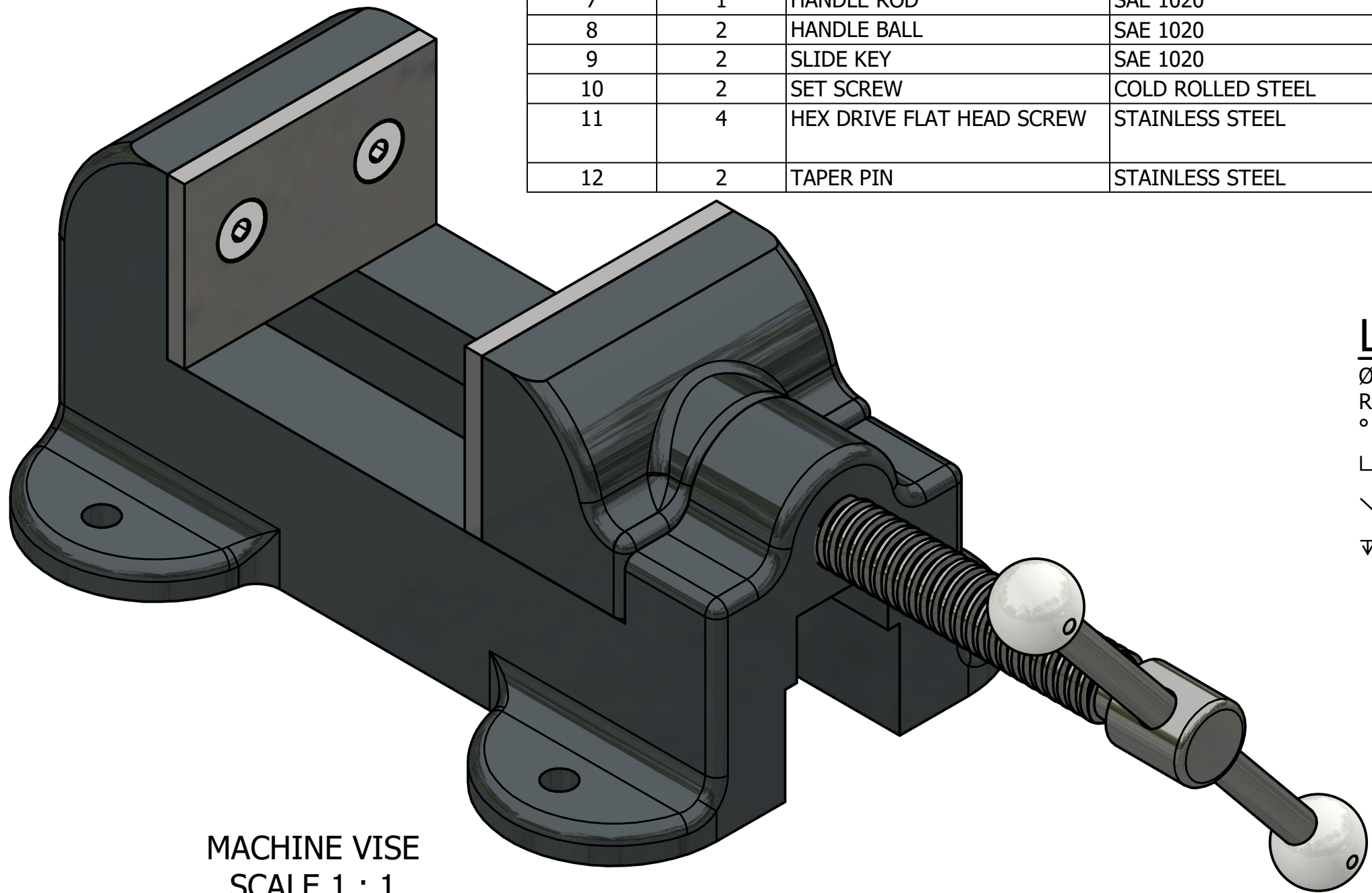




MACHINE VISE
SCALE 1 : 1

PARTS LIST				
ITEM	QTY	PART NUMBER	MATERIAL	DESCRIPTION
1	1	BASE	CAST IRON	
2	1	SLIDING JAW	CAST IRON	
3	2	JAW PLATE	SAE 1020	
4	1	WISE SCREW	SAE 1020	
5	1	COLLAR	SAE 1020	
6	1	SPECIAL KEY	SAE 1020	
7	1	HANDLE ROD	SAE 1020	
8	2	HANDLE BALL	SAE 1020	
9	2	SLIDE KEY	SAE 1020	
10	2	SET SCREW	COLD ROLLED STEEL	
11	4	HEX DRIVE FLAT HEAD SCREW	STAINLESS STEEL	MCMaster CARR 92210A540 1/4-20UNC, 3/4 LONG
12	2	TAPER PIN	STAINLESS STEEL	#000, 3/4 LONG

LEGEND:

- Ø DIAMETER
- R RADIUS
- ° ANGLE
- COUNTERBORE/SPOTFACE
- COUNTERSINK
- DEPTH

GENERAL NOTES:

ALL ROUNDS AND FILLETS R 1/8" UNLESS OTHERWISE SPECIFIED

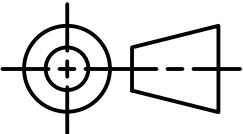


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XX = ±.010
XXX = ±.005
FRACTIONAL ±1/64"
ANGLES ±1 DEGREE
SURFACES ³²✓

