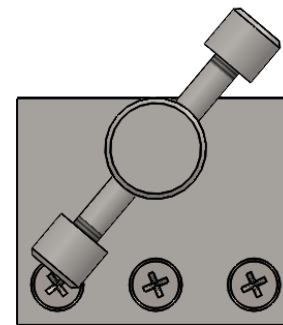
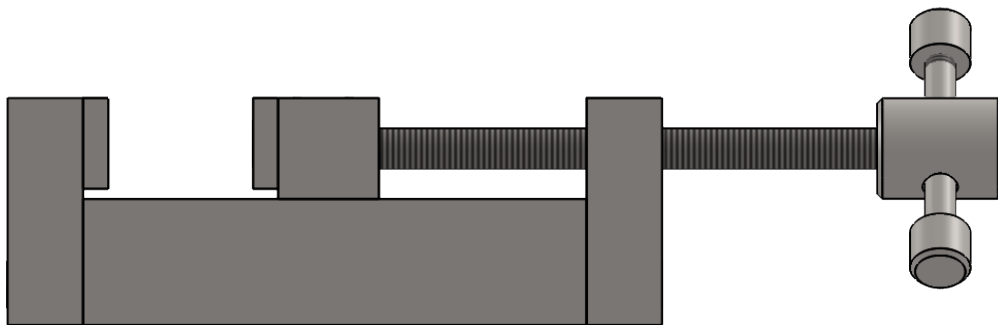
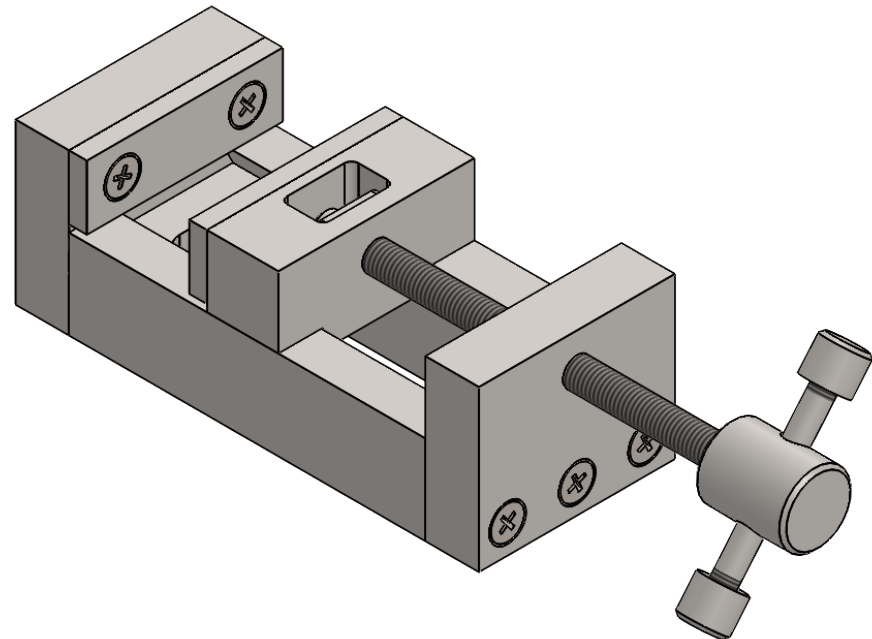
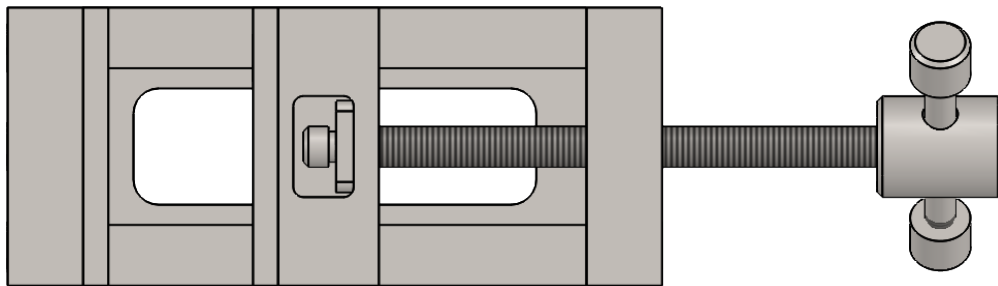


2

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|-------------|---------|--------------------------------------|
| | | UNLESS OTHERWISE SPECIFIED: |
| | | DIMENSIONS ARE IN INCHES |
| | | TOLERANCES: |
| | | FRACTIONAL: \pm |
| | | ANGULAR: MACH \pm BEND \pm |
| | | TWO PLACE DECIMAL \pm |
| | | THREE PLACE DECIMAL \pm |
| | | INTERPRET GEOMETRIC TOLERANCING PER: |
| | | MATERIAL |
| | | FINISH |
| NEXT ASSY | USED ON | |
| APPLICATION | | DO NOT SCALE DRAWING |

| | | |
|-----------|------|------|
| | NAME | DATE |
| DRAWN | | |
| CHECKED | | |
| ENG APPR. | | |
| MFG APPR. | | |
| Q.A. | | |
| COMMENTS: | | |

