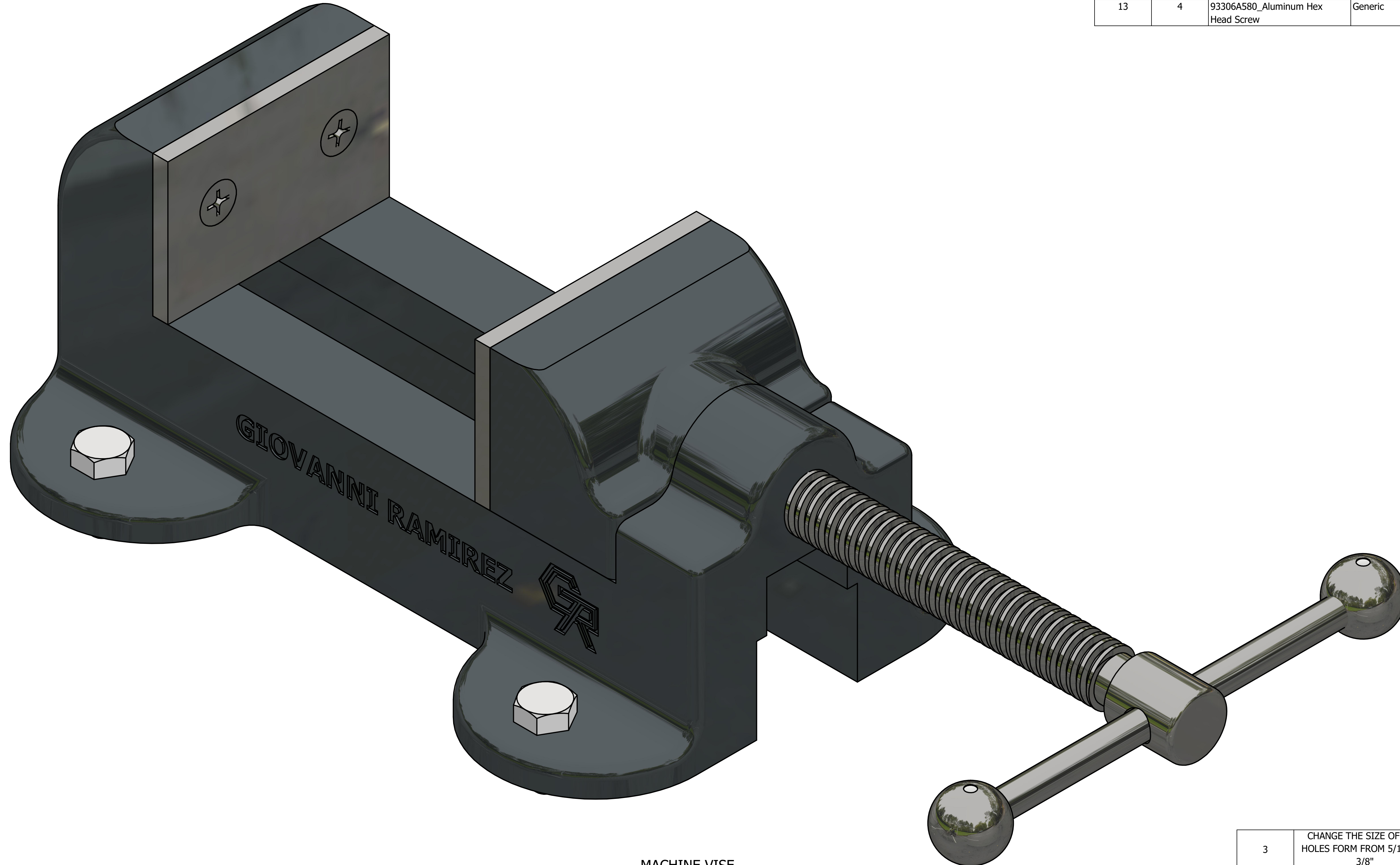


**GENERAL NOTES:**

ALL FILLETS R 1/8 UNLESS OTHERWISE SPECIFIED

**LEGEND:**

- ∅ DIAMETER
- R RADIUS
- ° DEGREES
- COUNTER BORE/SPOTFACE
- ∨ COUNTERSINK
- ▽ DEPTH



MACHINE VISE  
SCALE 2 : 1

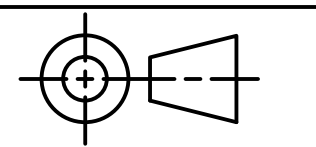
PARTS LIST				
ITEM	QTY	PART NUMBER	MATERIAL	DESCRIPTION
1	1	BASE	CAST IRON	
2	1	SLIDING JAW	CAST IRON	
3	2	JAW PLATE	STEEL ALLOY	
4	1	VISE SCREW	STEEL ALLOY	
5	1	COLLAR	COLD ROLLED STEEL	
6	1	SPECIAL KEY	COLD ROLLED STEEL	
7	1	HANDLE ROD	COLD ROLLED STEEL	
8	2	HANDLE BALL	COLD ROLLED STEEL	
9	2	SLIDE KEY	COLD ROLLED STEEL	
10	2	SET SCREW	CARBON STEEL	
11	4	COUNTERSUNK HEAD MACHINE SCREW	MILD STEEL	TYPE 1 CROSS FLAT ANSI B18.6.3 - 1/4-20 x 3/4
12	2	TAPER PIN	CARBON STEEL	#000 98390A160_12L14
13	4	93306A580_Aluminum Hex Head Screw	Generic	STEP AP203



DIGITAL DESIGN  
GRAPHIC  
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GENERAL NOTES:  
ALL FILLETS R 1/8  
UNLESS OTHERWISE  
SPECIFIED



TOLERANCES UNLESS SPECIFIED:  
DECIMAL INCHES:  
X = ±.010  
XX = ±.020  
XXX = ±.005  
FRACTIONAL = ±1/64"  
ANGLES ±1 DEGREE

SURFACES √

CLASS: DDGT 240

ASSIGNMENT NUMBER: 38

INVENTOR DRAWING NAME: MACHINE VISE

FIG #: 14-71

MANAGER: G. STROMMEN

DRAFTER: G. RAMIREZ

DATE: 9/30/2024

SCALE: AS NOTED

PAGE #: 1 OF 6

REV	DESCRIPTION	DATE	APPROVED
3	CHANGE THE SIZE OF THE HOLES FORM FROM 5/16" TO 3/8"	10/15/2024	G.STROMMEN
2	CHANGE THE OVERALL LENGTH OF THE VISE SCREW FROM 6 1/4" TO 7". SPECIFICALLY THE LENGTH OF THE THREAD FROM 3 15/16 TO 4 11/16"	10/15/2024	G.STROMMEN
1	CHANGED OVERALL LENGTH OF BASE FROM 7 1/4" TO 8"	10/15/2024	G.STROMMEN

REVISION HISTORY

**GENERAL NOTES:**

ALL FILLETS R 1/8 UNLESS OTHERWISE SPECIFIED

**LEGEND:**

- ∅ DIAMETER
- R RADIUS
- ° DEGREES
- COUNTER BORE/SPOTFACE
- ∨ COUNTERSINK
- ▽ DEPTH

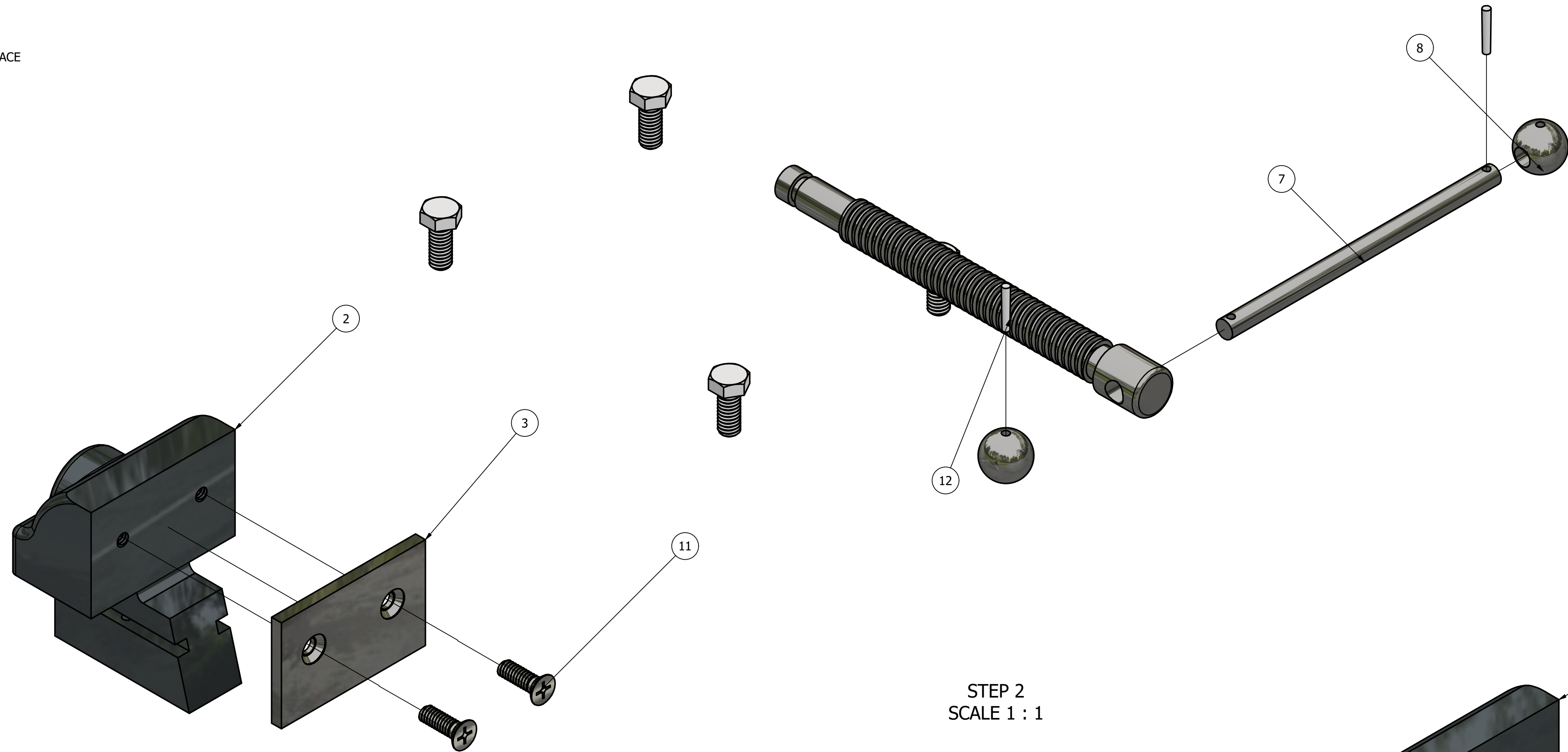
PARTS LIST		
ITEM	QTY	PART NUMBER
1	1	BASE
2	1	SLIDING JAW
3	2	JAW PLATE
4	1	WISE SCREW
7	1	HANDLE ROD
8	2	HANDLE BALL
11	4	COUNTERSUNK HEAD MACHINE SCREW
12	2	TAPER PIN
13	4	93306A580_Aluminum Hex Head Screw



