



YOST 865-DI Owner's Manual

Thank you for choosing a Yost 865-DI. For future reference please record the following:

Model #: 865-DI

Purchase Date: _____

Supplier: _____

Please note that you can register your product at <http://www.yostvises.com/warranty-registration/>

Inspection and Acceptance: Claims for damage, shortage or errors in shipping should be reported as soon as possible following delivery. The time frame for reporting damage is determined by the common carrier that delivered the product. Please contact the carrier for additional information about reporting a claim. If no damage is reported to carrier or Yost, the vise is determined to be accepted. After acceptance of the vise, the Buyer is subject to a returns policy as dictated by the company the product was purchased from. For additional information on warranty contact support@yostvises.com or view the terms of sale at www.yostvises.com.

Important Safety Instructions: Misuse of vises can cause serious injury to eyes, hands and or other body parts. Vises must be set up and used properly. Before setup and use, read, understand and follow all instructions outlined below. Additional information can be found at www.yostvises.com

ALWAYS make sure bench tops are properly secured.

ALWAYS use proper nuts, bolts and lock washers in all mounting holes, to hold bench vise down.

ALWAYS use vise of proper size and capacity to hold work object.

ALWAYS wear eye, face, and ear protection when striking or using power tools with a vise.

ALWAYS wear restrictive hair covering and anti slip footwear while operating vise.

ALWAYS inspect vise for stress fatigue or damage to the vise before using.

ALWAYS maintain the vise – grease main screw regularly.

NEVER use a hammer, extension pipe, or cheater bar on spindle handle of vise.

NEVER weld base of vise to any metal object.

NEVER use a vise to press an object into or out of another object.

NEVER use an extension pipe to tighten handles of lockdowns.

NEVER place pressurized containers or combustible materials in vise.

NEVER apply extreme heat or prolong heat to the vise as it may alter structural properties.

Product Specifications:

Model: 865-DI

Jaw Width: 6-1/2"

Jaw Opening: 7" (11")

Throat Depth: 4" (3")

Pipe Capacity: 1/8" - 3-1/2"

Weight: 49lbs.

Jaws able to withstand a load of up to 1600 inch pounds without distortion of the vise or any components. Hardened steel serrated jaws have a Rockwell C hardness of RC 52-58.

Yost Vises
388 W. 24th St.
Holland MI 49423

Contact:
support@yostvises.com
www.yostvises.com
616.396.2063 Customer Service

Yost 865-DI



If there is any question about a condition being safe or unsafe, do not operate the vise.

To avoid risk of personal injury, equipment damage, fire & shock, make sure work area has the following conditions:

- Floor is dry. Damp, wet or rainy conditions can cause operator to slip.
- Operator must be of sufficient age to operate vise in a safe condition.
- Well Lit.
- Clean and unobstructed.
- Workbench is properly secured to floor or wall.
- Workbench is designed sufficiently to handle vise and work load (torque placed upon the vise and workbench).

Mount Vise To A Secure Workbench

1. Place vise on the workbench to identify location of mounting holes.
2. For added strength to the workbench prior to installing and securing vise, reinforce the workbench with additional wood or metal plates. Failure to mount the vise to a sturdy table can result in injury.
3. Mark and drill holes through the workbench and wood / metal plate using the swivel base as the template for the mounting holes. Prior to drilling, make sure area is free & clear of any hazards.
4. Install proper length & diameter bolts into the swivel base of the vise. Yost recommends at the minimum the following configuration:

Install proper length & diameter bolts along with flat washer through the swivel base of the vise. The bolt should be long enough to protrude at least 1" beyond, the underside of the workbench and wood / metal plate. On the underside of the workbench and wood / metal plate, place a flat washer, lock washer and locking nut to the bolt. Securely tighten vise to the workbench. Periodically, recheck and re-tighten the nuts.

Vise Operation

Make sure vise selection (size and type) is appropriate for use and application. Larger vises are readily available through Yost Vises. Never force or use cheater bars, pipe extensions on the screw handle of the vise as this places excessive pressure on the vise components and they may fail resulting in severe bodily injury.

Step 1: Make sure vise is securely mounted to the workbench.

Step 2: Make sure the swivel base lockdowns are secure.

Step 3: Open the vise by turning the vise handle counterclockwise. Do not open beyond the vises rated capacity (jaw opening).

Step 4: Place item between the serrated jaws of the vise.

Step 5: Close the vise by turning the vise handle clockwise until the item is snug between the serrated jaws.



Step 6: Continue to tighten the screw handle until you can no longer move (twist) the clamped item. Do not over tighten as this may damage item and / or the vise.

Step 7: When finished working on the item, slowly turn screw handle counterclockwise to release the item.

Swivel Base Operation:

The vise is generally operated perpendicular to the workbench, enabling work to be performed from either side of the vise. In some cases, the vise may need to be rotated to allow better and safer access to the item. In order to change the position of the vise, please follow the steps below:

Step 1: After item is securely mounted in the vise, slowly loosen each lockdown located on both sides of the vise. Care should be taken not to over-loosen or remove the lockdowns as this may cause the vise to tip over and cause great bodily injury. Loosen (turn counterclockwise) each lock down about $\frac{1}{4}$ of a turn until the vise is able to swivel from the base.

