

Large vise project cut list

Steel, 3.5" x .38" x 7.125" 1 piece

Steel, 1.75" x .75" x 3.75" 2 pieces

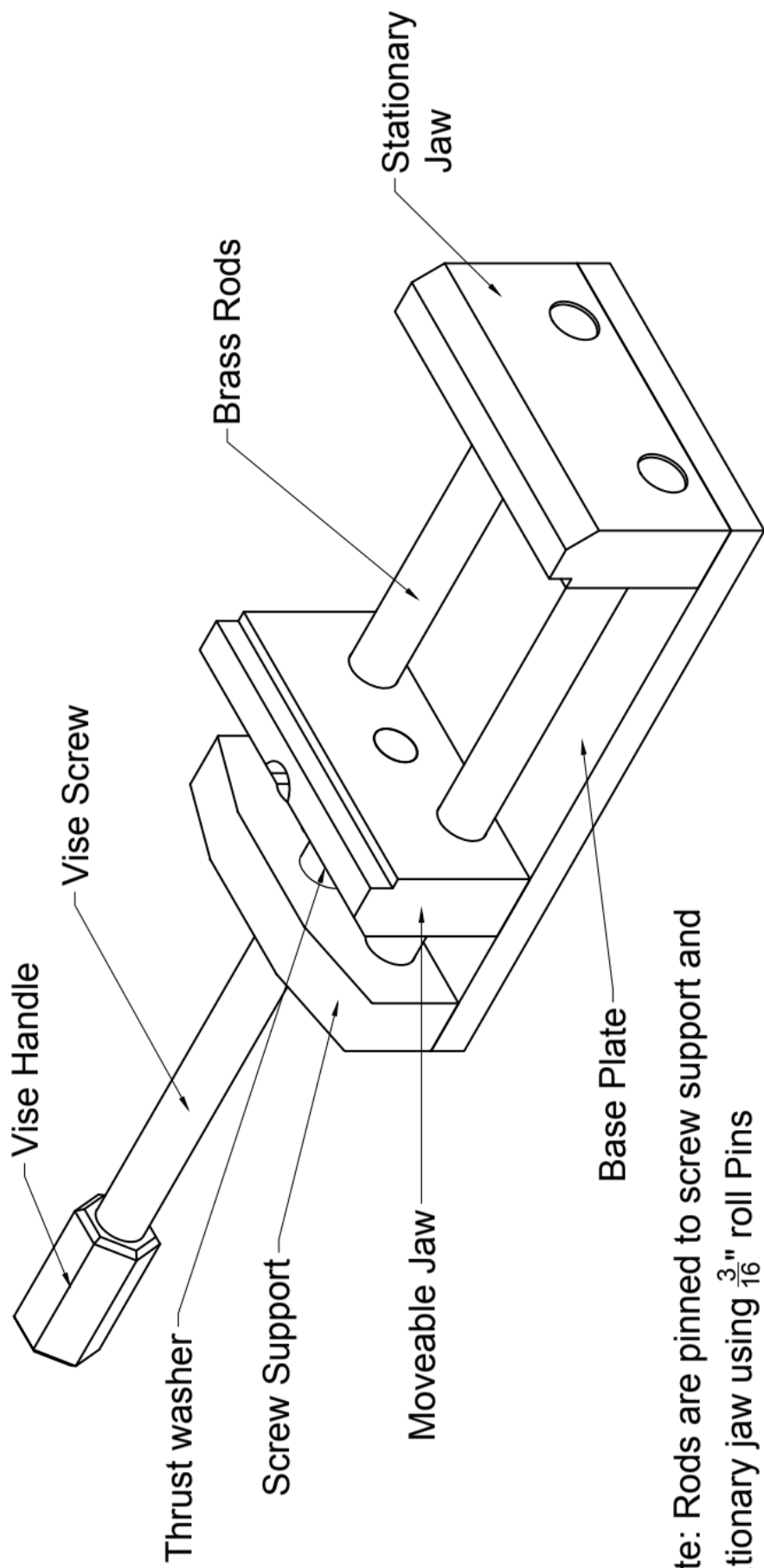
Steel, 1.25" x .625" x 3.75" 1 piece

1/2-13 threaded rod x 7.125" 1 piece

Brass, .50" DIA. X 7.125" L 2 pieces

Alum. Hex stock, .75"/1" x 1.75" L 1 piece

Brass, 1" DIA. X .50" L 1 piece

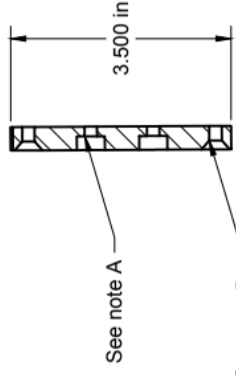
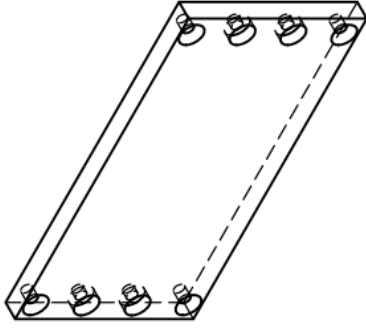


Note: Rods are pinned to screw support and stationary jaw using $\frac{3}{16}$ " roll Pins

Vise handle is pressed onto screw, then pinned using $\frac{1}{8}$ " roll pin

