

MASTER ASSEMBLY  
SCALE 1 / 2

PARTS LIST				
ITEM	QTY	PART NUMBER	MATERIAL	DESCRIPTION
1	1	BASE	CAST IRON	
2	1	COLLAR	SAE 1020	
3	2	SET SCREW	SAE 1016	
4	1	SPECIAL KEY	SAE 1020	
5	1	WISE SCREW	SAE 3140	
6	2	SLIDE KEY	SAE 1020	
7	2	JAW PLATE	SAE 3140	
8	1	SLIDING JAW	CAST IRON	
9	4	COUNTER SUNK MACHINE HEAD SCREW	MILD STEEL	COUNTER SUNK MACHINE HEAD SCREW ANSI B18.6.3 - 1/4-20 UNC x 0.75, CRCTFCHMSTII(2)
11	1	HANDLE ROD	COLD ROLLED STEEL	
12	2	HANDLE BALL	SAE 1020	
13	2	TAPER PIN	STEEL	#000

### LEGEND:

- ∅ DIAMETER
- R RADIUS
- ° DEGREES
- COUNTERBORE
- ∇ DEPTH
- ∨ COUNTERSINK

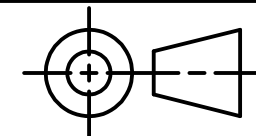
### GENERAL NOTES:

ALL FILLETS AND ROUNDS ARE 1/8  
UNLESS NOTED OTHERWISE



DIGITAL DESIGN  
GRAPHICS  
TECHNOLOGY

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TOLERANCES UNLESS SPECIFIED:  
DECIMAL INCHES:  
X = ±.020  
XX = ±.010  
XXX = ±.005  
FRACTIONAL ±1/64"  
ANGLES ±1 DEGREE  
SURFACES 32 ✓