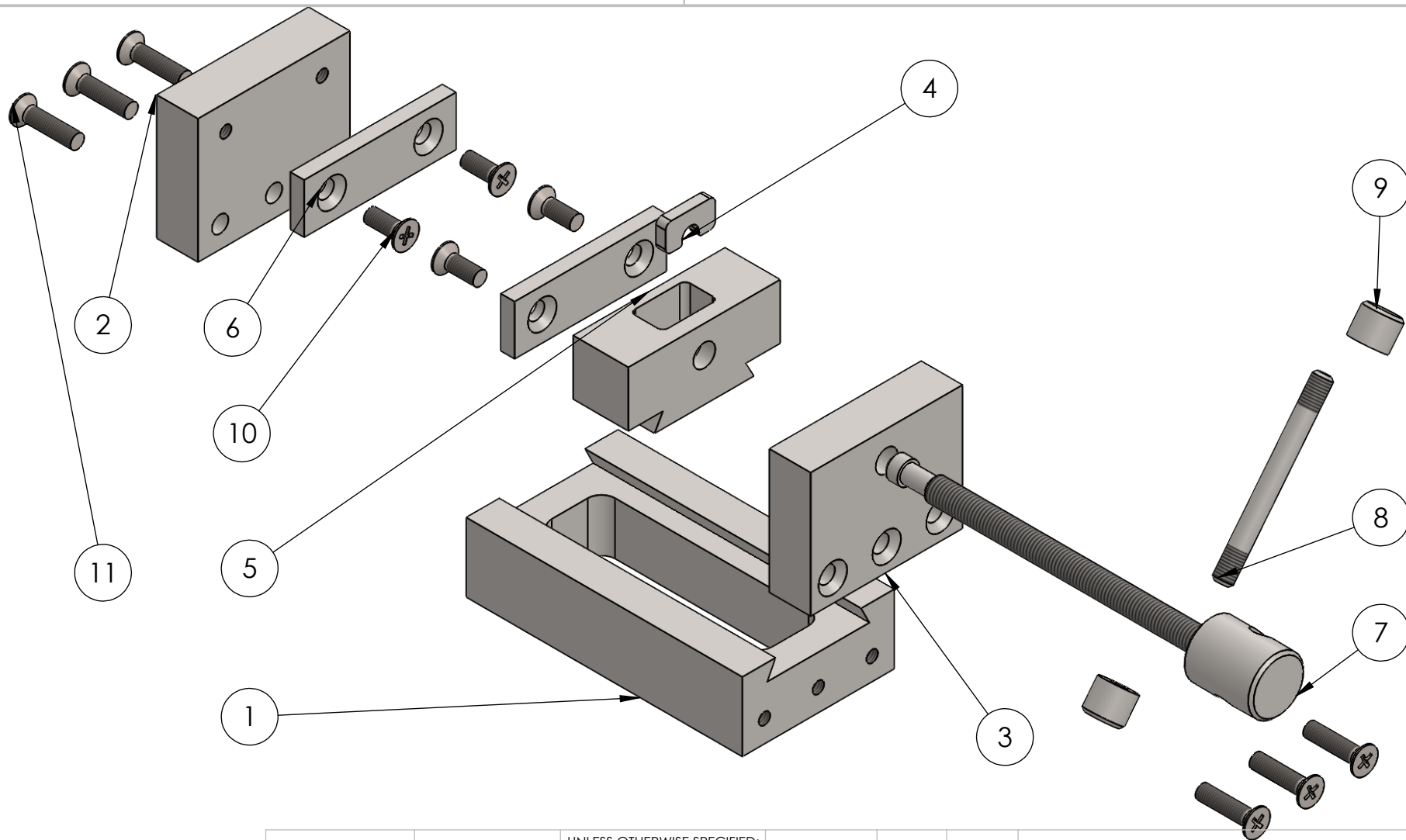
| | | |
|---------------------------|----------|--------------|
| TITLE: | | |
| Drill Press Vise Assembly | | |
| SIZE | DWG. NO. | REV |
| A | | |
| SCALE: 1:2 | WEIGHT: | SHEET 1 OF 1 |

2

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B



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| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE |
| | | DIMENSIONS ARE IN INCHES | DRAWN | | |
| | | TOLERANCES: | CHECKED | | |
| | | FRACTIONAL \pm | ENG APPR. | | |
| | | ANGULAR: MACH \pm BEND \pm | MFG APPR. | | |
| | | TWO PLACE DECIMAL \pm | Q.A. | | |
| | | THREE PLACE DECIMAL \pm | COMMENTS: | | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | | | |
| | | MATERIAL | | | |
| NEXT ASSY | USED ON | FINISH | | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | |

TITLE:
**Drill Press Vise
Assembly - Exploded**

| | | |
|------------|----------|--------------|
| SIZE | DWG. NO. | REV |
| A | | |
| SCALE: 1:2 | WEIGHT: | SHEET 1 OF 1 |

2

1

Material: Plain Carbon Steel for all parts

| ITEM NO. | PART NUMBER | QTY. |
|----------|---|------|
| 1 | BASE PLATE | 1 |
| 2 | BACK PLATE | 1 |
| 3 | FACE PLATE | 1 |
| 4 | LOCK PLATE | 1 |
| 5 | PIN PLATE | 1 |
| 6 | SPACER PLATE | 2 |
| 7 | SHAFT | 1 |
| 8 | LEVER ARM | 1 |
| 9 | CAP | 2 |
| 10 | B18.6.7M - M5 X 0.8 X 13 TYPE I CROSS RECESSED FHMS --13C | 4 |
| 11 | B18.6.7M - M5 X 0.8 X 20 TYPE I CROSS RECESSED FHMS --20C | 6 |

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| | | | | | |
|-----------|-------------|--------------------------------------|-----------|------|------|
| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE |
| | | DIMENSIONS ARE IN INCHES | DRAWN | | |
| | | TOLERANCES: | CHECKED | | |
| | | FRACTIONAL ± | ENG APPR. | | |
| | | ANGULAR: MACH ± BEND ± | MFG APPR. | | |
| | | TWO PLACE DECIMAL ± | Q.A. | | |
| | | THREE PLACE DECIMAL ± | COMMENTS: | | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | | | |
| | | MATERIAL | | | |
| NEXT ASSY | USED ON | FINISH | | | |
| | APPLICATION | DO NOT SCALE DRAWING | | | |

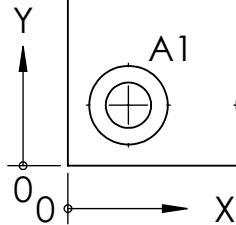
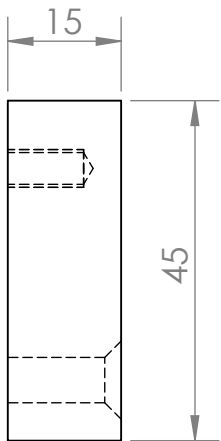
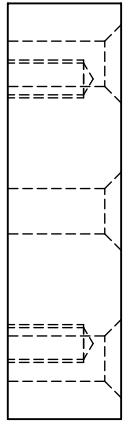
TITLE:
BOM - Drill Press
Vise

| | | |
|------------|----------|--------------|
| SIZE | DWG. NO. | REV |
| A | | |
| SCALE: 1:2 | WEIGHT: | SHEET 1 OF 1 |

2

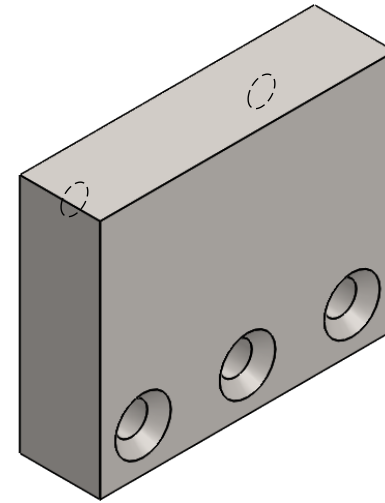
1

B



2

| TAG | X LOC | Y LOC | SIZE |
|-----|-------|-------|--|
| A1 | 8 | 8 | ϕ 6 THRU ALL \checkmark ϕ 10 X 90° |
| A2 | 27.50 | 8 | ϕ 6 THRU ALL \checkmark ϕ 10 X 90° |
| A3 | 47 | 8 | ϕ 6 THRU ALL \checkmark ϕ 10 X 90° |
| B1 | 10 | 36 | ϕ 4 ∇ 10 M5X0.8 - 6H ∇ 10 FAR SIDE |
| B2 | 45 | 36 | ϕ 4 ∇ 10 M5X0.8 - 6H ∇ 10 FAR SIDE |



