



PALMGREN
STEEL PRODUCTS, INC.

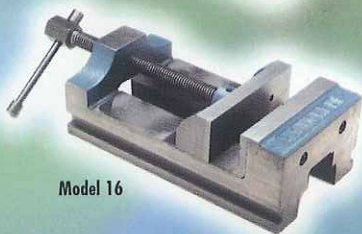
MACHINE TOOL ACCESSORIES



DRILL PRESS VISES



Model 14



Model 16



Model DP35

The traditional Palmgren design for drilling, tapping, reaming and grinding. The rectangular shape allows it to be used laying on its base, sides or end for tremendous flexibility. Machined on five sides.



Model	Jaw Width	Jaw Depth	Jaw Opening	Height	Jaw Type	Lead Screw Type	Weight (LBS)
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Traditional Drill Press Vises

6	1½	1	1½	1¾	Grooved*	V-Thread	2
10	2¾	1½	3	2¾	Grooved**	V-Thread	6
30	2¾	1½	2½	2¾	Grooved*	V-Thread	6
13	3	1¾	3	3	Smooth	Acme	11
14	4	1¾	4	3¼	Grooved	Acme	19
16	6	2	6	4	Grooved	Acme	39



International Drill Press Vises

DP35	3½	1¾	3	2¾	Grooved	Acme	9
DP60	6	2	6	4	Grooved	Acme	35

* Also includes smooth jaw plate

** Grooves made directly on fixed jaw

GROUND VISES



Model 22G



Precision ground for squareness and parallelism to ±.0002 per inch. These vises are a high grade grey iron, machined and ground on five sides to assure accurate positioning for grinding and layout operations. Adjusting screws are steel with long bearing in the vise body. Both jaws are ground smooth.

Model	Jaw Width	Jaw Depth	Jaw Opening	Height Overall	Weight (LBS)
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Ground Vises

11G	1½	1	1¾	1¾	2
22G	2¾	1½	2¾	2¾	6
14G	4	1¾	4	3¼	19

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DRILL PRESS VISES WITH MOUNTING LUGS

General purpose vises recommended for use on drill presses, milling machines, grinders, and other machine tools. They have fine thread adjusting screws and ground steel jaws. The fixed jaw is grooved horizontally and vertically for convenience in holding round pieces. They feature bolt lugs for mounting on a machine table.

Model 7 is a sturdy and compact 3½" vise with an overall height of only 2¼". The base includes three bolt lugs for versatility in mounting. The steel adjusting screw has a coarse pitch Acme thread for fast action. The movable jaw is grooved vertically.

Low Profile vises' low overall height and four mounting slots provide tool clearance and firm mounting on most machine tables.

Model 320



Model 7



Model DPL40



Model	Jaw Width	Jaw Depth	Jaw Opening	Height Overall	Weight (LBS)
Drill Press Vises with Mounting Lugs					
120	1¾	1	1½	1½⅙	3
320	3	1½	3	2⅝	8
Utility Vise					
7	3½	1½	4	2⅞⅙	12
Low Profile Drill Press Vises					
DPL30	3	1⅞	2¾	2¼	6
DPL40	4	1⅞⅙	3½	2⅝	9
DPL60	6	1½	5⅝	3	19
DPL80	8	1¾	8	3⅝	37

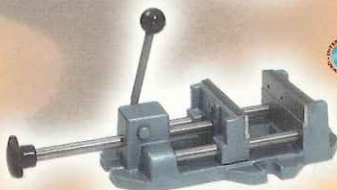
QUICK VISES

A particularly sturdy quick-action cam vise for machine applications where the work must be secured and released rapidly. Precision-ground guide bars and forceful locking cam provide smooth, secure clamping. The QV30 features a side-actuated cam; the QV40 and QV60 utilize a top-actuated cam.