Thrust washer is pinned to screw using $\frac{1}{8}$ " roll pin

PROJECT		Large Vise	
TITLE		Assembly Drawing	
APPROVED	SIZE	CODE	DWG NO
CHECKED			
DRAWN	SCALE	WEIGHT	SHEET
			REV



SECTION A-A
SCALE 1:2

remove all burrs and sharp edges

Note A:
4 Interior holes are drilled
.201 DIA. and countersunk
for a #10 SHCS

Note B:
4 Corner holes are drilled
.201 DIA. and countersunk
for a #10 flat HD. screw

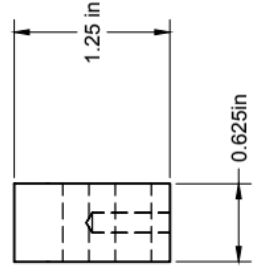
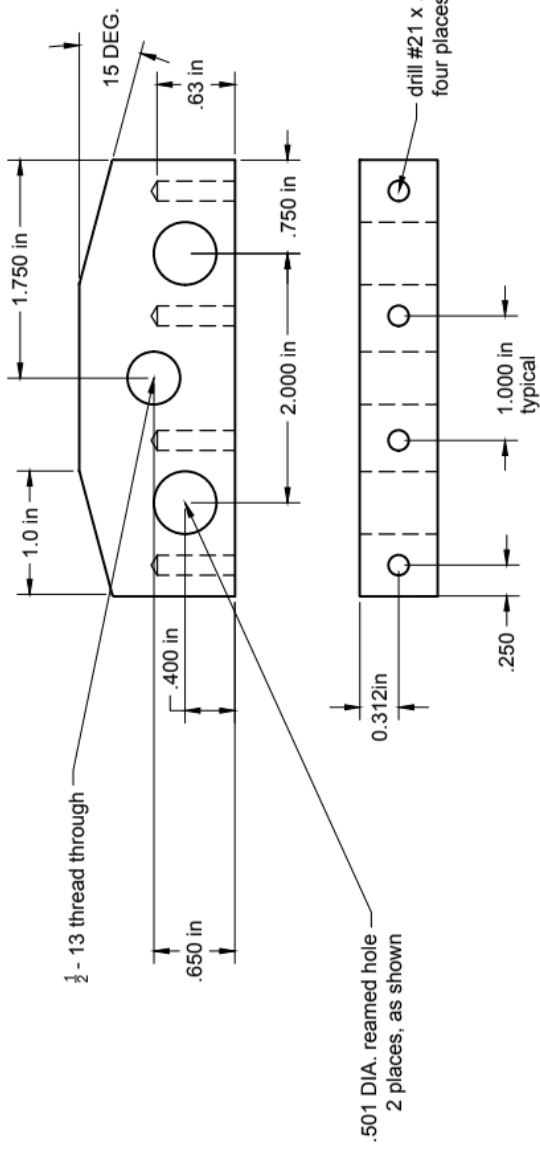
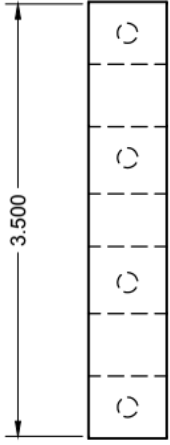
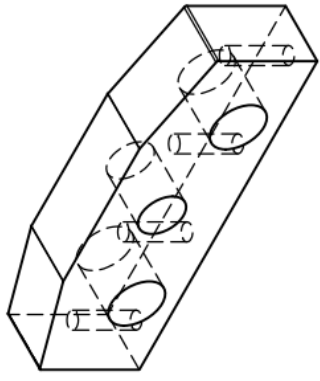
tolerances unless otherwise noted PROJECT

