



VIDEO INSTRUCTIONS

FIXTURE PLATE INSTALLATION



1. Clean & Stone Table

- The top face of the table must be clear of chips, burrs, and nicks.

2. Apply a Light Coating of Rust Preventative

- Use LPS3 or your rust inhibitor of choice.

3. Clean Underside of Plate(s)

- Ensure the fixture plate bottom is clean and free of debris.

4. Install T-Nuts in Table Slots

- Install t-nuts in the approximate location of the plate's mounting holes.

5. Place Fixture Plate on Table

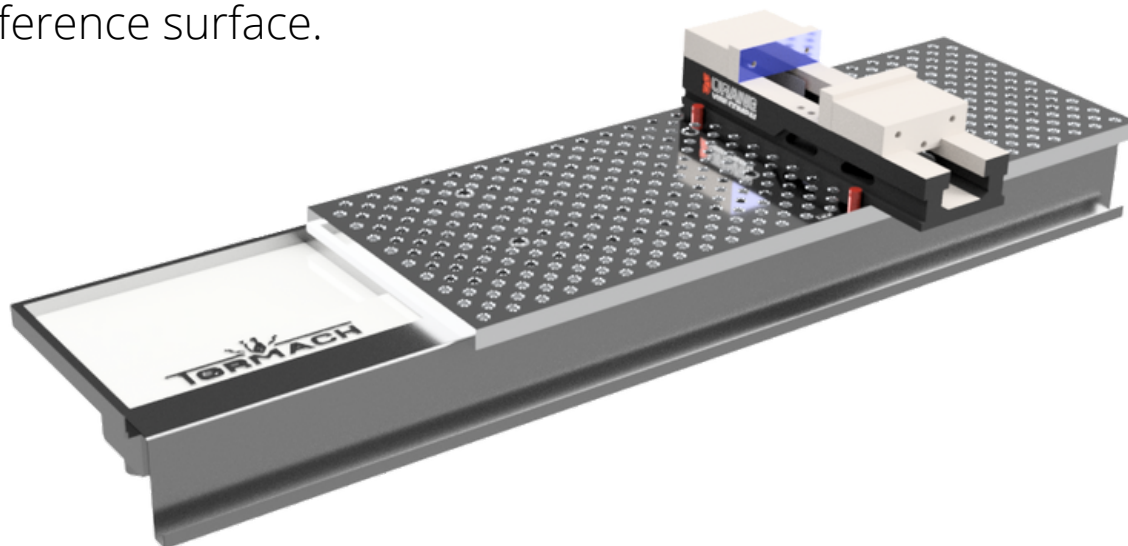
- *For a set of multiple plates, refer to Step 10 (page 3).*

6. Screw Mounting Bolts Into T-Nuts

- For smaller plates, shift the plate to align mounting holes and t-nuts.
- For larger plates, t-nuts can be slid into place beneath mounting holes. using a slim screwdriver or awl, reaching through the 1/2" fixture holes to slide the t-nuts.
- *These bolts should be snug but not tight to allow for tramming of fixture plate.*

7. Indicate Plate

- Use a precision straight edge pushed up against two dowel pins (**shown in red**). A vise or 2-4-6 block also works.
- Ensure no mounting holes are covered.
- Secure straight-edge to fixture plate.
- In the sample photo, the fixed jaw (**shown in blue**) will be used as the reference surface.



8. Tram Plate

- Sweep precision straight edge with a dial indicator.
- Tap corners of plate with a mallet to tram plate.
- Gradually tighten mounting bolts, checking tram as you go.
 - *We recommend 60 ft-lbs max torque for our standard 1/2" or M12 hardware.*

9. Remove Precision Straight Edge

- Installation for a single plate is now complete. Proceed to the next page if installing a set of multiple plates.

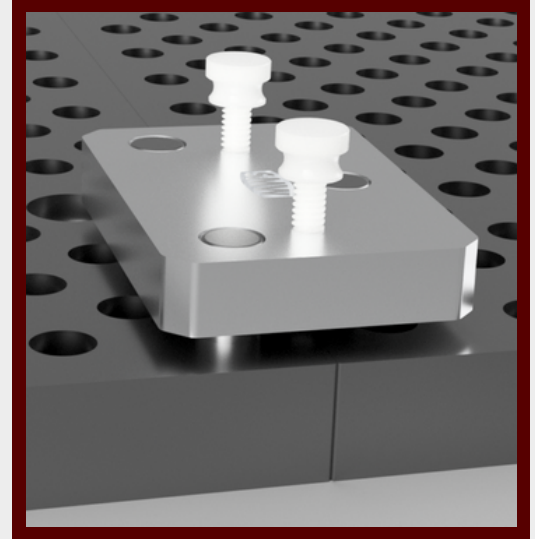
10. Follow Steps 3-6 for Each Plate

- For sets of two plates, begin with either plate.
- For sets of 3+, install the center plate(s) first.
- Place additional plates flush with already trammed plates.

11. Install Alignment Jigs

- Place one jig base* at the bottom of the plates and one jig base at the top.
- Ensure no mounting holes are covered.
- *For best results, place the two-pin side of the jig on the already trammed plate.*
- Alignment jig fit will be snug. Use provided nylon thumb screws for easy removal.

**Alignment jig sets sold separately. SMW Fixture Pallets with (3) 1/2" pins each may be used in place of (1) alignment jig base*



12. Tighten Mounting Bolts

- Start with the mounting holes nearest the alignment jig and move outwards, gradually working up to max torque.

13. Repeat Steps 10-12 for Additional Plates