

The Veritas® Inset Vise is similar to a wagon vise in function, but in a compact, self-contained form for easy installation in a work surface, adding a permanent, adjustable dog right where it is needed.

Designed to hold work between its single jaw and an external stop such as a bench dog, it has a clamping capacity that is limited only by the size and dog-hole spacing of your work surface. The knurled stainless-steel toggle handle turns a $\frac{1}{2}$ " diameter Acme-threaded steel rod to move the jaw in a 4" range of travel. The $\frac{1}{2}$ " tall, $\frac{13}{16}$ " wide jaw has two jaw-mounting positions spaced $\frac{37}{8}$ " apart, for compatibility with dog-hole spacing up to $7\frac{3}{4}$ ". A keyway in the jaw face accepts a #10 nut for affixing custom shop-built jaws. When the vise is not in use, the jaw can be removed whenever you need an unobstructed work surface.

The complete vise is $10\frac{3}{4}$ " long, 3" wide and $\frac{29}{32}$ " deep, and can be installed in any workbench that is at least $1\frac{1}{4}$ " thick.

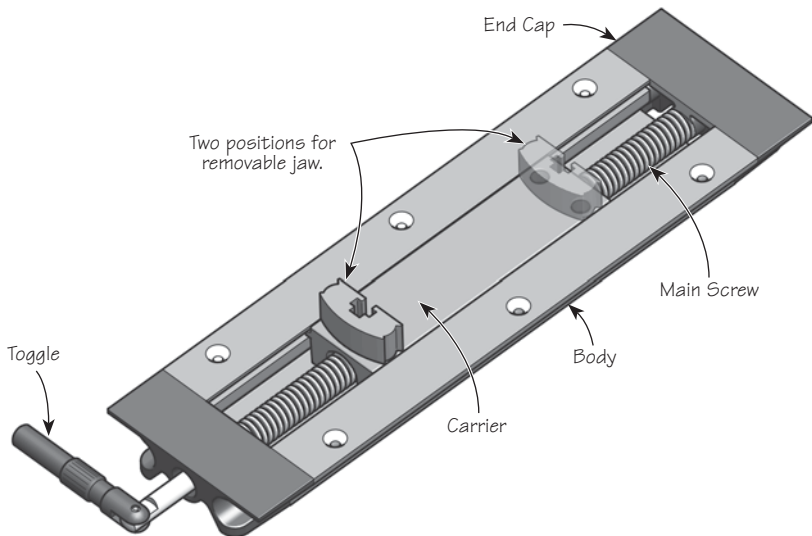


Figure 1: Inset vise parts.

Installation

To install the inset vise, a suitable cavity will need to be cut out of the workbench top. The vise can be located anywhere on the edge of the workbench to suit the required clamping needs. Typically, this would be in line with the dog-hole matrix (as shown in **Figure 2**), but this is not required.

Note: In this installation, the dog holes must be minimum $1\frac{1}{2}$ " offset from the edge of the workbench.

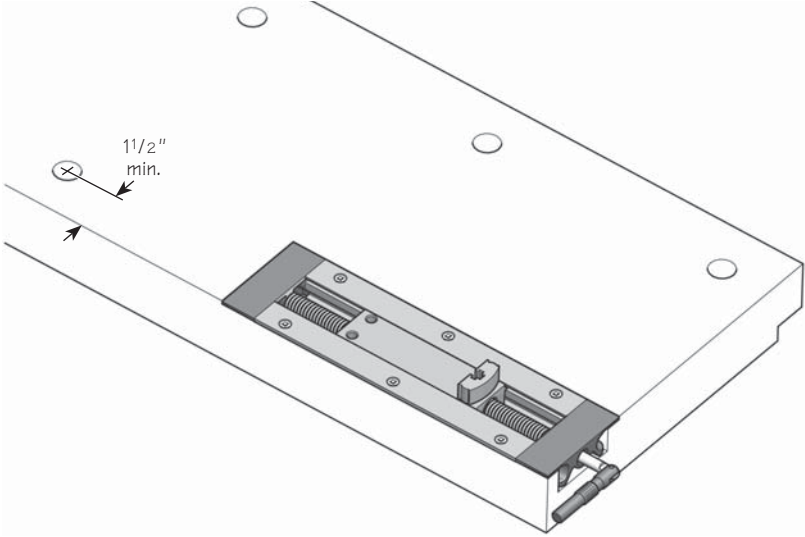


Figure 2: Inset vise installed in line with dog holes.

