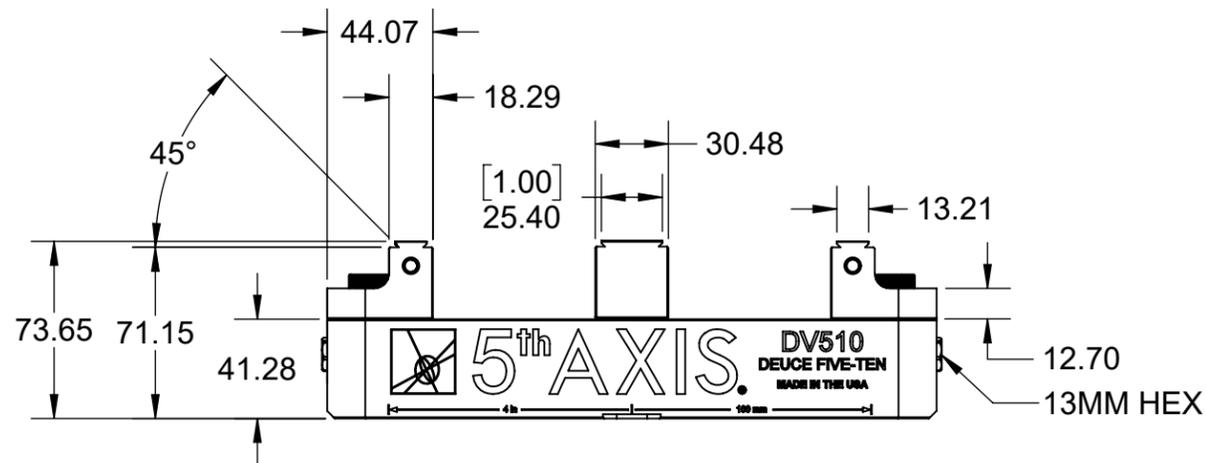
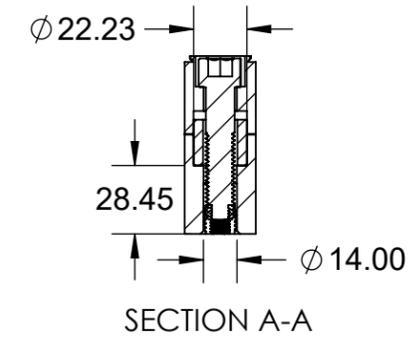
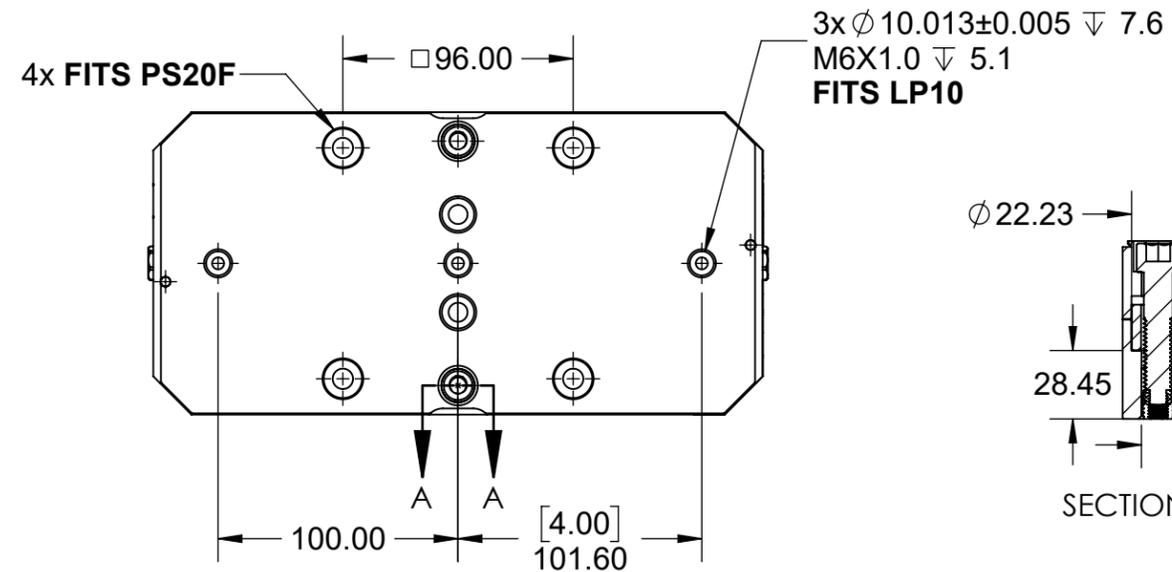
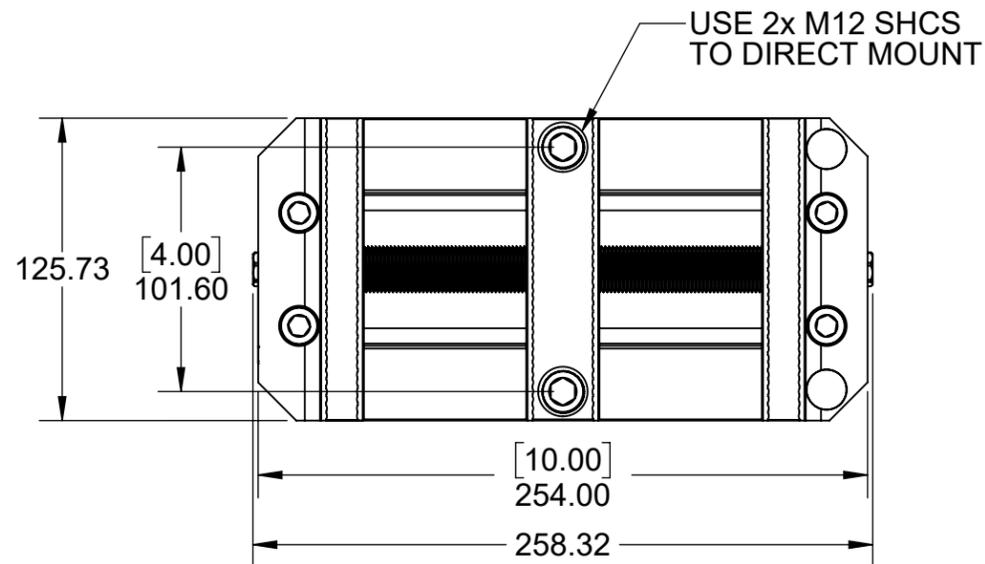
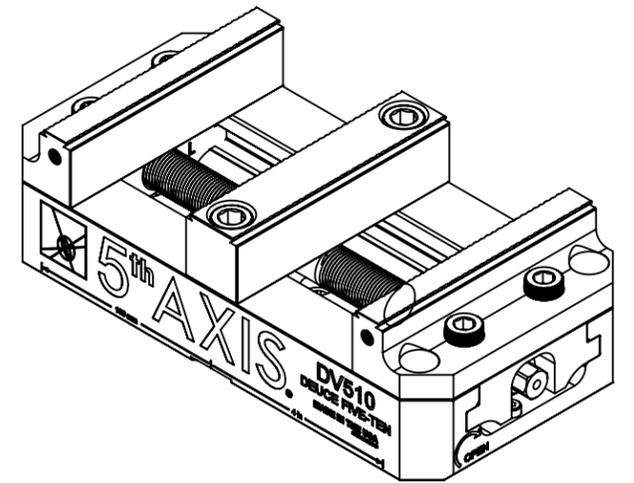