COURSE: DDGT 240

INVENTOR DRAWING NAME:  
MACHINE VISE

FIG #: 14-71

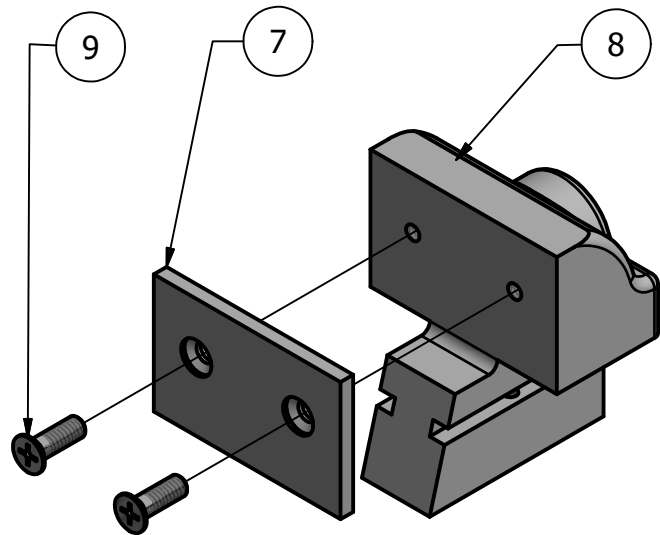
DRAFTER: MMCDONOUGH

DATE: 10/1/2020

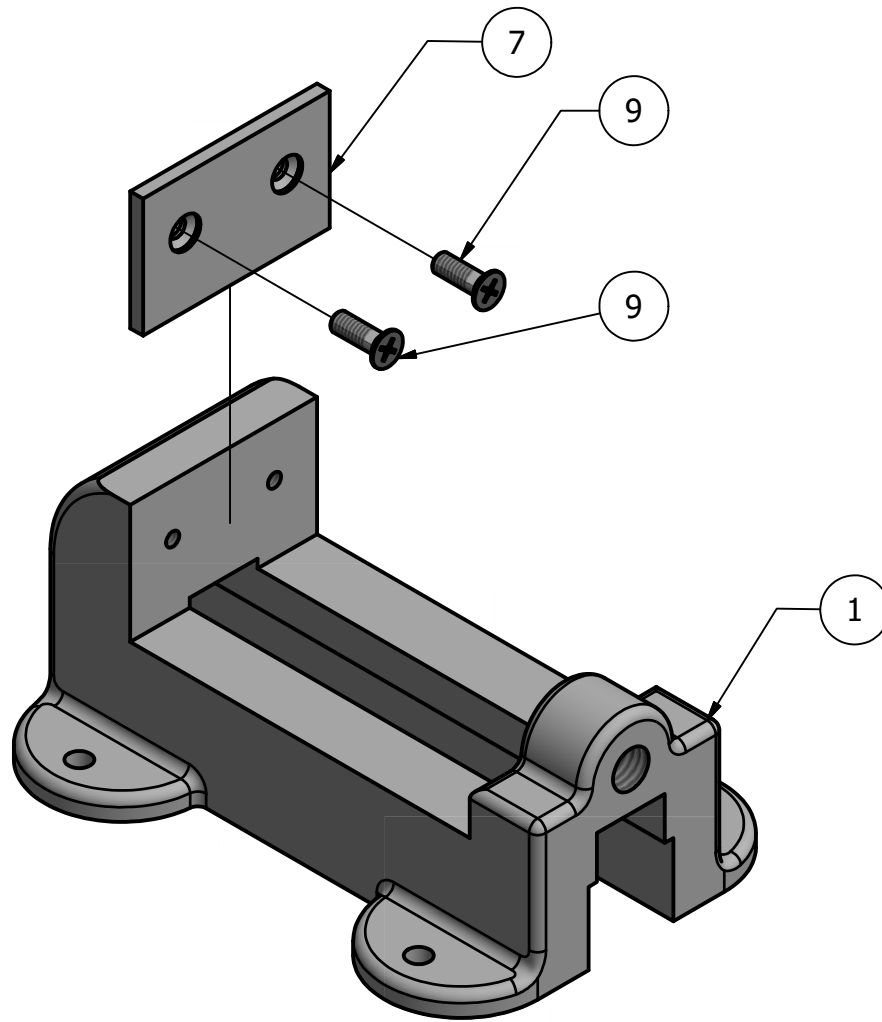
SCALE: AS NOTED

PAGE #: 1 OF 5

PARTS LIST		
ITEM	QTY	PART NUMBER
1	1	BASE
7	2	JAW PLATE
8	1	SLIDING JAW
9	4	COUNTER SUNK MACHINE HEAD SCREW



STEP 1  
SCALE 1 / 2



STEP 2  
SCALE 1 / 2

**LEGEND:**

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- R RADIUS
- ° DEGREES
- COUNTERBORE
- ∇ DEPTH
- ∨ COUNTERSINK

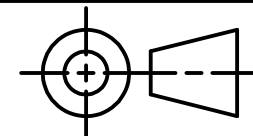
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SURFACES 32 ✓