Step 2: Swivel the vise to allow better and safer access to the item.

Step 3: Tighten (turn clockwise) each lockdown so that the vise is securely clamped to the base.

Reversing your vise:

When reversing your vise, please follow these steps:

Step 1: Make sure vise is securely mounted to the workbench.

Step 2: Make sure the swivel base lockdowns are secure.

Step 3: Open the vise by turning the vise handle counterclockwise. While opening the vise, have a secure grip on the bar of the vise to prevent it from falling. For additional safety do one of the following:

- Rotate vise using swivel base so that the vise is over the work surface prior to sliding out the front jaw or
- Use an adjustable table that is slightly lower than the work bench while sliding the front jaw out of the back jaw of the vise.

Step 4: Once the screw is no longer engaged in the nut carefully remove the bar of the vise while making sure to hold the bar of the vise securely.

Step 5: Carefully set the bar of the vise on a work surface

Step 6: Rotate the vise 180°

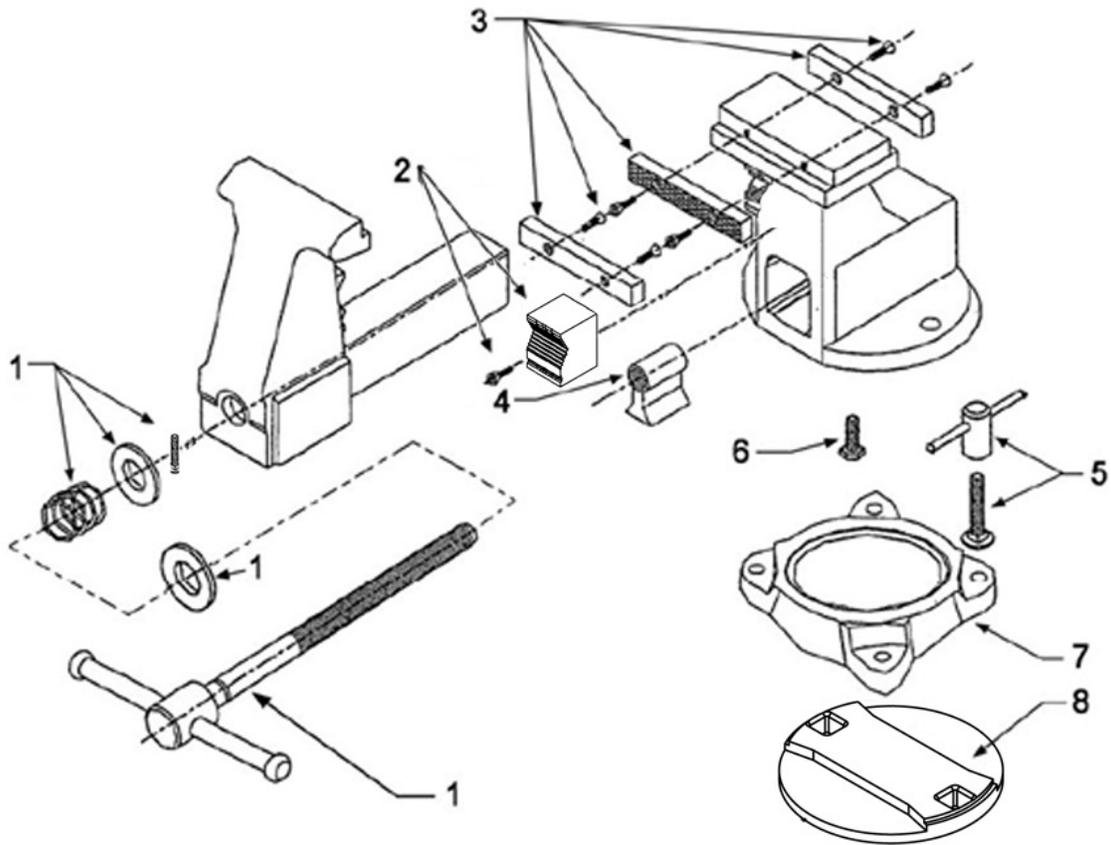
Step 7: Insert the bar of the vise into the back jaw of the vise. Again, be sure to have a tight grip on the bar of the vise

Step 9: Begin threading the main screw of the vise into the back jaw of the vise. Once the screw has been engaged you have successfully reversed your vise.

Step 10: Retighten the lockdowns before using the vise.

YOST VISES

EST. 1908



Part	Description	Quantity
865-DI-01	Main Screw Assembly	1
865-DI-02	Serrated Pipe Jaw Assembly	2
865-DI-03	Machinist Jaw Assembly	3
865-DI-04	Nut	1
865-DI-05	Lock Down Assembly	2
865-DI-06	Pin	1
865-DI-07	Outer Base	1
865-DI-08	Inner Base	1

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