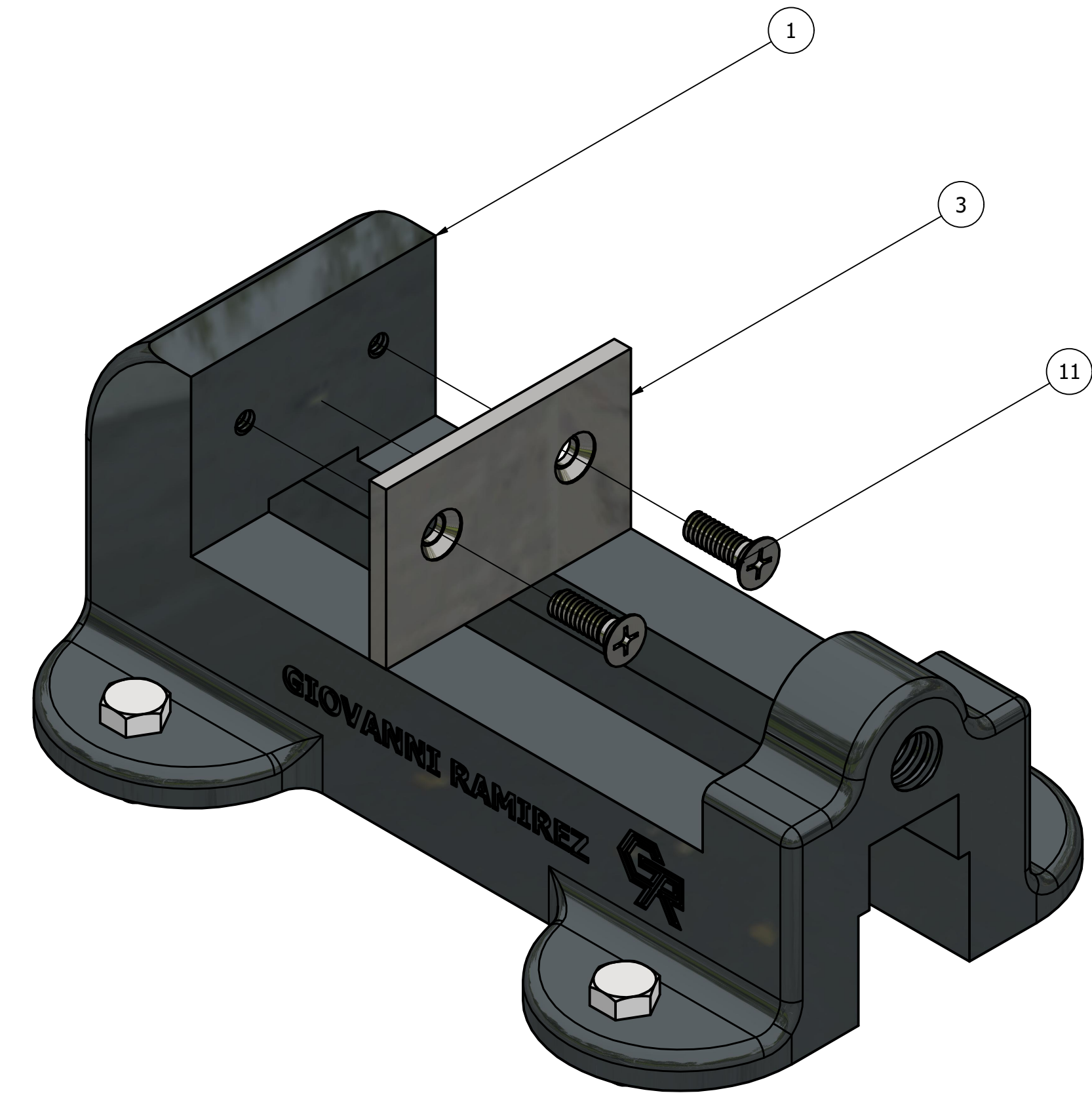
DIGITAL DESIGN  
GRAPHIC  
TECHNOLOGY

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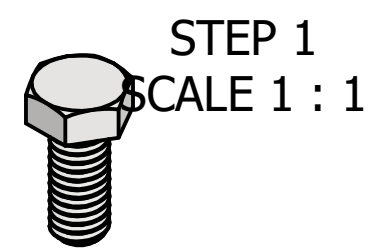
GENERAL NOTES:  
ALL FILLETS R 1/8  
UNLESS OTHERWISE  
SPECIFIED



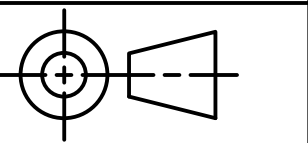
STEP 2  
SCALE 1 : 1



STEP 3  
SCALE 1 : 1



STEP 1  
SCALE 1 : 1



TOLERANCES UNLESS SPECIFIED:  
DECIMAL INCHES:  
X = ±.010  
XX = ±.020  
XXX = ±.005  
FRACTIONAL = ±1/64"  
ANGLES ±1 DEGREE

SURFACES ∨

CLASS: DDGT 240

ASSIGNMENT NUMBER: 38

INVENTOR DRAWING NAME: MACHINE VISE

FIG #: 14-71

MANAGER: G. STROMMEN

DRAFTER: G. RAMIREZ

DATE: 9/30/2024

SCALE: AS NOTED

PAGE #: 2 OF 6

**GENERAL NOTES:**

ALL FILLETS R 1/8 UNLESS OTHERWISE SPECIFIED

**LEGEND:**

- ∅ DIAMETER
- R RADIUS
- ° DEGREES
- ┌ COUNTER BORE/SPOTFACE
- ∨ COUNTERSINK
- ▽ DEPTH

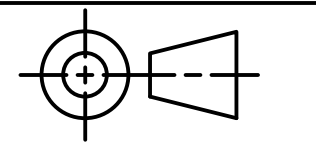
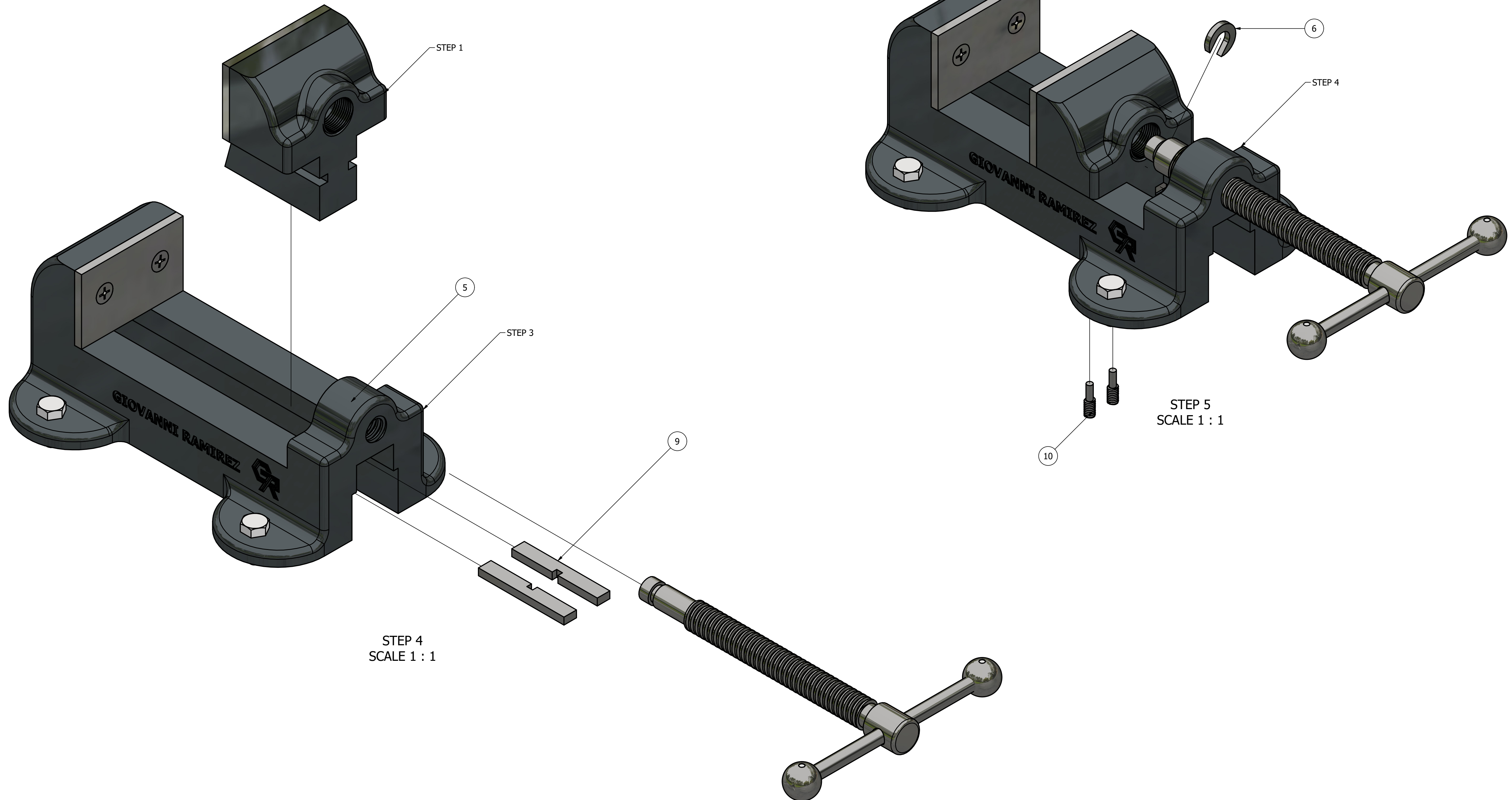
PARTS LIST		
ITEM	QTY	PART NUMBER
1	1	BASE
2	1	SLIDING JAW
3	2	JAW PLATE
4	1	WISE SCREW
5	1	COLLAR
6	1	SPECIAL KEY
7	1	HANDLE ROD
8	2	HANDLE BALL
9	2	SLIDE KEY
10	2	SET SCREW
11	4	COUNTERSUNK HEAD MACHINE SCREW
12	2	TAPER PIN
13	4	93306A580_Aluminum Hex Head Screw