| TECHNICAL DATA                 | DV510-J4           |
|--------------------------------|--------------------|
| JAW WIDTH                      | 125.73mm           |
| BASE LENGTH                    | 254.00mm           |
| MAXIMUM TORQUE (JAW BOLT)      | 47.45 Nm           |
| CLAMPING FORCE                 | 19.57kN @ 74.57 Nm |
| MAXIMUM TORQUE (LEADSCREW)     | 74.57 Nm           |
| MAXIMUM TORQUE (MOUNTING BOLT) | 47.45 Nm           |
| SELF-CENTERING ACCURACY        | ± 12.7µm           |

# DV510-J4



| MILLIMETER                                |  | TOLERANCES UNLESS OTHERWISE SPECIFIED |              | 5 <sup>th</sup> AXIS®  |                             |         |              |
|---|--|---------------------------------------|--------------|--|-----------------------------|---------|--------------|
| DRAWN IN ACCORDANCE WITH ASME Y14.5-2009  |  | x ± 0.1                               | .xx ± 0.01   | DESCRIPTION<br><b>LARGE DOUBLE STATION VISE WITH 1" CENTER</b> |                             |         |              |
| WWW.5THAXIS.COM                           |  | .x ± 0.05                             | .xxx ± 0.005 |  |                             |         |              |
| 7140 ENGINEER ROAD<br>SAN DIEGO, CA 92111 |  | ANGULAR ± 0.5°                        |              |  |                             |         |              |
| P (858) 505-0432<br>F (858) 505-9344      |  | THIRD ANGLE PROJECTION                |              | SIZE<br><b>B</b>   | PART NO.<br><b>DV510-J4</b> |         |              |
|   |  |                                       |              | DO NOT SCALE DRAWING   | SCALE 1:3                   | WEIGHT: | SHEET 1 OF 7 |