B

A

A

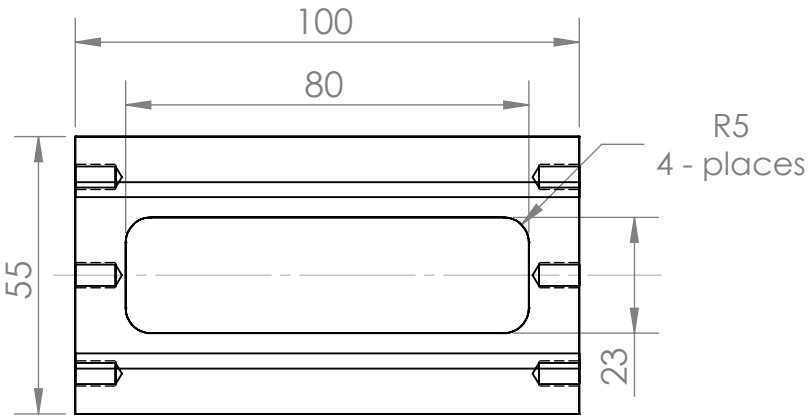
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|-------------|---------|---|-----------------------------------|------|------|---|--|--|
| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | TITLE: | | |
| | | DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ± | DRAWN | | | | | |
| | | | CHECKED | | | | | |
| | | | ENG APPR. | | | | | |
| | | | MFG APPR. | | | | | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | Q.A. | | | SIZE DWG. NO. REV A Back Plate | | |
| | | MATERIAL | COMMENTS: Units: mm | | | | | |
| | | FINISH | | | | | | |
| NEXT ASSY | USED ON | | | | | SCALE: 1:1 WEIGHT: SHEET 1 OF 1 | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | | | | |

1

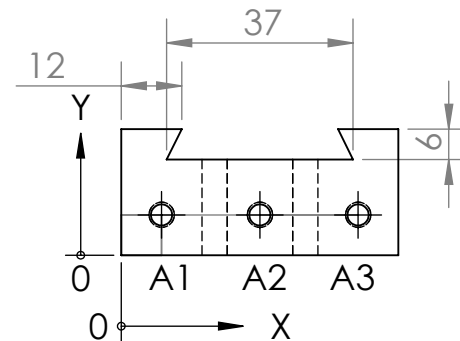
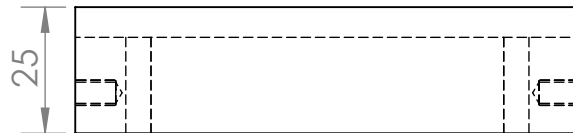
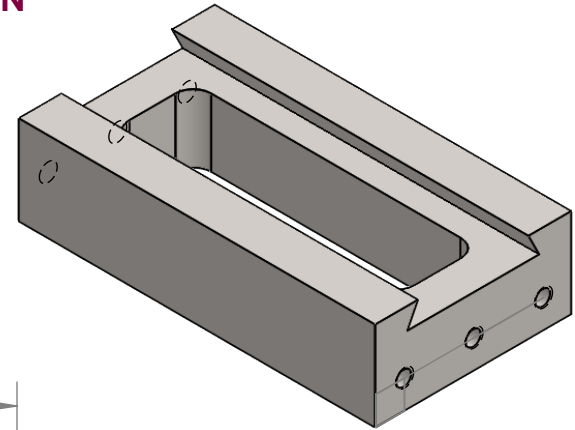
2

B



| TAG | X LOC | Y LOC | SIZE |
|-----|-------|-------|--|
| A1 | 8 | 8 | $\phi 4 \downarrow 8$ M5X0.8 - 6H $\downarrow 10$ |
| A2 | 27.50 | 8 | $\phi 4 \downarrow 8$ M5X0.8 - 6H $\downarrow 10$ |
| A3 | 47 | 8 | $\phi 4 \downarrow 8$ M5X0.8 - 6H $\downarrow 10$ |