.X = +/- .015
.XX = +/- .01
.XXX = +/- .005
.XXXX = +/- .0005
units are inches

Large Vise

TITLE Base Plate, make from steel
Part #3

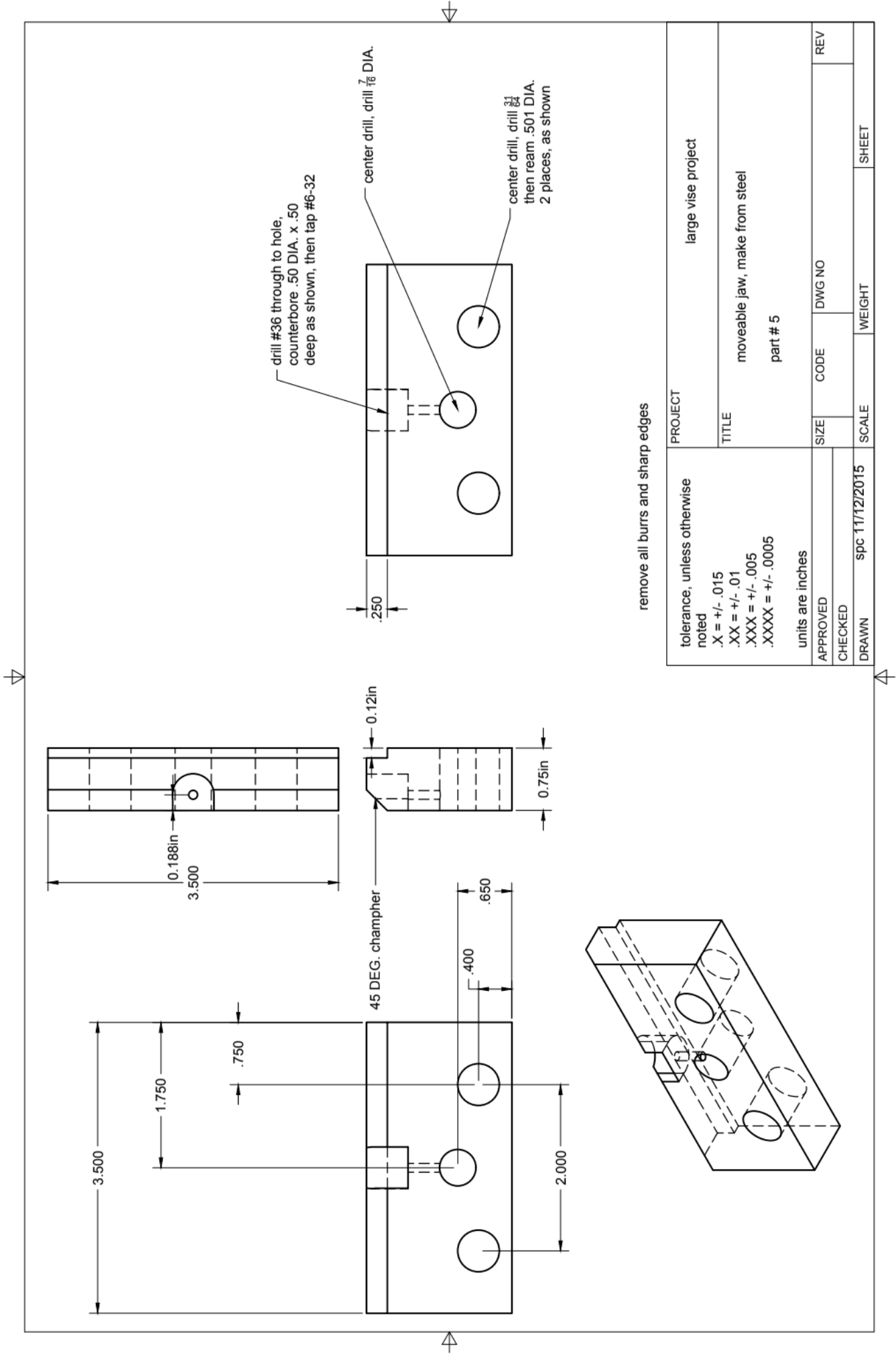
APPROVED	SIZE	CODE	DWG NO	REV
CHECKED	SCALE		WEIGHT	SHEET
DRAWN	spc 11/9/2015			

