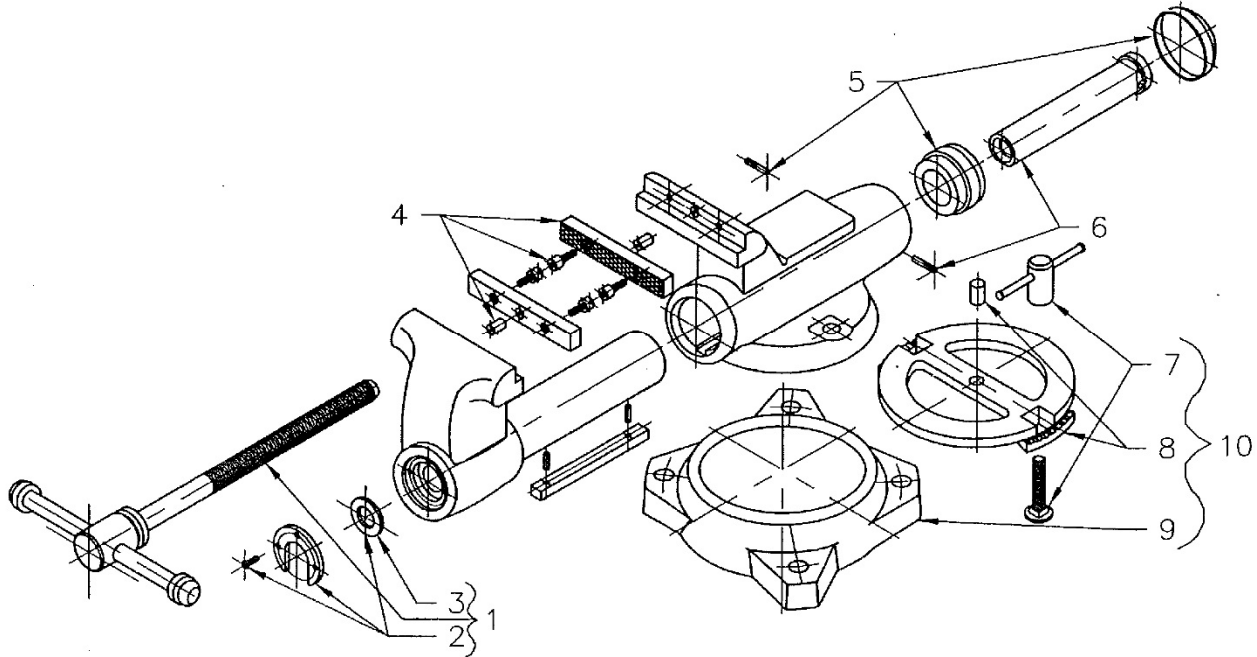




## #28831, 4-inch Swivel Base Machinist Vise (model 400S)



### Replacement parts

Item	Part No.	Description
1	2900020	Spindle Assembly Complete
2	2904010	Spindle Retainer (with 3 screws and #3)
3	---	Thrust Washer ( <i>not available separately</i> )
4	2904980	Serrated Jaw Inserts with 4 screws
5	2900080	End Piece Assembly Complete, with 2 pins
6	2900120	Casing Nut with 2 pins
7	2904270	Lock Nut Assemblies
8	1010810	Inner Ring with Dowel Pin
9	1011980	Outer Ring only
10	2904120	Swivel Base Assembly Complete (includes #7,8,9)

### Specifications

Stock no.	<b>28831</b>
Model no.	400S
Jaw width	4 in. (102 mm)
Jaw opening	6-1/2 in. (165 mm)
Throat depth	3-1/2 in. (89 mm)
Net weight	62 lbs. (28 kg)



## IMPORTANT SAFETY INSTRUCTIONS

- Misuse of vise can cause serious injury to eyes, hands, limbs, etc.
- To ensure safety, vise must be set up and used properly.
- Before setting up and using, read, understand, and follow all instructions as outlined below.

When setting up vise:

- Use proper size bolts, nuts, lock and flat washers, in all base mounting Holes. Never weld base of vise to any metal object.
- Only hand-tighten swivel base lock down nuts at the sides of the vise.
- Never use a pipe extension to tighten lock nut handles; this can cause the handles to bend and overstress the lock down bolts.
- Make sure the bench top to which the vise is mounted is properly secured.