CLASS: DDGT 240

ASSIGNMENT #: 38

INVENTOR DRAWING NAME:
MACHINE VISE

FIG #: 14-71

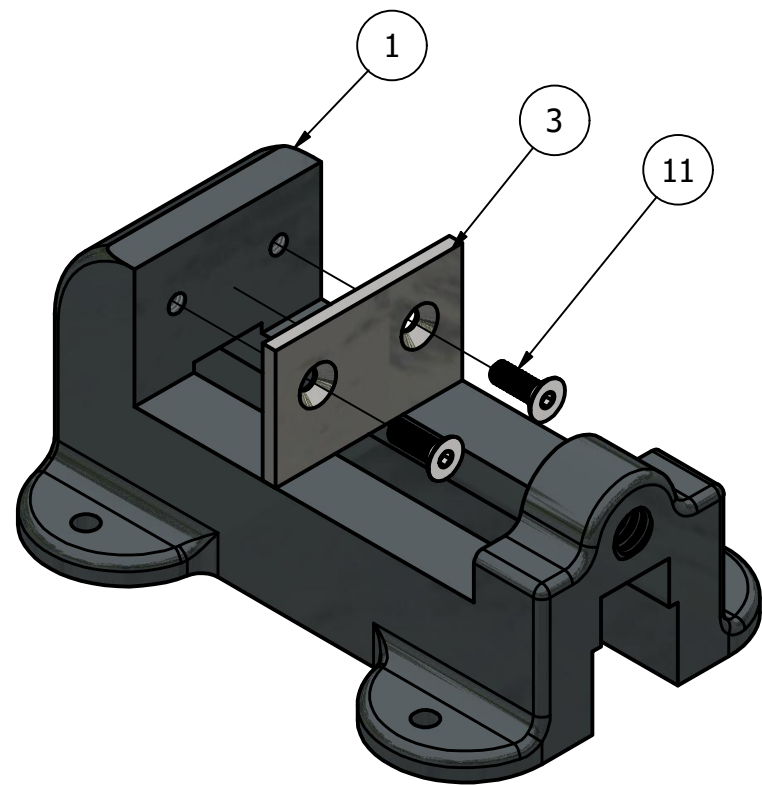
MANAGER: G. STROMNEN

DRAFTER: P. BELL

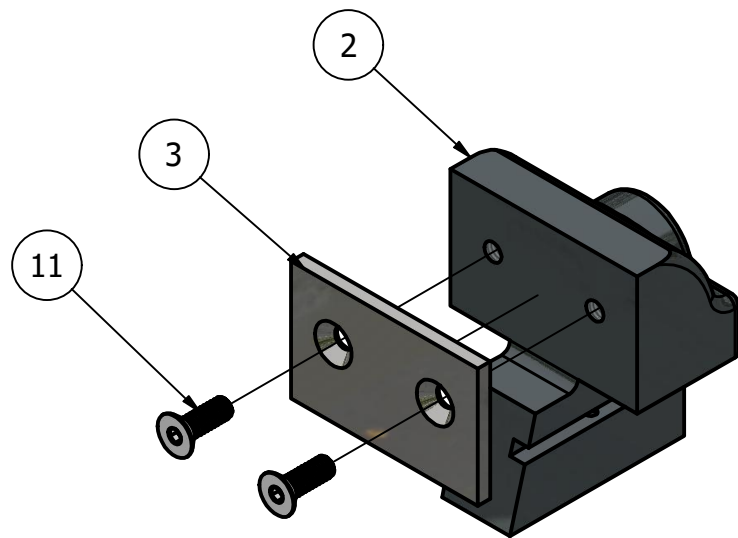
DATE: 9/21/2025

SCALE: AS NOTED

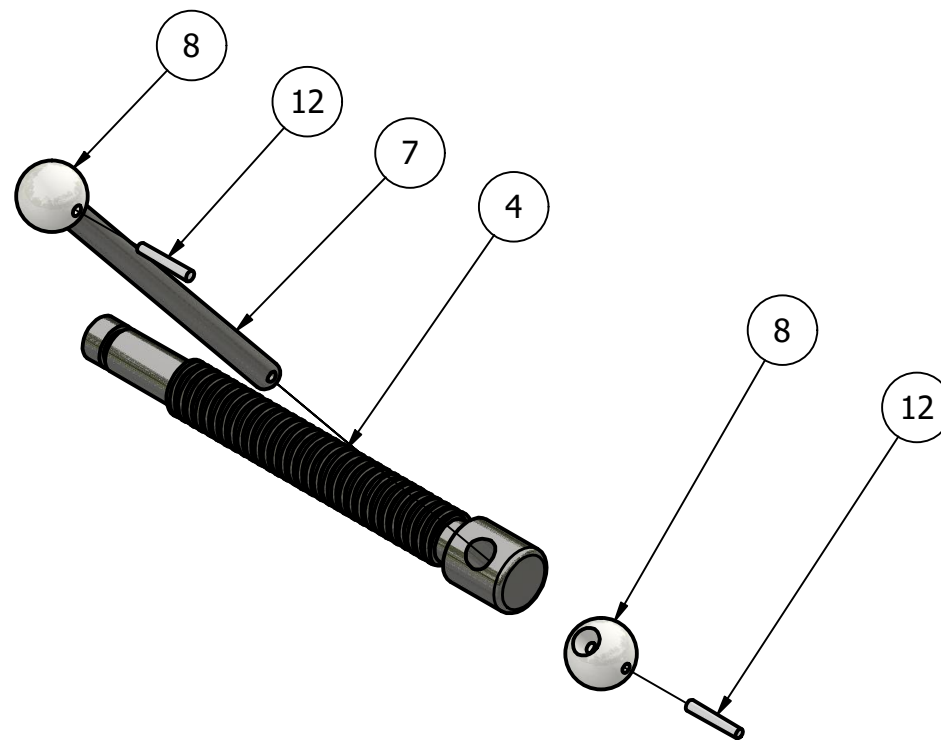
PAGE #: 1 OF 7



STEP 1
SCALE 1 / 2

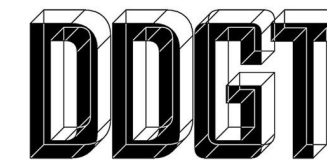


STEP 2
SCALE 1 / 2



STEP 3
SCALE 1 / 2

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	HEX DRIVE FLAT HEAD SCREW

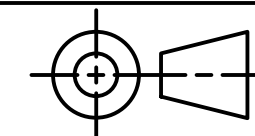


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CLASS: DDGT 240

ASSIGNMENT #: 38

INVENTOR DRAWING NAME:
MACHINE VISE

FIG #: 14-71

MANAGER: G. STROMNEN

DRAFTER: P. BELL

DATE: 9/21/2025

SCALE: AS NOTED

PAGE #: 2 OF 7

LEGEND:

Ø DIAMETER

R RADIUS

° ANGLE

└─ COUNTERBORE/SPOTFACE

✓ COUNTERSINK

▽ DEPTH

GENERAL NOTES:

ALL ROUNDS AND FILLETS R 1/8" UNLESS OTHERWISE SPECIFIED

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
5	1	COLLAR	
6	1	SPECIAL KEY	
9	2	SLIDE KEY	
10	2	SET SCREW	

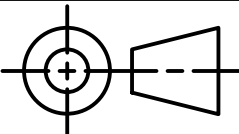


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FRACTIONAL ±1/64"
ANGLES ±1 DEGREE
SURFACES $\sqrt{32}$