THREE IDENTICAL HOLES ON THE FACE IN LEFT VIEW



B

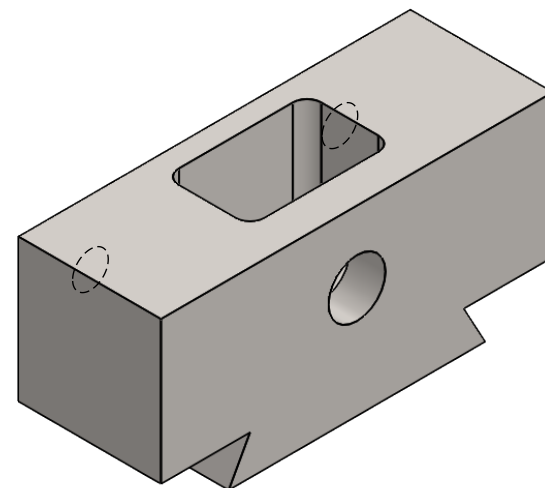
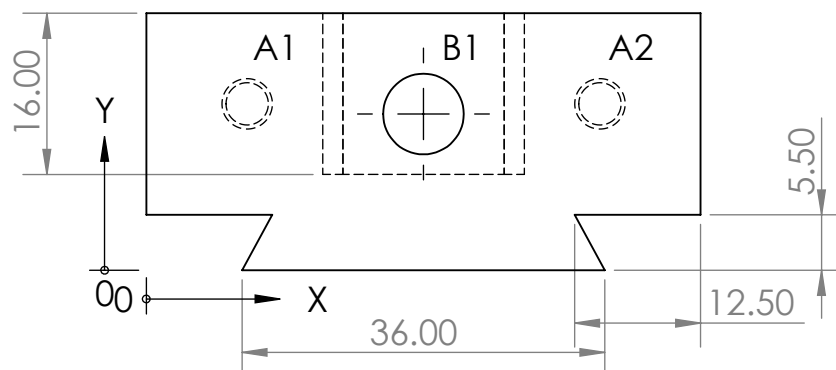
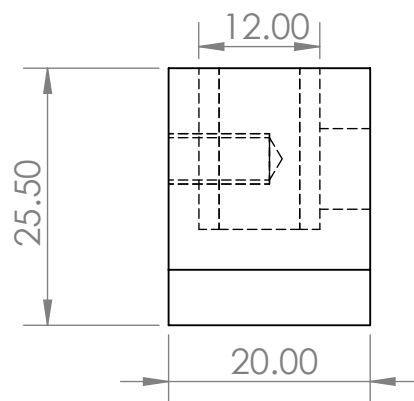
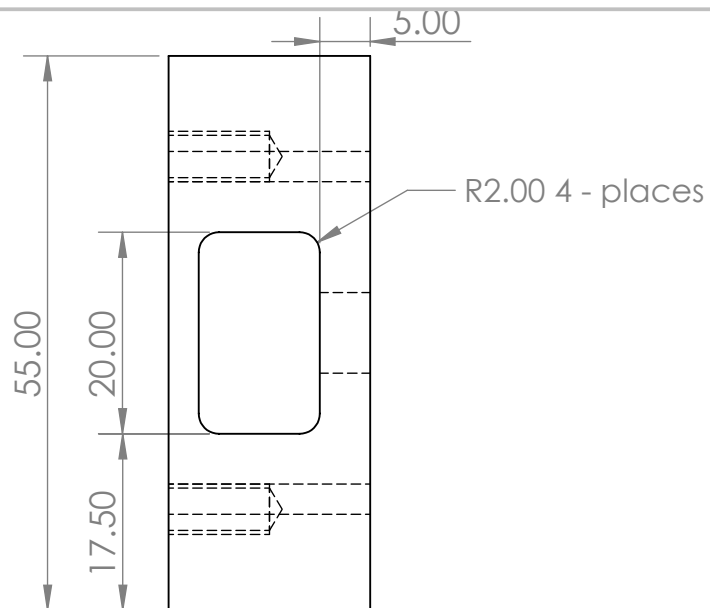
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| | | UNLESS OTHERWISE SPECIFIED: | | | NAME | DATE | TITLE: | |
| | | DIMENSIONS ARE IN INCHES | DRAWN | | | | | |
| | | TOLERANCES: | CHECKED | | | | | |
| | | FRACTIONAL \pm | ENG APPR. | | | | | |
| | | ANGULAR: MACH \pm BEND \pm | MFG APPR. | | | | | |
| | | TWO PLACE DECIMAL \pm | Q.A. | | | | SIZE DWG. NO. REV A Base Plate | |
| | | THREE PLACE DECIMAL \pm | COMMENTS: | | | | | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | | | | | | |
| | | MATERIAL | | | | | SCALE: 1:2 WEIGHT: SHEET 1 OF 1 | |
| NEXT ASSY | USED ON | FINISH | | | | | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | | | | |

B



B

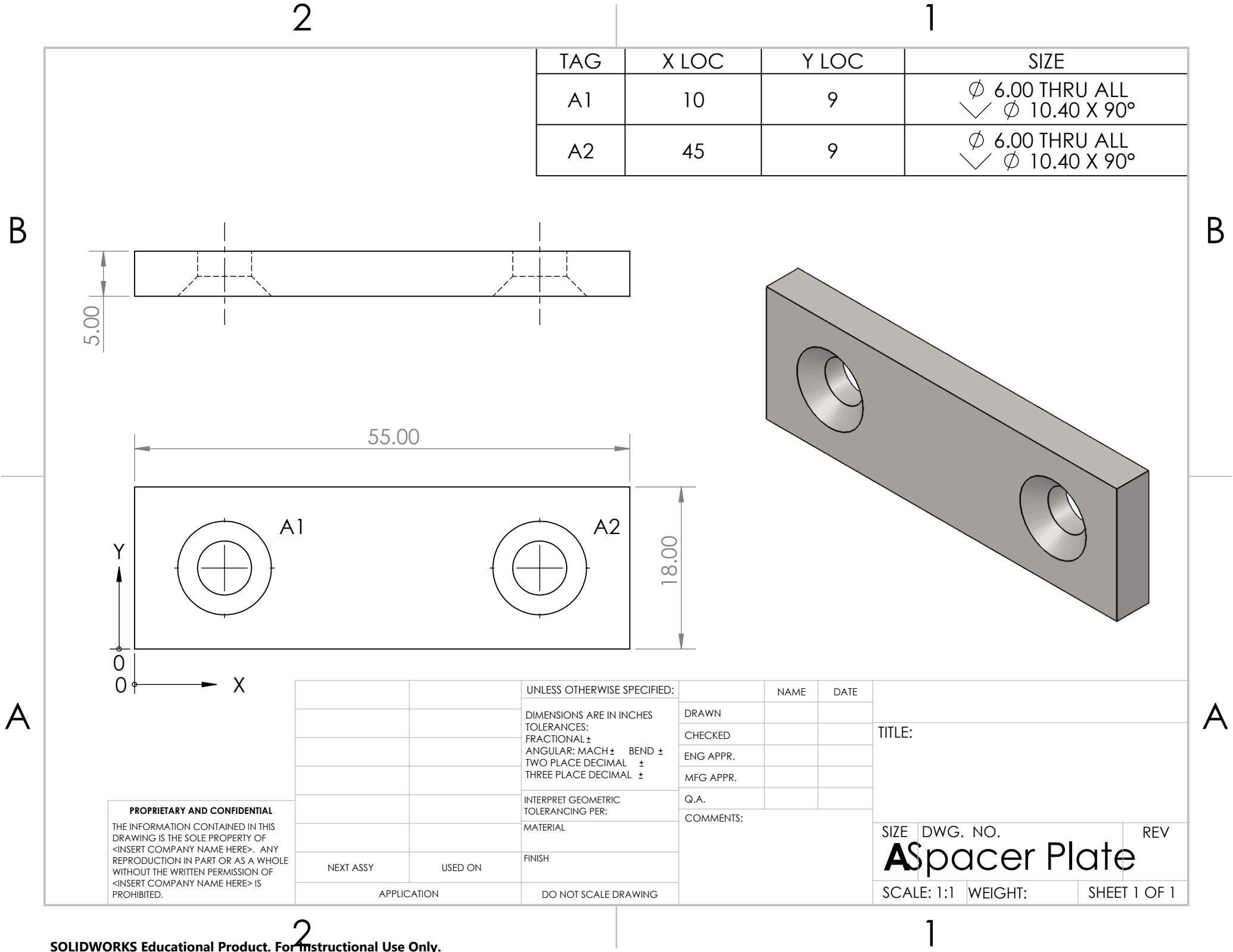
A

A

| TAG | X LOC | Y LOC | SIZE |
|-----|-------|-------|---|
| A1 | 10 | 16.50 | ϕ 4.20 ∇ 10.00 M5X0.8 - 6H ∇ 10.00 FAR SIDE |
| A2 | 45 | 16.50 | ϕ 4.20 ∇ 10.00 M5X0.8 - 6H ∇ 10.00 FAR SIDE |
| B1 | 27.50 | 15.50 | ϕ 8.00 ∇ 5.00 |