A

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# DV510-J4

C

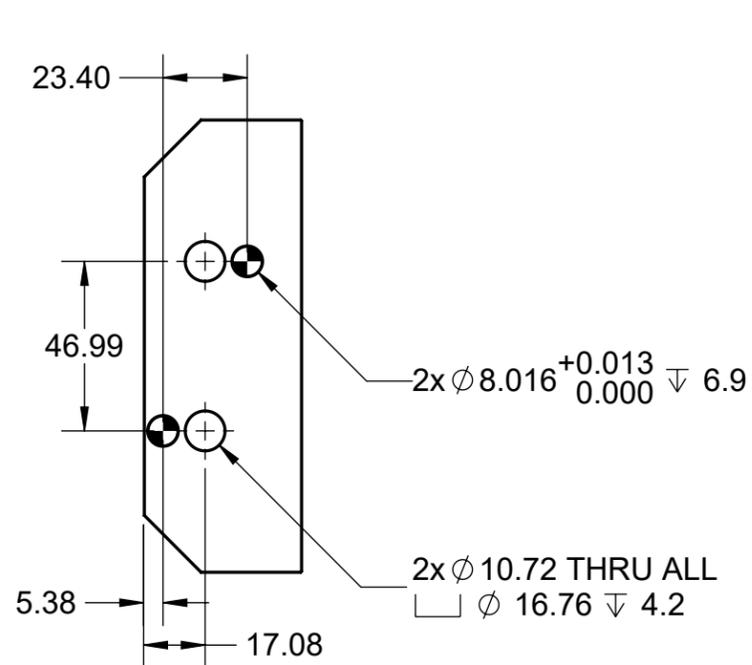
C

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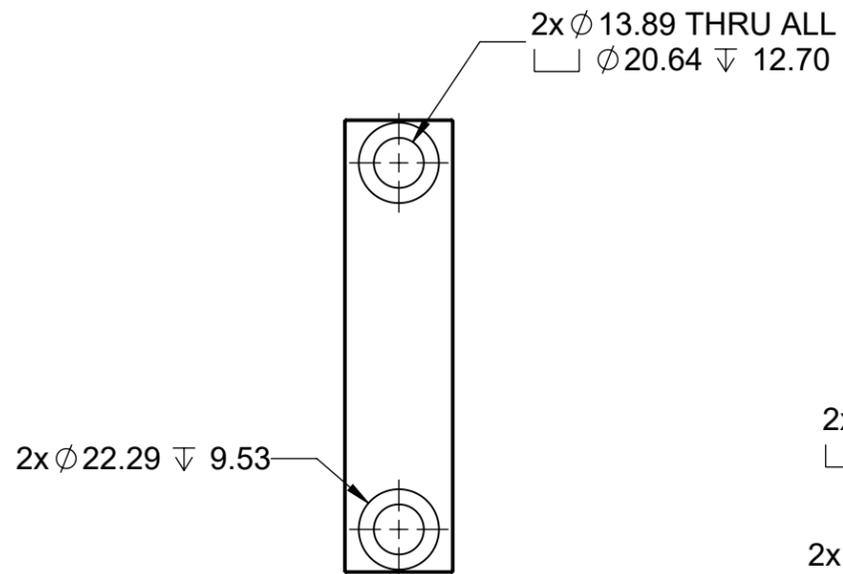
B

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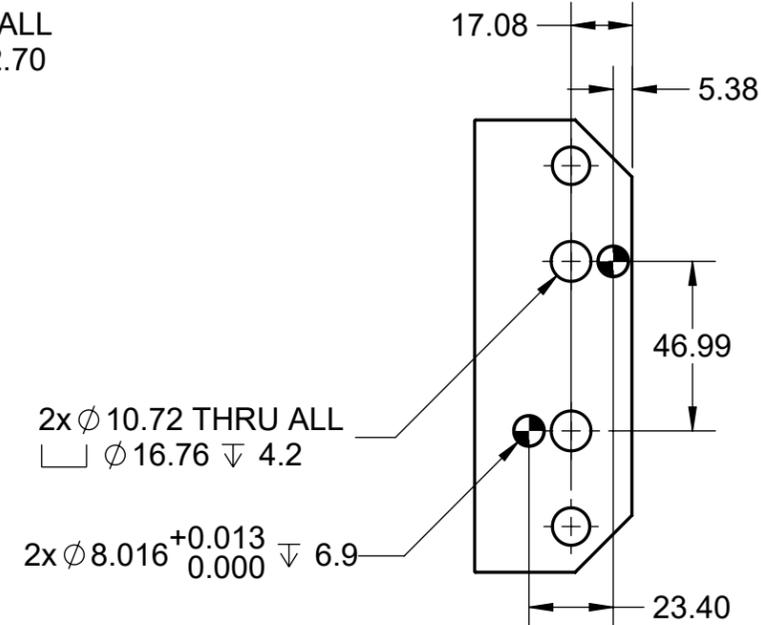
A



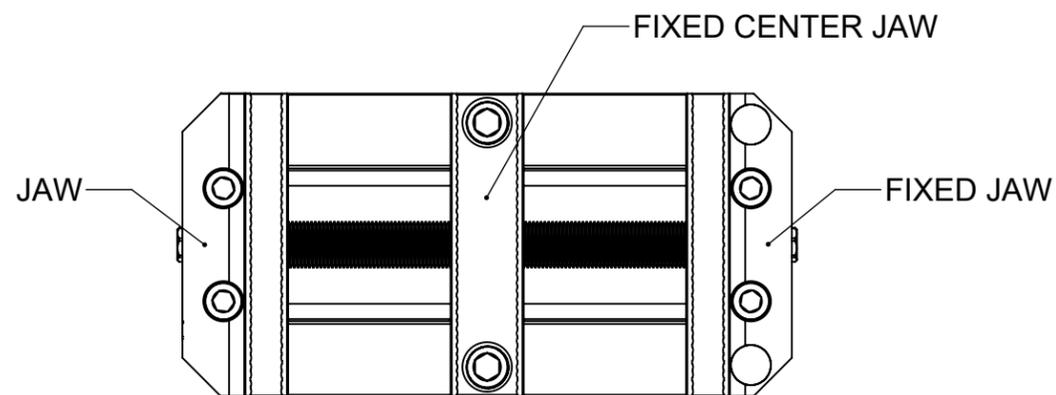
JAW MOUNTING



FIXED CENTER JAW MOUNTING



FIXED JAW MOUNTING



|   |  |  |                             |   |                 |
|---|--|--|-----------------------------|---|-----------------|
| <b>MILLIMETER</b>                           |  | <b>TOLERANCES</b><br>UNLESS OTHERWISE SPECIFIED  |                             |  |                 |
| DRAWN IN ACCORDANCE WITH<br>ASME Y14.5-2009 |  | x ± 0.1    .xx ± 0.01<br>.x ± 0.05    .xxx ± 0.005<br>ANGULAR ± 0.5°<br>THIRD ANGLE PROJECTION |                             |   |                 |
| WWW.5THAXIS.COM                             |  | DESCRIPTION<br><b>LARGE DOUBLE STATION VISE WITH 1" CENTER</b>                                 |                             |   |                 |
| 7140 ENGINEER ROAD<br>SAN DIEGO, CA 92111   |  | SIZE<br><b>B</b>   | PART NO.<br><b>DV510-J4</b> |   | REV<br><b>A</b> |
| P (858) 505-0432<br>F (858) 505-9344        |  | DO NOT SCALE DRAWING   |                             | SCALE 1:2   | WEIGHT:         |
|   |  |  |                             | SHEET 2 OF 7  |                 |