DIGITAL DESIGN  
GRAPHIC  
TECHNOLOGY

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GENERAL NOTES:  
ALL FILLETS R 1/8  
UNLESS OTHERWISE  
SPECIFIED



TOLERANCES UNLESS SPECIFIED:  
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ANGLES ±1 DEGREE  
SURFACES √

CLASS: DDGT 240

ASSIGNMENT NUMBER: 38

INVENTOR DRAWING NAME: MACHINE VISE

FIG #: 14-71

MANAGER: G. STROMMEN

DRAFTER: G. RAMIREZ

DATE: 9/30/2024

SCALE: AS NOTED

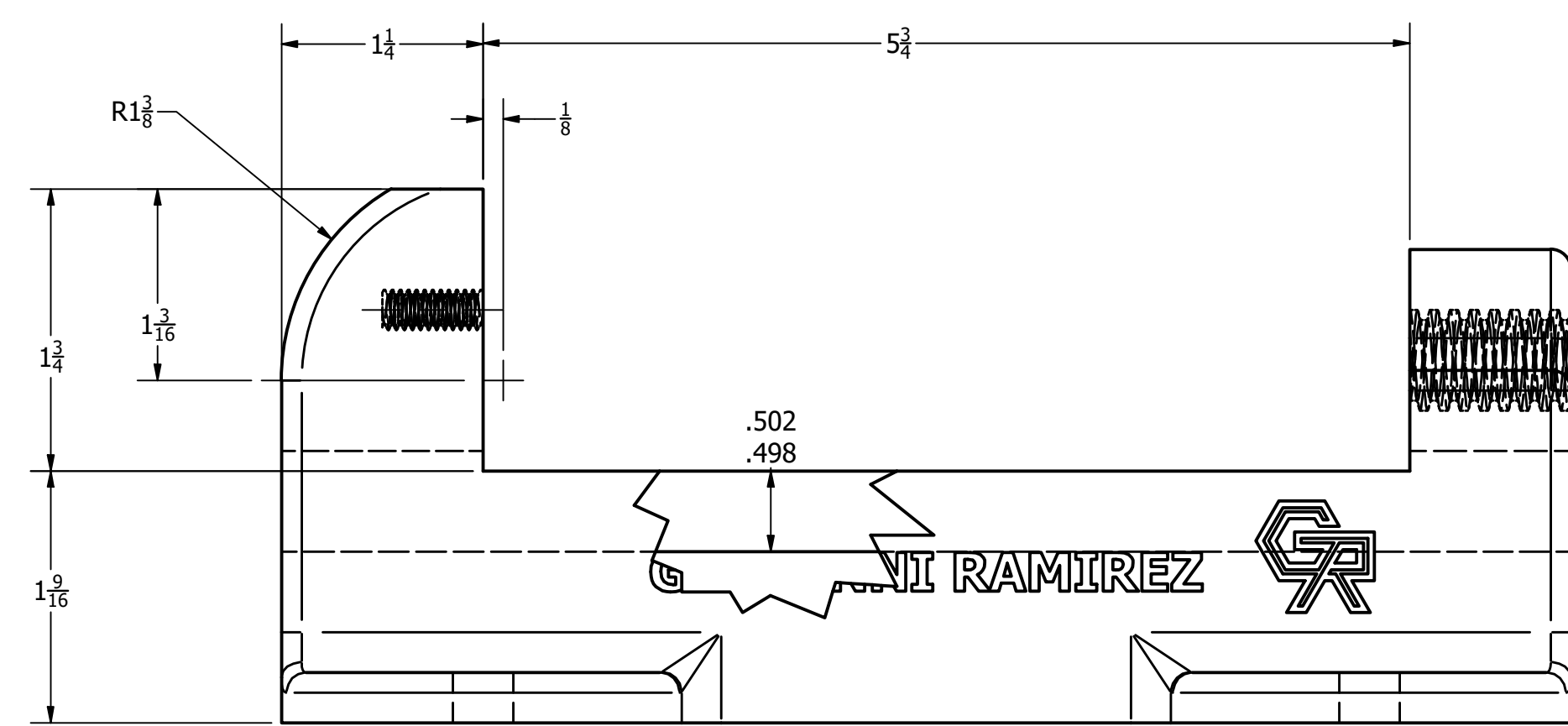
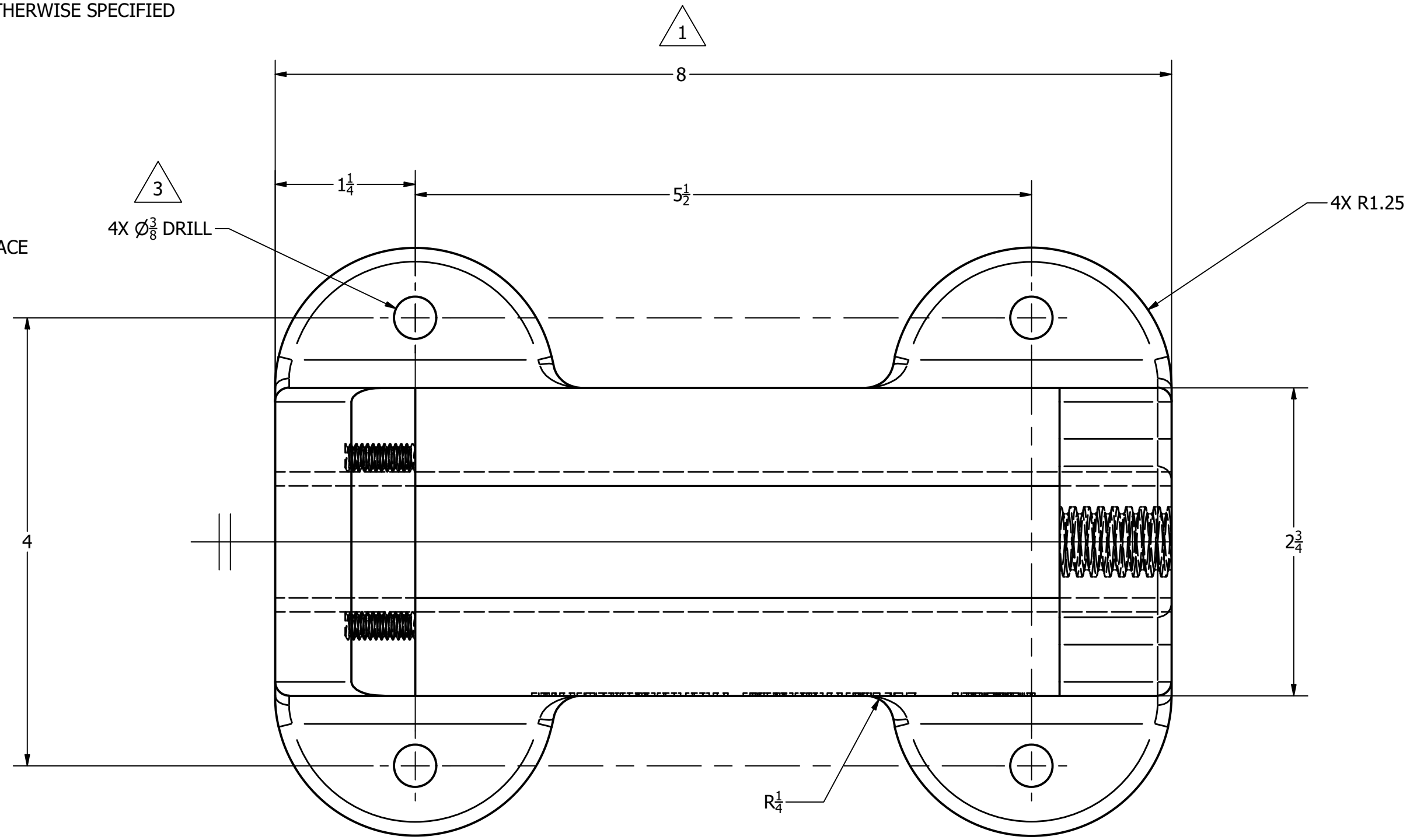
PAGE #: 3 OF 6

