



Buehler, An ITW Company

Worldwide Headquarters

📍 41 Waukegan Road, Lake Bluff, Illinois, 60044 USA

☎ +1.847.295.6500 | 800-BUEHLER

✉ info@buehler.com

🌐 www.buehler.com

INSTRUCTIONS – IS103593

Quick Sliding Vise – CAM Shaft Replacement

Safety Information

Carefully read and understand the contents of this instruction sheet. Improper operation, handling, or maintenance can result in equipment damage or personal injury.

Tools Needed:

- Screwdriver (Phillips and Flathead)
- Grease
- Hex Key Set



CAUTION: Wear Eye Protection, flying debris can cause severe eye injury.



I. Replacing the CAM-Shaft

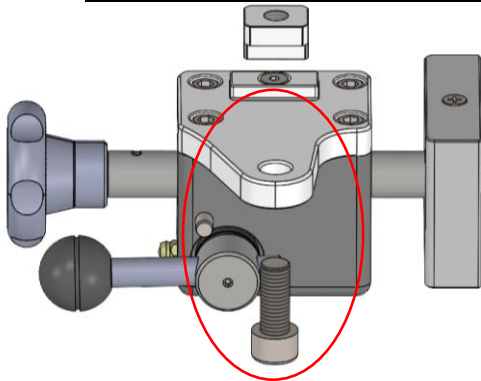


Figure 1: Removing T-nut bolt

1. Unscrew the T-nut bolt by hand then place the screw/T-nut to the side.

Note: Ensure to keep all nuts and bolts nearby for later re-assembly.

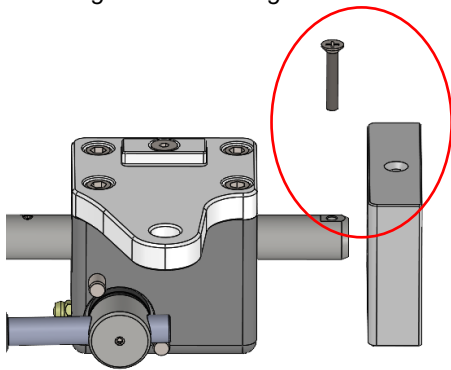


Figure 2: Removing sliding jaw block

2. Use a Phillips head screwdriver to remove the screw from the sliding jaw block then remove the sliding jaw block.

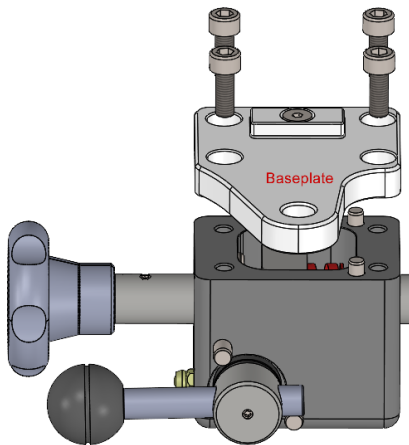


Figure 3: Removing baseplate

3. Remove the four bolts on the baseplate with a 5mm hex wrench.

Note: Use a rubber hammer to remove the baseplate if it is difficult to remove.



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Warning: Removing the sliding jaw block shaft exposes the inner spring. Wear eye protection and angle the vise away from the body/face whenever the spring is exposed.