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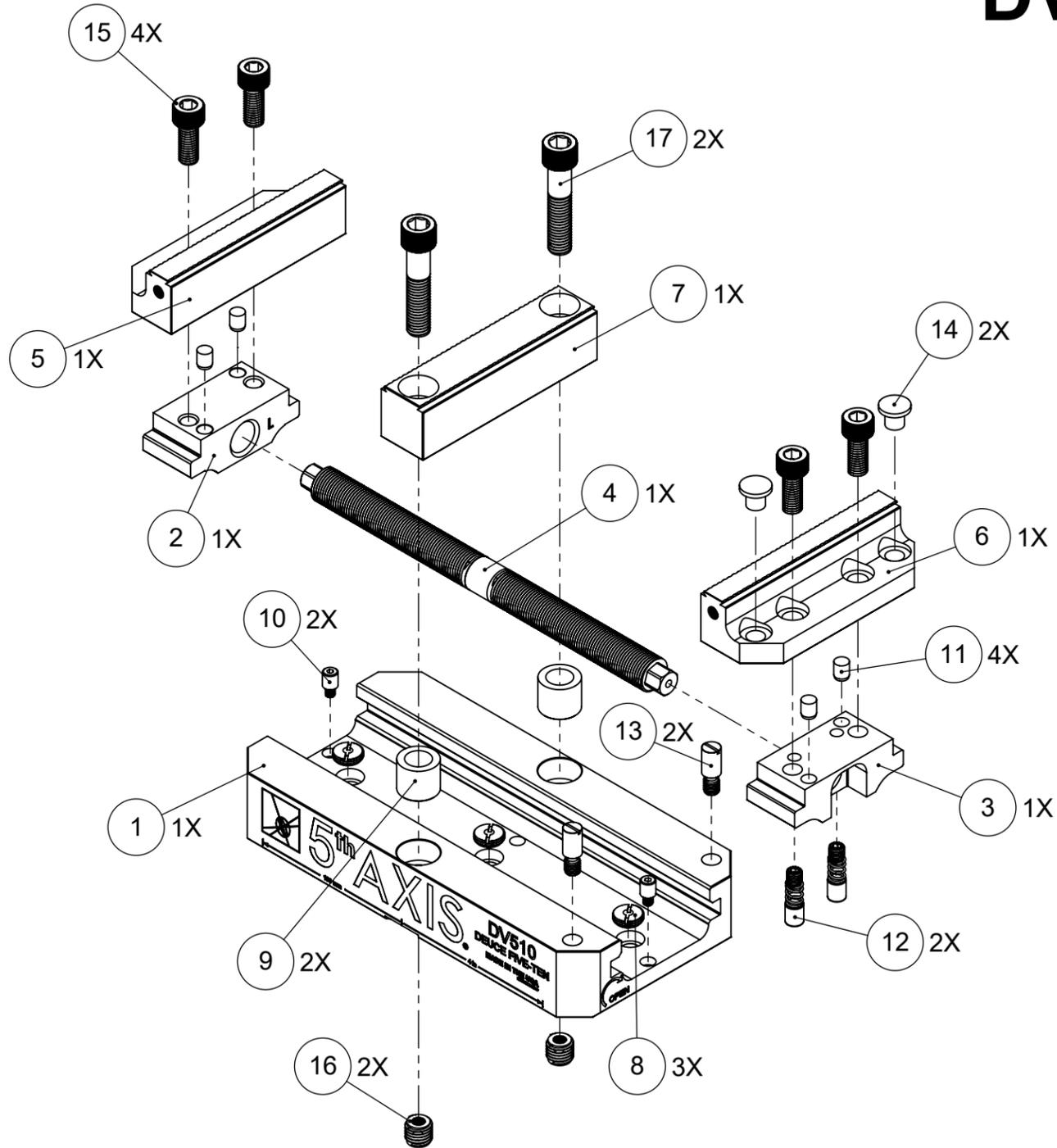
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# DV510-J4



| ITEM NO. | PART NUMBER  | DESCRIPTION              | QTY. |
|----------|--------------|--------------------------|------|
| 1        | V5104-1DV    | BASE                     | 1    |
| 2        | V562M-2L     | LEFT TRUCK               | 1    |
| 3        | V562M-2RDV   | RIGHT TRUCK              | 1    |
| 4        | V5104M-4     | LEAD SCREW               | 1    |
| 5        | V562M-5      | JAW                      | 1    |
| 6        | V562M-5F     | FIXED JAW                | 1    |
| 7        | V562-5CDV    | FIXED CENTER JAW         | 1    |
| 8        | M6X1.0       | THREADED INSERT          | 3    |
| 9        | 0875X0750.DB | BUSHING DRILL            | 2    |
| 10       | LP8          | LOCATING PIN             | 2    |
| 11       | M8X12.DP     | DOWEL PIN, M8 X 12mm     | 4    |
| 12       | 76384        | FRICTION PIN             | 2    |
| 13       | BASE.PLUG    | BASE PLUG                | 2    |
| 14       | JAW.PLUG     | JAW PLUG                 | 2    |
| 15       | 76300        | SOCKET HEAD CAP SCREW    | 4    |
| 16       | 450-12       | THREADED INSERT          | 2    |
| 17       | 91290A628    | SOCKET HEAD CAP SCREW    | 2    |
| 18       | ANTI-SEIZE   | ANTI-SEIZE (NOT SHOWN)   | 1    |
| 19       | LP10         | LOCATING PIN (NOT SHOWN) | 2    |
| 20       | TS13         | THUMB SCREW (NOT SHOWN)  | 1    |

FOR REFERENCE ONLY - NOT FOR RESALE

### MILLIMETER

DRAWN IN ACCORDANCE WITH  
ASME Y14.5-2009

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SAN DIEGO, CA 92111

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F (858) 505-9344

### TOLERANCES

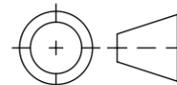
UNLESS OTHERWISE SPECIFIED

x ± 0.1 .xx ± 0.01

.x ± 0.05 .xxx ± 0.005

ANGULAR ± 0.5°

THIRD ANGLE PROJECTION



DESCRIPTION

LARGE DOUBLE STATION VISE WITH 1" CENTER

SIZE

**B**

PART NO.