**GENERAL NOTES:**

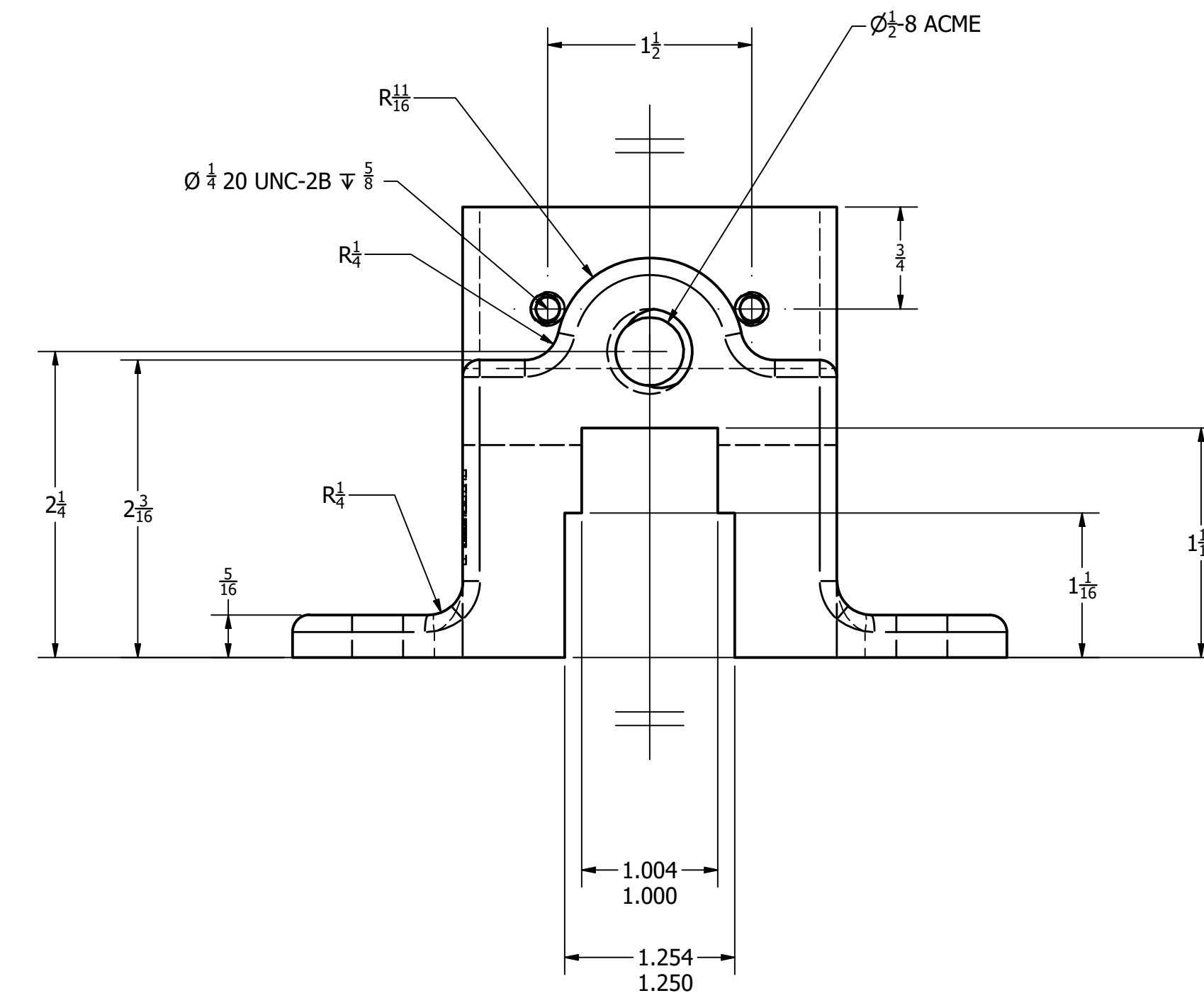
ALL FILLETS R 1/8 UNLESS OTHERWISE SPECIFIED

**LEGEND:**

- ∅ DIAMETER
- R RADIUS
- ° DEGREES
- ┌ COUNTER BORE/SPOTFACE
- ∨ COUNTERSINK
- ▽ DEPTH



BASE  
SCALE 1 : 1



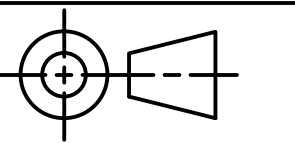
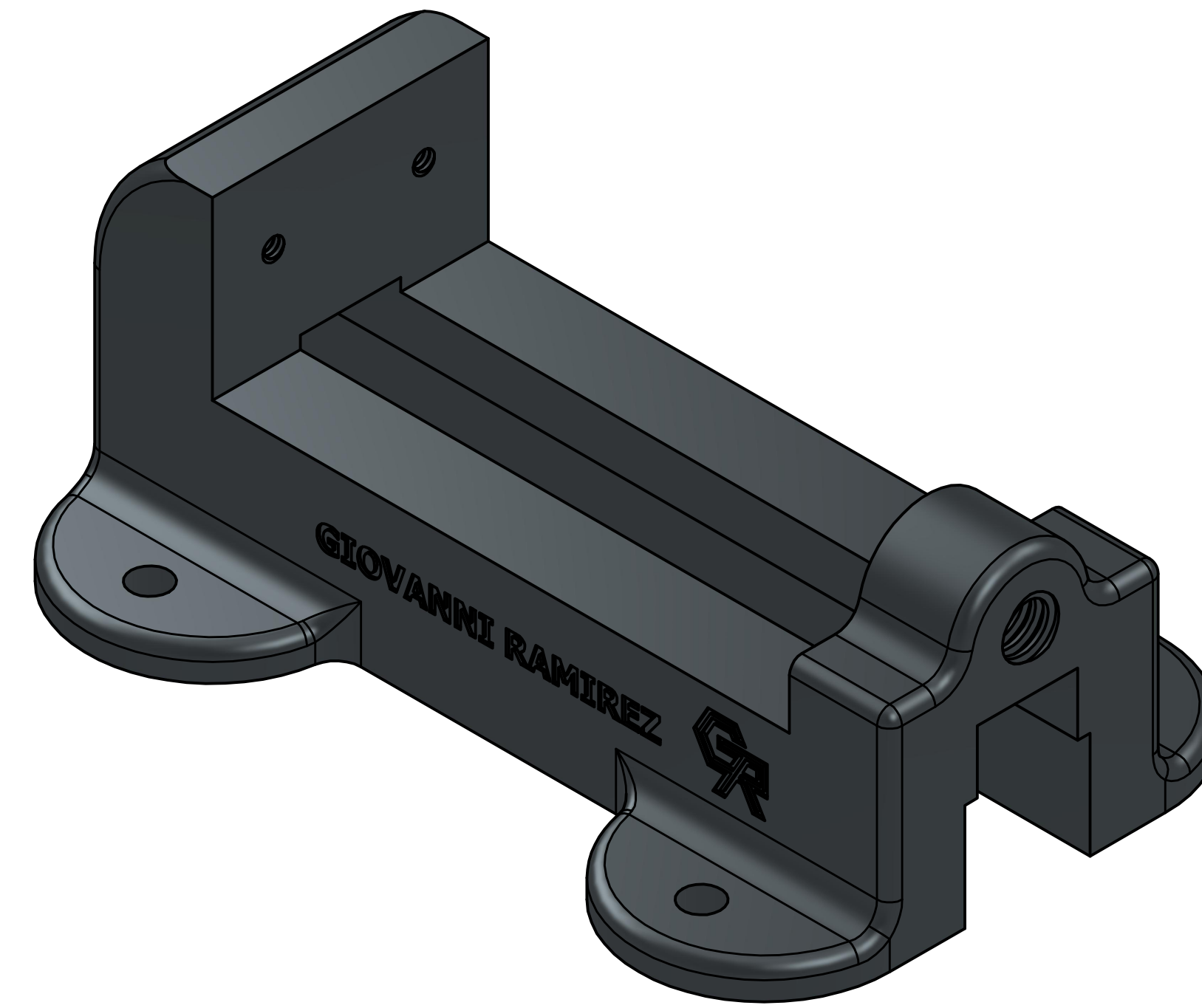
PARTS LIST		
ITEM	QTY	PART NUMBER
1	1	BASE



DIGITAL DESIGN  
GRAPHIC  
TECHNOLOGY

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GENERAL NOTES:  
ALL FILLETS R 1/8  
UNLESS OTHERWISE  
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TOLERANCES UNLESS SPECIFIED  
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FRACTIONAL = ±1/64"  
ANGLES = ±1 DEGREE  
SURFACES ∨

CLASS: DDGT 240

ASSIGNMENT NUMBER: 38

INVENTOR DRAWING NAME:  
MACHINE VISE

FIG #: 14-71

MANAGER: G. STROMMEN

DRAFTER: G. RAMIREZ

DATE: 9/30/2024

SCALE: AS NOTED

PAGE #: 4 OF 6

REV	DESCRIPTION	DATE	APPROVED
3	CHANGE THE SIZE OF THE HOLES FROM 5/16" TO 3/8"	10/15/2024	G.STROMMEN
1	CHANGED OVERALL LENGTH OF BASE FROM 7 1/4" TO 8"	10/15/2024	G.STROMMEN