When using vise:

- Always use vise of proper size and capacity to hold work object.
- Never use a hammer, pipe extension or cheater bar on spindle handle of vise.
- Never unscrew moveable jaw beyond the maximum specified opening of the vise.
- Never use vise as a press for assembly or disassembly of objects.
- Always wear eye and face protection when striking vise-held objects or when using power tools with a vise.
- NOTE: The spindle handle ("tommy bar") has been engineered to bend if excessive clamping pressure is applied, to prevent potential damage to vise.



**WARNING:** This product can expose you to chemicals including titanium dioxide which is known to the State of California to cause cancer.



# #28831 Model 400S Machinist Vise Mounting Template

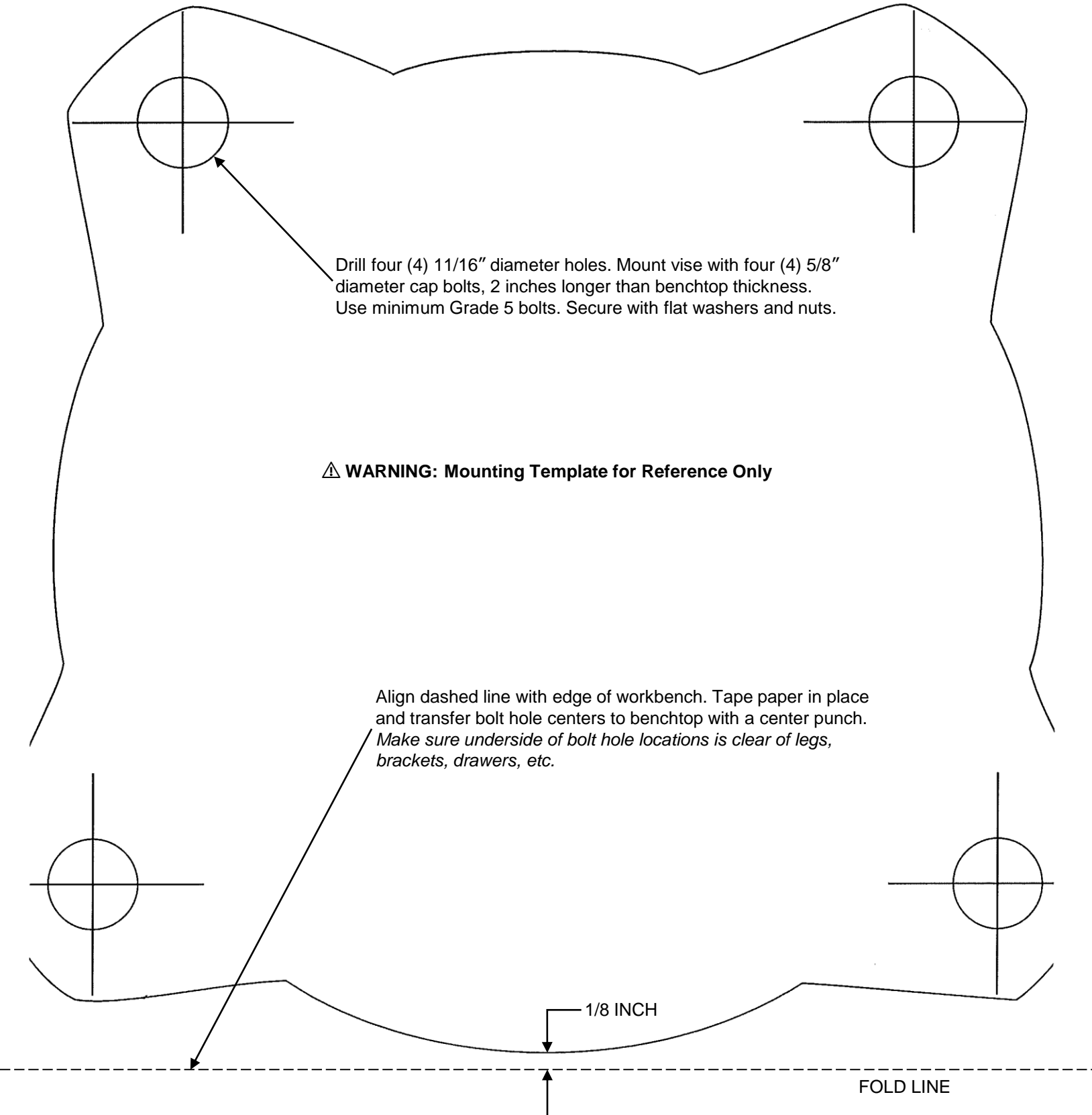
Drill four (4) 11/16" diameter holes. Mount vise with four (4) 5/8" diameter cap bolts, 2 inches longer than benchtop thickness. Use minimum Grade 5 bolts. Secure with flat washers and nuts.

