

PARTS LIST				
ITEM	QTY	PART NUMBER	MATERIAL	DESCRIPTION
1	1	BASE	CAST IRON	
2	1	SLIDING JAW	CAST IRON	
3	1	JAW PLATE	SAE 3140	
4	1	WISE SCREW	SAE 3140	
5	1	HANDLE ROD	COLD ROLLED STEEL	
6	1	HANDLE BALL	SAE 1020	
7	1	COLLAR	SAE 1020	
8	1	SPECIAL KEY	SAE 1020	
9	2	SLIDE KEY	SAE 1020	
10	2	SET SCREW	SAE 1016	
11	4	FLAT HEAD MACHINE SCREW	TYPICAL	1/4"-20 UNC, 5/8 DEEP
12	2	TAPER PIN	TYPICAL	#000 TAPER PIN

MASTER ASSEMBLY
SCALE 1 : 1

LEGEND:

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

GENERAL NOTES:

ALL FILLETS AND ROUNDS 1/8, UNLESS OTHERWISE SPECIFIED



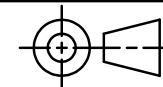
DIGITAL DESIGN
GRAPHICS
TECHNOLOGY

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

COURSE: DDGT240

INVENTOR DRAWING NAME
MACHINE VISE

FIG #: 14-71

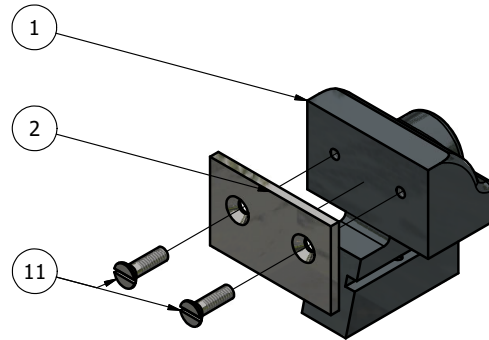
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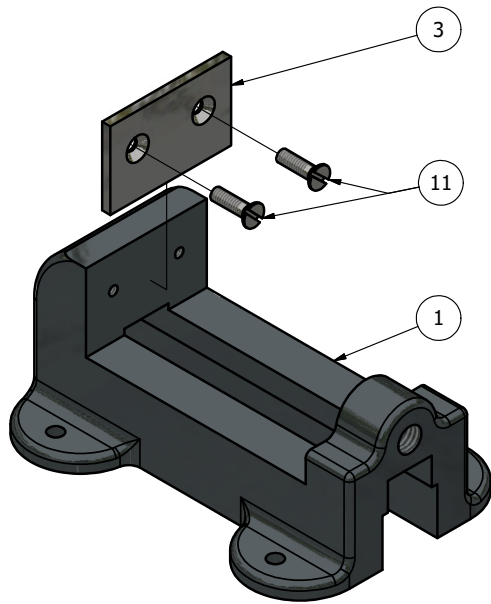
SCALE: AS NOTED

PAGE #: 1 OF 5

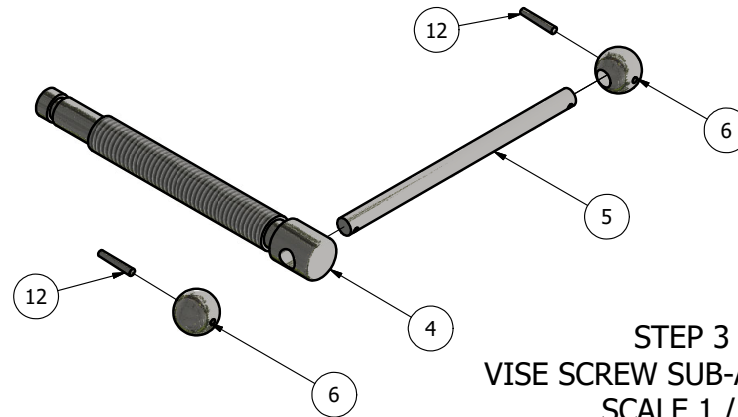
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1	1	BASE
2	1	SLIDING JAW
3	1	JAW PLATE
4	1	WISE SCREW
5	1	HANDLE ROD
6	1	HANDLE BALL
7	1	COLLAR
8	1	SPECIAL KEY
9	2	SLIDE KEY
10	2	SET SCREW
11	4	FLAT HEAD MACHINE SCREW
12	2	TAPER PIN