COURSE: DDGT 240

INVENTOR DRAWING NAME:  
MACHINE VISE

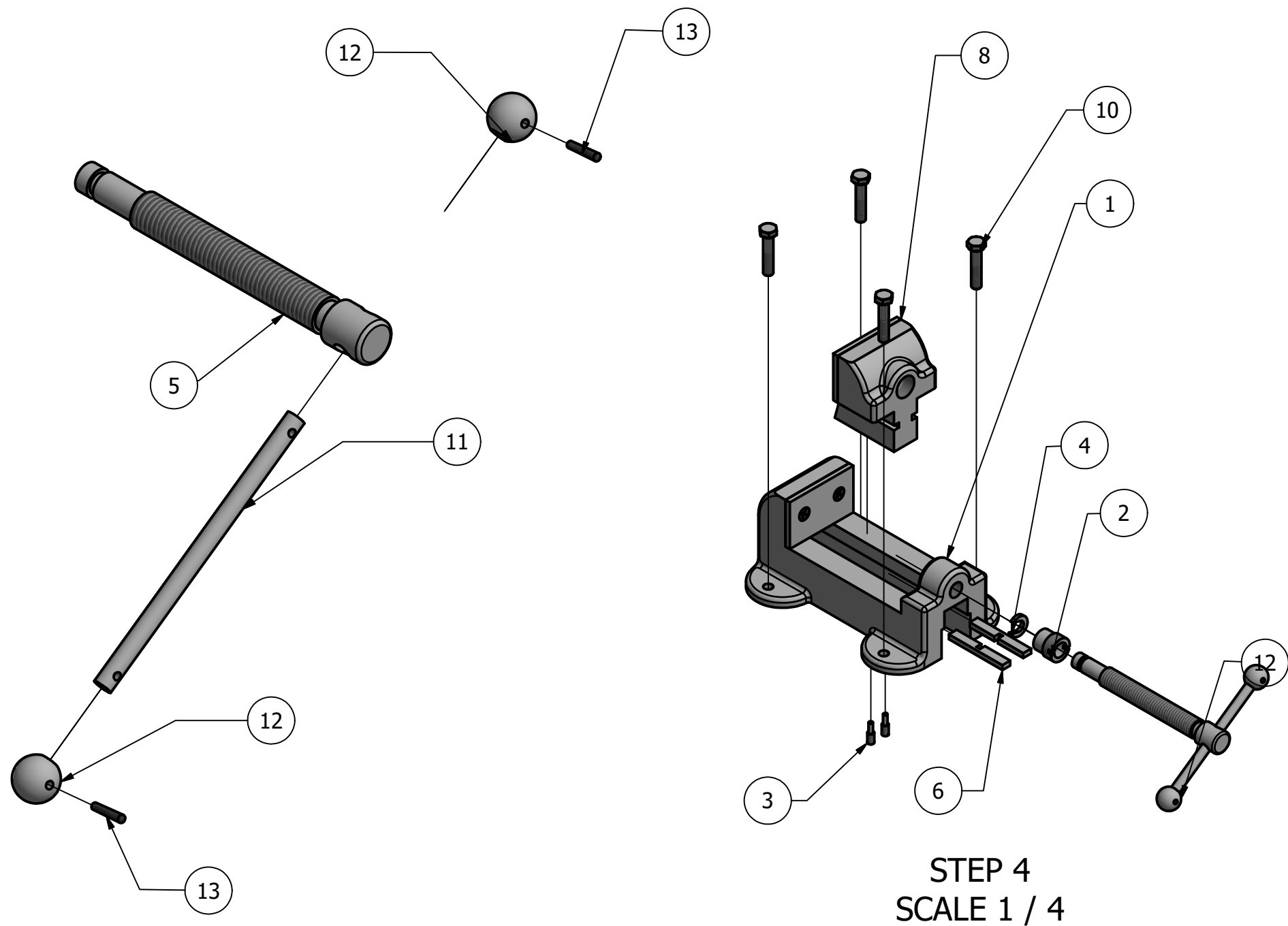
FIG #: 14-71

DRAFTER: MMCDONOUGH

DATE: 10/1/2020

SCALE: AS NOTED

PAGE #: 2 OF 5



STEP 3  
SCALE 1 / 2

STEP 4  
SCALE 1 / 4

PARTS LIST		
ITEM	QTY	PART NUMBER
1	1	BASE
2	1	COLLAR
3	2	SET SCREW
4	1	SPECIAL KEY
5	1	VISE SCREW
6	2	SLIDE KEY
7	2	JAW PLATE
8	1	SLIDING JAW
10	4	AS 2465 - 5/16 x 1 1/2 UNC
11	1	HANDLE ROD
12	2	HANDLE BALL
13	2	TAPER PIN