DV510-J4

REV

**A**

DO NOT SCALE DRAWING

SCALE 1:3

WEIGHT:

SHEET 3 OF 7

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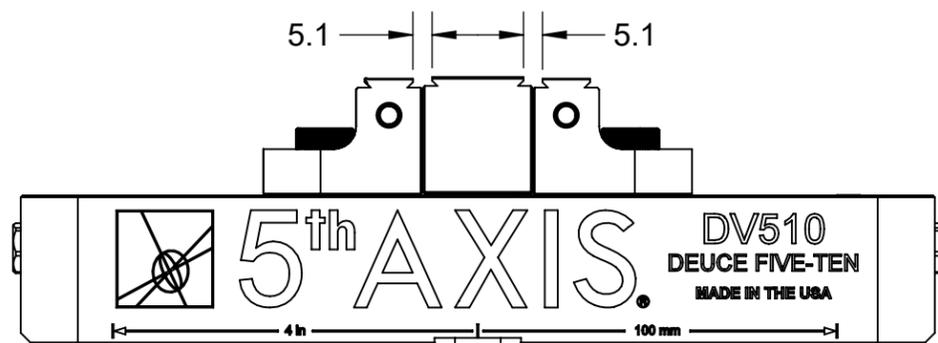
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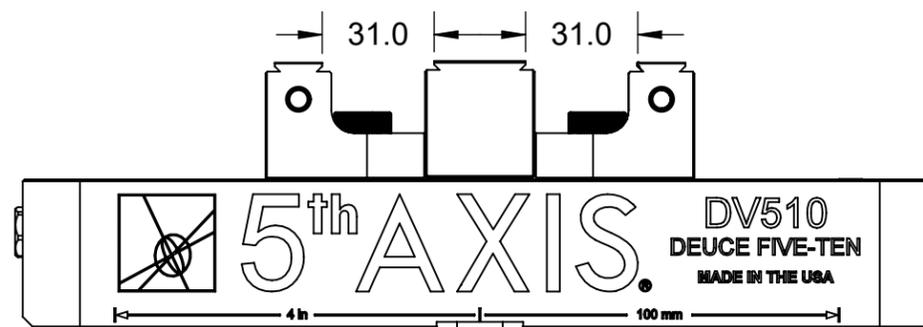
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**NOTE:** USING DOVETAIL ALLOWS VISE TO CLAMP LARGER PART.  
BELOW CLAMPING RANGE ONLY SHOWS THE CAPABILITY OF THE GRIPPER TEETH.

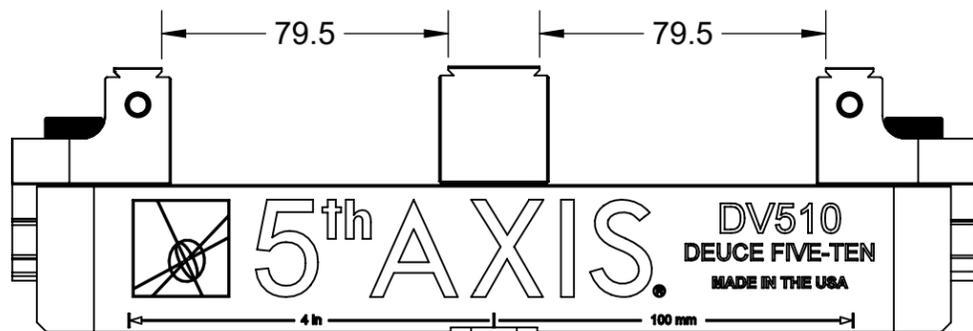
# DV510-J4



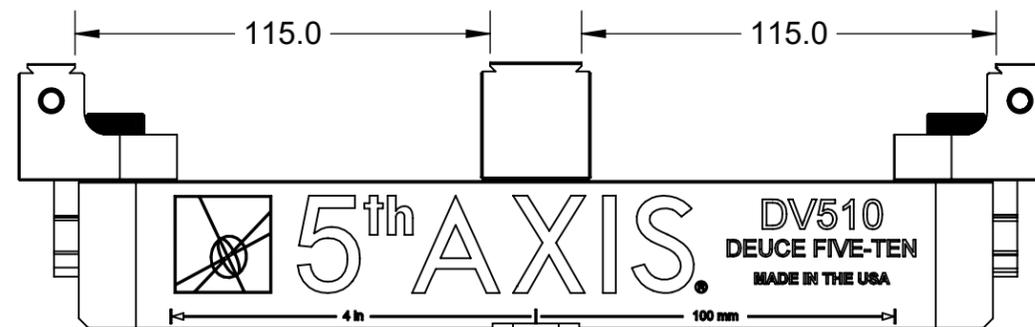
FORWARD JAWS (MINIMUM CLAMPING RANGE)



REVERSE JAWS (MINIMUM CLAMPING RANGE)



FORWARD JAWS (MAXIMUM CLAMPING RANGE)