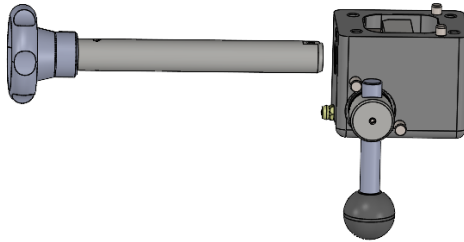


Figure 4: Removing jaw block shaft

4. Rotate the CAM-locking handle so it is vertical and unlocked (*Figure 4*) and pull out the sliding jaw block shaft.

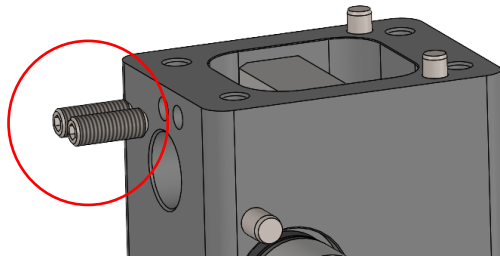


Figure 5: Removing set screws

5. Remove the two set screws with a 3mm hex wrench.

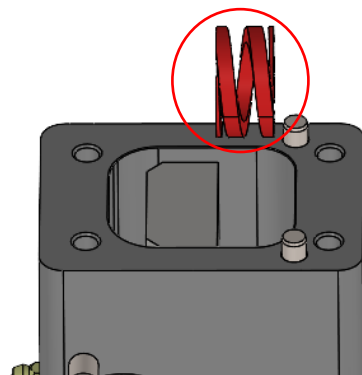


Figure 6: Removing spring

6. Remove the spring with a screwdriver/elongated tool.

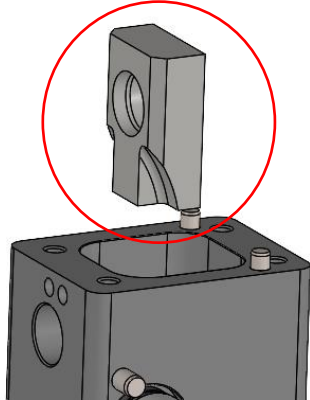


Figure 7: Internal locking block removal

7. Remove the internal locking block from the vise body by hand.

Note: Keep note of the correct orientation of the internal locking block (*Figure 7*) for re-assembly.

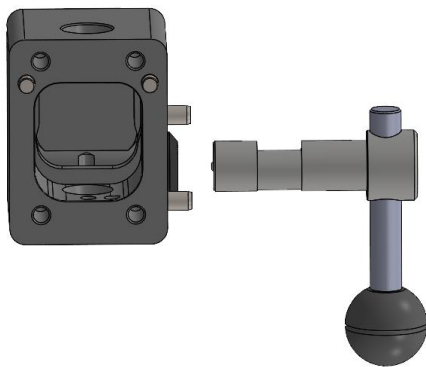


Figure 8: CAM shaft removal

8. Pull out the CAM shaft.

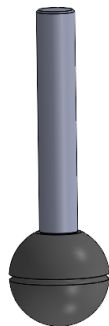
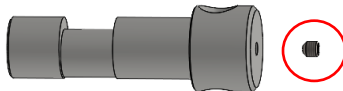


Figure 9: Set screw removal

9. Remove the set screw with a 2.5mm hex key and remove the CAM-locking handle.



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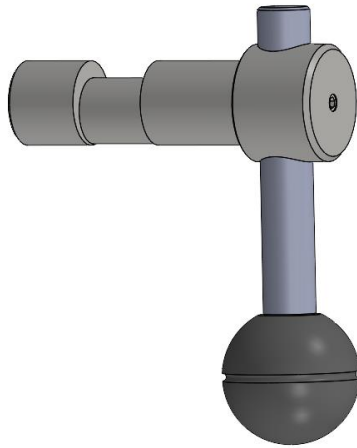


Figure 10: Reinstalling CAM-shaft

10. Replace the CAM shaft and insert the handle into the replacement CAM shaft. Reinstall the set screw to secure the handle to the CAM shaft.

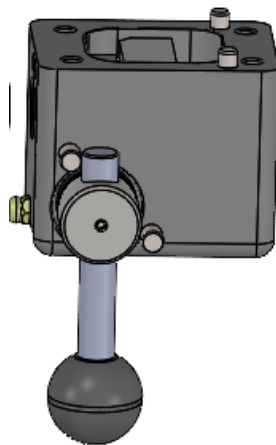


Figure 11: Reinstalling CAM-shaft

11. Insert the CAM-shaft assembly into the housing and rotate the handle to the unlocked position (*Figure 11*).

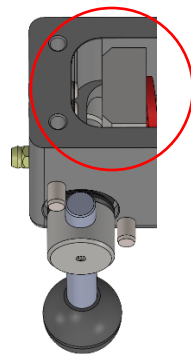


Figure 12: Inserting internal locking block

12. Set the internal locking block into the housing beside the CAM shaft in the correct unlocked orientation (*Figure 12*).

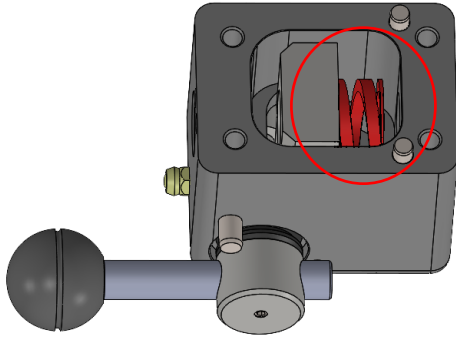


Figure 13: Reinstalling spring

13. Set the spring into the housing (*Figure 13*). Line up the central hole in the spring with the holes in both the internal locking block and vise body.

Note: The Set Screws will change this alignment in the next step.

