



Assembling Your Moxon Vice

Thank you for purchasing your Acer-Ferrous Moxon vise kit. The following instructions will aid in assembly and help to ensure your satisfaction.

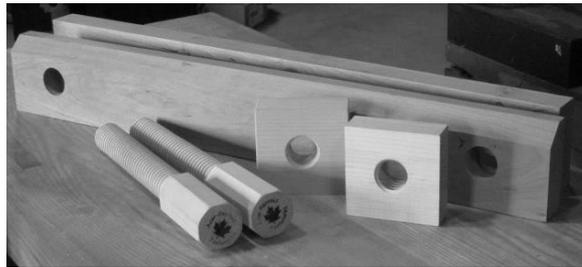
You will need:

2 planks for vise jaws, each 4" wide, 1 1/2" thick, and 32" long

An 1 1/2" drill (a spade bit works well)

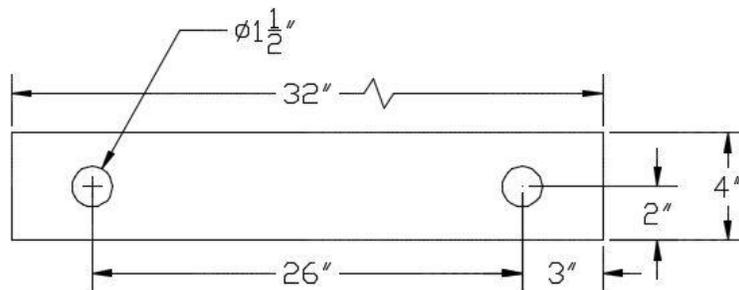
Hand plane, for trimming nut flush with jaw

Several strips of cereal-box cardboard, for shims



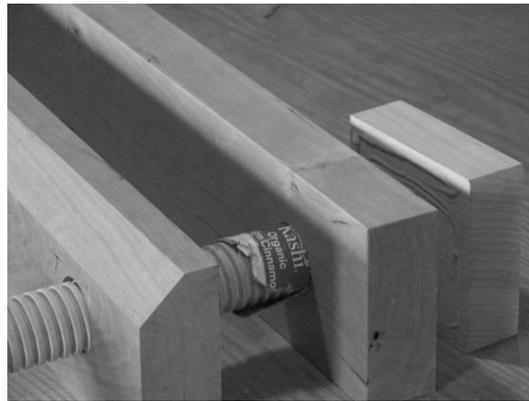
Begin by preparing and laying out the jaw stock. Careful layout is important.

Shown below are some *suggested dimensions*. The model shown below has a maximum clamping width of 24 1/2" between the screws. You may desire a longer or shorter vise. The holes could also be placed a little closer to the ends to gain clamping area if necessary, but 3" is pleasing to the eye. Thickness is not critical but should be at least 1 1/2".



Drill the 1 1/2" holes in both jaws. A spade bit in a drill press is recommended, but satisfactory results may be had using other methods as well. *Clamping the two jaws together while drilling will ensure the holes are aligned.* Again, proper layout and perpendicular holes are important.

Insert the screws through the front jaw. Carefully wrap a shim around the end of each screw before inserting the screw through the back jaw (2 layers of cereal-box cardboard works well). This ensures the screw is centered in the hole and that the necessary clearance exists to prevent binding after assembly. The fit should be snug, not at all loose.



Spread glue on one face of the nut. Avoid spreading glue directly around the hole to prevent squeeze-out onto the screw. Carefully thread the screw into the nut, tightly clamping the whole assembly together. After the glue is dry, remove the cardboard shims.

After the glue is dry, plane the top and bottom of the fixed jaw flush with the nuts to provide a stable clamping surface. The threaded surfaces of your kit are pre-waxed and require no other finish. Finish the non-threaded portions of the vise as you please, leaving the clamping surfaces bare wood for best gripping. Your vise is now done!

Congratulations on finishing your Moxon vise. We hope you will enjoy using it for many years to come.

We appreciate your feedback. If you have any questions or comments, feel free to contact me at prpinthehills@gmail.com.

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Sincerely,
Paul Peters
Acer-Ferrous Toolworks