**LEGEND:**

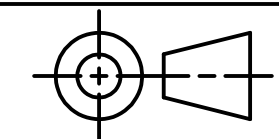
- ∅ DIAMETER
- R RADIUS
- ° DEGREES
- COUNTERBORE
- ∇ DEPTH
- ∨ COUNTERSINK

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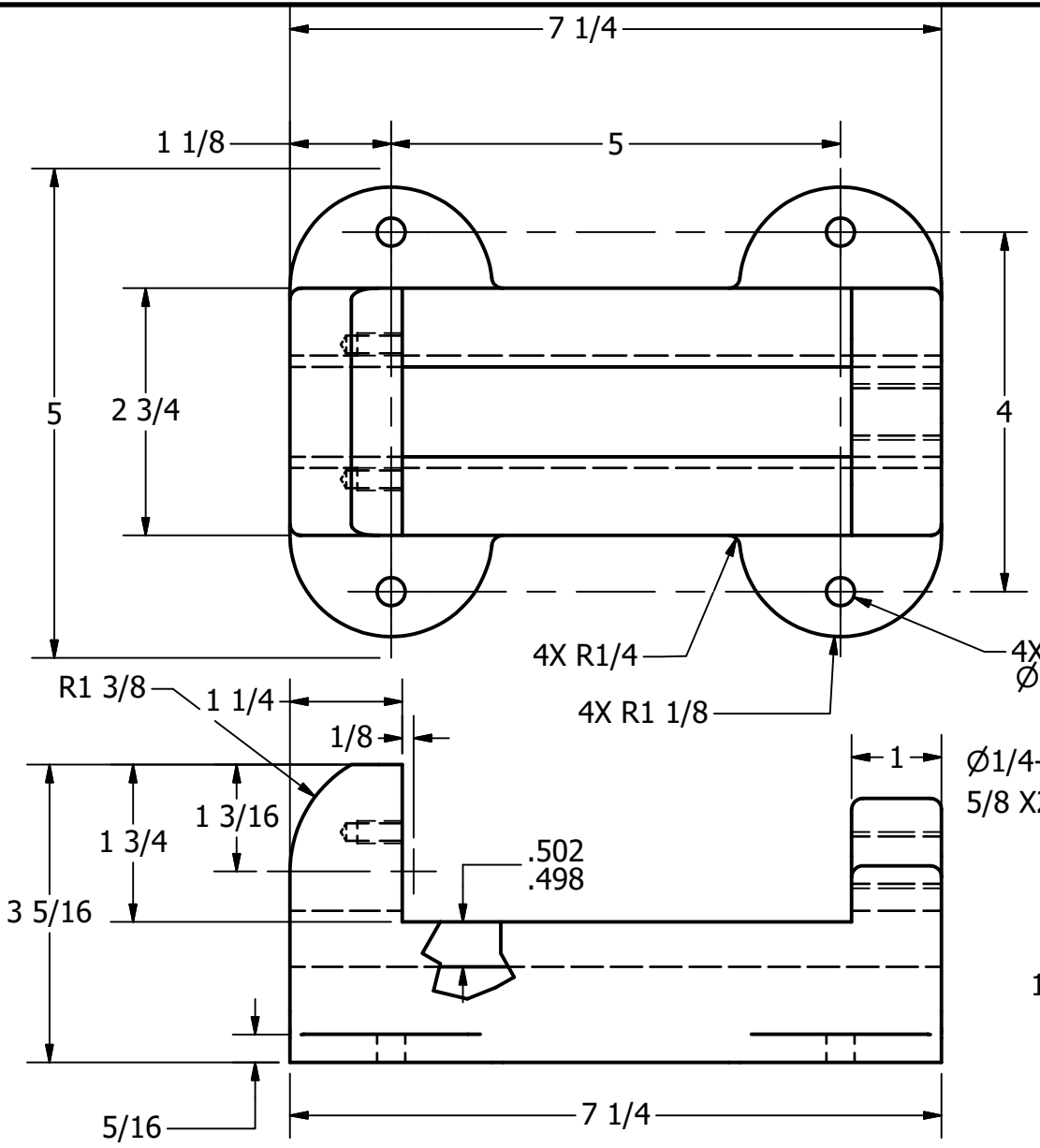
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GRAPHICS  
TECHNOLOGY

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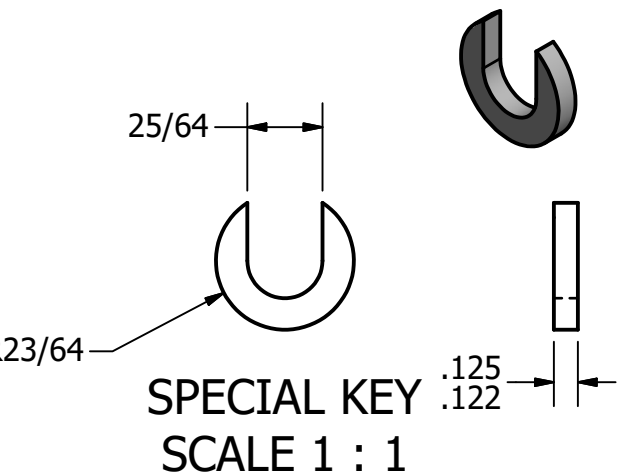