Model QV30



Model QV60



Model	Jaw Width	Jaw Depth	Jaw Opening	Height	Base Size	Weight (LBS)
Quick Vises						
QV30	3	1⅞⅙	3	2⅞⅙	5⅞ × 5⅞⅙	6
QV40	4	1⅞⅙	4	3	10½ × 5⅞	12
QV60	6	1⅞	6	3¾	14¼ × 8⅞⅙	31

ANGLE VISES



Models X1 - 24B are the time-tested Palmgren angle vises, with an optional twist. Models 000B, and 24B come with a robust 360° swivel base which may be locked at any point via two bolts. Securely fasten at any angle from 0 to 90° with four bolts and two side plates.

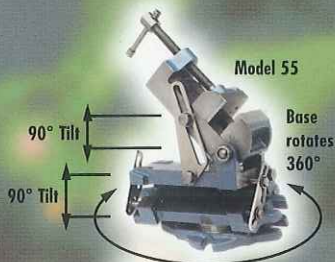
Models AVC25 and AVC35, the Palmgren cradle-style angle vise, allows rapid set-up at 0°, 30°, 45° and 90° with positive pin-stops drilled into the cradle base. A hand-tightened mechanism allows locking at all other positions.

Models AVS 40 and AVS 60 sideplate angle vises are designed for drilling, tapping or reaming operations where a firm vertical setup angle is required. The base has a 90° vertical scale in 1" graduations. Two bolts on each sideplate insure ridged locking in all positions.

Model	Jaw Width	Jaw Depth	Jaw Opening	Height at 0°	Base Size	Weight (LBS)
Angle Vises						
X1*	1½	1	1½	2½	5¾ × 2½	4
000*	2¾	1½	2½	3¾	7½ × 3¼	10
000B*	2¾	1½	2½	4¾	4 × 6¾	14
24	4	1¾	4	4¾	12¾ × 5½	31
24B	4	1¾	4	5¾	5¾ × 8¾	36
International Angle Vises						
AVC25	2½	1½	2½	3¾	5½ × 6¾	10
AVC35	3½	1½	3½	4¾	7 × 7¾	17
AVS40	4	1½	4	4¾	12¼ × 5½	31
AVS60	6	2	6	5¼	14¾ × 7¼	51

*Also includes an additional smooth jaw plate

COMPOUND ANGLE VISES



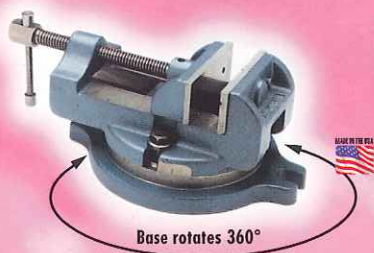
Model 55 2½" all angle vise permits fast, easy setup for compound angles. Adaptable for drilling, tapping, milling, and grinding, both angles are calibrated 0° to 90° and can be securely locked in place. The detachable swivel base provides complete rotation and is graduated in degrees. Bases have ¾" keyway and ¾" bolt slots.

The model 45V all angle vise offers 360° calibrated rotation of the 4" vise, a 0° through 90° angular precision calibrated adjustment, and a 360° swivel base. This combination of movements make setups possible at any angle.

The detachable base has an 1¼" keyway and ¾" bolt slots for machine mounting.

Model	Jaw Width	Jaw Depth	Jaw Opening	Height Overall	Weight (LBS)
Compound Angle Vises					
55	2¾	1½	2½	5¾	18
45V	4½	1¼	4	5½	49

SWIVEL MACHINE VISES



Base rotates 360°

Model 410B

Durable, general-purpose machine vises. All sizes available with a 360° swivel base (indicated with a "B" at the end of the model number). Locking bolts fasten the vise at the desired position in 1° increments.

Model	Jaw Width	Jaw Depth	Jaw Opening	Height	Base Size	Weight (LBS)
Swivel Machine Vises						
310	3	1½	3	2¼	6¾ × 4½	9
310B	3	1½	3	4	8 × 5¾	12
410	4	1¾	4	3¾	8¼ × 6¼	18
410B	4	1¾	4	4¾	9 × 7½	23
610	6	2	6	3¾	11¼ × 8½	35
610B	6	2	6	5½	12 × 10	50

"LOW PROFILE" VISES



Base rotates 360°

Model 425B

A rugged vise designed for low clearance applications. Both sizes available with a 360° swivel base (indicated with a "B" at the end of the model number). Locking bolts fasten the vise at the desired position in 1° increments.