CLASS: DDGT 240

ASSIGNMENT #: 38

INVENTOR DRAWING NAME:
MACHINE VISE

FIG #: 14-71

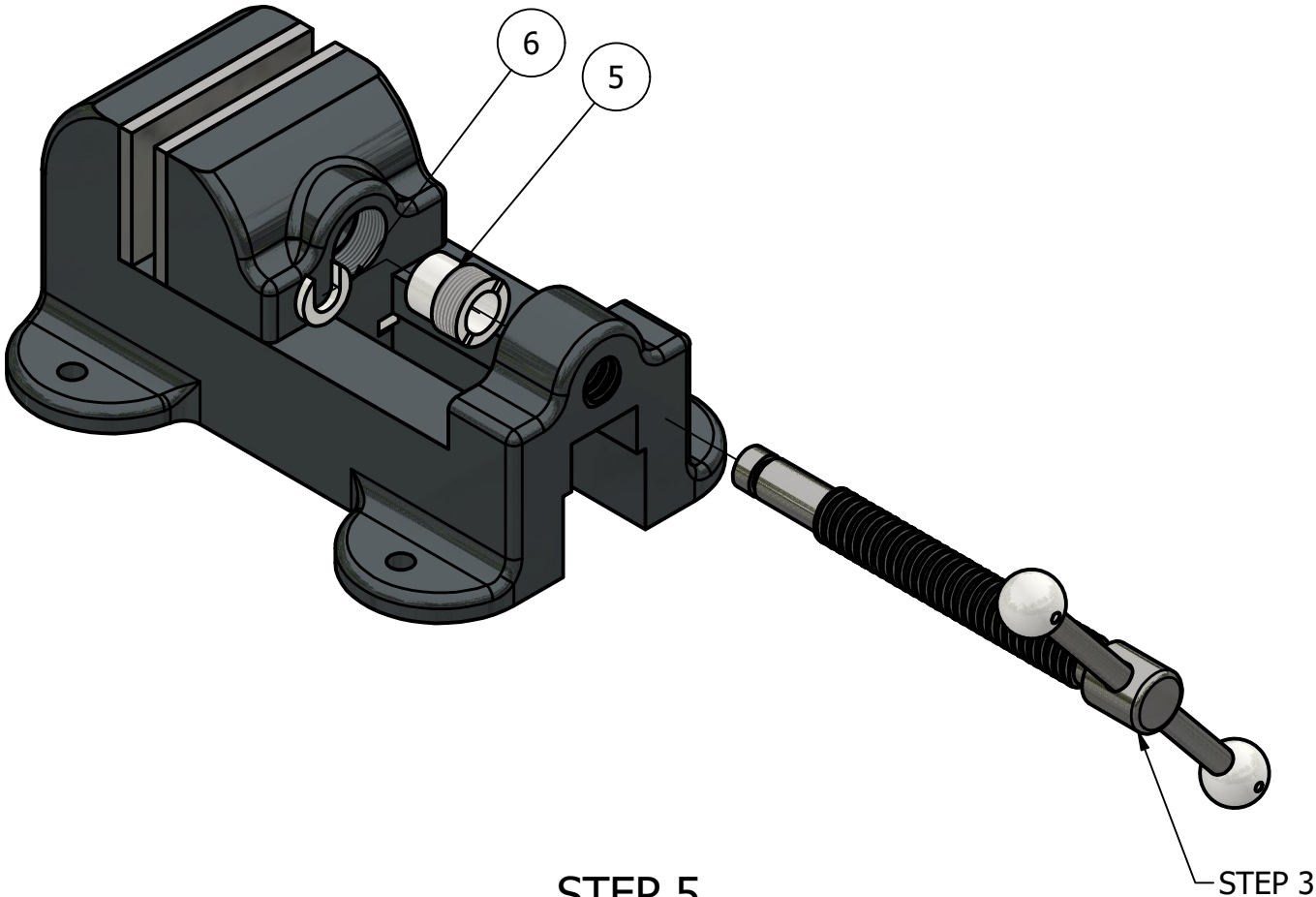
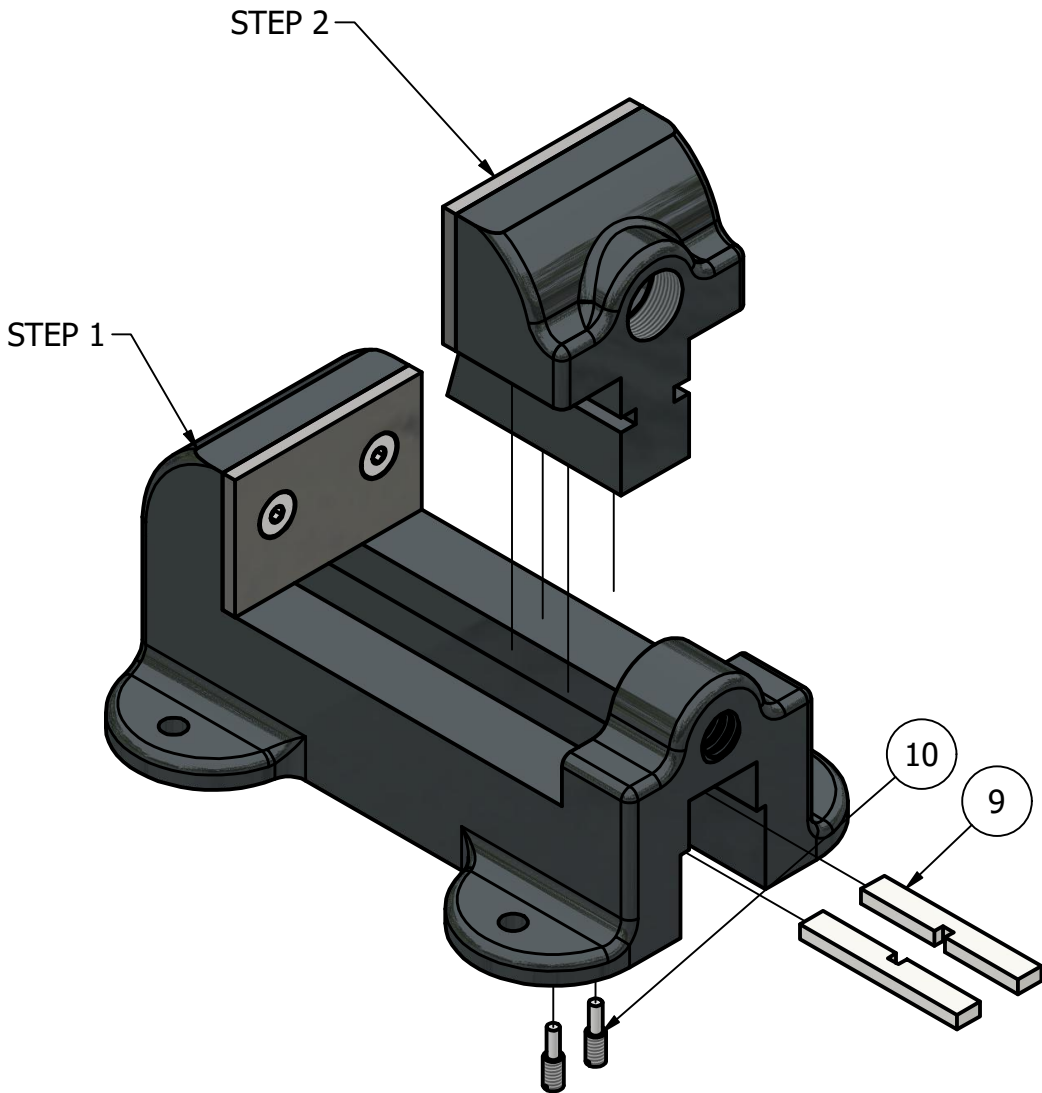
MANAGER: G. STROMNEN