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INVENTOR DRAWING NAME:	MACHINE VISE
FIG #:	14-71
DRAFTER:	MMCDONOUGH
DATE:	10/1/2020
SCALE:	AS NOTED
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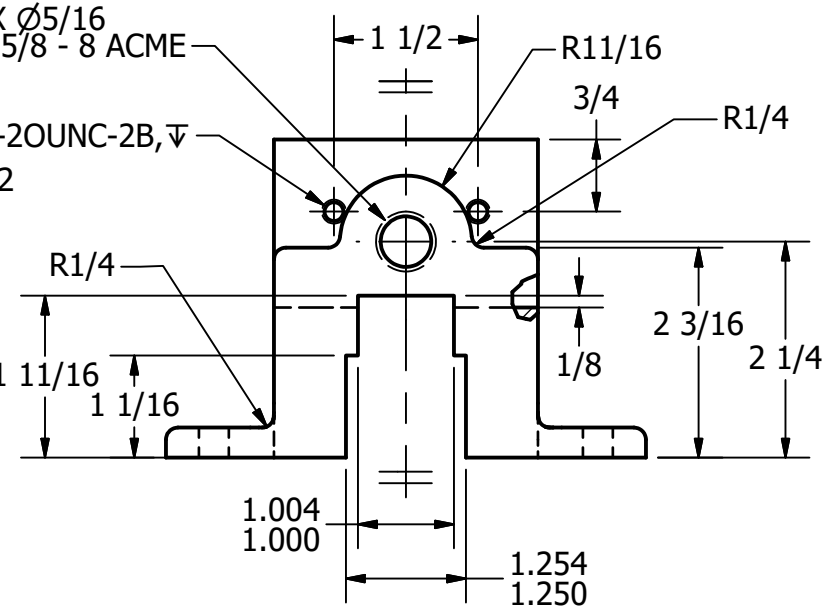
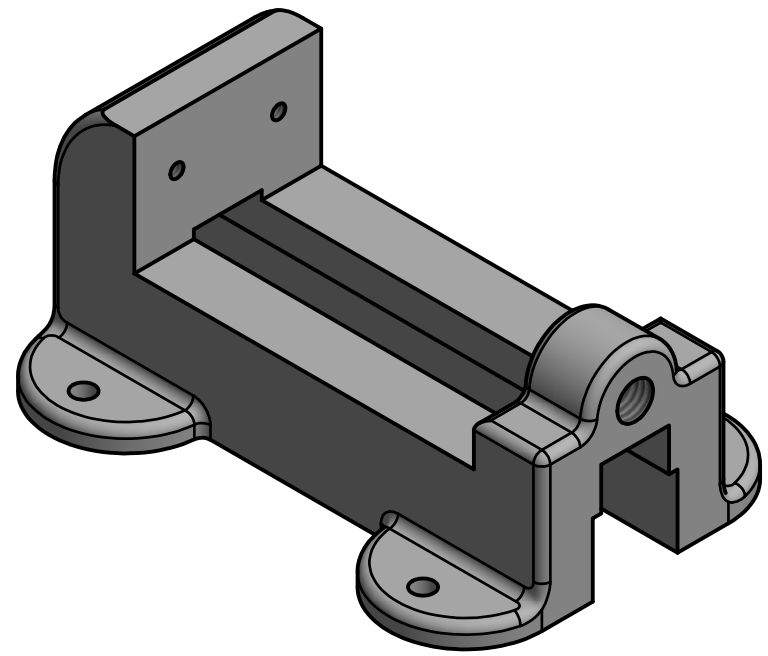


