WELDED TOGETHER TO FORM A CHANNEL SECTION.

USING PLATE OR TWO LENGTHS OF ANGLED ROD.

IF THIS IS UNAVAILABLE, IT CAN BE REPLACED

FOR THE SLIDE, SLEEVE TOWER AND BODY TOWER.

THE DESIGN IS BASED ON CHANNEL SECTION.
<table>
<thead>
<tr>
<th>No.</th>
<th>DESCRIPTION</th>
<th>QUANTITY</th>
<th>DIMENSIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>BASE</td>
<td>1</td>
<td>8 x 150 x 150</td>
</tr>
<tr>
<td>2</td>
<td>BODY SIDE</td>
<td>2</td>
<td>8 x 150 x 38</td>
</tr>
<tr>
<td>3</td>
<td>BODY TOP</td>
<td>1</td>
<td>8 x 150 x 95</td>
</tr>
<tr>
<td>4</td>
<td>NUT</td>
<td>2</td>
<td>M20 NUT</td>
</tr>
<tr>
<td>5</td>
<td>BODY TOWER</td>
<td>1</td>
<td>38 x 77 CHANNEL SECTION x 85</td>
</tr>
<tr>
<td>6</td>
<td>BODY BACK</td>
<td>1</td>
<td>8 x 77 x 50</td>
</tr>
<tr>
<td>7</td>
<td>TOWER TOP</td>
<td>2</td>
<td>8 x 77 x 50</td>
</tr>
<tr>
<td>8</td>
<td>JAW</td>
<td>2</td>
<td>15 x 40 x 120</td>
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<tr>
<td>9</td>
<td>SLIDE</td>
<td>1</td>
<td>38 x 77 CHANNEL SECTION x 365</td>
</tr>
<tr>
<td>10</td>
<td>SLIDE TOWER</td>
<td>1</td>
<td>38 x 77 CHANNEL SECTION x 90</td>
</tr>
<tr>
<td>11</td>
<td>SLIDE BACK</td>
<td>1</td>
<td>8 x 77 x 95</td>
</tr>
<tr>
<td>12</td>
<td>BACK SUPPORT</td>
<td>1</td>
<td>8 x 77 x 38</td>
</tr>
<tr>
<td>13</td>
<td>THREAD</td>
<td>1</td>
<td>M20 STUDDING x 350</td>
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<tr>
<td>14</td>
<td>BOSS</td>
<td>1</td>
<td>#30 (#20 BORE) x 70</td>
</tr>
<tr>
<td>15</td>
<td>HANDLE</td>
<td>1</td>
<td>#12 x 200</td>
</tr>
<tr>
<td>16</td>
<td>NUT</td>
<td>2</td>
<td>M12 NUT</td>
</tr>
<tr>
<td>17</td>
<td>SPLIT PIN</td>
<td>2</td>
<td>#5 x 50 SPLIT PIN OR NAIL</td>
</tr>
<tr>
<td>18</td>
<td>WASHERS</td>
<td>2</td>
<td>M20 WASHER</td>
</tr>
</tbody>
</table>
Slide Back.

Washers Either Side of the Split Pin Secures the Two Offset Into Sliding Jaw.

Part Section Showing Assembly

Washer to Turn Freely.

Inside of Channel to Allow Inside of Channel to Allow.

Do Not Weld Back Support To

Welding Nuts Together.

Base Before Alignment Weld Nuts To

To Ensure Thread

4 Holes Ø11

Do Not Weld Jaw Sides

To Avoid Jaw Distortion

SECTION A-A

The Jaws Must Close
To Fit when Tightened.

INSIDE THE BODY SO AS NOT
MUST BE A GOOD SNIFF FIT
THE CHANNEL SECTION SLIDE

PARALLEL TO EACH OTHER.

The Jaws Must Close
To Fit when Tightened.

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The Jaws Must Close
To Fit when Tightened.
KNURLED JAW SURFACE

1. Scribe lines at 45° as a guide.

2. Use a cold chisel to produce a knurled gripping surface.

ENLARGED SECTION OF KNURLED SURFACE.
Note top surface must be flat to clamp effectively with opposite jaw.

REPLACEABLE JAWS

Round off the heads of four M10 bolts and saw a slot across.

Jaw support plate welded to tower channel section.

PART SECTION SHOWING CONSTRUCTION OF REPLACEABLE JAW.

HARD JAWS
If hard jaws are required, these can be made from lorry leaf-spring:
1. Anneal before cutting jaws (heat to dull red and cool very slowly).
2. After making them, re-harden by heating to dull red and quenching in oil.

ApT ENGINEERS BENCH VICE

TITLE: JAW OPTIONS

SCALE: 1:1

DRAWN: ABATEC PAGE: 4 of 4

CAD No: APT-01-4