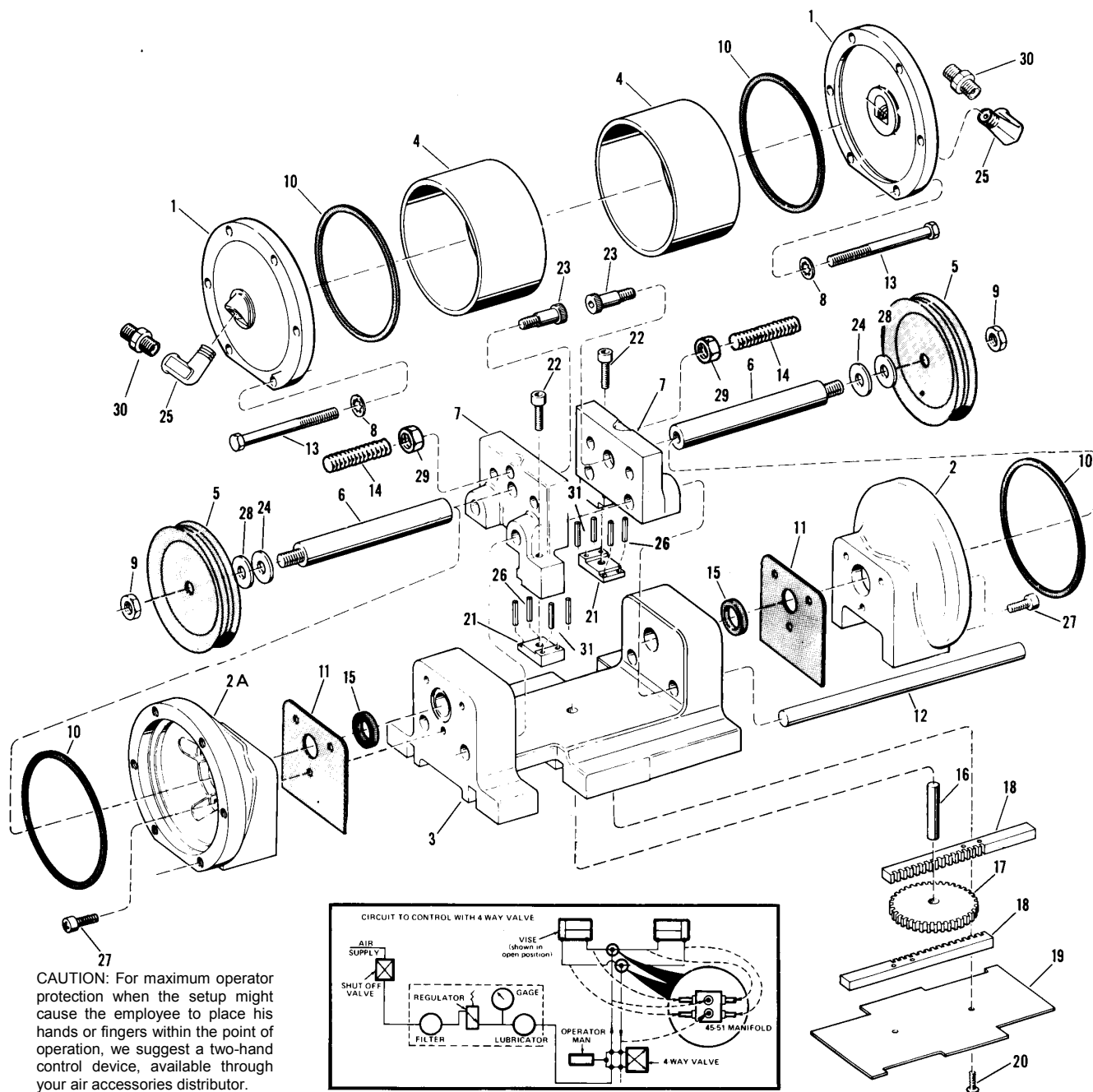


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# SELF-CENTERING VISES



**CAUTION:** For maximum operator protection when the setup might cause the employee to place his hands or fingers within the point of operation, we suggest a two-hand control device, available through your air accessories distributor.

## OPERATION:

The two air outlets on the end of each cylinder must be connected through air hose or piping to the same outlet of a four-way valve, by means of a "7" or manifold. Likewise, the two air outlets on the vise body casting must be connected to the other outlet of the same four-way valve. See diagram above. Heinrich Air Vises can be used safely on air supply lines with pressures up to 120 psi.

The range of holding power can be controlled by installing an air regulator between the air supply line and the four-way valve. To

remove foreign matter in the air line, which could damage the air cylinder and controls, install an air filter between the air supply and the air regulator and/or control valve. See page 13 for accessories for Model DA-2200-SC. We do not furnish 3/8" air accessories for Models DA-6600-SC and DA 8800-SC. These are available from several air component manufacturers.