REVERSE JAWS (MAXIMUM CLAMPING RANGE)

### MILLIMETER

DRAWN IN ACCORDANCE WITH  
ASME Y14.5-2009

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SAN DIEGO, CA 92111

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F (858) 505-9344

### TOLERANCES

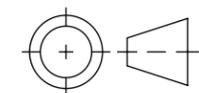
UNLESS OTHERWISE SPECIFIED

x ± 0.1 .xx ± 0.01

.x ± 0.05 .xxx ± 0.005

ANGULAR ± 0.5°

THIRD ANGLE PROJECTION



DESCRIPTION  
**LARGE DOUBLE STATION VISE WITH 1" CENTER**

|                  |                             |                 |
|------------------|-----------------------------|-----------------|
| SIZE<br><b>B</b> | PART NO.<br><b>DV510-J4</b> | REV<br><b>A</b> |
|------------------|-----------------------------|-----------------|

DO NOT SCALE DRAWING

SCALE 1:2

WEIGHT:

SHEET 4 OF 7

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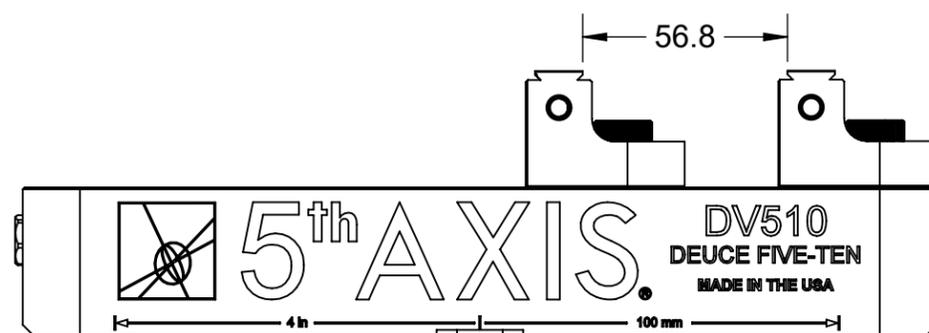
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**NOTE:** USING DOVETAIL ALLOWS VISE TO CLAMP LARGER PART.  
BELOW CLAMPING RANGE ONLY SHOWS THE CAPABILITY OF THE GRIPPER TEETH.

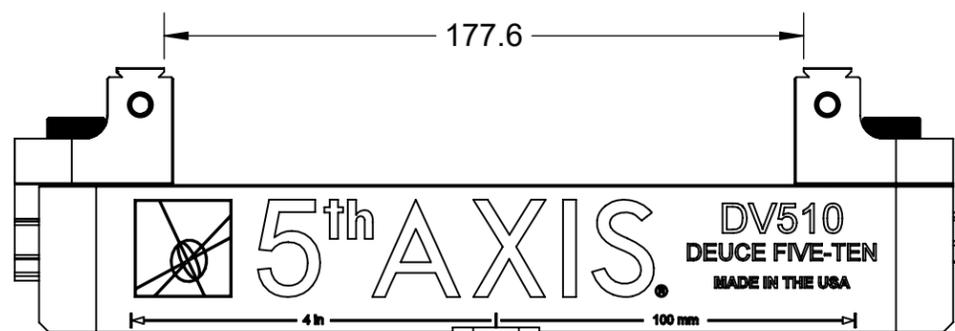
# DV510-J4



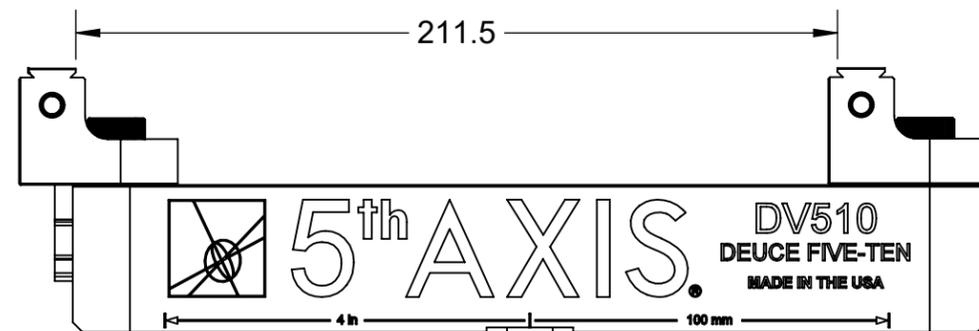
FORWARD JAWS (MINIMUM CLAMPING RANGE)  
FIXED JAW CONFIGURATION



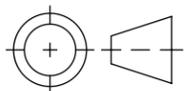
REVERSE JAWS (MINIMUM CLAMPING RANGE)  
FIXED JAW CONFIGURATION



FORWARD JAWS (MAXIMUM CLAMPING RANGE)  
FIXED JAW CONFIGURATION



REVERSE JAWS (MAXIMUM CLAMPING RANGE)  
FIXED JAW CONFIGURATION

|  |   |   |                                    |                        |
|--|---|---|------------------------------------|------------------------|
| <b>MILLIMETER</b><br><small>DRAWN IN ACCORDANCE WITH<br/>ASME Y14.5-2009</small>                             | <b>TOLERANCES</b><br><small>UNLESS OTHERWISE SPECIFIED</small><br>x ± 0.1    .xx ± 0.01<br>.x ± 0.05    .xxx ± 0.005<br>ANGULAR ± 0.5°<br><small>THIRD ANGLE PROJECTION</small> |  |                                    |                        |
|  |   | <b>DESCRIPTION</b><br><b>LARGE DOUBLE STATION VISE WITH 1" CENTER</b>                 |                                    |                        |
| WWW.5THAXIS.COM<br><br>7140 ENGINEER ROAD<br>SAN DIEGO, CA 92111<br><br>P (858) 505-0432<br>F (858) 505-9344 |    | <b>SIZE</b><br><b>B</b>   | <b>PART NO.</b><br><b>DV510-J4</b> | <b>REV</b><br><b>A</b> |
|  |   | DO NOT SCALE DRAWING  |                                    | SCALE 1:2              |
|  |   |   | SHEET 5 OF 7                       |                        |