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|-------------|---------|--------------------------------------|--|-----------|------|---|---------|--------------|
| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | TITLE: | | |
| | | DIMENSIONS ARE IN INCHES | | DRAWN | | | | |
| | | TOLERANCES: | | CHECKED | | | | |
| | | FRACTIONAL \pm | | ENG APPR. | | | | |
| | | ANGULAR: MACH \pm BEND \pm | | MFG APPR. | | | | |
| | | TWO PLACE DECIMAL \pm | | Q.A. | | SIZE DWG. NO. REV A Pin Plate | | |
| | | THREE PLACE DECIMAL \pm | | COMMENTS: | | | | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | | | | | | |
| | | MATERIAL | | | | | | |
| NEXT ASSY | USED ON | FINISH | | | | SCALE: 1:1 | WEIGHT: | SHEET 1 OF 1 |
| APPLICATION | | DO NOT SCALE DRAWING | | | | | | |

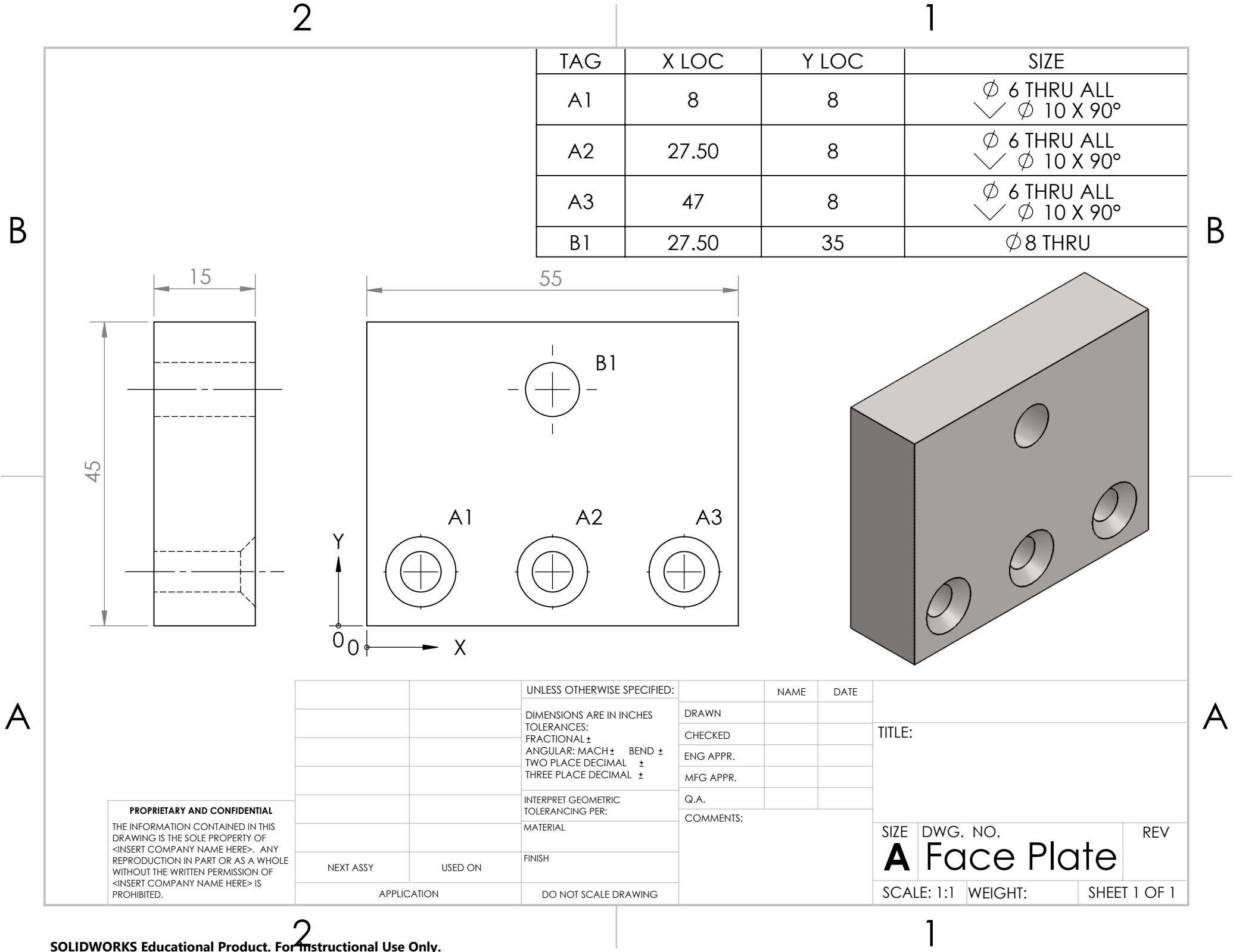


| TAG | X LOC | Y LOC | SIZE |
|-----|-------|-------|---|
| A1 | 10 | 9 | ϕ 6.00 THRU ALL \checkmark ϕ 10.40 X 90° |
| A2 | 45 | 9 | ϕ 6.00 THRU ALL \checkmark ϕ 10.40 X 90° |

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|-------------|---------|--------------------------------------|--|-----------|------|
| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE |
| | | DIMENSIONS ARE IN INCHES | | DRAWN | |
| | | TOLERANCES: | | CHECKED | |
| | | FRACTIONAL \pm | | ENG APPR. | |
| | | ANGULAR: MACH \pm BEND \pm | | MFG APPR. | |
| | | TWO PLACE DECIMAL \pm | | Q.A. | |
| | | THREE PLACE DECIMAL \pm | | COMMENTS: | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | | | |
| | | MATERIAL | | | |
| | | FINISH | | | |
| NEXT ASSY | USED ON | | | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | |

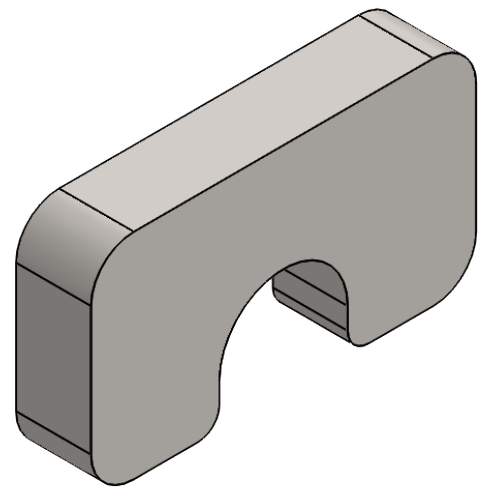
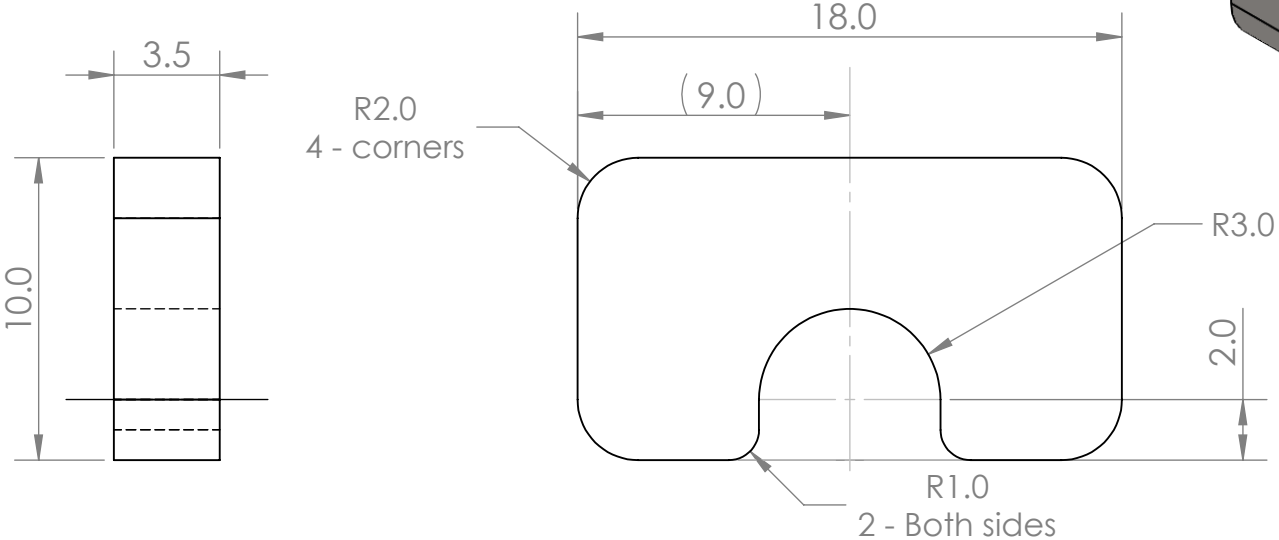
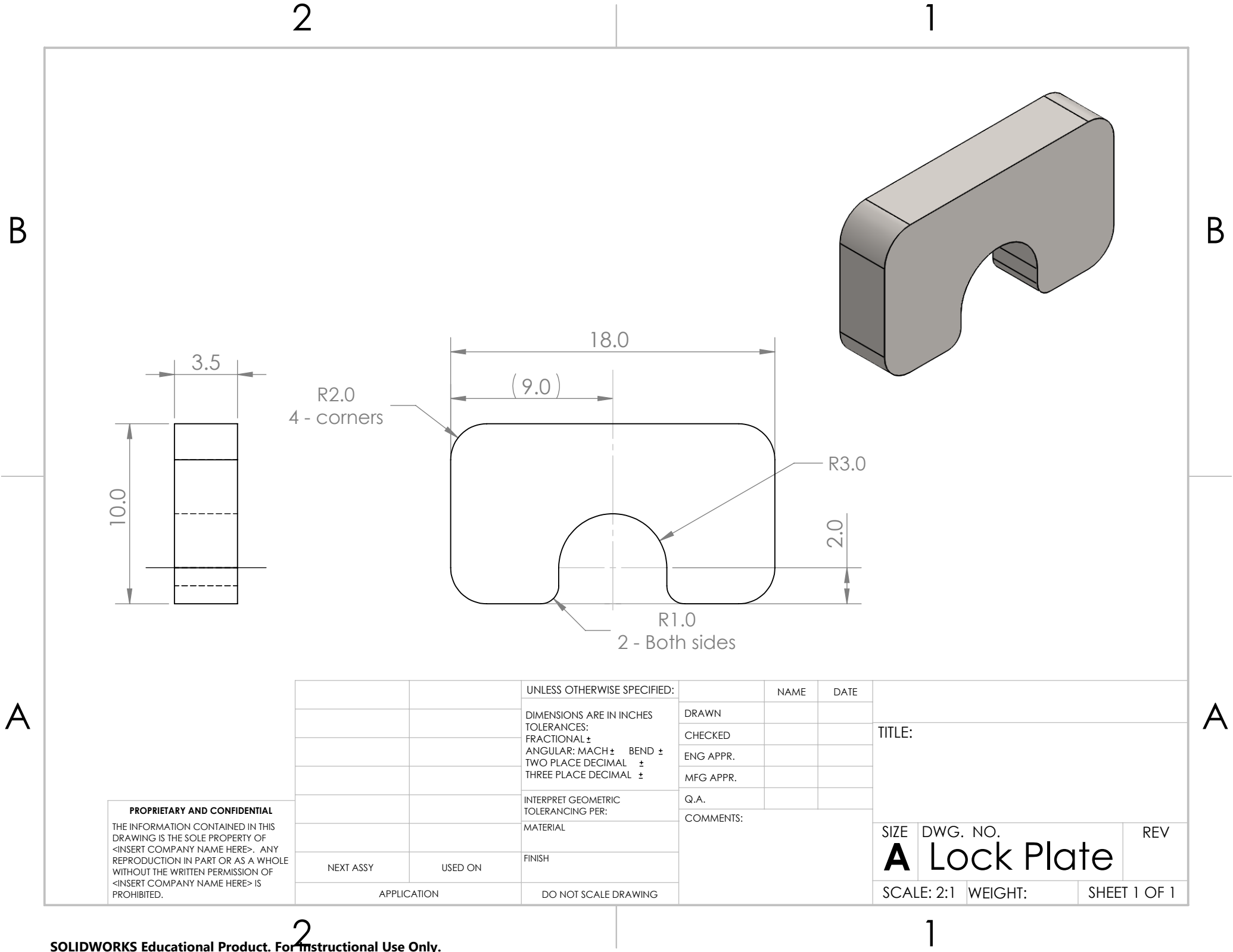
| | | | | |
|---------------|----------|---------|--|--------------|
| TITLE: | | | | |
| SIZE | DWG. NO. | | | REV |
| ASpacer Plate | | | | |
| SCALE: 1:1 | | WEIGHT: | | SHEET 1 OF 1 |



