aluminum cover*** – Hold the two end caps in place over the ends of the main cover as shown in **Figure 3**. The flange on the end caps should overlap the main cover by their width (approximately $\frac{1}{4}$ "). With a third hand (supplied by a friend or family member), mark the four screw hole locations onto the front jaw. Put the end caps and main cover aside and drill $\frac{5}{32}$ " pilot holes for the mounting screws, $\frac{3}{4}$ " to 1" deep. Secure one end cap with two screws, but do not tighten them fully. Slip one end of the main cover under this end cap, followed by holding the other end cap over the opposite end of the main cover. Install the remaining two screws and tighten all.

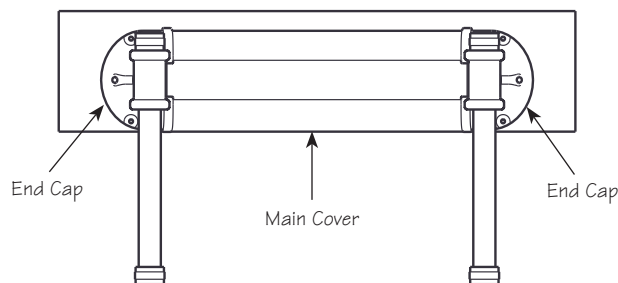


Figure 3

** If your vise has Veritas-made jaws, or you installed your vise with the full length of chain originally supplied, the standard-length main cover (05G12.23) will fit without requiring modification. However, if the vise jaws are shop made and the vise screw center-to-center distance is smaller than $16\frac{7}{8}$ ", the main cover will have to be cut. A hacksaw can be used, but take care not to distort the cover when holding it in a vise or clamping it to a bench top while cutting.*

The long main cover (05G12.24), which can also be cut shorter as needed, is for vise screws with a center-to-center distance greater than $16\frac{7}{8}$ " (but up to 24"). The 53" long chain supplied with this cover is required only for first-time vise installation.