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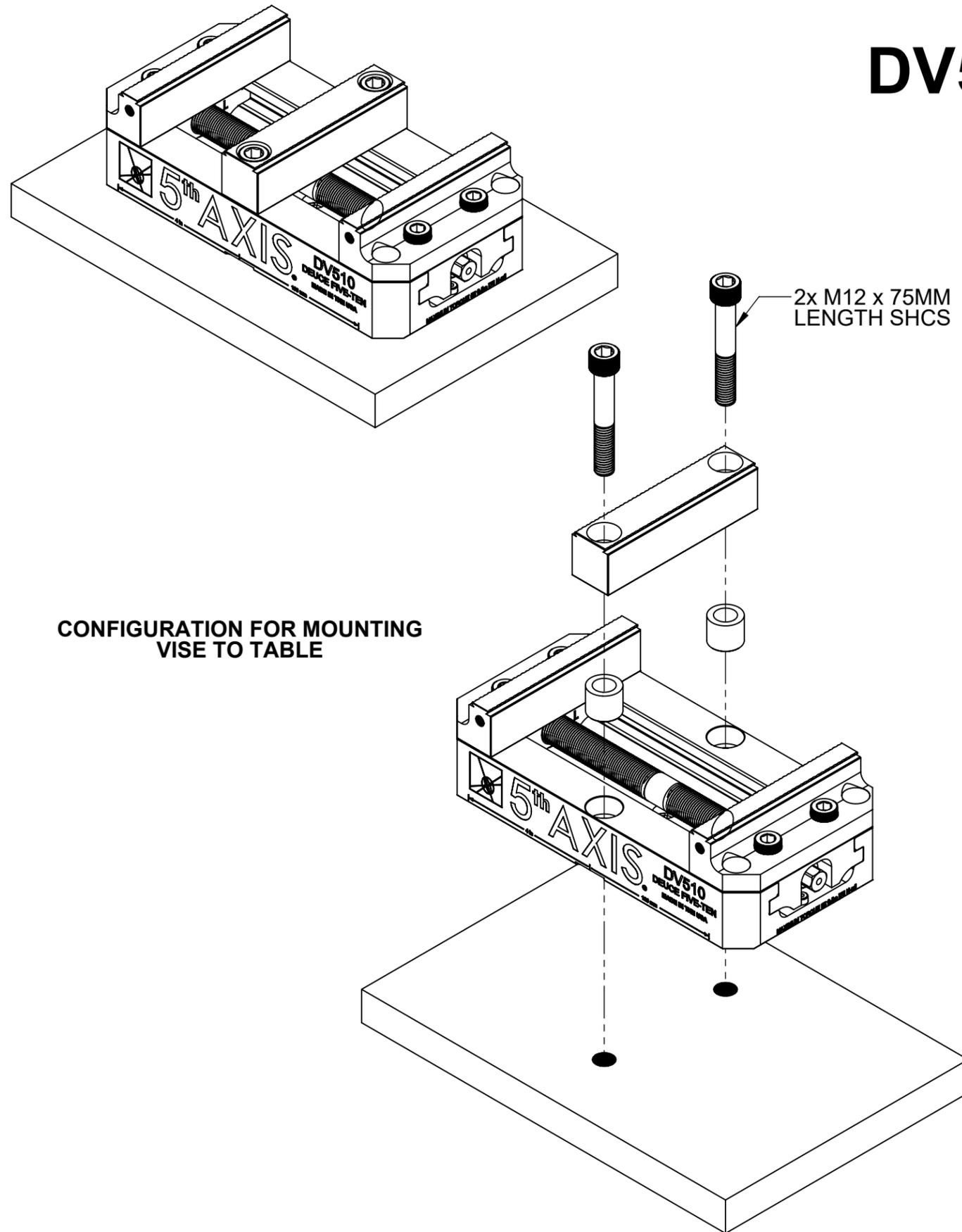
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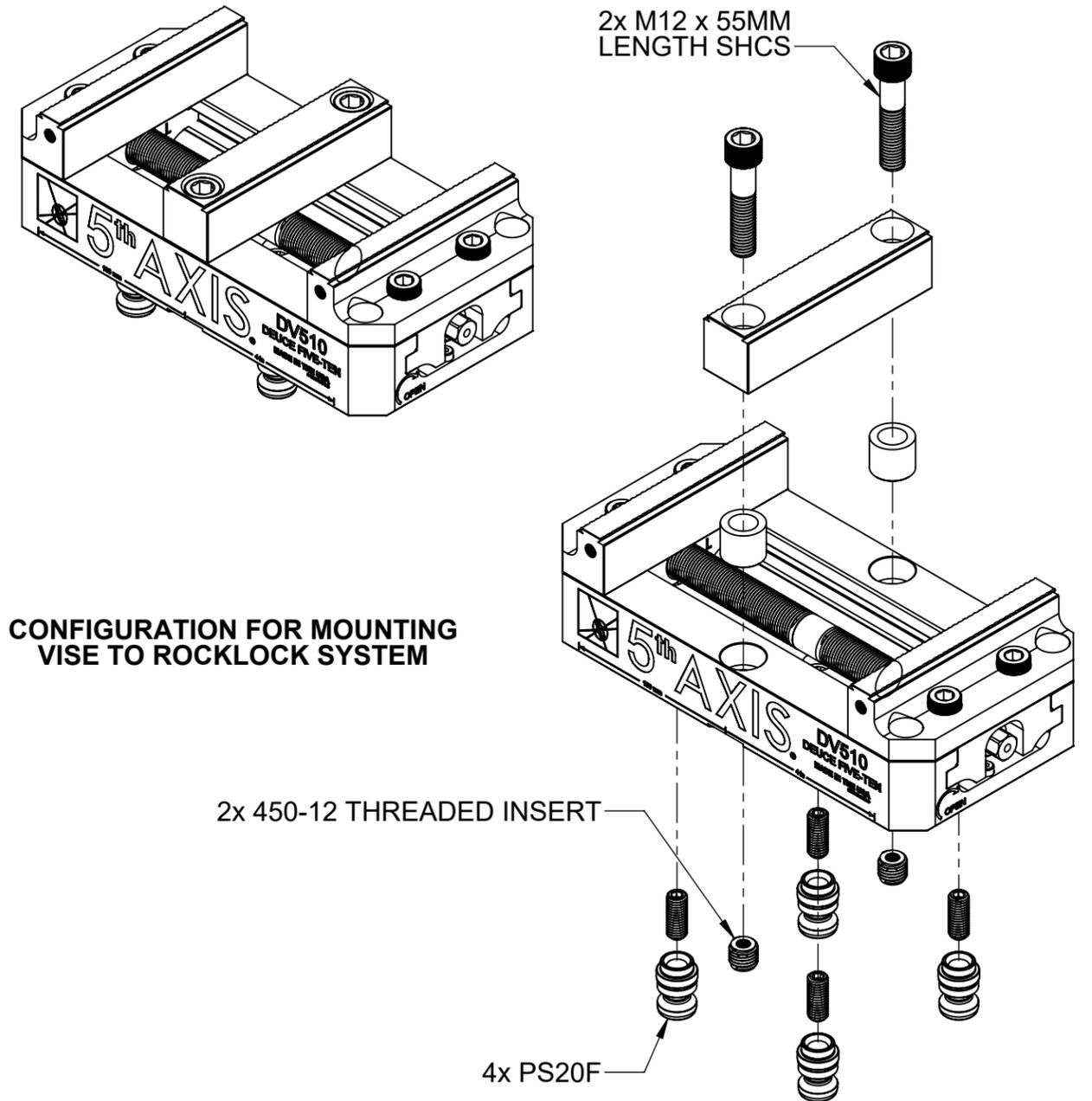
A