DRAFTER: P. BELL

DATE: 9/21/2025

SCALE: AS NOTED

PAGE #: 3 OF 7



LEGEND:

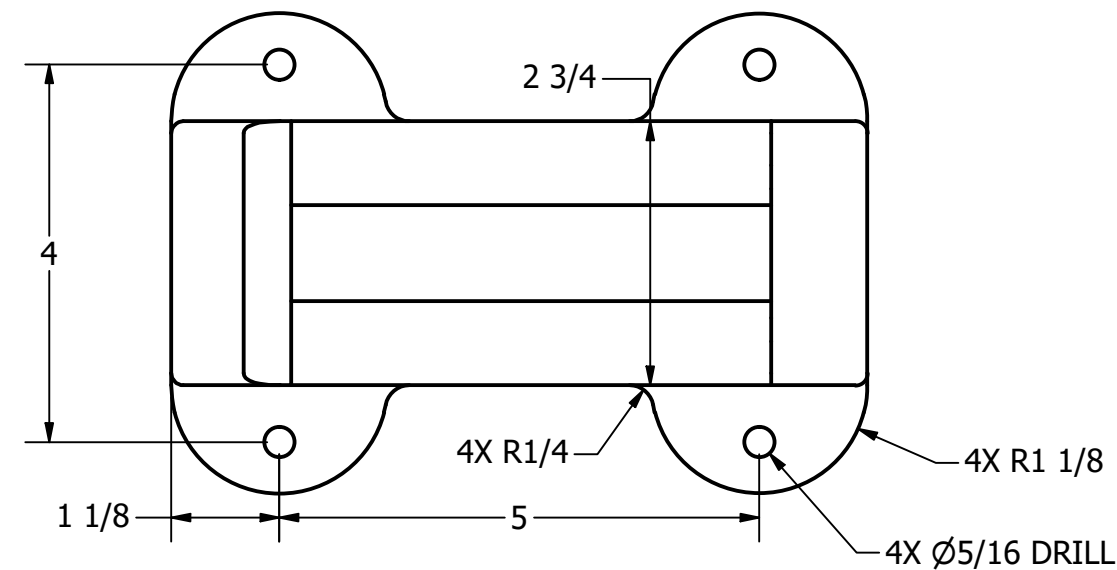
- Ø DIAMETER
- R RADIUS
- ° ANGLE
- COUNTERBORE/SPOTFACE
- COUNTERSINK
- ∇ DEPTH

STEP 4
SCALE 1 / 2

STEP 5
SCALE 1 / 2

GENERAL NOTES:

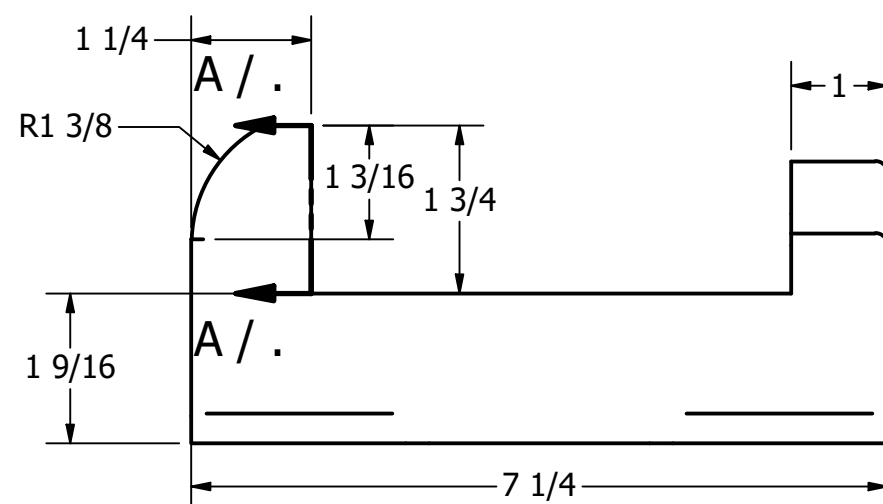
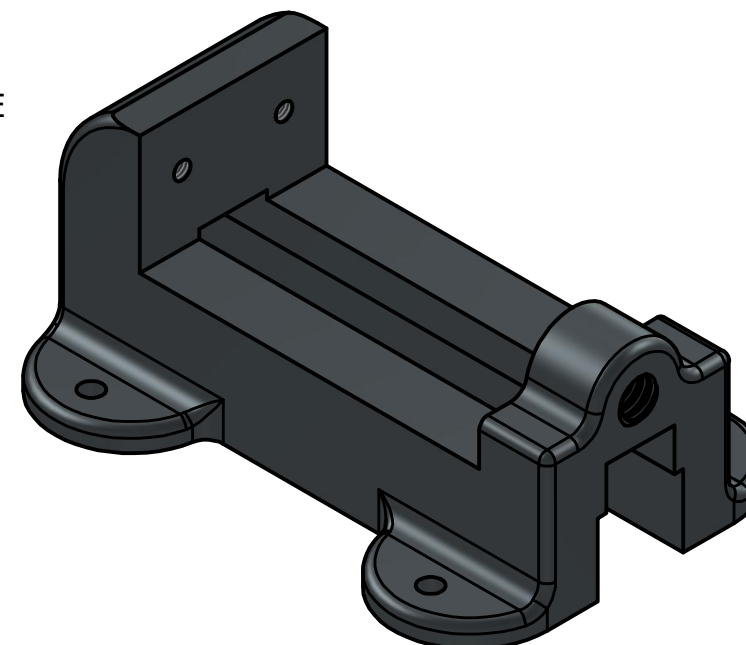
ALL ROUNDS AND FILLETS R 1/8" UNLESS OTHERWISE SPECIFIED



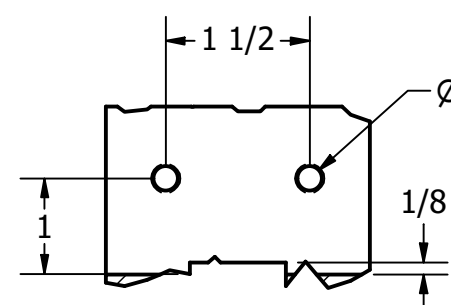
LEGEND:

- Ø DIAMETER
- R RADIUS
- ° ANGLE
- ┌ COUNTERBORE/SPOTFACE
- ∨ COUNTERSINK
- ▽ DEPTH

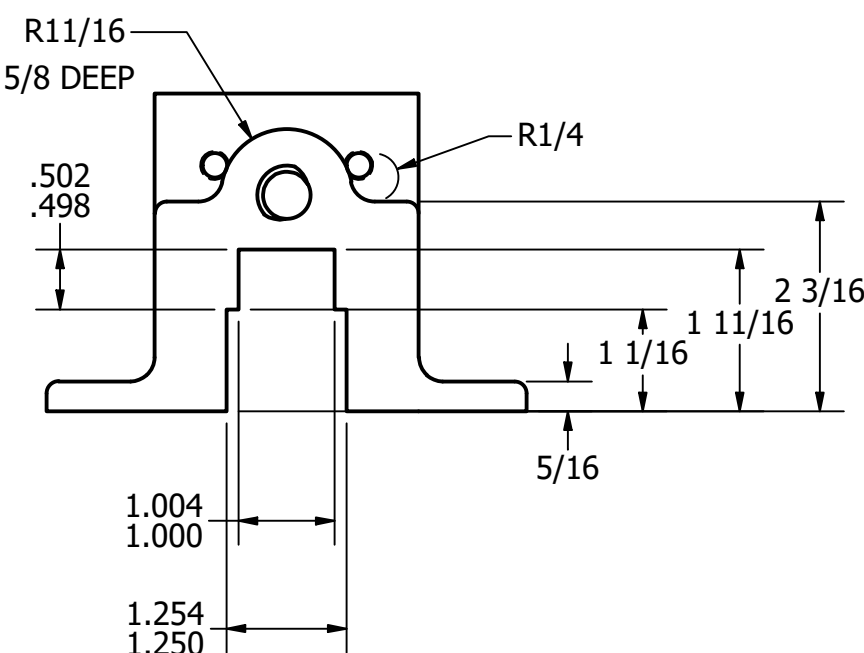
PARTS LIST		
ITEM	QTY	PART NUMBER
1	1	BASE



BASE
SCALE 1 / 2

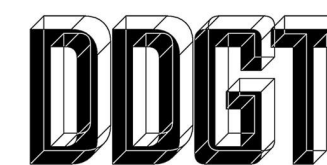


SECTION A-A
SCALE 1 / 2 / .



GENERAL NOTES:

ALL ROUNDS AND FILLETS R 1/8" UNLESS OTHERWISE SPECIFIED

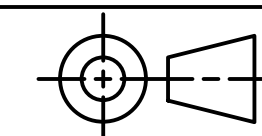


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FRACTIONAL ±1/64"
ANGLES ±1 DEGREE
SURFACES 32

CLASS: DDGT 240

ASSIGNMENT #: 38

INVENTOR DRAWING NAME:
MACHINE VISE

FIG #: 14-71

MANAGER: G. STROMNEN

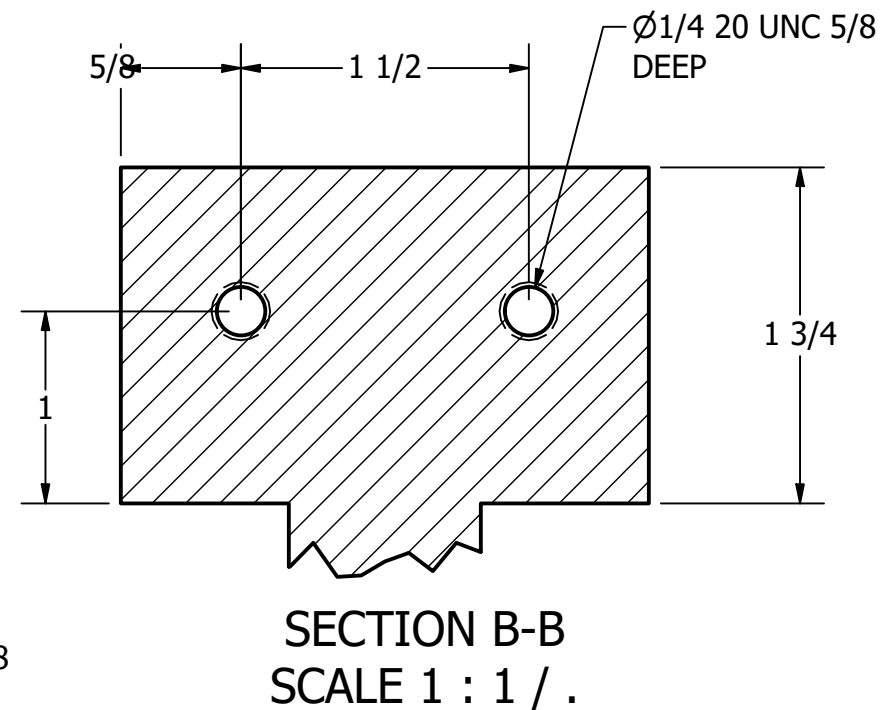
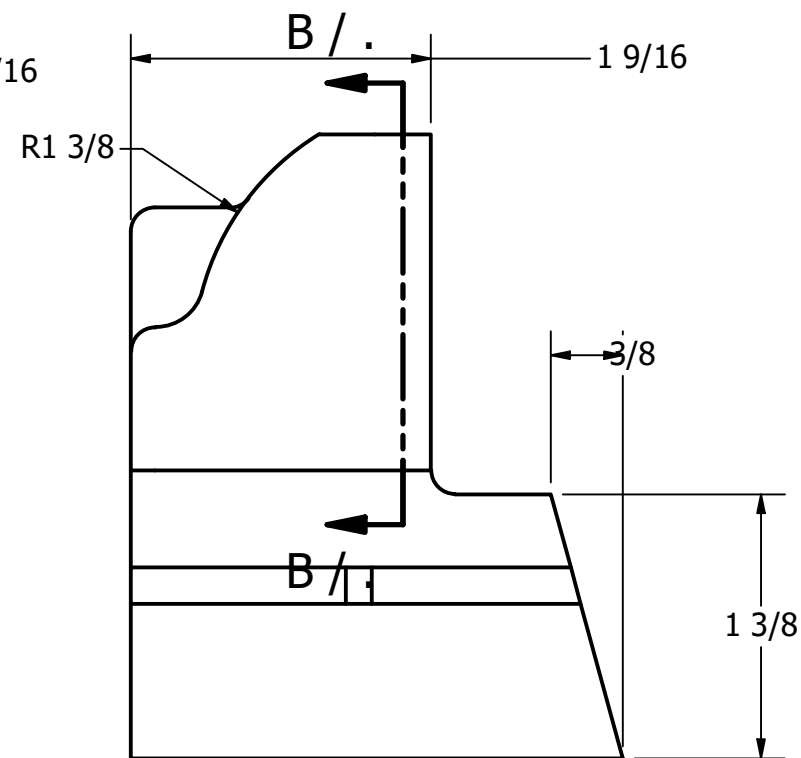
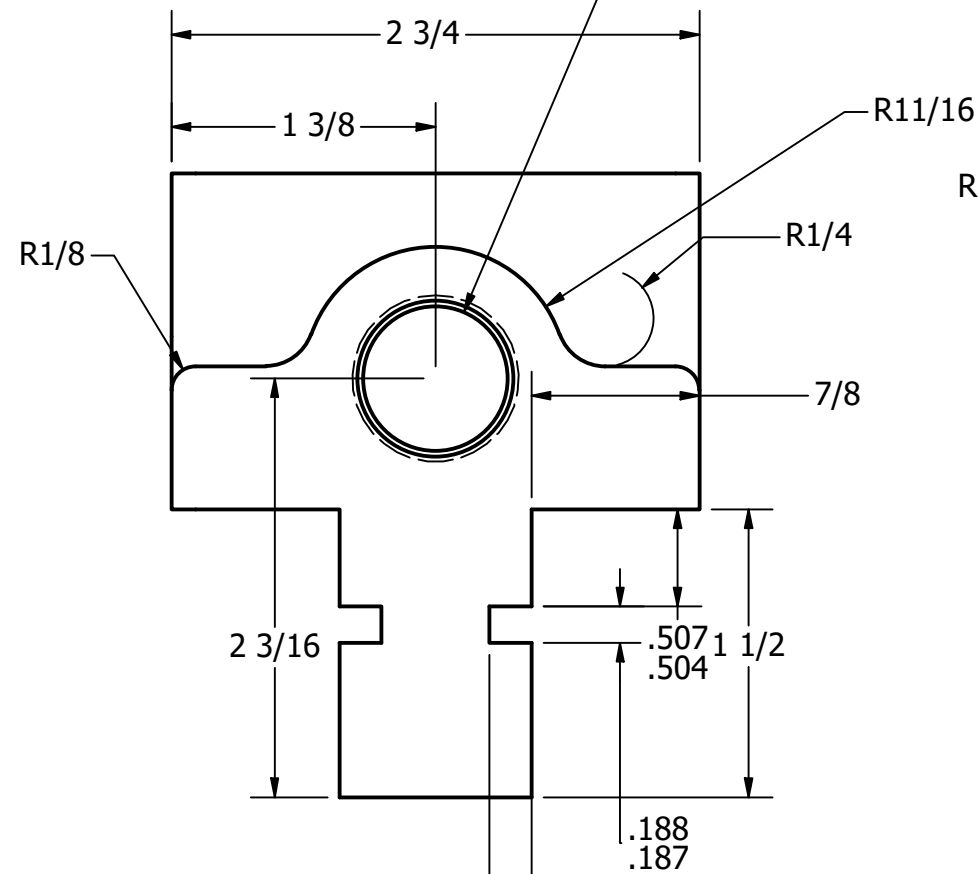
DRAFTER: P. BELL