To set up vise for operation, follow these instructions:  
1. SHUT OFF AIR PRESSURE. (Cont. on next page)

## ... double-acting cylinders

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Index No.		DA-2200-SC			DA-6600-SC			DA-8800-SC		
		No, Req.	Part No.	Price	No, Req.	Part No.	Price	No, Req.	Part No.	Price
1	Cylinder Head Casting	(2)	3301-1		(1) (1)	6601-1 6601-1R (Note 3)		(2)	8800-1	
2	Cylinder Body Casting	(2)	3301-2 + 2-A		--	Part of Body Casting		--	Part of Body Casting	
3	Body Casting (Note 1)	(1)	2200-3		(1)	6600-3		(1)	8800-3	
4	Cylinder Tube	(2)	2200-4		(2)	6600-4		(2)	8800-4	
5	Piston Cup	(2)	3301-5		(2)	6601-5		(2)	8800-5	
6	Piston Rod	(2)	2200-6		(2)	6600-6		(2)	8800-6	
7	Jaw Casting (Note 2)	(2)	DA-2200-7		(2)	6600-7		(2)	8800-7	
8	5/16" I.D. Star Washer	(12)	3301-9		(10)	3301-9		(12)	3301-9	
9	1/2-20 x 1/4 Jam Nut	(2)	3301-11		--	--		--	--	
9	3/4-16 Jam Nut	--	--		(2)	6601-11		(2)	6601-11	
10	Cylinder Gasket	(4)	3301-12		(4)	6601-12		(4)	8800-12	
11	Body Gasket	(2)	3301-13		--	--		--	--	
12	Guide Bar	(2)	44-14		(2)	6600-14		(2)	8800-14	
13	Cylinder Tie Rod	(12)	2200-15 5/16-18 x 2 3/4		(10)	4401-15 5/16-188 x 6		(12)	8800-15 5/16-18 x 89.	
14	Stop Bar	(2)	2200-17		(2)	6600-17		(2)	8800-17	
15	U-Packing	(2)	3301-18 D-26-R-16		(2)	6601-18 D-26-R-20		(2)	8800-18 D-26-R-24	
16	Gear Pin	(1)	2200-20 3/8 x 1 Dowel		(1)	6600-20 5/8 x 1 1/2 Dowel		(1)	6600-20 5/8" x 1 1/2 Dowel	
17	Gear	(1)	2200-21		(1)	77-21 Boston YA-80		(1)	8800-21 Boston YA-120	
18	Rack	(2)	2200-22		(2)	6600-22		(2)	8800-22	
19	Cover Plate	(1)	2200-23		(1)	6600-23		(1)	8800-23	
20	1/4-20 x 1/2 Screw	(2)	2200-42		(4)	2200-42		(4)	2200-42	
21	Rack Locking Plate	(2)	2200-44		--	--		--	--	
22	5/16-18 x 2 1/4 Soc. Hd. Cap Screw	(2)	2200-45		--	--		--	--	
22	1/4-20 x 7/8 Soc. Hd. Cap Screw	--	--		(2)	305-8		(2)	305-8	
23	Shoulder Screw	(2)	3301-39		(2)	6601-39		(2)	6601-39	
24	Stat-O-Seal	(2)	600-1/2"		(2)	600-3/4"		(2)	600-3/4"	
25	1/4" Street Elbow	(2)	2200-33		--	--		--	--	
26	Rack Rollpin	(4)	4CL-6 1/8 x 7/8		(4)	2316-A 3/16 x 1 1/8		(4)	2316-A 3/16 x 1 1/81	
27	5/16-18 x 3/4 Screw	(6)	33-8		--	--		(2)	None Required	
28	Back-up Washer	(2)	3301-5A		(2)	6601-5A		(2)	6601-5A	
29	Nut	(2)	2200-17A (3/8-16)		(2)	H-76 (1/2-13)		(2)	H-76 (1/2-13)	
30	Adapter	(2)	33-16		--	--		--	--	
31	Rack Rollpin	(4)	4CL-6		--	--		--	--	

**Note 1.** Price not shown, as replacement body castings are not available.

**Note 2.** If replacement of jaw casting (7) is necessary, it is recommended that the entire vise be returned to the factory, freight charges prepaid, for machining of the jaw, assembled in customer's vise

**Note 3.** When the letters DA-6600-3 are facing front, the -- 1R is on the left end.

Recommended spare parts to be retained in stock at all times to support each unit in service: Index (5) Piston Cup, Index (10) Cylinder Gasket, Index (11) Body Gasket, Index (15) U-Packing.

### WHEN ORDERING PARTS, INDICATE PART NUMBER AND MODEL NUMBER.

(Cont. from prev. page)

- Adjust and secure stop screws (or bars in the case of DA-2200-SC) (14) to limit jaw return, for desired jaw opening. Allow minimum clearance to insert and remove part piece. It is important to set stop screws (or bars) on each jaw with equal accuracy.
- Place work in vise AS CLOSE AS POSSIBLE TO CENTER OF JAWS and apply air pressure. Regulate air pressure as required for the operation to be performed. AVOID EXCESSIVE AIR PRESSURE.
- Move **entire** vise to center workpiece.
- For maximum accuracy, securely clamp the vise to the work table, using the **center** side lugs.

### MAINTENANCE:

All operating parts, particularly the gear and rack mechanism in the base, should be kept free of foreign material. Periodic greasing of operating parts is recommended.

If vise becomes inoperable, disassemble as shown in exploded view. Clean and check each part for wear or damage. Replacement parts are available for immediate shipment from factory stock, or you may order through your local Heinrich distributor. When re-assembling, all screws and nuts should be evenly and securely tightened.