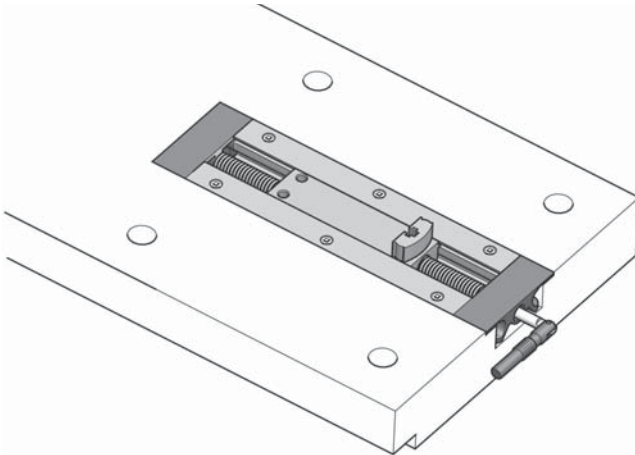


Figure 3: Inset vise mounted in the middle of the edge of the workbench.

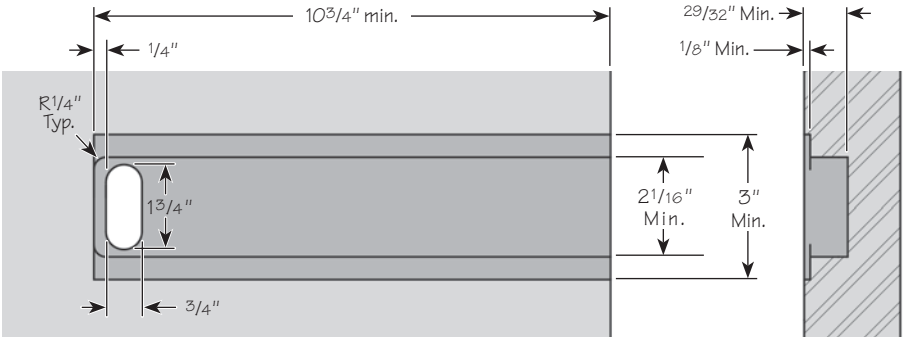


Figure 4: Inset vise cavity dimensions.

Note: The minimum bench thickness is 1 1/4". If a thinner bench is used, suitable reinforcing will need to be added in order to maintain the strength of the bench.

When laying out the location for the vise, ensure that the mounting screws will not run through any glue joints in the workbench slab.

Begin by cutting out the main body cavity (minimum 2 1/16" wide, 29/32" deep and 10 3/4" long, as shown in **Figure 5**). The corners of this cavity do not need to be square, and can have a maximum 1/4" radius (as would be created if a 1/2" router bit had been used to cut the cavity).

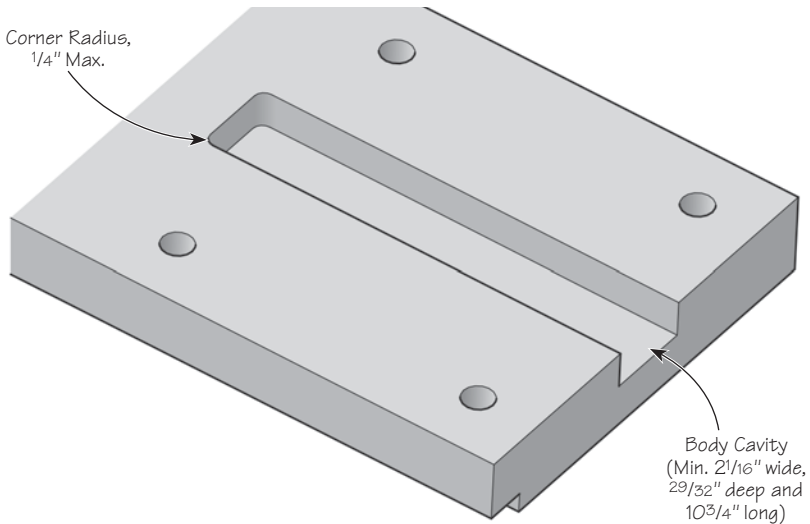


Figure 5: Cutting the main body cavity.

Next, cut the wing cavity minimum 3" wide, 1/8" deep and 10 3/4" long, centered on the body cavity. A depth of 1/8" should create a flush mount for the vise.