REVISION HISTORY

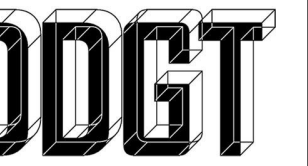
**GENERAL NOTES:**

ALL FILLETS R 1/8 UNLESS OTHERWISE SPECIFIED

**LEGEND:**

- ∅ DIAMETER
- R RADIUS
- ° DEGREES
- COUNTER BORE/SPOTFACE
- ∨ COUNTERSINK
- ▽ DEPTH

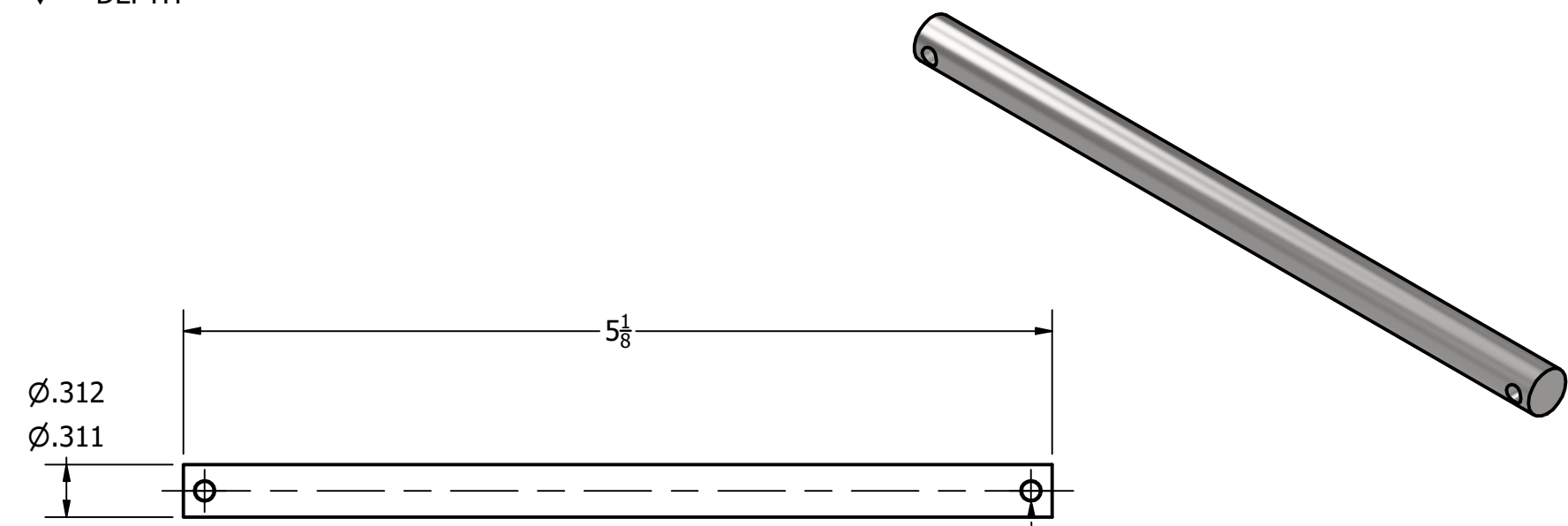
PARTS LIST		
ITEM	QTY	PART NUMBER
3	2	JAW PLATE
5	1	COLLAR
6	1	SPECIAL KEY
7	1	HANDLE ROD
8	2	HANDLE BALL
10	2	SET SCREW
12	2	TAPER PIN
13	4	93306A580_Aluminum Hex Head Screw