Model	Jaw Width	Jaw Depth	Jaw Opening	Height	Base Size	Weight (LBS)
Low-Profile Machine Vises						
325	3½	1½	3	2¼	7½ × 5¼	11
325B	3½	1½	3	3	8 × 6½	15
425	4½	1¼	4	2¾	8¼ × 6¼	18
425B	4½	1¼	4	3½	9¾ × 7¾	25

HEAVY DUTY SWIVEL MACHINE VISES



Base rotates 360°

Model 60B

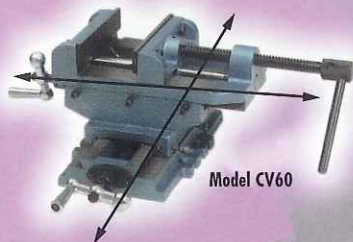
A large, heavy-duty vise built for production, tooling and maintenance. The body features a double-ribbed forward section to meet the requirements of demanding machine applications. The removable handle is extra-long and machined from a single casting for increased leverage. Includes a coolant trough. Both sizes available with a 360° swivel base (indicated with a "B" at the end of the number). Locking bolts fasten the vise at the desired position in 1° increments.

Model	Jaw Width	Jaw Depth	Jaw Opening	Height	Base Size	Weight (LBS)
Heavy-Duty Machine Vises						
60	6	2	6	5	18 × 9	80
60B	6	2	6	6¾	12½ × 10½	107
80	8	2¼	8	5¾	21¼ × 11	150
80B	8	2¼	8	7¾	15¼ × 12½	190

CROSS SLIDE VISES



Model 32



Model CV60

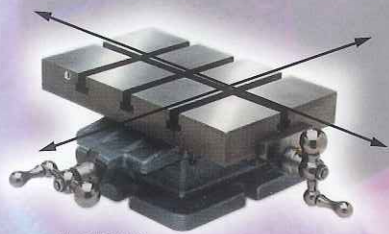
These units will accurately move the work in two directions. This gives you drill press movements and positioning similar to a vertical mill.

Model 32 is a durable vise built on a rugged, cast base. Counter-balanced solid steel ball-crank handles enable smooth movement and do not extend below the base, eliminating interference from the machine top. Dials graduated in 0.001" increments. By removing two screws, the vise can be removed from the base and used conventionally.

Models CV30 - CV80 have a range of sizes to fit most cross-slide applications. Long leadscrew and handle for tight workholding. Locking levers on the X and Y axis to secure the vise in position.

Model	Jaw Width	Jaw Depth	Jaw Opening	Height	Base Size	Weight (LBS)
Traditional Cross Slide Vise						
32	3	1 3/4	3	5 1/2	7 7/8 x 6 3/8	26
International Cross Slide Vises						
CV30	3	1	2 3/8	4 1/2	8 1/4 x 6	32
CV60	6	1 3/4	5 5/8	6 1/2	11 x 6 3/4	43
CV80	8	2	7 1/16	7 7/8	12 1/4 x 7 5/8	68

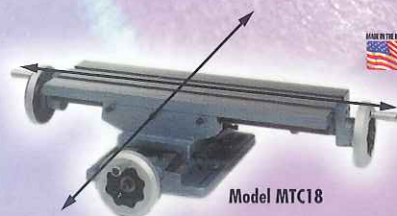
CROSS SLIDE TABLES



Model 92-10

A range of tables to satisfy a wide variety of applications. All tables in this series have precision-ground tops to 0.001" total indicator reading. Dials are graduated in 0.001" increments and have thumbscrews for easy "0" setting. The 90-10, 90-12 and 190-16 feature single axis movement only, while the 92, and 192 series all provide both X and Y axis movement. The 93-12 also has angular inclination from 0 to 90° via two side plates secured with four bolts. Models 90, 92 and 93 series have a single longitudinal T-slot with three transverse 7/16" T-slots. The 190 and 192 series three longitudinal 3/8" T-slots.