**BASE**  
SCALE 1 / 2

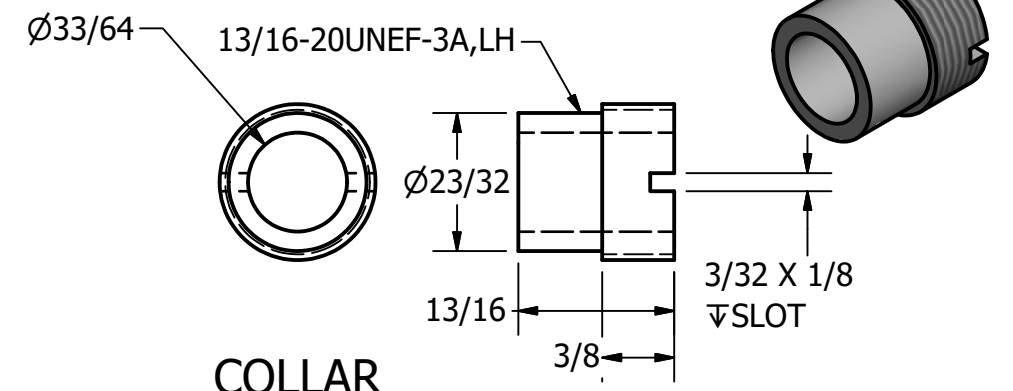


**SPECIAL KEY**  
SCALE 1 : 1

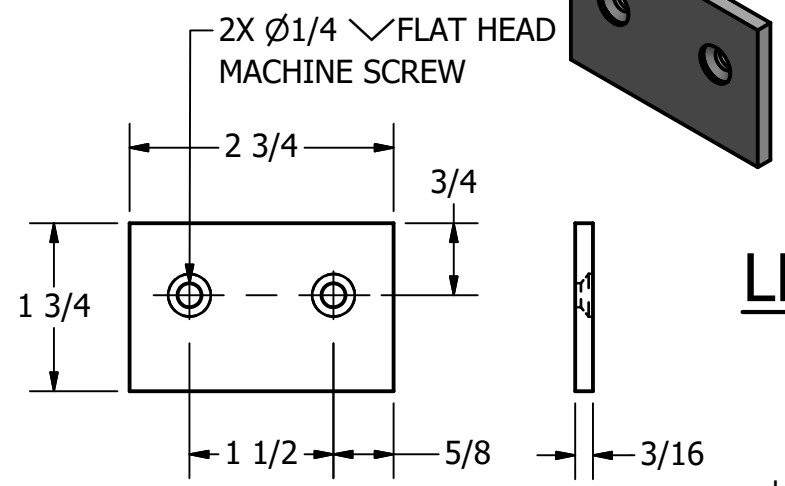
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PARTS LIST		
ITEM	QTY	PART NUMBER
1	1	BASE
2	1	COLLAR
4	1	SPECIAL KEY
7	2	JAW PLATE