DATE: 9/21/2025

SCALE: AS NOTED

PAGE #: 4 OF 7

Ø.750 BORE X 1 13/16 DEEP, FLAT BOTTOM
Ø.748
13/16 20 UNEF-3B, LH 7/16 DEEP



SLIDING JAW
SCALE 1 : 1

LEGEND:

Ø DIAMETER
R RADIUS
° ANGLE

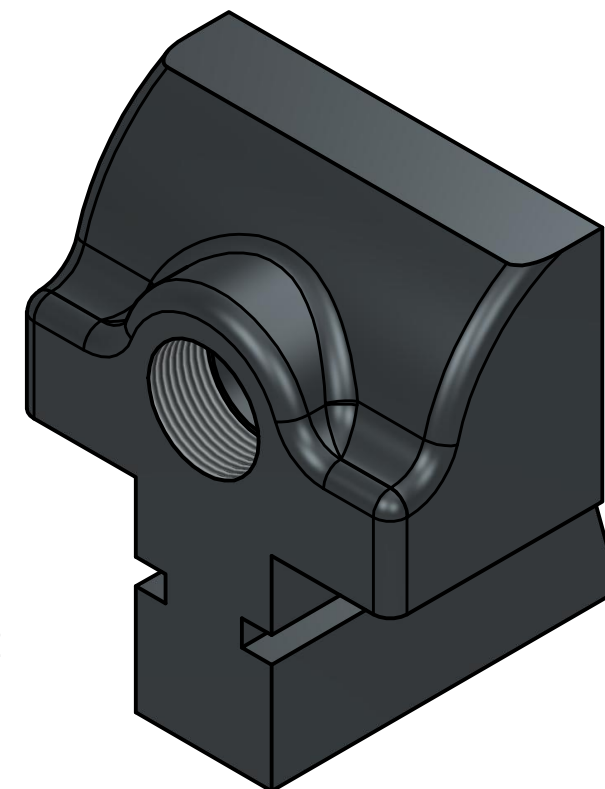
□ COUNTERBORE/SPOTFACE

∇ COUNTERSINK

∇ DEPTH

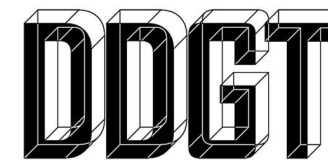
GENERAL NOTES:

ALL ROUNDS AND FILLETS R 1/8" UNLESS OTHERWISE SPECIFIED



PARTS LIST

ITEM	QTY	PART NUMBER
2	1	SLIDING JAW

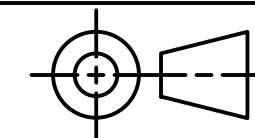


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SURFACES 32

CLASS: DDGT 240

ASSIGNMENT #: 38

INVENTOR DRAWING NAME:
MACHINE VISE

FIG #: 14-71

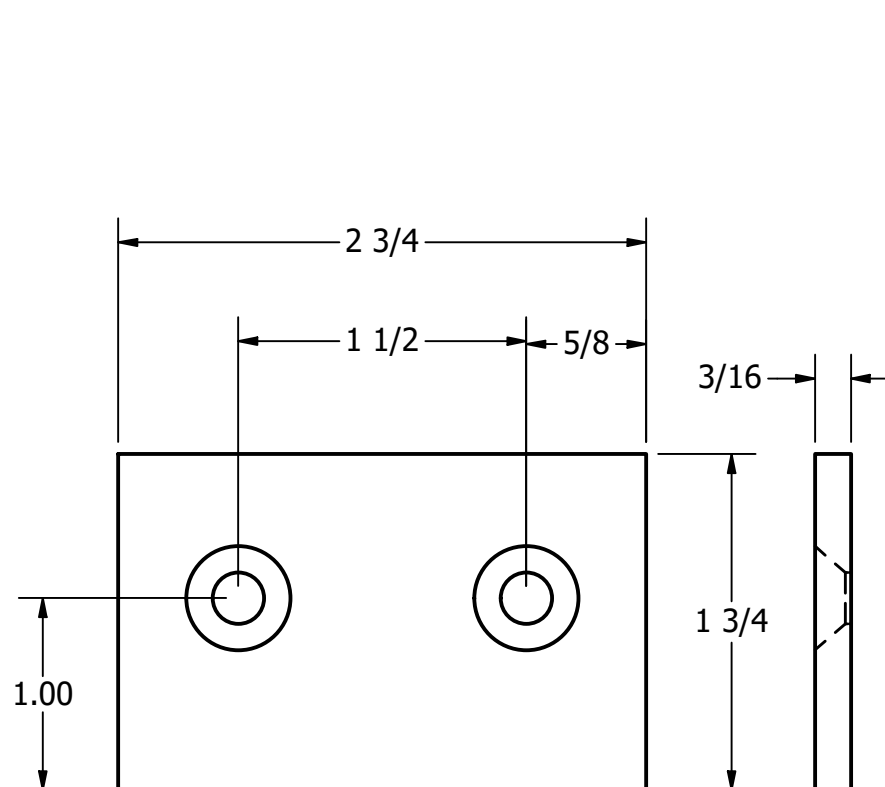
MANAGER: G. STROMNEN

DRAFTER: P. BELL

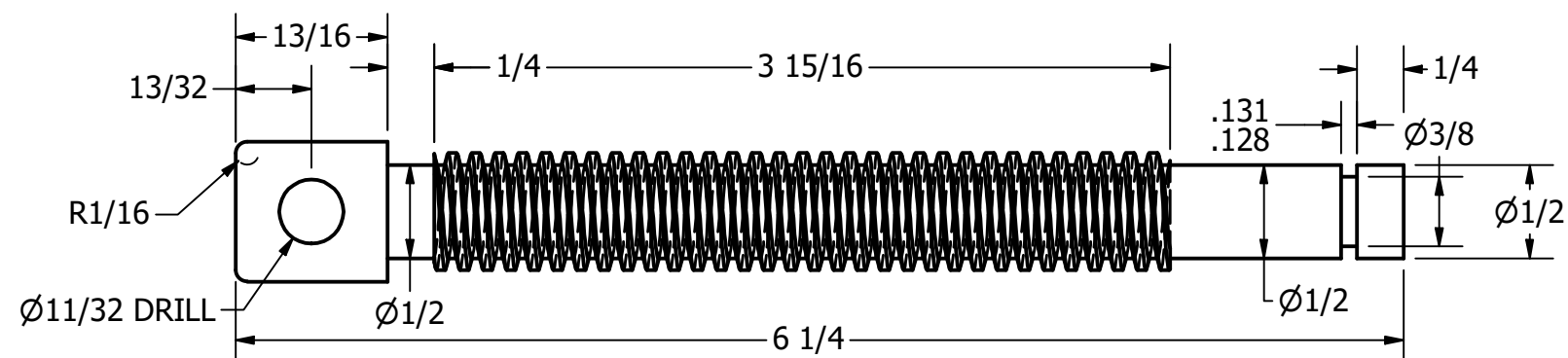
DATE: 9/21/2025

SCALE: AS NOTED

PAGE #: 5 OF 7



JAW PLATE
SCALE 1 : 1



WISE SCREW
SCALE 1 : 1

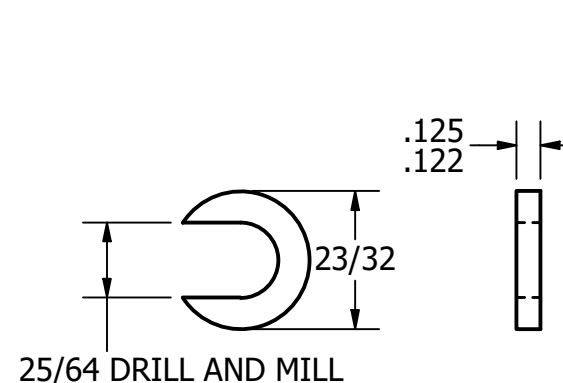
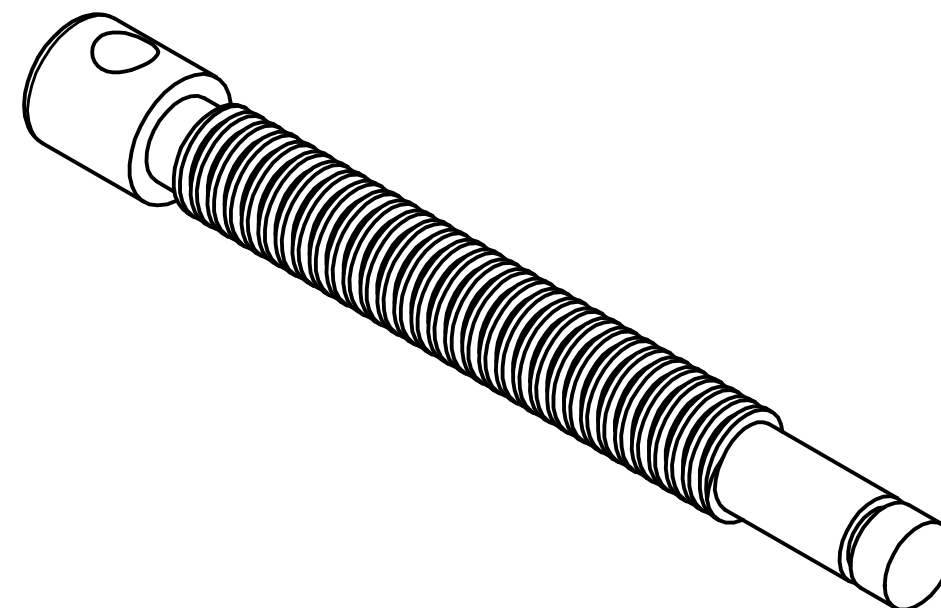
LEGEND:

- Ø DIAMETER
- R RADIUS
- ° ANGLE
- └┐ COUNTERBORE/SPOTFACE
- ∨ COUNTERSINK
- ▽ DEPTH

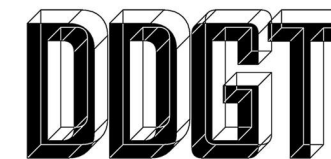
GENERAL NOTES:

ALL ROUNDS AND FILLETS R 1/8" UNLESS OTHERWISE SPECIFIED

PARTS LIST		
ITEM	QTY	PART NUMBER
3	2	JAW PLATE
4	1	WISE SCREW
6	1	SPECIAL KEY



SPECIAL KEY
SCALE 1 : 1

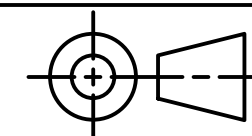


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SURFACES ³²✓

CLASS: DDGT 240

ASSIGNMENT #: 38

INVENTOR DRAWING NAME:
MACHINE VISE

FIG #: 14-71

MANAGER: G. STROMNEN

DRAFTER: P. BELL

DATE: 9/21/2025

SCALE: AS NOTED

PAGE #: 6 OF 7

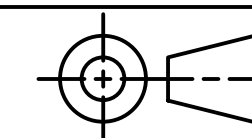


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XXX = ± 0.005
FRACTIONAL $\pm 1/64$ "
ANGLES ± 1 DEGREE
SURFACES $\sqrt{32}$