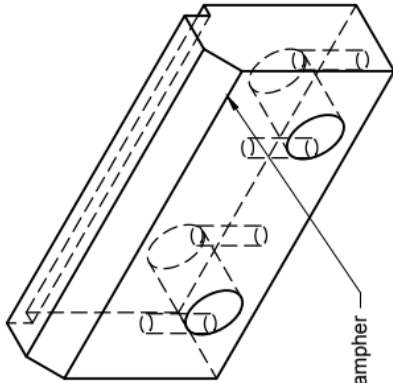


drill #21 x .63 deep. Then tap #10 - 32 x .38 deep, four places as shown

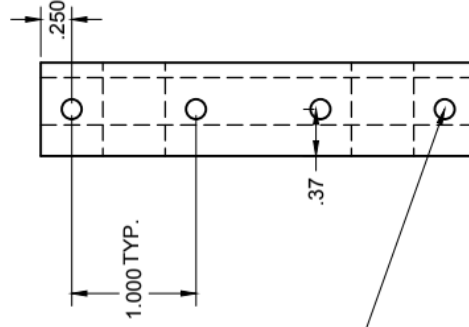
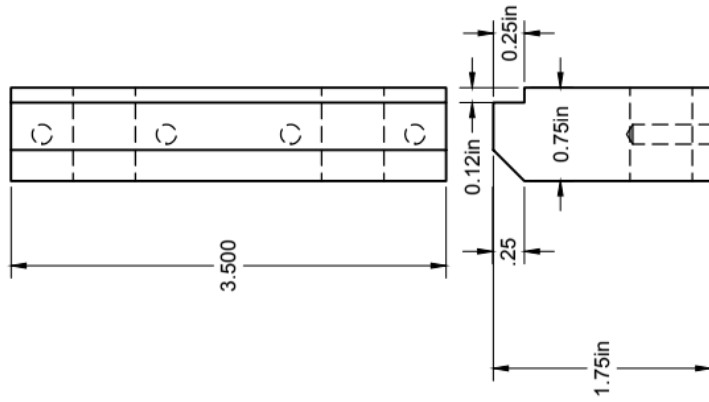
remove all burrs and sharp edges

Tolerances, unless otherwise noted		PROJECT		Large Vise	
X = +/- .015		TITLE		screw support, make from steel	
.XX = +/- .01		part #4		REV	
.XXX = +/- .005		SIZE	CODE	DWG NO	REV
.XXXX = +/- .0005		SCALE		WEIGHT	SHEET
units are inches		DRAWN		spc 11/10/2015	
APPROVED	CHECKED	SCALE		WEIGHT	SHEET

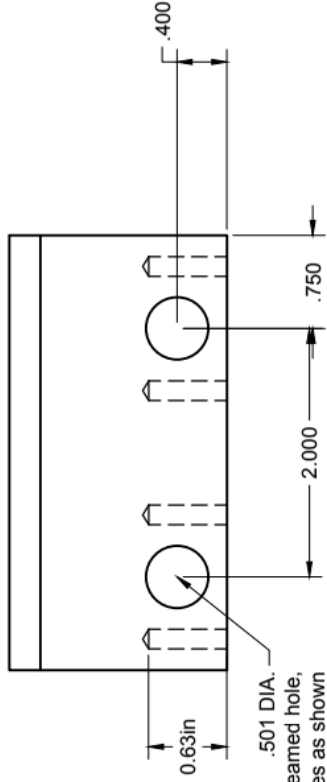




45 DEG. champher



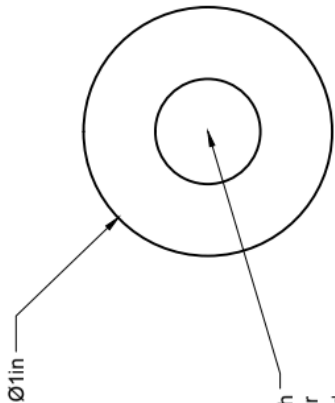
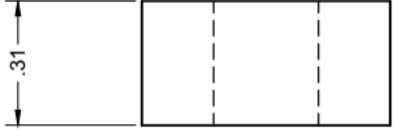
drill #21 x .63 deep then
tap #10-32 x .38 deep,
4 places as shown