**COLLAR**  
SCALE 1 : 1



**JAW PLATE**  
SCALE 1 / 2

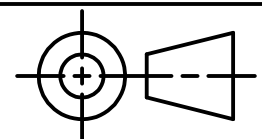
**LEGEND:**

- Ø DIAMETER
- R RADIUS
- ° DEGREES
- COUNTERBORE
- ∇ DEPTH
- ∨ COUNTERSINK



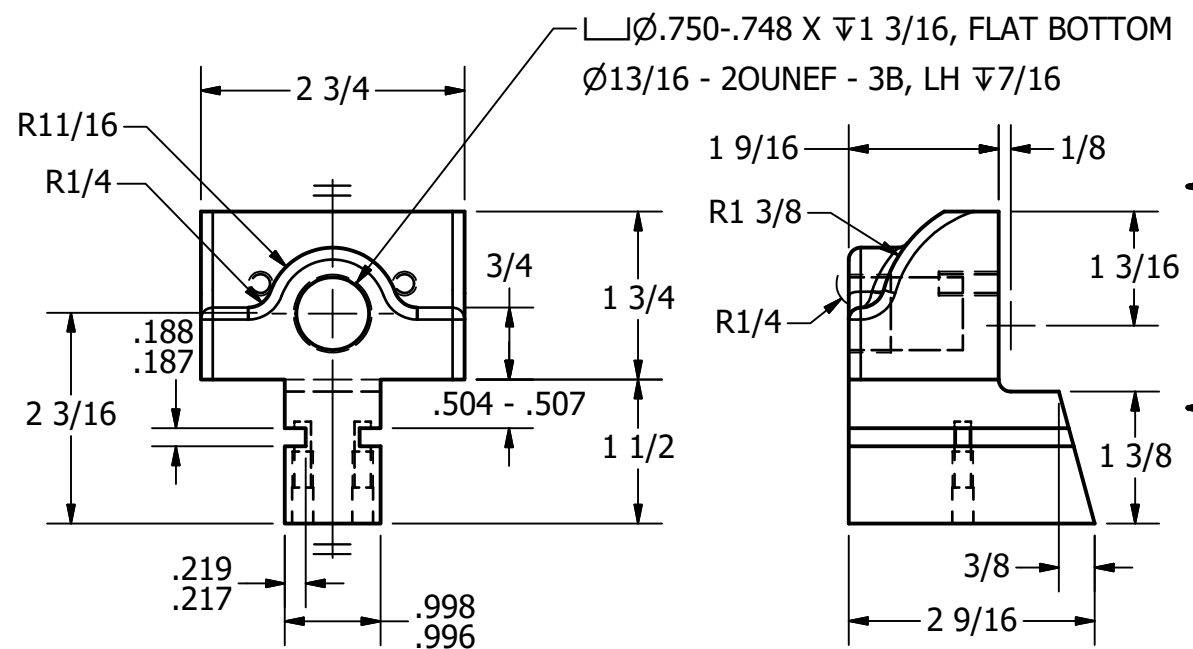
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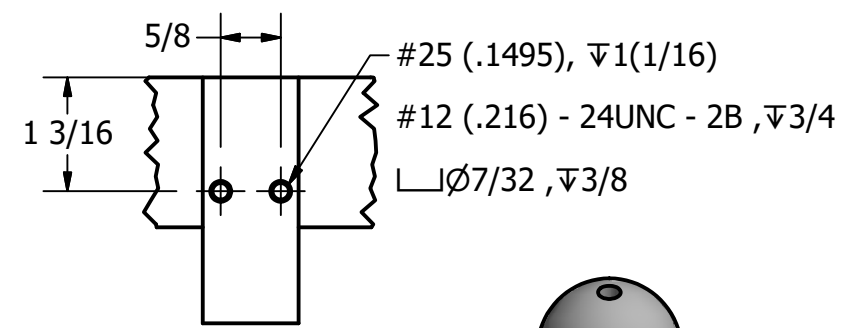


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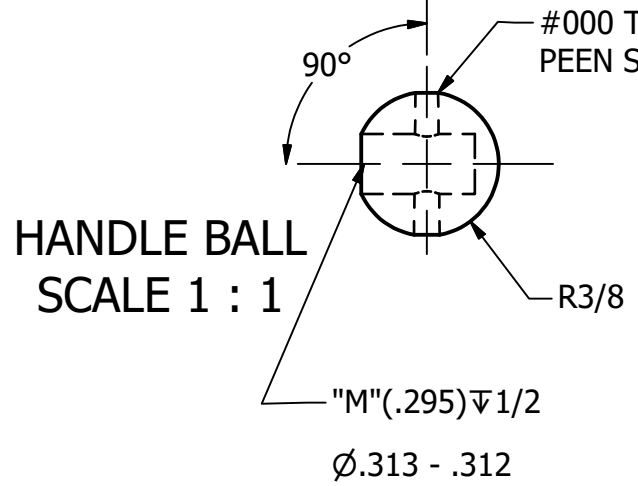
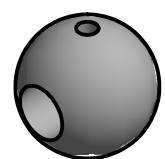
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INVENTOR DRAWING NAME:	MACHINE VISE
FIG #:	14-71
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SLIDING JAW  
SCALE 1 / 2

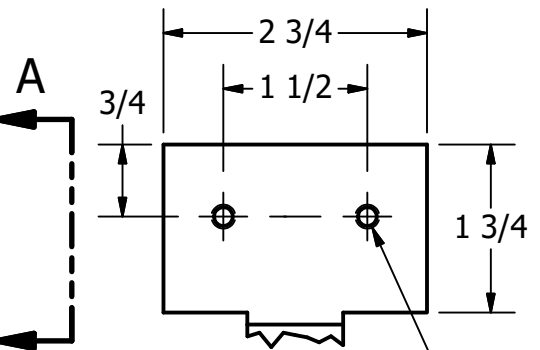


VIEW B-B  
SCALE 1 / 2

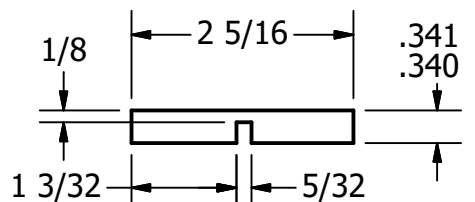
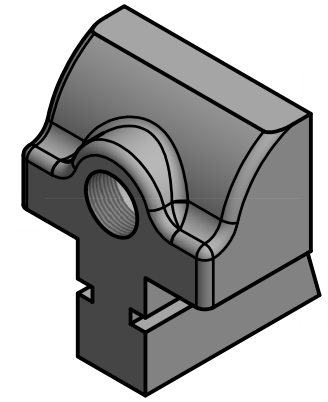