STEP 2
SLIDING JAW SUB-ASSEMBLY
SCALE 1 / 2



STEP 1
BASE SUB-ASSEMBLY
SCALE 1 / 2



STEP 3
WISE SCREW SUB-ASSEMBLY
SCALE 1 / 2

LEGEND:

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

GENERAL NOTES:

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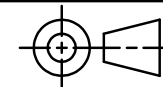
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MACHINE VISE

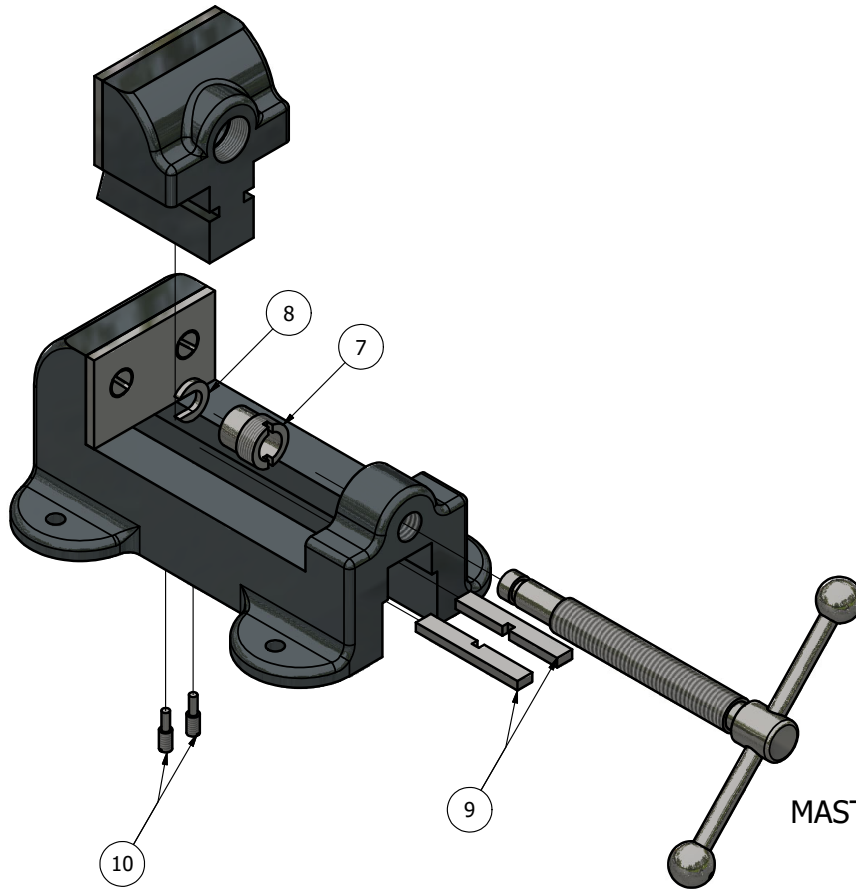
FIG #: 14-71

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SCALE: AS NOTED

PAGE #: 2 OF 5



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

STEP 4
 MASTER ASSEMBLY EXPLODED VIEW
 SCALE 1 / 2

LEGEND:

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

GENERAL NOTES:

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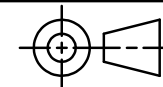
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MACHINE VISE

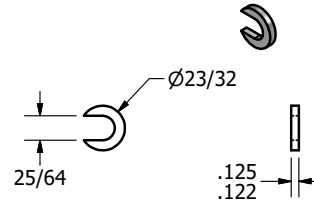
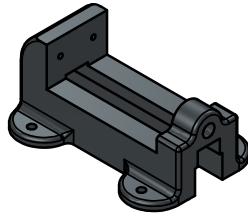
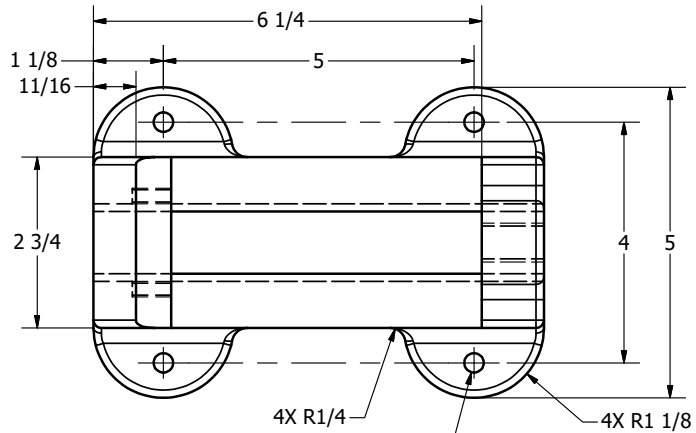
FIG #: 14-71