CLASS: DDGT 240

ASSIGNMENT #: 38

INVENTOR DRAWING NAME:
MACHINE VISE

FIG #: 14-71

MANAGER: G. STROMNEN

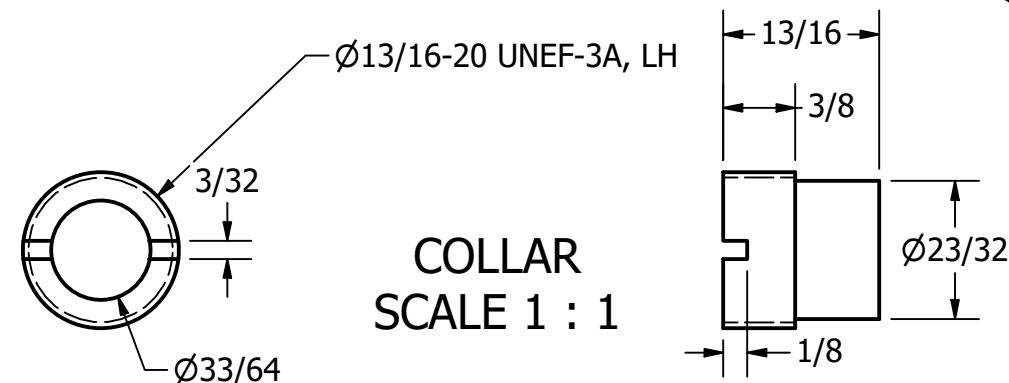
DRAFTER: P. BELL

DATE: 9/21/2025

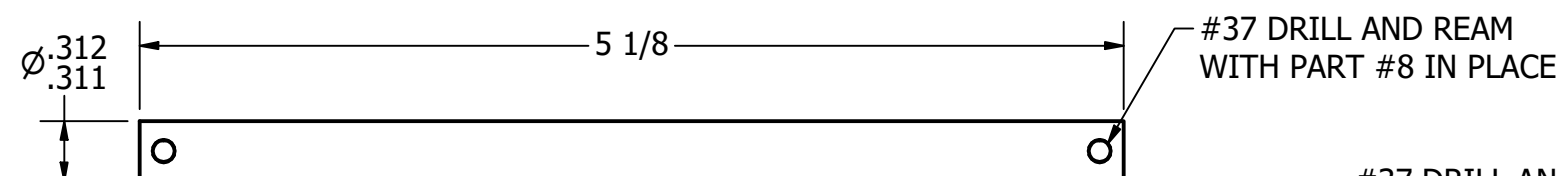
SCALE: AS NOTED

PAGE #: 7 OF 7

PARTS LIST		
ITEM	QTY	PART NUMBER
5	1	COLLAR
7	1	HANDLE ROD
8	2	HANDLE BALL
9	2	SLIDE KEY
10	2	SET SCREW

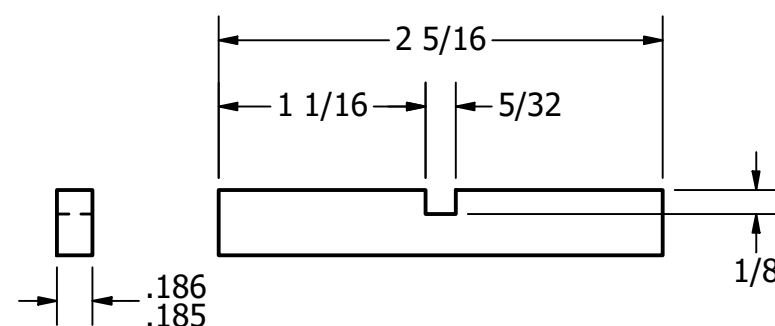


COLLAR
SCALE 1 : 1

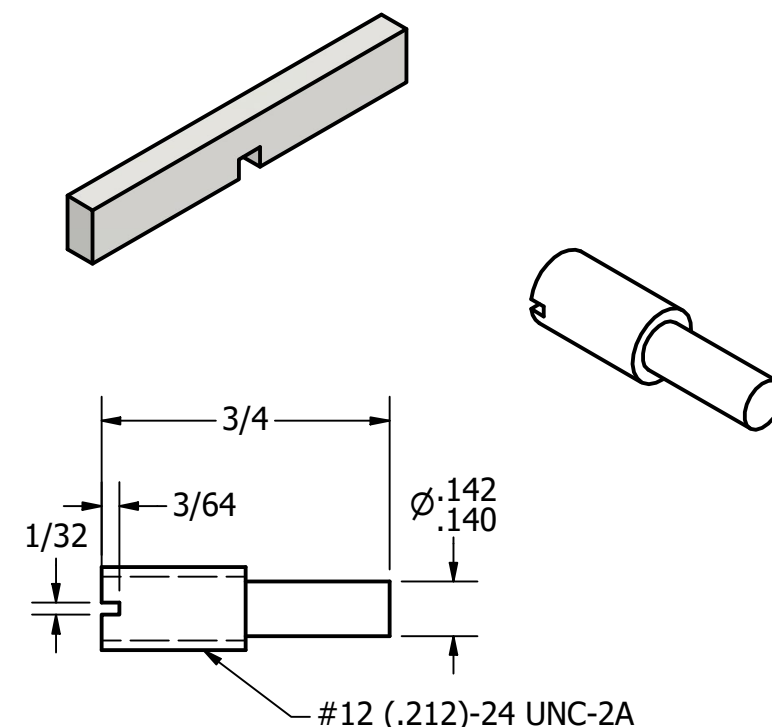


HANDLE ROD
SCALE 1 : 1

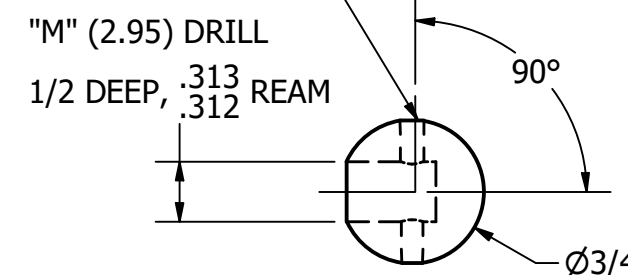
#37 DRILL AND REAM FOR #000 TAPER PIN
CLEAR THROUGH PEEN
SMALL END OVER



SLIDE KEY
SCALE 1 : 1



SET SCREW
SCALE 2 : 1



HANDLE BALL
SCALE 1 : 1

LEGEND:

- Ø DIAMETER
- R RADIUS
- ° ANGLE
- COUNTERBORE/SPOTFACE
- ∨ COUNTERSINK
- √ DEPTH

GENERAL NOTES:

ALL ROUNDS AND FILLETS R 1/8" UNLESS OTHERWISE SPECIFIED