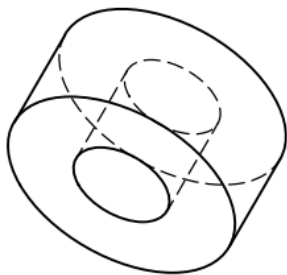
.501 DIA.
reamed hole,
2 places as shown

remove all burrs and sharp edges

TOLERANCES, UNLESS OTHERWISE NOTED		PROJECT	
X = +/- .015		Large Vise	
XX = +/- .01		TITLE	
XXX = +/- .005		stationary jaw, make from steel	
XXXX +/- .0005		part #6	
units are inches		SIZE	DWG NO
APPROVED	CODE	SCALE	WEIGHT
CHECKED		SPC 11/12/2015	SHEET
DRAWN			

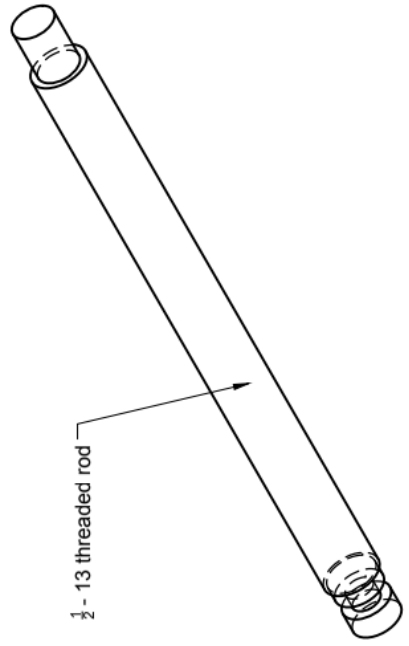
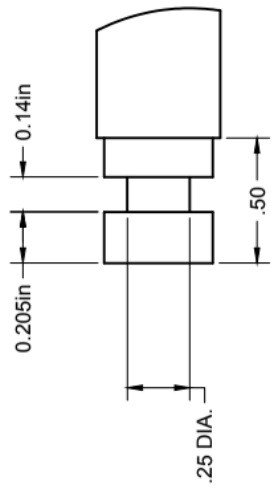
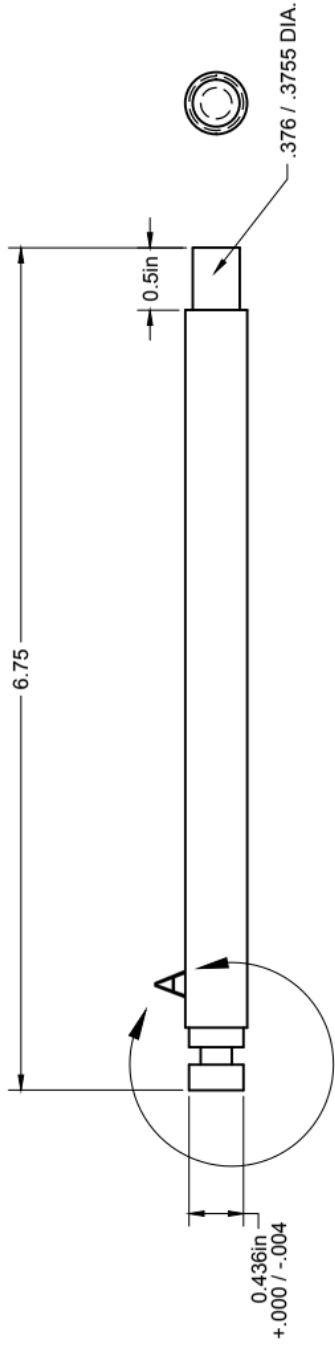


drill $\frac{7}{8}$ through
then tap for
 $\frac{1}{2}$ -13 thread



remove all burrs and sharp edges

tolerances unless otherwise noted		PROJECT	
X = +/- .015	Large Vise		
XX = +/- .01	thrust washer, make from Brass		
XXX = +/- .005	Part #7		
XXXX = +/- .0005	units are inches		
APPROVED	SIZE	CODE	DWG NO
CHECKED	SCALE		REV
DRAWN	SPC 11/12/2015	WEIGHT	SHEET