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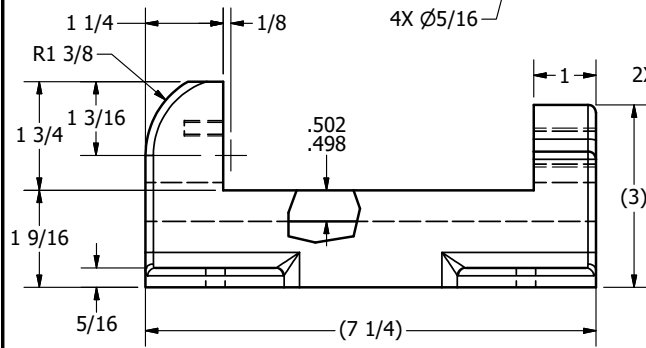
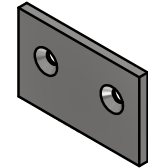
SCALE: AS NOTED

PAGE #: 3 OF 5

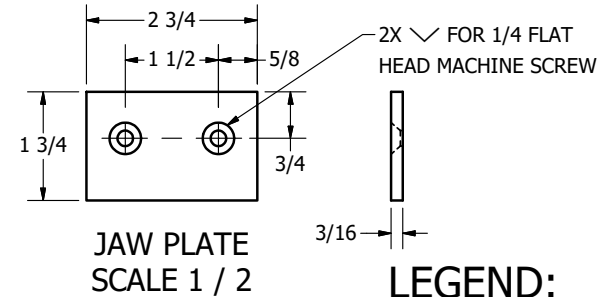
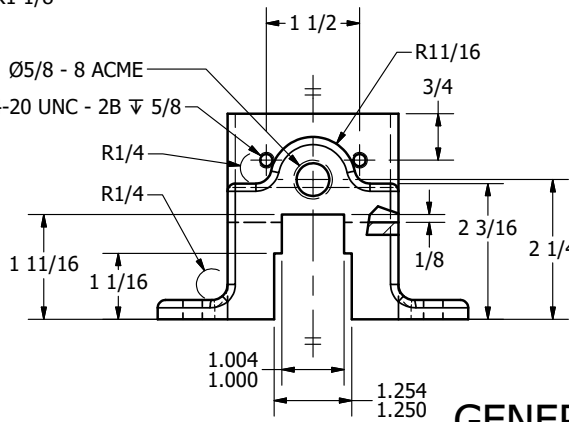


SPECIAL KEY
SCALE 1 / 2

PARTS LIST		
ITEM	QTY	PART NUMBER
1	1	BASE
3	1	JAW PLATE
7	1	COLLAR
8	1	SPECIAL KEY



BASE
SCALE 1 / 2



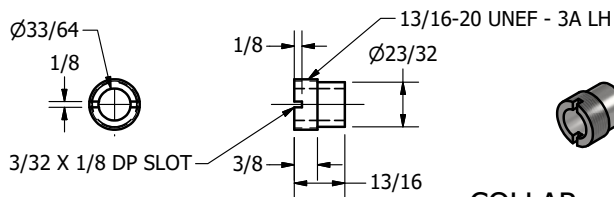
JAW PLATE
SCALE 1 / 2

LEGEND:

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

GENERAL NOTES:

ALL FILLETS AND ROUNDS 1/8, UNLESS OTHERWISE SPECIFIED



COLLAR
SCALE 1 / 2

DDGT

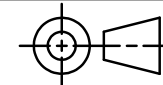
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SURFACES 32 ∇

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INVENTOR DRAWING NAME
MACHINE VISE