Model MTC18 - with a wheel handle at each end of the table-top, positioning may be performed from either side. Rotary dials graduated in 0.001" increments. Two longitudinal 3/8" T-slots.



Model MTC18

Model	Table Size	Height	Base Size	Table Travel	Weight
Slide Tables & Cross Slide Tables					
90-10	10 x 6	3 1/2	6 3/8 x 7 3/8	6	34
90-12	12 x 6	3 1/2	6 3/8 x 7 3/8	8	39
92-10	10 x 6	4 3/8	7 7/8 x 6 3/8	6 x 4	40
92-12	12 x 6	4 3/8	7 7/8 x 6 3/8	8 x 4	44
93-12	12 x 6	4 3/8	9 x 5	8 x 4	48
190-16	16 x 8	4 3/8	10 x 11 1/2	10	102
192-16	16 x 8	6 1/8	11 1/2 x 10	10 x 8	149
Compound Milling Table					
MTC18	18 3/8 x 6	5	10 1/2 x 7 7/8	12 1/2 x 7 1/2	57

CROSS SLIDE ROTARY TABLES

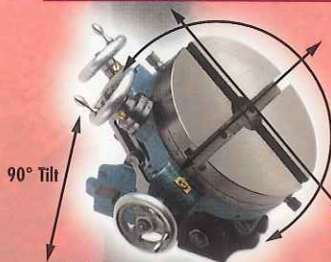


Table rotates 360° Model 83

Now you can do hundreds of jobs that were never before possible using a standard drill press. Palmgren Rotary Tables accurately position work in one, two or three separate directions. You feed the work into the spindle by using any combination of movements, or use the table for accurate positioning of the work below the spindle. Cross slide travel is 4" on 8" and 10" tables, 8" on 12" and 15" tables. Rotary dials are direct 1 minute readings on 12" and 15" models.

Model	Table Dia.	Height Overall	Top Grad.	Base Keyway	Gear Ratio	Table T-Slots	Weight (LBS)
Cross Slide Rotary Tables							
83	8	5½	360°	⅝	40:1	⅝	40
103	8	5¼	360°	⅝	40:1	⅝	44
183	10	5¾	360°	⅝	40:1	⅝	52
1583	15	8¾	360°	1⅞	90:1	⅝	215

ROTARY TILTING CROSS SLIDE TABLE

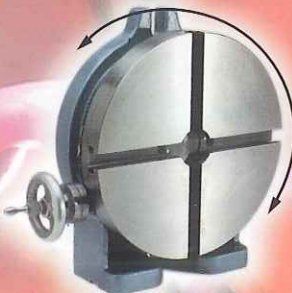


90° Tilt Table rotates 360° Model 84

These remarkably precise Palmgren® Rotary Tables provide all of the combinations of movements and positioning necessary to add complete versatility for your drill press, milling machine, surface grinder or layout table.

Model	Table Diameter	Table Travel (X × Y)	Base (X × Y)	Height at 0°	Weight (LBS)
Rotary Tilting Cross Slide Table					
84	8	4 × 4	9 × 5	5	45
184	10	4 × 4	9 × 5	5¾	54

ROTARY INDEXING TABLES



Model 1062

For use in either the horizontal or vertical position. The table top and the vertical and horizontal bases are ground for overall squareness. A keyway and bolt lugs are provided on both mounting surfaces.

Model	Table Diameter	Height at 0°	Base	Gear Ratio	Weight (LBS)
Vertical/Horizontal Rotary Indexing Tables					
862	8	3½	12 x 9½	40:1	44
1062	10	3¾	12 x 9½	40:1	52
1562	15	4¾	17 x 14	90:1	192

HORIZONTAL MATERIAL SUPPORT STAND



Model MVR18

Model MSH14

The Palmgren material support stand is designed for handling heavy loads of flat stock. Chrome plated, 2" x 14" ball bearing roller head smoothly moves the work stock. Clamping mechanism allows for quick and easy height adjustments. Locking screws provide added safety. Made of heavy-duty cast iron and steel.