2

1

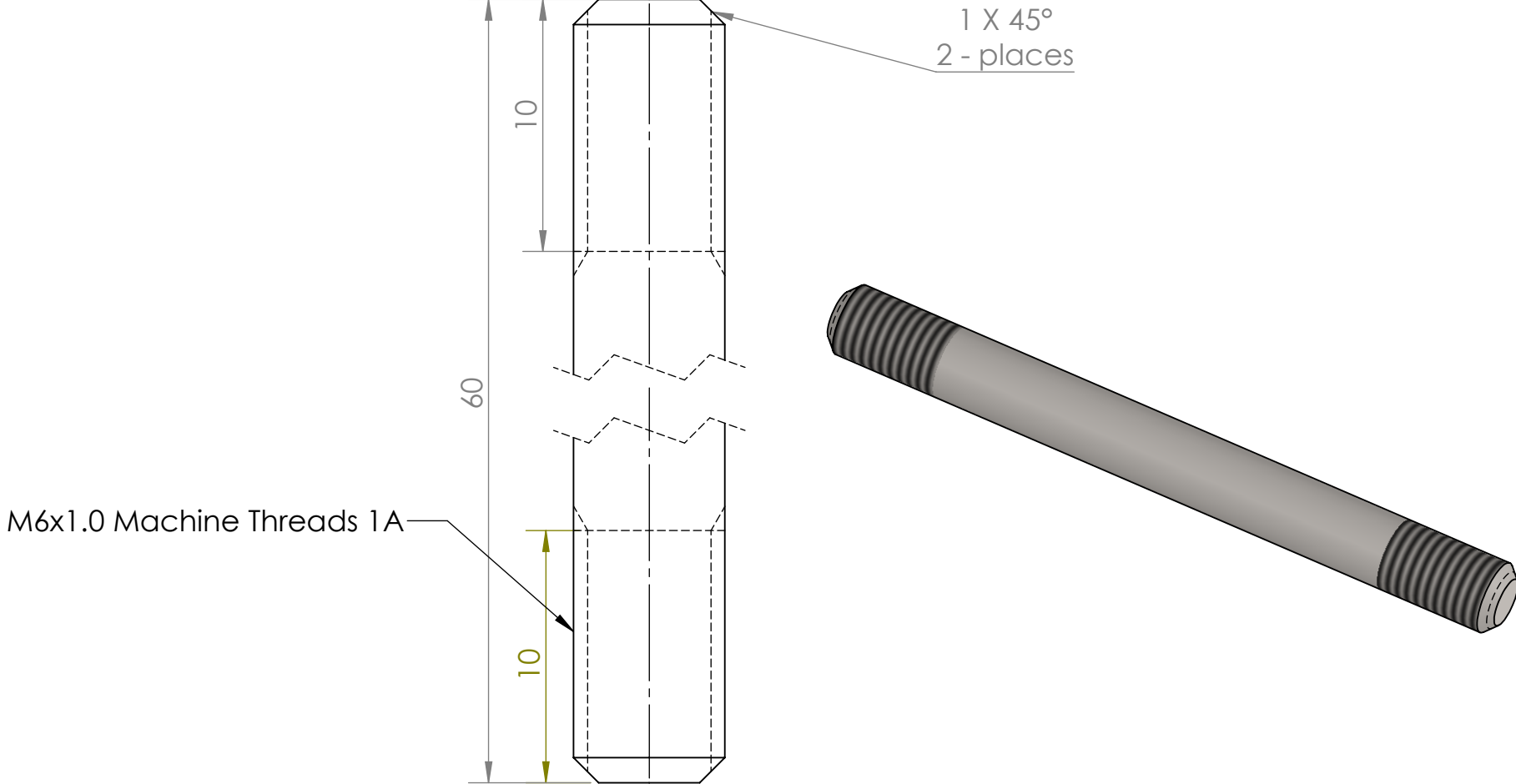
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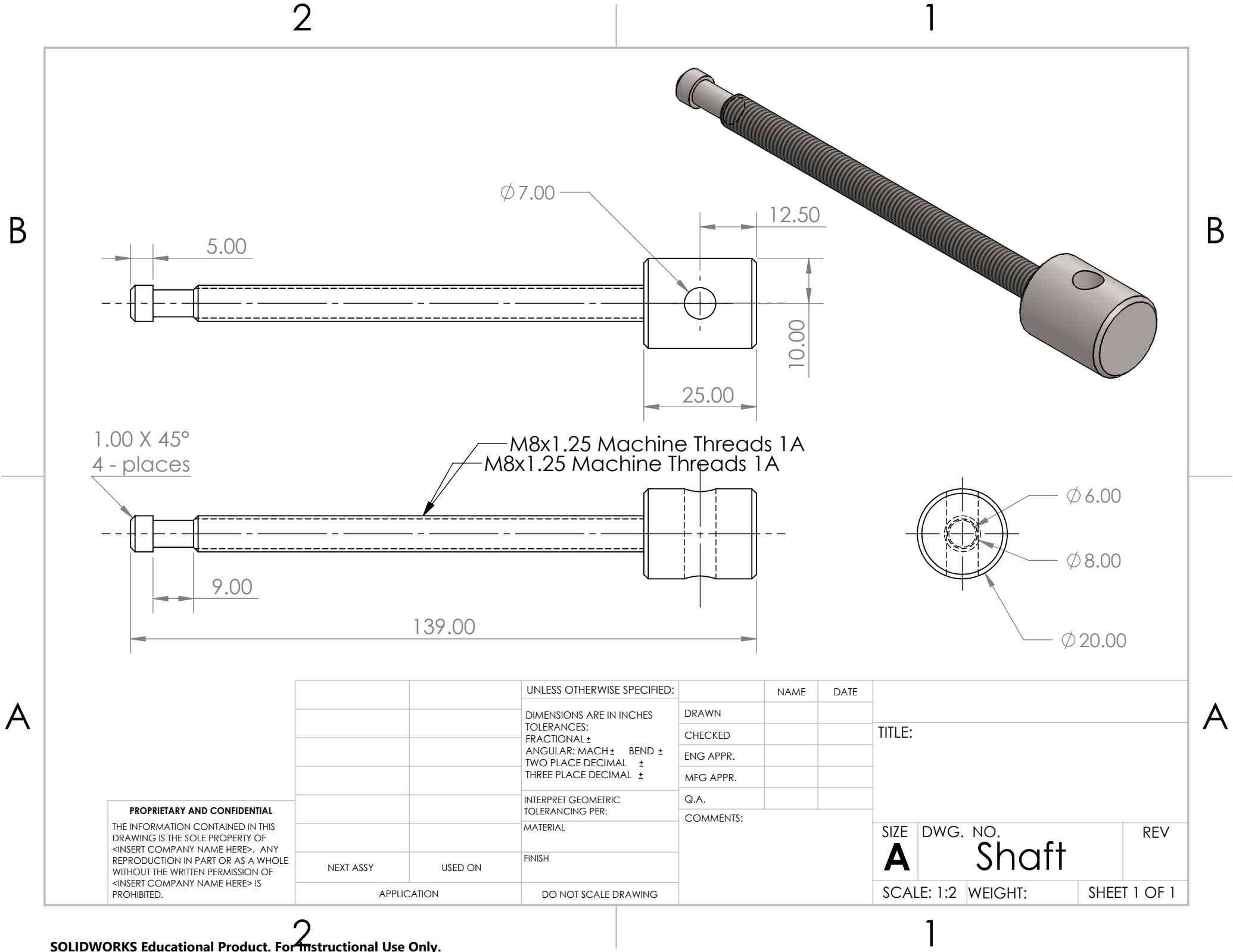
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| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE |
| | | DIMENSIONS ARE IN INCHES | DRAWN | | |
| | | TOLERANCES: | CHECKED | | |
| | | FRACTIONAL: ± | ENG APPR. | | |
| | | ANGULAR: MACH ± BEND ± | MFG APPR. | | |
| | | TWO PLACE DECIMAL ± | Q.A. | | |
| | | THREE PLACE DECIMAL ± | COMMENTS: | | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | | | |
| | | MATERIAL | | | |
| NEXT ASSY | USED ON | FINISH | | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | |

| | | |
|------------|-------------------|--------------|
| TITLE: | | |
| SIZE | DWG. NO. | REV |
| A | Lock Plate | |
| SCALE: 2:1 | WEIGHT: | SHEET 1 OF 1 |



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| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | TITLE: | | |
| | | DIMENSIONS ARE IN INCHES | DRAWN | | | | | |
| | | TOLERANCES: | CHECKED | | | | | |
| | | FRACTIONAL ± | ENG APPR. | | | | | |
| | | ANGULAR: MACH ± BEND ± | MFG APPR. | | | | | |
| | | TWO PLACE DECIMAL ± | Q.A. | | | SIZE | DWG. NO. | REV |
| | | THREE PLACE DECIMAL ± | COMMENTS: | | | | A Lever Arm | |
| NEXT ASSY | USED ON | MATERIAL | | | | SCALE: 1:1 | WEIGHT: | SHEET 1 OF 1 |
| | APPLICATION | FINISH | | | | | | |
| | | DO NOT SCALE DRAWING | | | | | | |

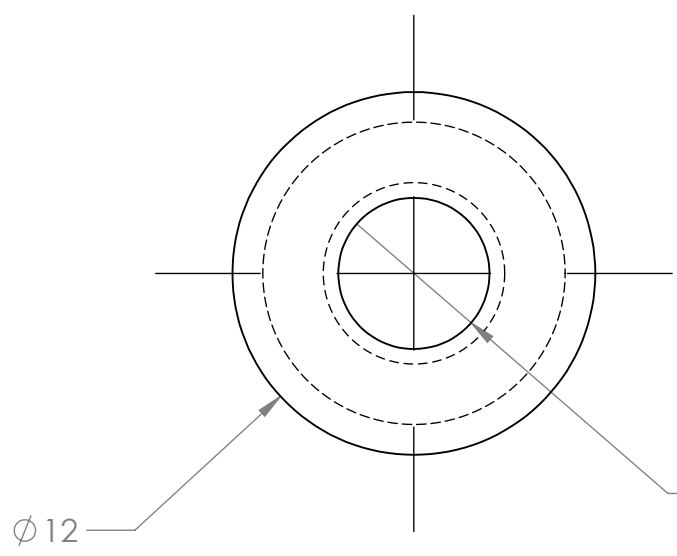
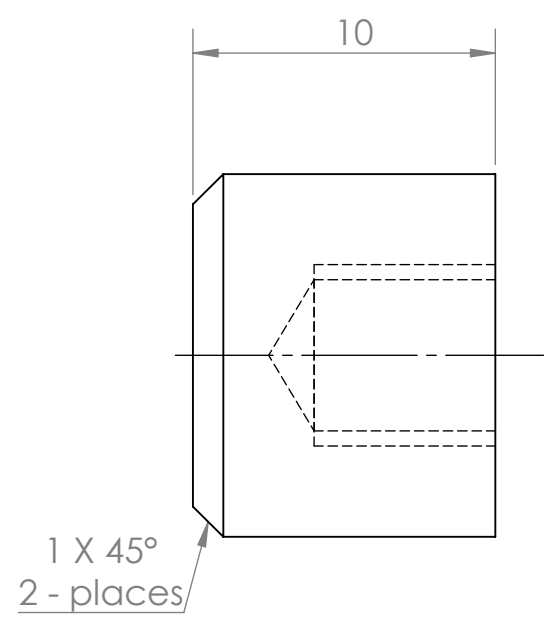


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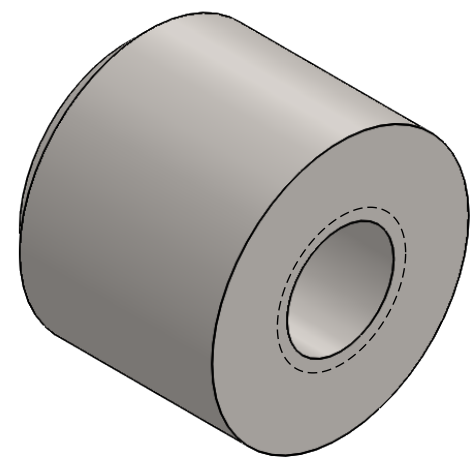
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6
M6X1.0 - 6H 6



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|-------------|---------|--------------------------------------|-----------|------|------|
| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE |
| | | DIMENSIONS ARE IN INCHES | DRAWN | | |
| | | TOLERANCES: | CHECKED | | |
| | | FRACTIONAL ± | ENG APPR. | | |
| | | ANGULAR: MACH ± BEND ± | MFG APPR. | | |
| | | TWO PLACE DECIMAL ± | Q.A. | | |
| | | THREE PLACE DECIMAL ± | COMMENTS: | | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | | | |
| | | MATERIAL | | | |
| NEXT ASSY | USED ON | FINISH | | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | |

| | | |
|------------|----------|--------------|
| TITLE: | | |
| SIZE | DWG. NO. | REV |
| A | Cap | |
| SCALE: 2:1 | WEIGHT: | SHEET 1 OF 1 |