HANDLE BALL  
SCALE 1 : 1

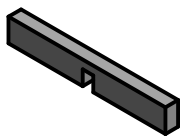
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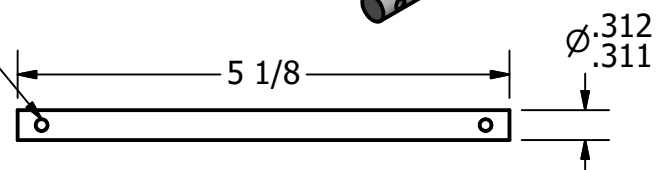
VIEW A-A  
SCALE 1 / 2



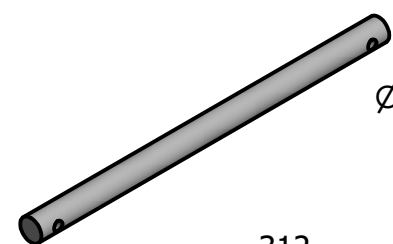
SLIDE KEY  
SCALE 1 / 2



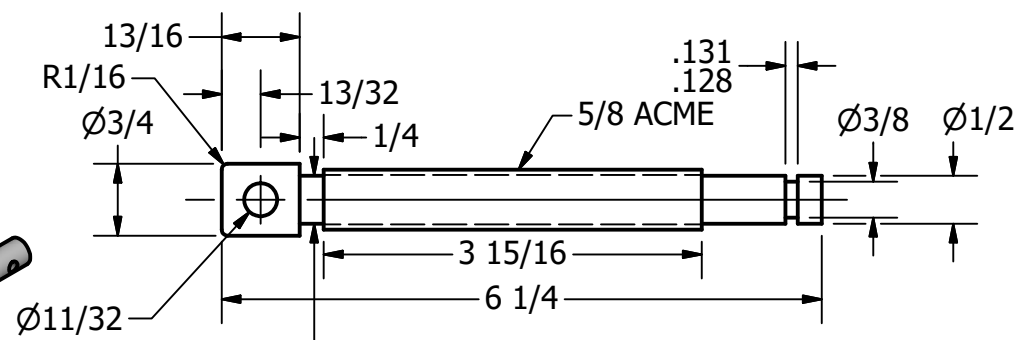
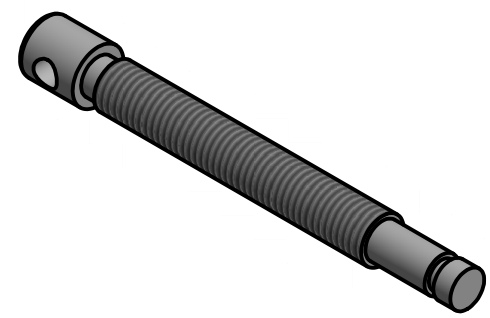
2X #37 DRILL AND  
REAM WITH PART  
#9 IN PLACE



HANDLE ROD  
SCALE 1 / 2



PARTS LIST		
ITEM	QTY	PART NUMBER
5	1	WISE SCREW
6	2	SLIDE KEY
8	1	SLIDING JAW
11	1	HANDLE ROD
12	2	HANDLE BALL



WISE SCREW  
SCALE 1 / 2

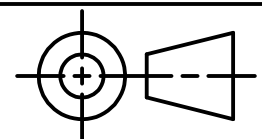
**LEGEND:**

- $\varnothing$  DIAMETER
- R RADIUS
- $\circ$  DEGREES
- $\sqcup$  COUNTERBORE
- $\nabla$  DEPTH
- $\sphericalangle$  COUNTERSINK



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