

How To...

Set the Third-Hand Mechanism

What is the Third-Hand mechanism?

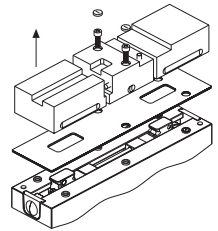
The Third-Hand mechanism allows an operator to change 2 workpieces independently with less than a half turn of the swivel handle.

Setting the Third-Hand mechanism saves time and reduces repetitive movements.

STEP 1

Access the SLIDE ASSEMBLY

- A. Remove the **Movable Jaws**, the **Fixed Center Jaw**, and the **Coverplate**.



STEP 2

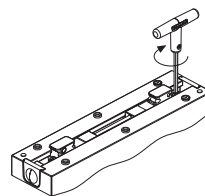
Verify that the THIRD-HAND SCREW is tight.

- A. The Third-Hand screw should be tightened using the **T-wrench**.

Recommended Torque Settings

Use supplied T-wrench and Third-Hand screw.

System Size	Torque (N•m)	Torque (ft-lb)
0520 - 0525	4	3
1030 - 1040	8	6
1540 - 1550	14	10



CAUTION: Do not use any tool other than the provided **T-wrench** to tighten the **Third-Hand Screw**. To ensure the maximum life of your **Workholding System**, do not over tighten the **Third-Hand Screw**. Proper torque is achieved by tightening with the **T-wrench** until finger tight.

How To...

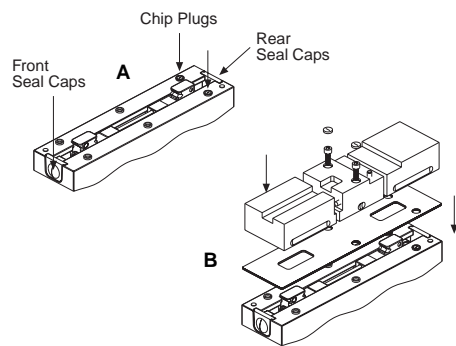
SYSTEM ⑤

Set the Third-Hand Mechanism

STEP 3

Reassemble the WORKHOLDING SYSTEM

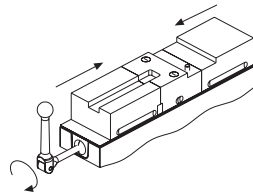
- A. Ensure all **Seal Caps** and **Chip Plugs** are in place to seal the system completely.
- B. Reassemble the system.



STEP 4

Close the MOVEABLE JAWS

- A. Insert the **Swivel Handle** and turn clockwise until both **Moveable Jaws** close completely. The rear **Moveable Jaw** might begin to close slightly. The front **Moveable Jaw** will close completely, then the rear **Moveable Jaw** will close completely.



- 📄 **IMPORTANT NOTE:** You will notice a slightly stiffer feel in the **Swivel Handle** as the second jaw closes. The stiffness is caused by resistance of the **Third-Hand** mechanism. If you do not notice a stiffer feel, then the **Third-Hand** screw is set incorrectly. Go to Step 2 to set the **Third-Hand** screw correctly.

2 OF 3

How To...

SYSTEM 5

Set the Third-Hand Mechanism

STEP 5

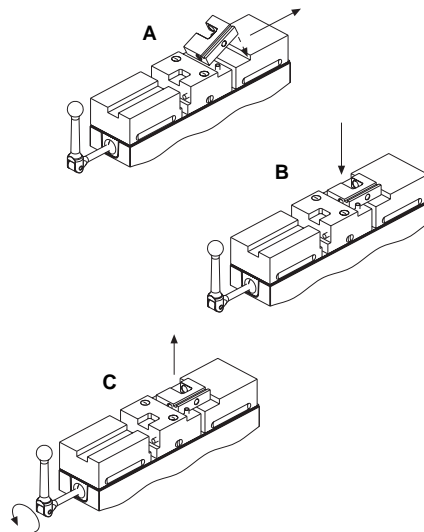
Set the **WORKHOLDING SYSTEM** to Hold Your Workpieces

A. Turn the **Swivel Handle** counterclockwise until the rear **Moveable Jaw** allows enough clearance to load a workpiece.

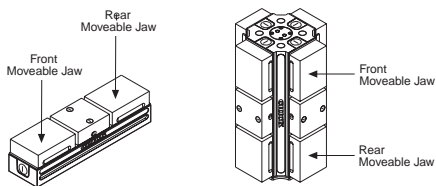
IMPORTANT NOTE: When opening the **Workholding System**, first the rear jaw opens approximately 12.7mm (.5"); then the front jaw begins to open. Continue opening until it reaches its maximum travel and the rear jaw again begins to move.

B. Insert a workpiece between the rear **Moveable Jaw** and the **Fixed Center Jaw**.

C. Rotate the **Swivel Handle** an additional half-turn, or until there is approximately 1.5mm (.06") of clearance between the rear **Moveable Jaw** and the workpiece. Remove the workpiece.



IMPORTANT NOTE: For both the **Qwik-Lok** and the **Multi-Lok Systems**, the **Moveable Jaw** located closest to the **Swivel Handle** is referred to as the **front Moveable Jaw**, and the **Moveable Jaw** located farthest from the **Swivel Handle** is referred to as the **rear Moveable Jaw**.



3 OF 3