DIGITAL DESIGN  
GRAPHIC  
TECHNOLOGY

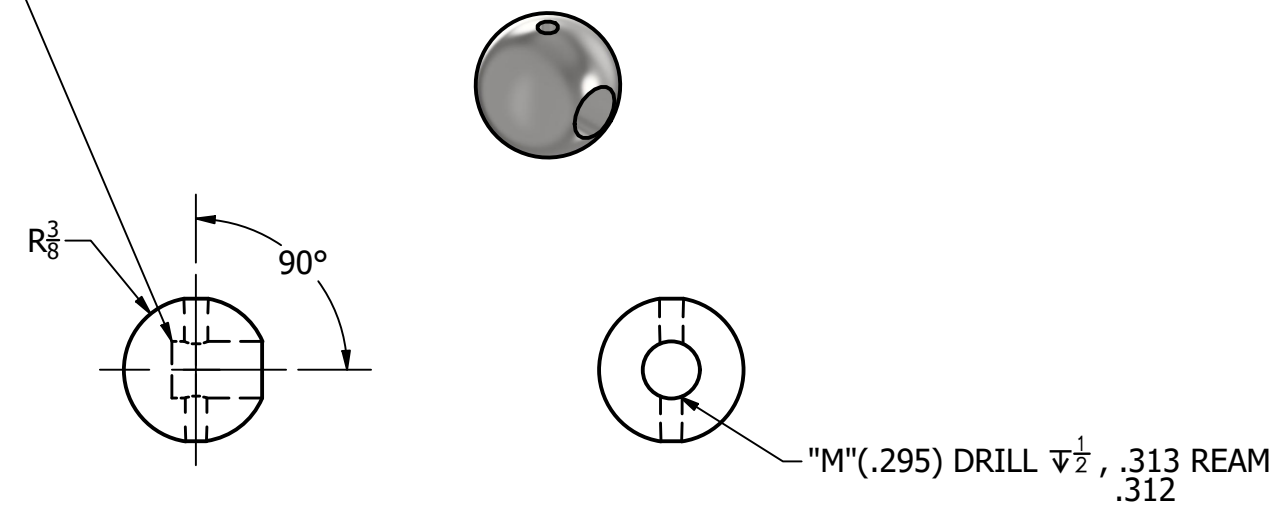
WWW.DDGT.NET

GENERAL NOTES:  
ALL FILLETS R 1/8  
UNLESS OTHERWISE  
SPECIFIED

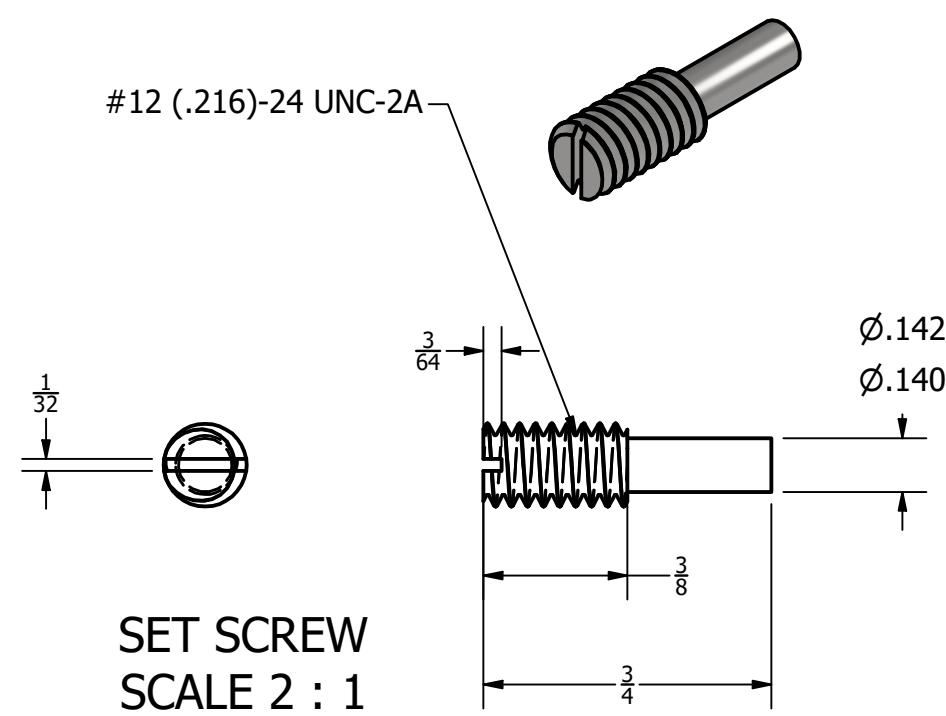


HANDLE ROD  
SCALE 1 : 1

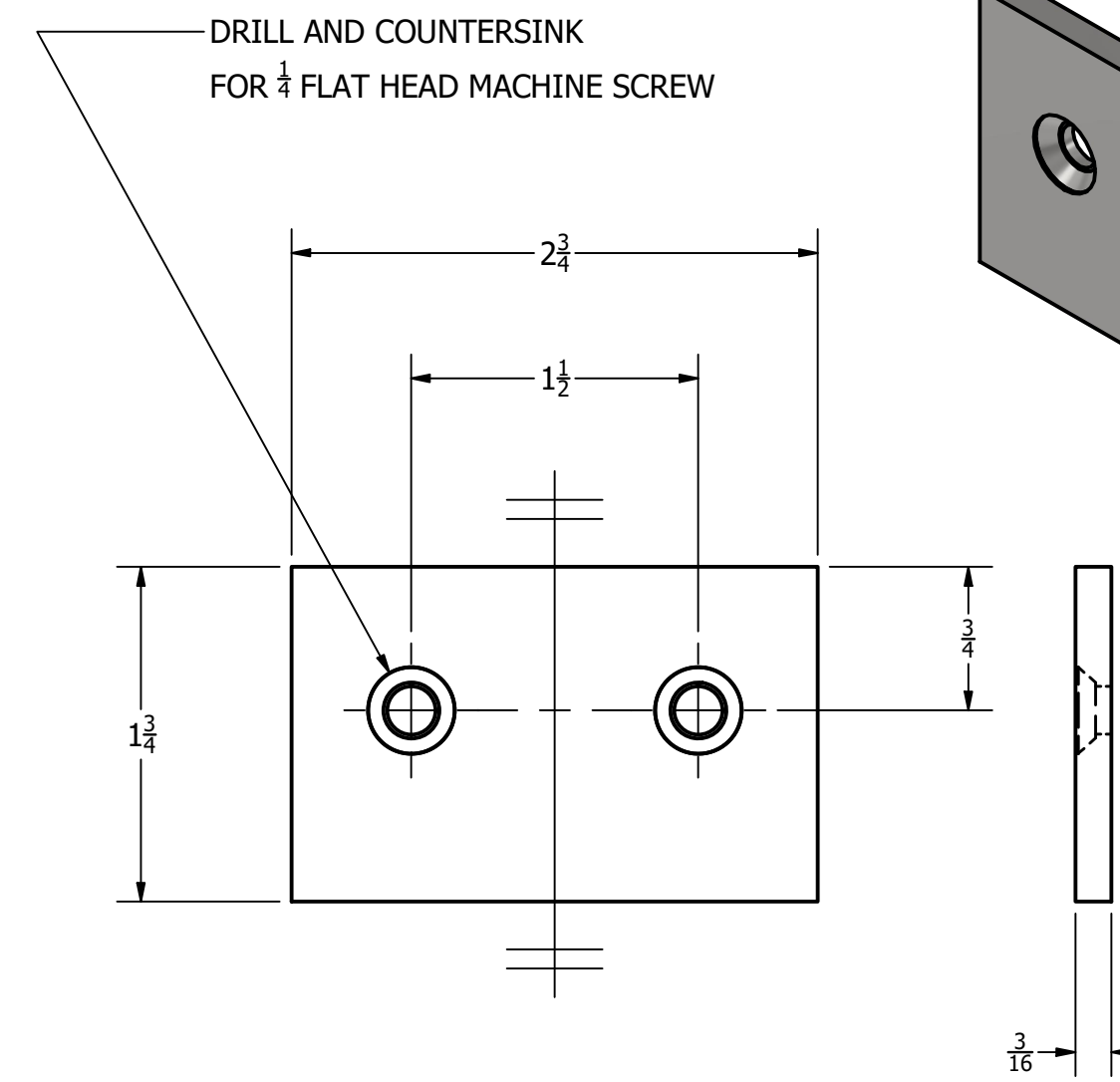
#37 DRILL AND REAM FOR  
#000 TAPER PIN CLEAR THROUGH  
PEEN SMALL END OVER



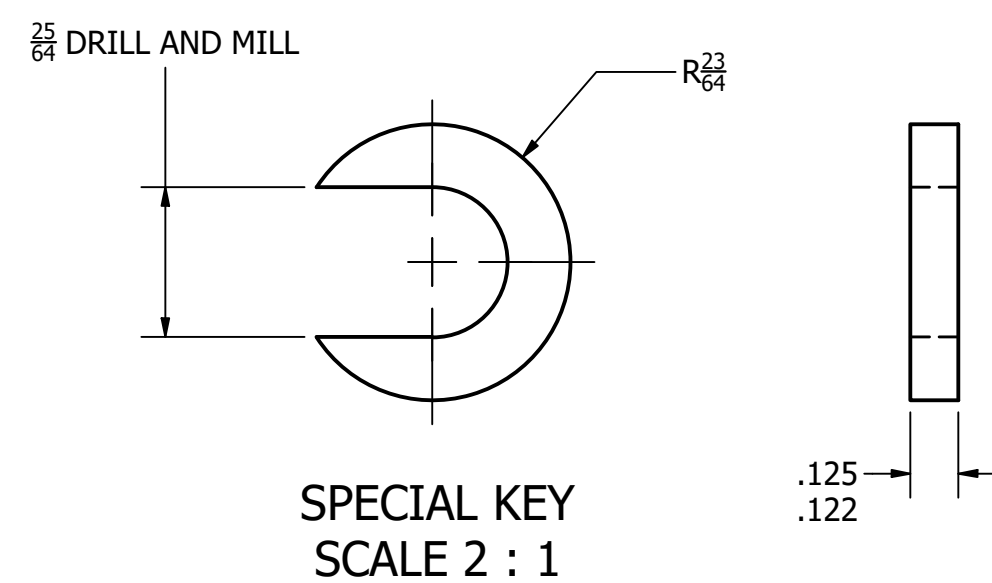
HANDLE BALL  
SCALE 1 : 1



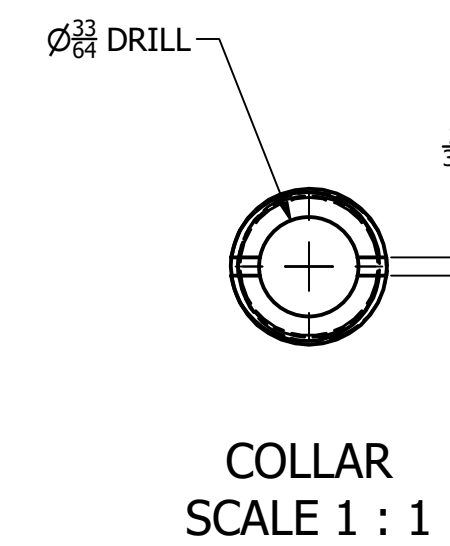
SET SCREW  
SCALE 2 : 1



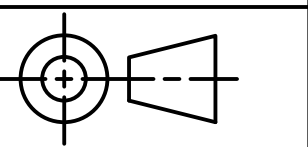
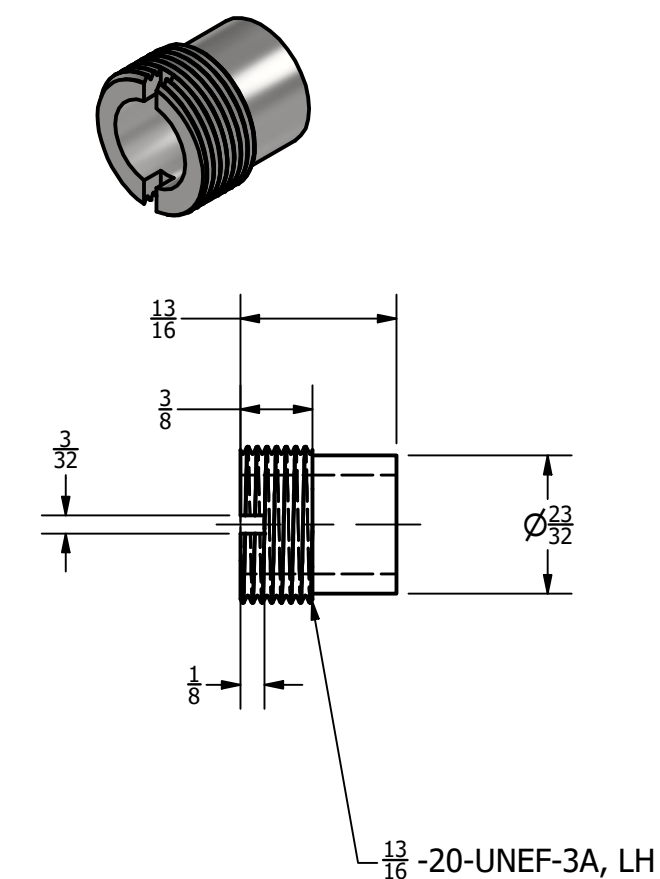
JAW PLATE  
SCALE 1 : 1



SPECIAL KEY  
SCALE 2 : 1



COLLAR  
SCALE 1 : 1



TOLERANCES UNLESS SPECIFIED  
DECIMAL INCHES:  
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XX = ±.005  
XXX = ±.005  
FRACTIONAL = ±1/64"  
ANGLES ±1 DEGREE

