

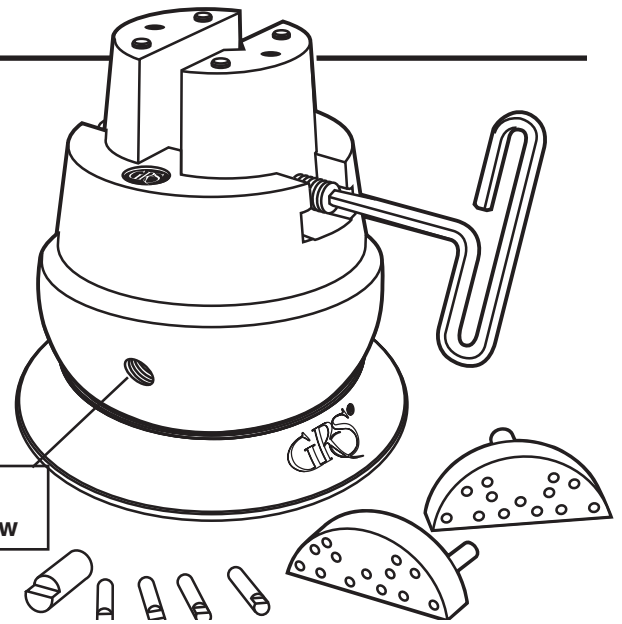
The GRS® Magnablock will provide many years of trouble-free service. It is extremely rugged in construction, yet is relatively simple and easy to maintain. Required lubrication is minimal.

The jaw adapter plates are drilled to accept engraving block attachments. GRS® offers the 520 Attachment Set (#003-520) that includes storage for the adapter plates and pins that come with the block.

**Maintenance**

Based on usage, open jaws fully and clean the dirt and metal pieces from the threads. After cleaning, apply a small amount of light oil to the threads.

Periodically wipe the vise and vise jaws with a lightweight oil to help prevent rust. All GRS vises are stainless steel except the ONE line vises. Although stainless steel is more rust-resistant, certain body chemistry can still cause it to rust. Recommended products include 3-IN-ONE oil, WD-40 Corrosion Inhibitor, and Super Lube Metal Protector.



**Vise Jaw Thread Replacement • #003-627 & #003-628**

Overtightening the jaws will cause wear and damage to the threads. If jaws become loose, replace with kit #003-627. Remove the jaws by opening them as wide as possible until they come off the end of the jaw screw (FIG. 1). The jaw thread pin is located on the underside of each jaw. NOTE: Before removing pins, locate the one with the “L”. This is the left hand thread pin and will need to be replaced with the same. Apply a small amount of synthetic grease (included in kit) to the O-rings and jaw screw before installing them. Lift the jaw screw out of the yoke and replace it. Note which side the left hand thread is on. Grease the threads and yoke well.

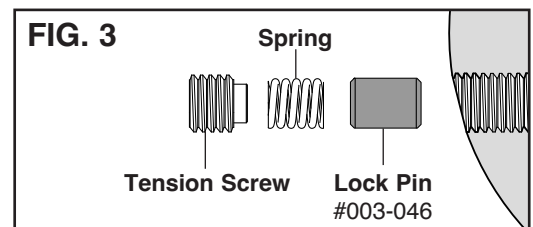
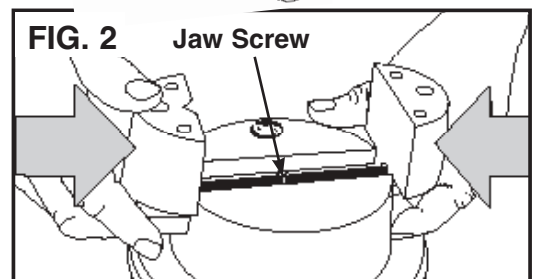
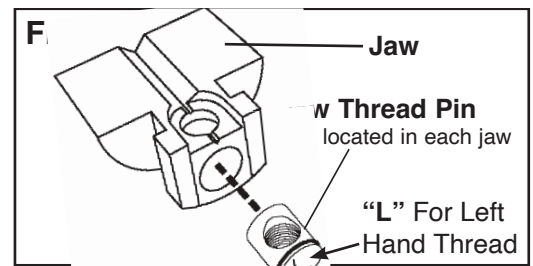
Start the jaw threads at the same time when replacing them (FIG. 2). Hold each jaw in position and turn the jaw screw to close them. Either a large rubber band or a second person is useful to hold the jaws against the thread while the jaw screw is turned. If the jaws don't meet at the same time in the center, remove them and try starting the threads at the same time again.