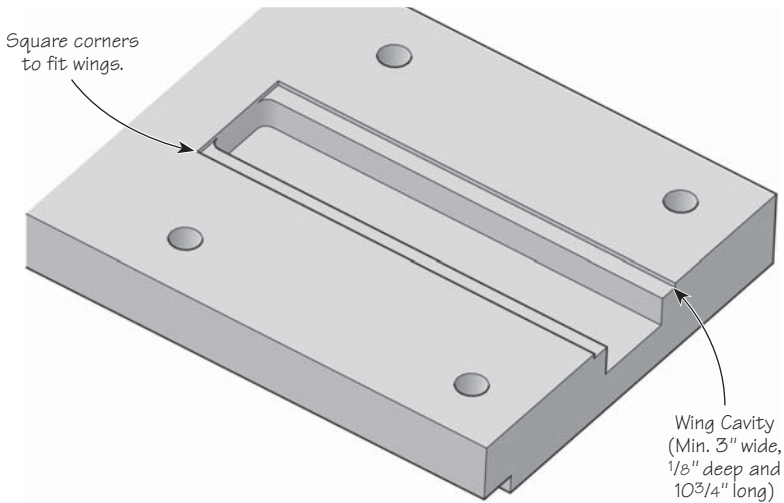


Figure 6: Cutting the wing cavity.

Unlike the body cavity, the wing cavity will need to have the corners squared in order to fit.

At the end of the body cut-out, cut a 3/4" wide by 1 3/4" long slot completely through the workbench (see **Figure 7**). This slot will allow chips and debris to be swept out of the inset vise.

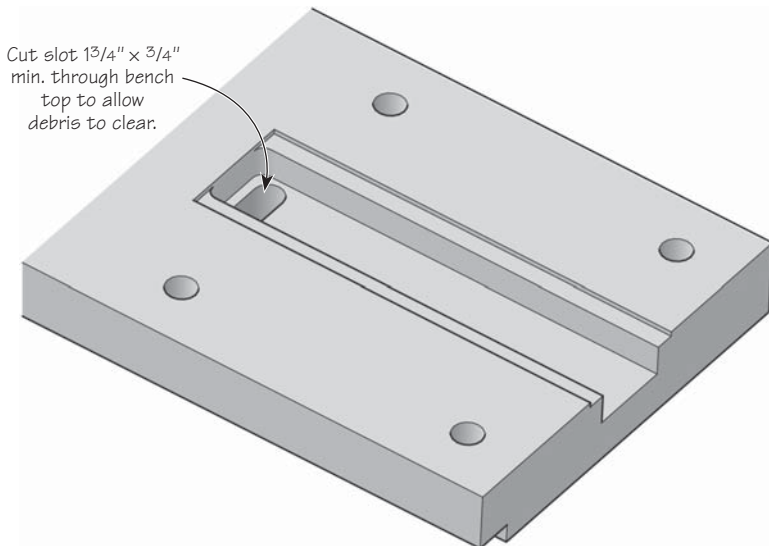


Figure 7: Debris clearing slot.

Test fit the inset vise and transfer the mounting screw-hole locations using a center punch. Drill out appropriate pilot holes for the #8 screws ($1/8''$ in softwood, $5/32''$ in hardwood). Install the inset vise with the six included #8 \times 1" flat-head screws.

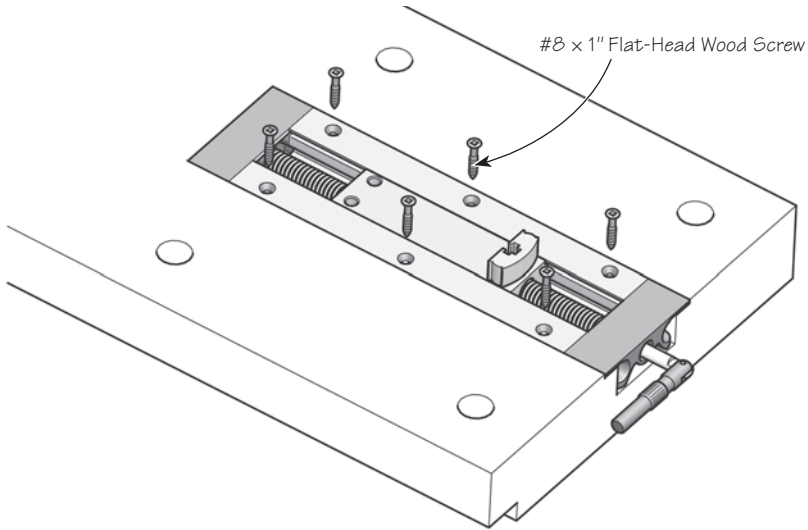


Figure 8: Final installation.

Maintenance

Once installed, the inset vise should be relatively maintenance free. All that should be required is periodic clearing of debris from the two ends (the end caps have openings to facilitate this) and occasional lubrication of the main screw, if required.

Accessories

- 05G31.02** Replacement Jaw
- 05G31.03** Pivoting Jaw
- 05G31.04** Low-Profile Jaw