SURFACES √

CLASS: DDGT 240

ASSIGNMENT NUMBER: 38

INVENTOR DRAWING NAME:  
MACHINE VISE

FIG #: 14-71

MANAGER: G. STROMMEN

DRAFTER: G. RAMIREZ

DATE: 9/30/2024

SCALE: AS NOTED

PAGE #: 5 OF 6

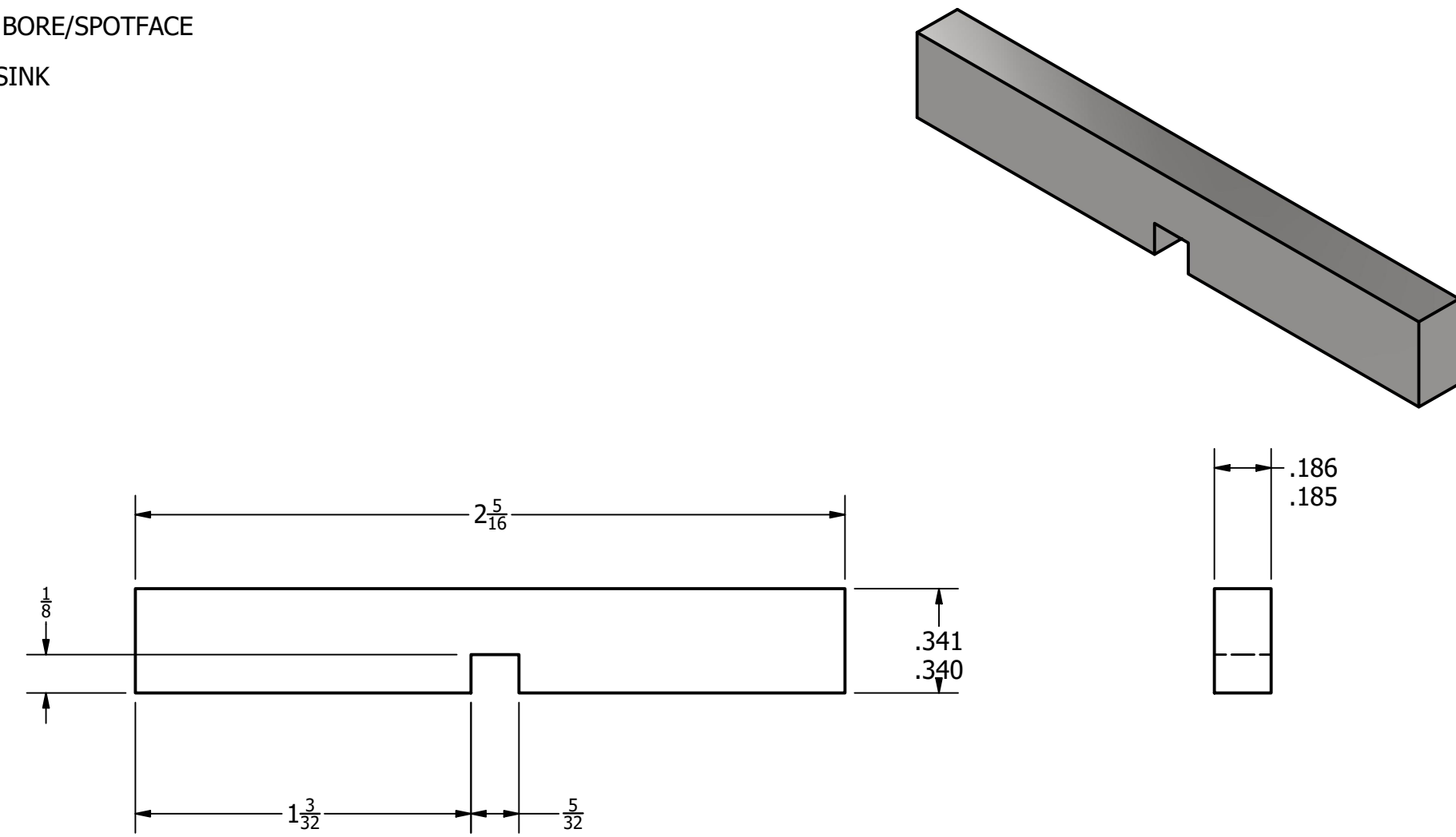
**GENERAL NOTES:**  
ALL FILLETS R 1/8 UNLESS OTHERWISE SPECIFIED

**LEGEND:**  
 Ø DIAMETER  
 R RADIUS  
 ° DEGREES  
 □ COUNTER BORE/SPOTFACE  
 ∨ COUNTERSINK  
 ▽ DEPTH

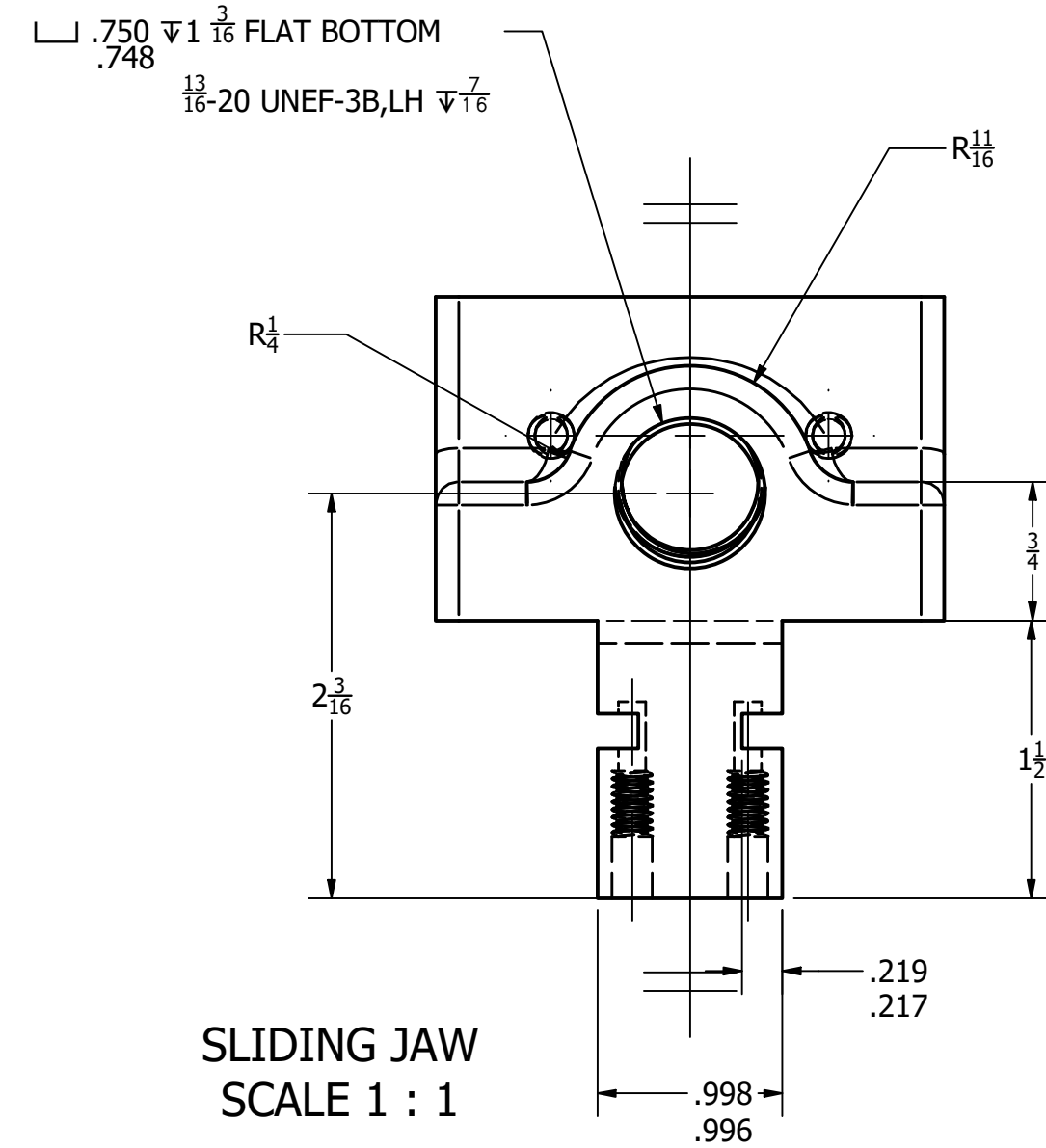
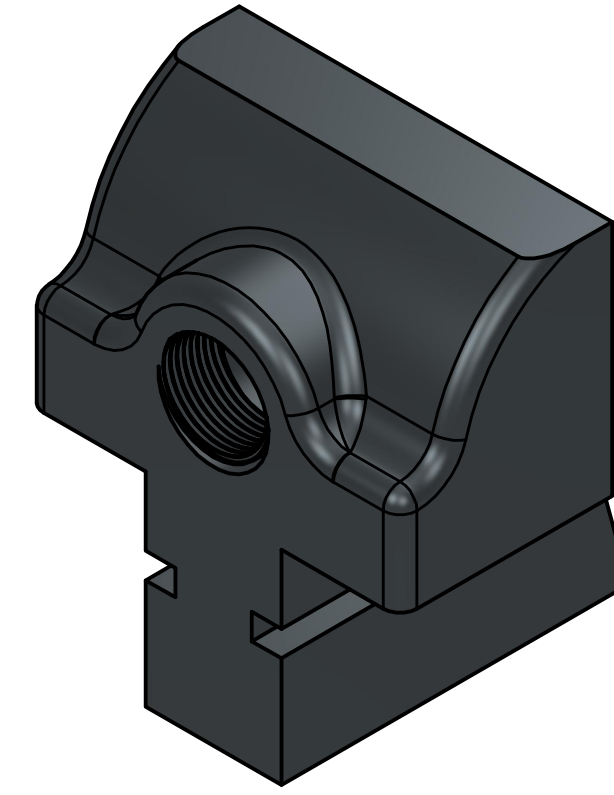
PARTS LIST		
ITEM	QTY	PART NUMBER
2	1	SLIDING JAW
4	1	WISE SCREW
9	2	SLIDE KEY
12	2	TAPER PIN
13	4	93306A580_Aluminum Hex Head Screw