**Rotational Lock Replacement**

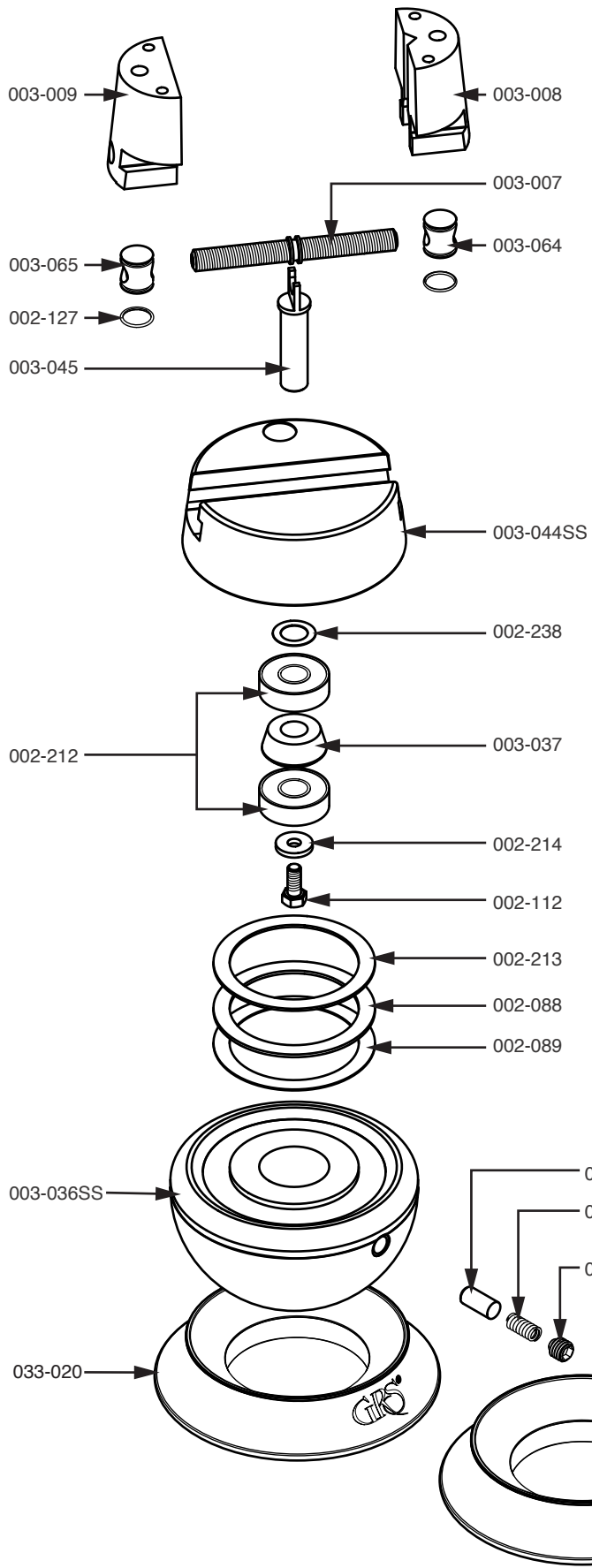
The LOCK or DRAG PIN is subject to wear and may need replacement after extended use. Simply remove the ball swivel tension screw with the hex wrench. The Spring and Lock Pin should follow (FIG. 3). If not, turn the ball until they fall out. Replace the Lock Pin (#003-046), Spring, and Tension Screw.

**Thread Pin Replacement Kit • #003-627**

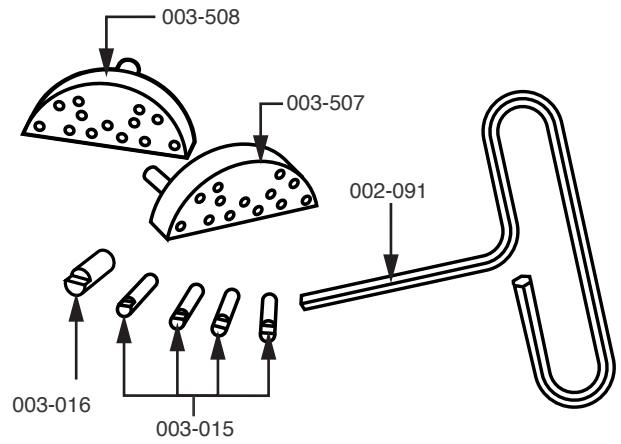
Includes Jaw Screw, Left and Right Thread Pins, O-Rings, and Tube of Synthetic Grease.



**GRS<sup>®</sup> Magnablock Ball Vice  
 Complete Assembly #003-021**



PART #	DESCRIPTION
002-088	Bearing, 0.078" THK
002-089	Bearing Race, 0.031" THK
002-091	Wrench - 1/4" T-Handle Hex
002-112	5/16-18 X 3/4" HHB
002-127	O-Ring - 0.625" x 0.75" x 0.062"
002-212	Bearing 5/8 x 1/2
002-213	Bearing Race, 0.078" THK
002-214	Washer - 0.312" x 0.859" x 0.125"
002-238	Thrust Washer
003-007	Screw Post
003-008	Jaw - Left Hand
003-009	Jaw - Right Hand
003-015	Jaw Pin - 1/4"
003-016	Jaw Pin - 3/8"
003-020	Spring, Block Drag
003-036SS	Block Base
003-037	Spacer
003-044SS	Block Crown S.S.
003-045	Post
003-046	Lock Pin
003-064	Pin - Left Hand
003-065	Pin - Right Hand
003-067	1/2-13 UNC x 1/2" SHSS
003-507	Pin Plate - 2 pin
003-508	Pin Plate - 1 pin
033-020	Large Block Base Ring Plastic
033-021	Large Block Base Ring Rubber



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