1/2 - 13 threaded rod

DETAIL A SCALE 2:1

remove all burrs and sharp edges

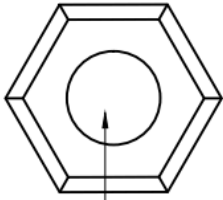
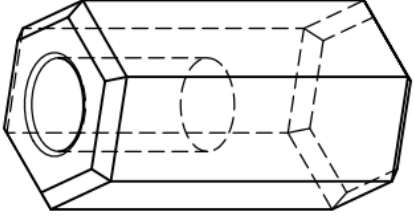
tolerances, unless otherwise noted

- X = +/- .015
- XX = +/- .01
- XXX = +/- .005
- XXXX = +/- .0005

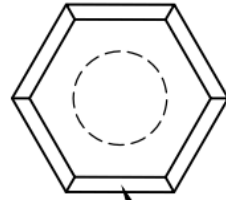
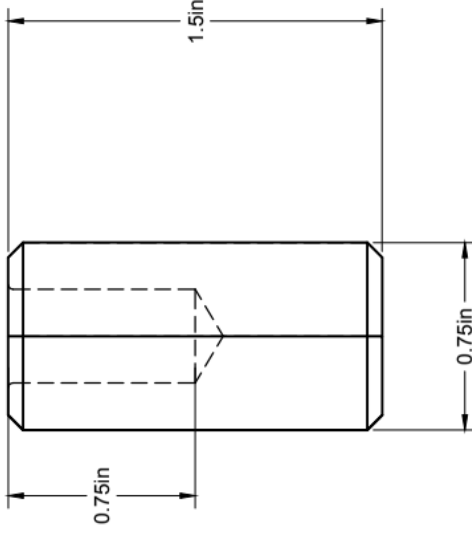
units are inches

PROJECT		Large Vise	
TITLE		Vise Screw, make from 1/2-13 threaded rod	
SIZE		CODE	DWG NO
DRAWN		SCALE	WEIGHT
APPROVED		REV	
CHECKED			
DRAWN		SCALE	SHEET
SPC 11/13/2015			





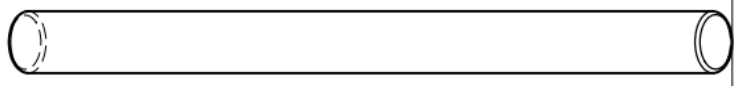
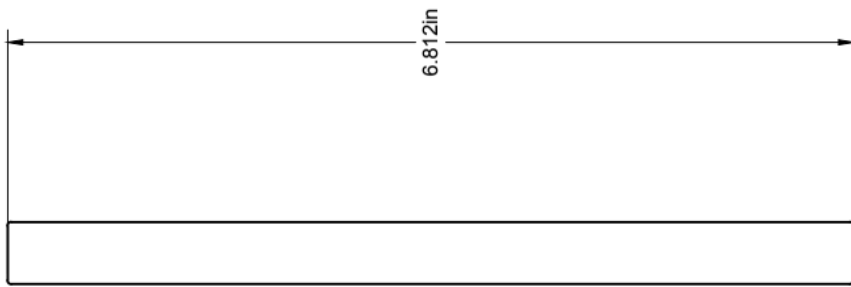
.3745 / .3750
DIA. hole



45 DEG. chamfer x .06"
as shown

remove all burrs and sharp edges

tolerances unless otherwise noted		PROJECT	
.X = +/- .015		Large Vise	
.XX = +/- .01		TITLE	
.XXX = +/- .005		Handle, make from Aluminum hex stock	
.XXXX = +/- .0005		Part #1	
units are inches		SIZE	DWG NO
APPROVED	CHECKED	SCALE	WEIGHT
DRAWN		SHEET	
spc 11/9/2015		REV	



Tolerances unless otherwise noted .XXX = +/- .005 units are inches		PROJECT Large Vise			
		TITLE Brass Rod, 2 pieces are required Part #2			
APPROVED		SIZE	CODE	DWG NO	REV
CHECKED					
DRAWN	spc 11/9/2015	SCALE	WEIGHT	SHEET	