**⚠ WARNING: Mounting Template for Reference Only**

Align dashed line with edge of workbench. Tape paper in place and transfer bolt hole centers to benchtop with a center punch. *Make sure underside of bolt hole locations is clear of legs, brackets, drawers, etc.*

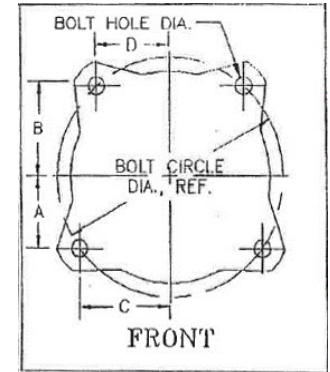
1/8 INCH

FOLD LINE





## Bullet Bench Vise Mounting Dimensions



	Stock No.	Model	Base Outer Ring Part No.	Dimension A (in.)	Dimension B (in.)	Dimension C (in.)	Dimension D (in.)	Bolt Circle Diameter (in.)	Bolt Hole Diameter (in.)	Mounting Bolt Diameter (in.)
Combo Pipe & Bench	28825	C0	1011990	2 3/16"	2 7/8"	3 1/16"	2 7/16"	7 1/2"	9/16"	1/2"
	28826	C1	1011980	2 9/16"	3 5/16"	3 9/16"	2 13/16"	8 3/4"	11/16"	5/8"
	28827	C2	1010840	2 13/16"	3 3/4"	4 "	3 1/8"	9 3/4"	11/16"	5/8"
	28828	C3	1011080	3 1/2"	4 3/8"	4 1/2"	3 5/8"	11 3/8"	11/16"	5/8"
Machinist	28830	300S	1012010	1 7/8"	2 7/16"	2 9/16"	2 1/16"	6 3/8"	7/16"	3/8"
	28831	400S	1011980	2 9/16"	3 5/16"	3 9/16"	2 13/16"	8 3/4"	11/16"	5/8"
	28832	500S	1011980	2 9/16"	3 5/16"	3 9/16"	2 13/16"	8 3/4"	11/16"	5/8"
	28833	600S	1010840	2 13/16"	3 3/4"	4 "	3 1/8"	9 3/4"	11/16"	5/8"
	28834	800S	1011080	3 1/2"	4 3/8"	4 1/2"	3 5/8"	11 3/8"	11/16"	5/8"
Tradesman XC	28840	1745XC	1011990XC	2 3/16"	2 7/8"	3 1/16"	2 7/16"	7 1/2"	9/16"	1/2"
	28841	1755XC	1011980XC	2 9/16"	3 5/16"	3 9/16"	2 13/16"	8 3/4"	11/16"	5/8"
	28842	1765XC	1011980XC	2 9/16"	3 5/16"	3 9/16"	2 13/16"	8 3/4"	11/16"	5/8"
	28843	1780XC	1010840XC	2 13/16"	3 3/4"	4 "	3 1/8"	9 3/4"	11/16"	5/8"
Tradesman	28805	1745	1011990	2 3/16"	2 7/8"	3 1/16"	2 7/16"	7 1/2"	9/16"	1/2"
	28806	1755	1011980	2 9/16"	3 5/16"	3 9/16"	2 13/16"	8 3/4"	11/16"	5/8"
	28807	1765	1011980	2 9/16"	3 5/16"	3 9/16"	2 13/16"	8 3/4"	11/16"	5/8"
	28808	1780A	1010840	2 13/16"	3 3/4"	4 "	3 1/8"	9 3/4"	11/16"	5/8"