**DDGT**  
 DIGITAL DESIGN  
 GRAPHIC  
 TECHNOLOGY  
 WWW.DDGT.NET

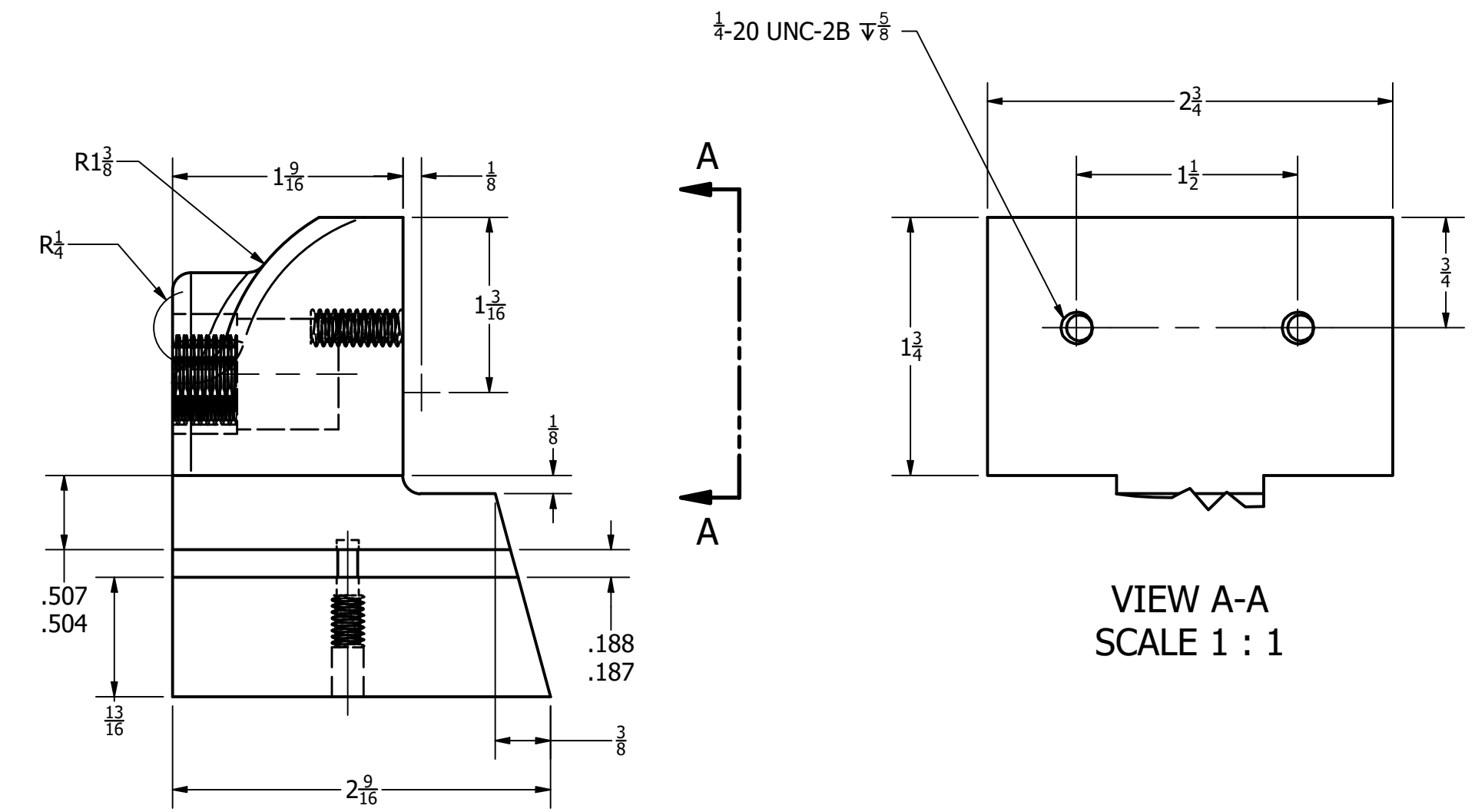
GENERAL NOTES:  
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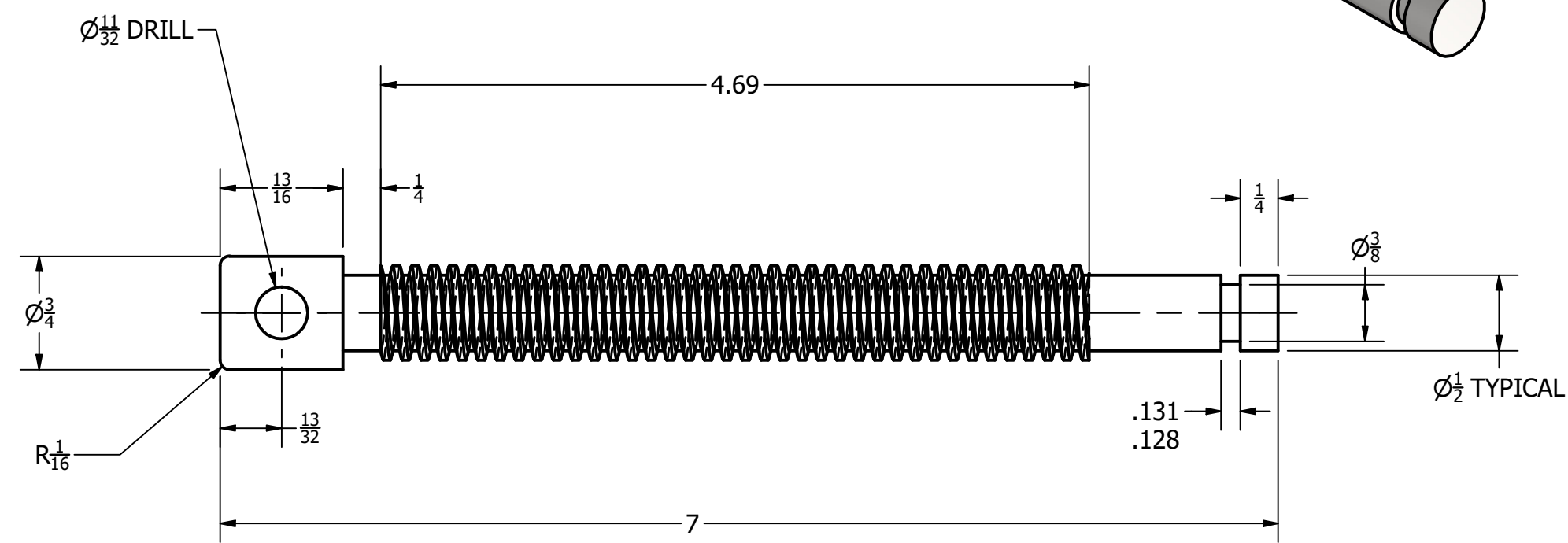
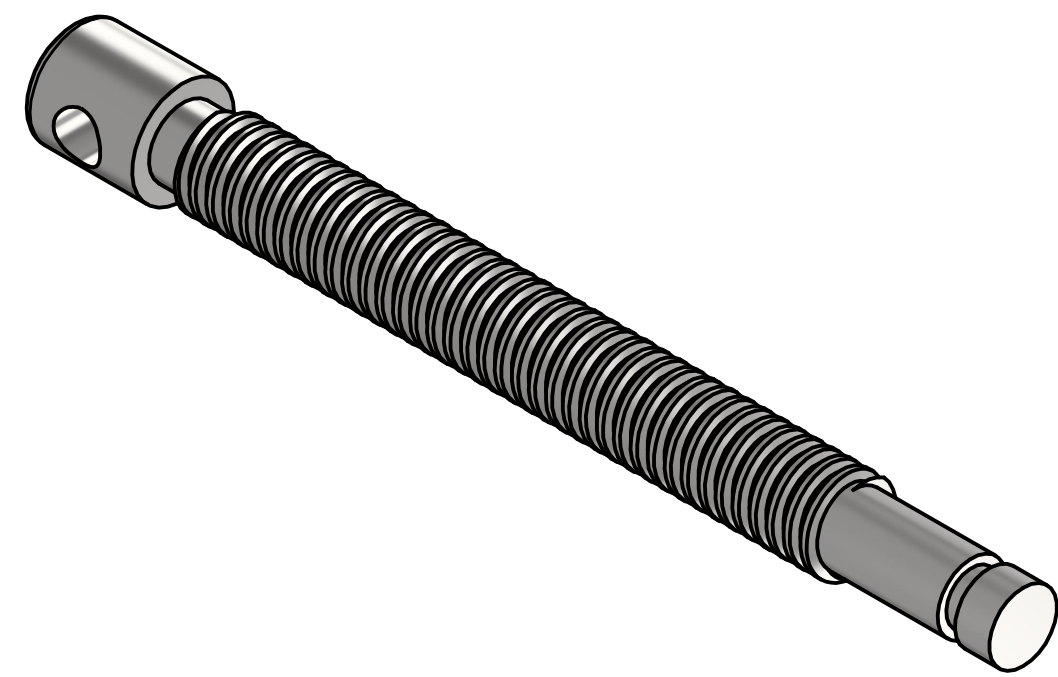
SLIDING KEY  
SCALE 2 : 1



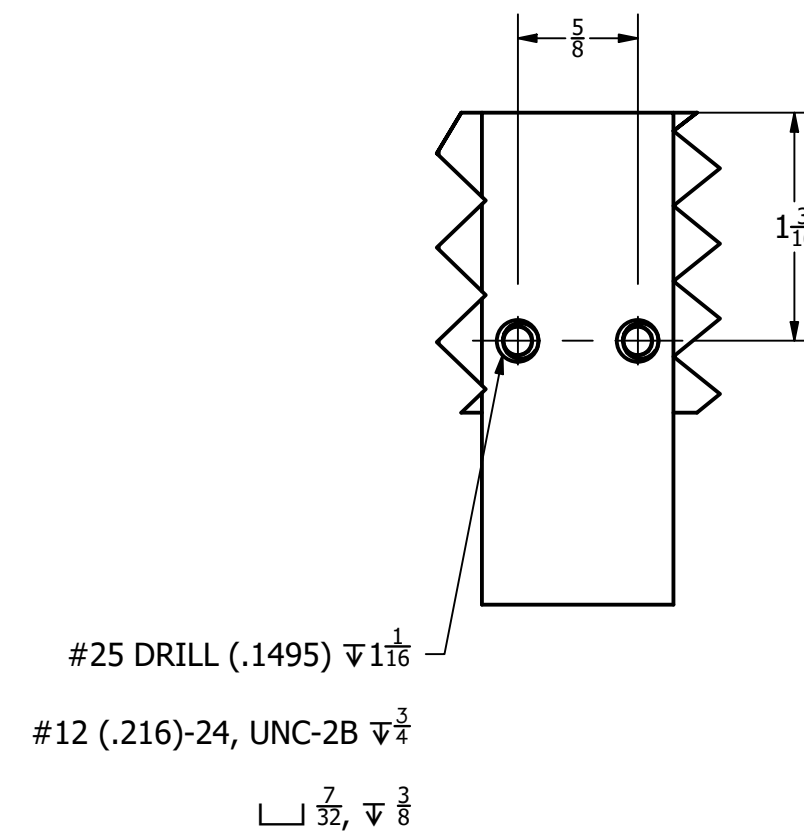
SLIDING JAW  
SCALE 1 : 1



VIEW A-A  
SCALE 1 : 1

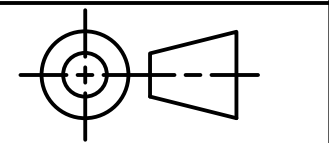


WISE SCREW  
SCALE 1 : 1



REV	DESCRIPTION	DATE	APPROVED
2	CHANGE THE OVERALL LENGTH OF THE VISE SCREW FROM 6 1/4" TO 7". SPECIFICALLY THE LENGTH OF THE THREAD FROM 3 15/16 TO 4 11/16"	10/15/2024	G.STROMMEN

REVISION HISTORY



TOLERANCES UNLESS SPECIFIED:  
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 XX = ±.005  
 XXX = ±.005  
 FRACTIONAL = ±1/64"  
 ANGLES = ±1 DEGREE

SURFACES √

CLASS: DDGT 240

ASSIGNMENT NUMBER: 38

INVENTOR DRAWING NAME:

MACHINE VISE

FIG #:

14-71

MANAGER: G. STROMMEN

DRAFTER: G. RAMIREZ

DATE: 9/30/2024

SCALE: AS NOTED

PAGE #: 6 OF 6