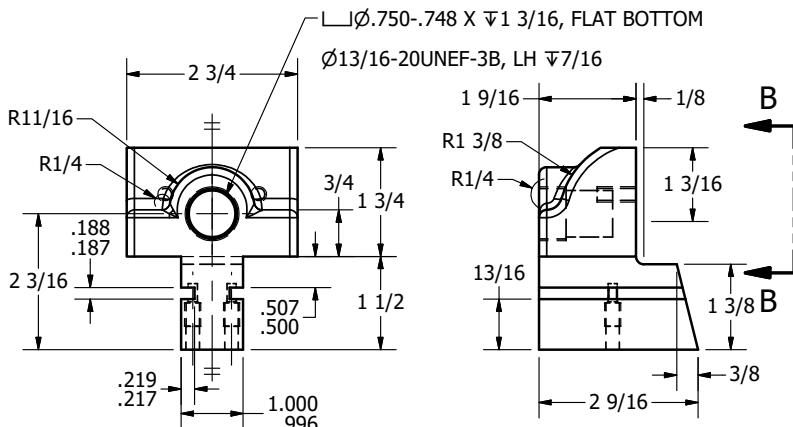
FIG #: 14-71

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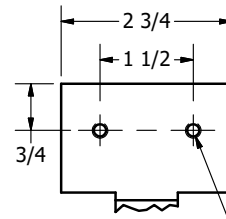
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SCALE: AS NOTED

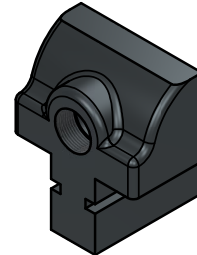
PAGE #: 4 OF 5



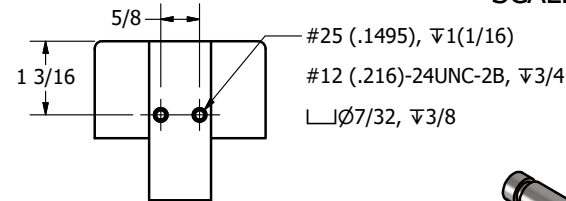
SLIDING JAW
SCALE 1 / 2



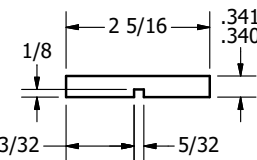
VIEW B-B
SCALE 1 / 2



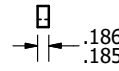
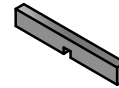
2X 1/4-20 UNC - 2B $\nabla 5/8$



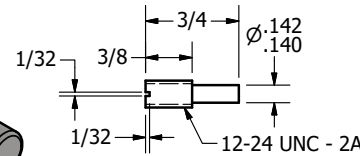
VIEW A-A
SCALE 1 / 2



SLIDE KEY
SCALE 1 / 2



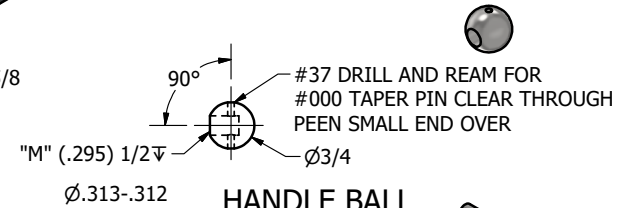
2X #37 DRILL AND REAM WITH PART #6 IN PLACE



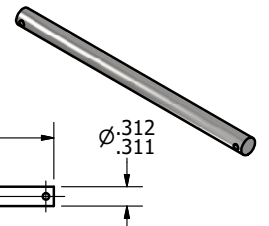
SET SCREW
SCALE 1 : 1



PARTS LIST		
ITEM	QTY	PART NUMBER
2	1	SLIDING JAW
4	1	WISE SCREW
5	1	HANDLE ROD
6	1	HANDLE BALL
9	2	SLIDE KEY
10	2	SET SCREW



HANDLE BALL
SCALE 1 / 2



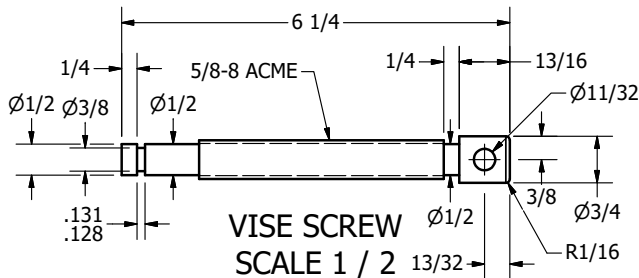
HANDLE ROD
SCALE 1 / 2

LEGEND:

- \varnothing DIAMETER
- R RADIUS
- ° DEGREES
- \perp COUNTERBORE
- ∇ COUNTERSINK
- ∇ DEPTH

GENERAL NOTES:

ALL FILLETS AND ROUNDS 1/8, UNLESS OTHERWISE SPECIFIED



WISE SCREW
SCALE 1 / 2

DDGT

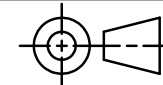
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FIG #: 14-71

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DATE: 5/26/2021

SCALE: AS NOTED

PAGE #: 5 OF 5