Model	Weight Holding Capacity	Length of Horizontal Roller	Height Range	Base Size	Weight (LBS)
Horizontal Material Support Stand					
MSH14	2000	14	23 to 38½	15 x 16½	45
Model	Weight Holding Capacity	Maximum Stock Diameter	Weight (LBS)		
V-Roller Head (without Pedestal)					
MVR18	2000	18	14		

V-ROLLER MATERIAL SUPPORT STAND



Model MHR14

Model MSV18

The Palmgren material support stand is designed for handling heavy loads of round stock. Chrome plated, 2" x 5" ball bearing roller heads smoothly move round stock of 1" to 18" diameter. Clamping mechanism allows for quick and easy height adjustments. Locking screws provide added safety. Made of heavy-duty cast iron and steel.

Model	Weight Holding Capacity	Minimum Stock Diameter	Maximum Stock Diameter	Height Range	Base Size	Weight (LBS)
Vertical Material Support Stand						
MSV18	2000	1	18	23 to 38½	15 x 16½	45
Model	Weight Holding Capacity	Length of Horizontal Roller	Weight (LBS)			
Horizontal Head (without Pedestal)						
MHR14	2000	14	14			

BENCH GRINDER PEDESTAL STAND



Model GS32

The Palmgren bench grinder stand is designed to accommodate most 6, 7, 8 and 10 bench grinders available in the market, including Baldor, Dayton, and Craftsman. Base and top made of heavy-duty cast iron with a 3½ steel column. Built-in water pot provides quenching for workpiece after grinding. Secure grinder mounting via holes and slots in the top.

Model	Column Diameter	Table Size	Height	Base Size	Weight (LBS)
Bench Grinder Pedestal Stand					
GS32	3½	10 x 11	32¾	15 x 16½	58

ARBOR PRESSES



Model AP10

The Palmgren arbor press delivers the heavy force needed for riveting, squeezing, punching, bending, and other pressing applications. Sturdy, cast-iron construction. Removable, machined steel anvil provides accurate work support in four slot positions. Rugged, steel ram is driven by a machined pinion. Punches or tools may be added to the end of the ram. Base drilled for mounting on a bench or pedestal.

Model	Force (Tons)	Swing	Anvil Dia.	Max. Work Hgt.	Ram Dim.	Height	Base Dimen.	Wgt. (LBS)
Arbor Presses								
AP05	0.5	6½	3½	4½	¾ × ¾	10¼	4 × 9¼	17
AP10	1.0	8	4½	5½	1 × 1	12	5 × 10½	25
AP20	2.0	10¾	6¾	8	1¼ × 1¼	17¼	6¾ × 16	59
AP30	3.0	11	6¾	12½	1½ × 1½	22	7¾ × 18	97
AP40	4.0	16¼	9½	15¾	1¾ × 1¾	29¾	9¼ × 21¼	197

LATHE MILLING ATTACHMENTS



Model 250

With the Palmgren Lathe Milling Attachment, you can adapt your lathe to mill, slot, grind, groove, dovetail, square, angle cut, recess and more. Simply mount the attachment to the tool post and the cutting tool in the lathe's chuck. It has 360° graduation for rotary angle adjustments and a graduated feed screw. Fits most major lathes with a single tool post. The 250V is recommended for 8 to 10" lathes and the 400V for 12 to 16". For smaller lathes, the 250V will fit if there is sufficient vertical clearance.

Model	Jaw Width	Jaw Depth	Jaw Opening	Tool Post to (Dia)	Vertical Travel	Weight (LBS)
Lathe Milling Attachments						
250V	2⅞	1½	2½	1¼	3	12
400V	4	1¾	4	1¾	4	36



T-Slotting



End Milling



External Dovetail



End Mill Angle Cut



Cutting Keyway



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