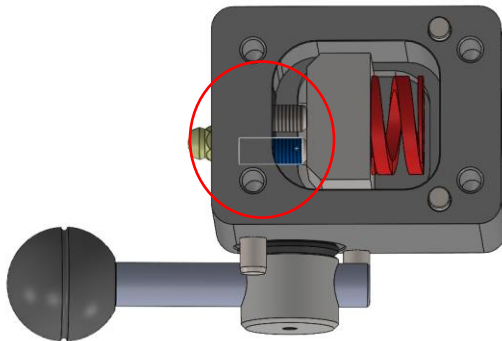


Figure 14: Tightening the set screws

14. Tighten the two set screws to push the internal locking block into the correct, vertical orientation.

Note: Overtightening the set screws may make it difficult to adjust the spring and internal locking block in later steps. Tighten the set screws only enough to put the internal locking block in the vertical position.



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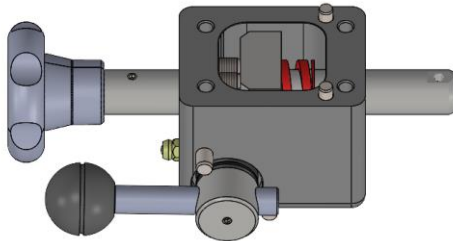


Figure 15: Installing moving jaw block shaft

15. Before re-installing the moving jaw block shaft, ensure the spring and internal locking block are aligned with both holes on the vise body.

This may require slight adjustment by using a screwdriver to push the spring or internal locking block into the correct position.

Insert the moving jaw block shaft through the vise body, internal locking block and spring.

Note: This may require a higher-than-normal effort if the internal locking block is not perfectly vertical or if the spring/internal locking block are not aligned properly. This is normal, Step 16 adjusts the vise to ensure the movement of the sliding jaw block shaft is fluid for normal use.

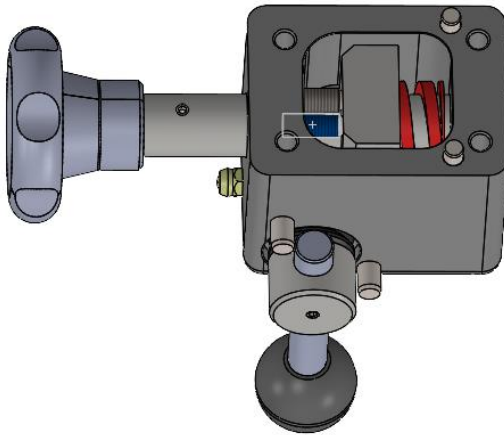


Figure 16: Installing sliding jaw block shaft

16. Ensure that the Cam-locking shaft is in the unlocked position.
Gradually adjust the two set screws until the sliding jaw block shaft can easily move in and out, this will signify that the screws have the correct tension.

17. Fill the housing with standard machine grease.

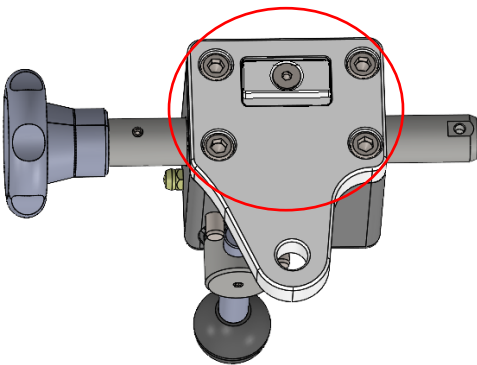


Figure 17: Reinstalling baseplate

18. Reinstall the baseplate and screw in the four bolts with a 5mm hex wrench.

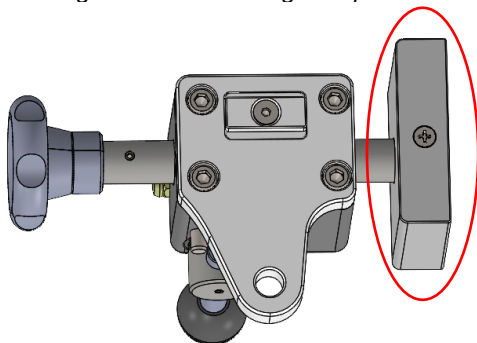


Figure 18: Reinstall sliding jaw block

19. Reinstall the sliding jaw block onto the sliding jaw block shaft. Ensure to align the screw hole on the sliding jaw block shaft with the hole on the sliding jaw block.
Reinstall the Phillips head screw and tighten to secure.



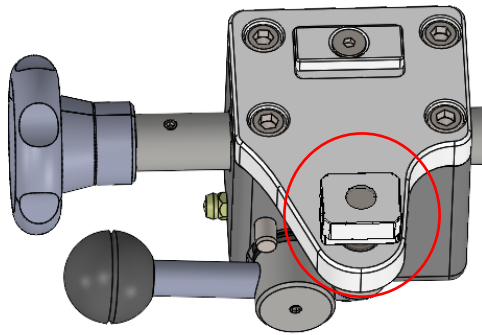
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20. Reinstall the T-nut bolt to T-nut.

Figure 19: Reinstalling T-nut bolt

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