



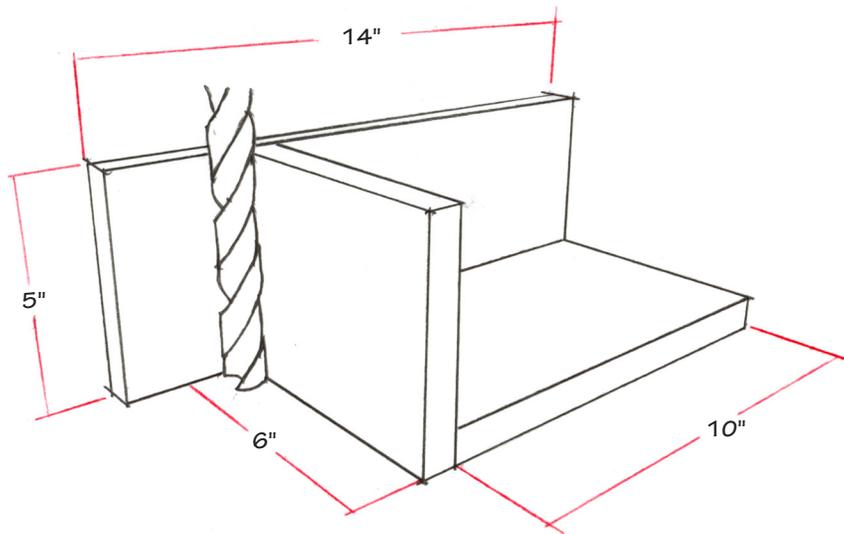
Crucible holdfasts are unlike many mass-manufactured holdfasts made today and require careful fitting to your benchtop for the best performance. This short tutorial guides you through the fitting process so the holdfast will grip tightly in even the thickest workbenches, and it will work even when its pad is 6" (or more) above the benchtop.

The shaft of your holdfast is about 1" in diameter - though every holdfast is a little different due to the casting and finishing process.

Bore the Holes

We recommend boring your holdfast holes with a 1" auger bit powered by a corded drill. The best bit we have found for the job is the Japanese-made WoodOwl. Though the bit is metric and a little undersized, you will be reaming this hole a little to fit your holdfast, so the slight size difference is immaterial.





For any holdfast to work, the hole in the benchtop needs to be plumb. While you can get away with using two try squares to guide you, we prefer to make a simple jig, above, which makes the process simple. The two vertical walls of the jig guide the auger bit.

While the location of your bench's holdfast holes can be guided by personal preference, we recommend the following historical pattern at right, which allows you to work without an end vise. (Note: the pattern shown is for right-handed benches. Reverse everything for a left-handed bench.)

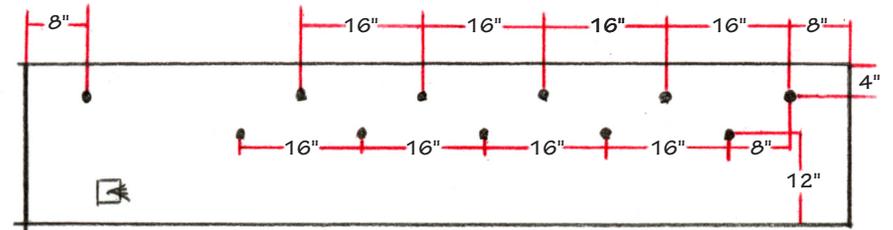
Lay out all your holes and bore them.

Fitting the Shaft

All workbench hardware works better when it is carefully fit to the bench. The Crucible holdfast works best when its shaft closely fits its hole. This allows it to work in thick workbenches.

After you bore your 1" holes, you likely will find that the tool's shaft will wedge in the hole at some point along its length. When this happens, use your auger bit to ream the circumference of the hole to slightly increase its diameter.

You do this by providing sideways pressure as you move the spinning bit up and down in the hole. The flutes of the bit and the spurs will remove a little material with each up-and-down stroke. It might take a minute or two of reaming to get the result



you want. Take your time and sneak up on the fit.

When the holdfast drops into the hole, you are done.

If your benchtop is somewhat wet when you drill the holes, it might distort as it dries and your holes might become oblong. A little gentle reaming will restore them to working order.

Setting and Releasing the Holdfast

You can use a mallet, hammer or small sledge to set and release the holdfast. To set it, strike the holdfast directly over the shaft. Always use a protective scrap of wood between the pad and your work. Otherwise the holdfast pad will dent your workpiece.

To release, strike the rear of the shaft.

Care of the Holdfast - Tarnish is Good

The Crucible holdfast has been treated so it will quickly patinate and even develop a little surface rust. This is intentional. Surface imperfections improve the holdfast's grip. Lubricating the holdfast or sanding the shaft smooth will decrease its grip. We recommend you leave the tool as-is and let nature take its course.

Additional Information

You can find this manual, links to videos and additional information on using holdfasts at the product page on our website at crucibletool.com