# DV510-J4

CONFIGURATION FOR MOUNTING VISE TO TABLE



CONFIGURATION FOR MOUNTING VISE TO ROCKLOCK SYSTEM



**MILLIMETER**

DRAWN IN ACCORDANCE WITH ASME Y14.5-2009

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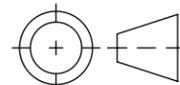
**TOLERANCES**

UNLESS OTHERWISE SPECIFIED

x ± 0.1    .xx ± 0.01  
.x ± 0.05    .xxx ± 0.005

ANGULAR ± 0.5°

THIRD ANGLE PROJECTION



DESCRIPTION  
**LARGE DOUBLE STATION VISE WITH 1" CENTER**

|                  |                             |                 |
|------------------|-----------------------------|-----------------|
| SIZE<br><b>B</b> | PART NO.<br><b>DV510-J4</b> | REV<br><b>A</b> |
|------------------|-----------------------------|-----------------|

|                      |           |         |              |
|----------------------|-----------|---------|--------------|
| DO NOT SCALE DRAWING | SCALE 1:3 | WEIGHT: | SHEET 6 OF 7 |
|----------------------|-----------|---------|--------------|

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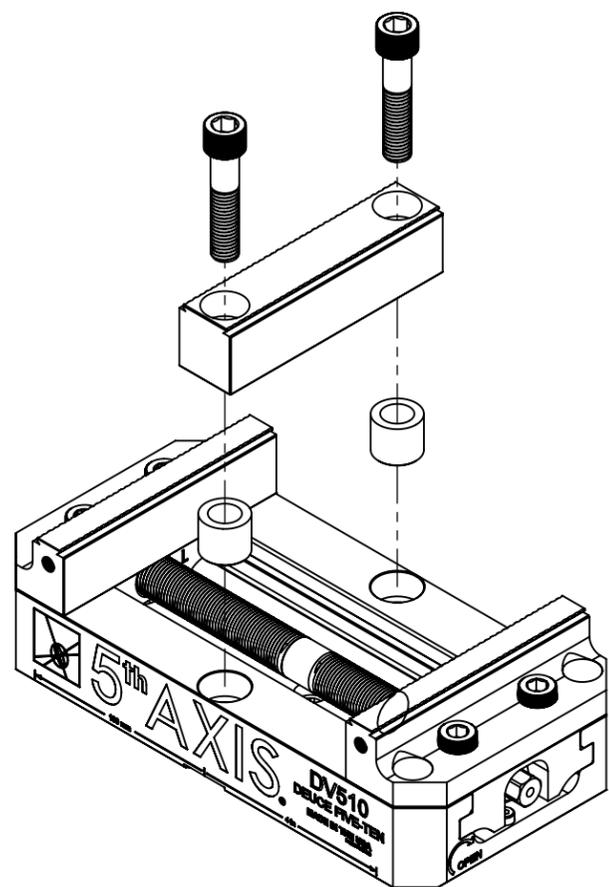
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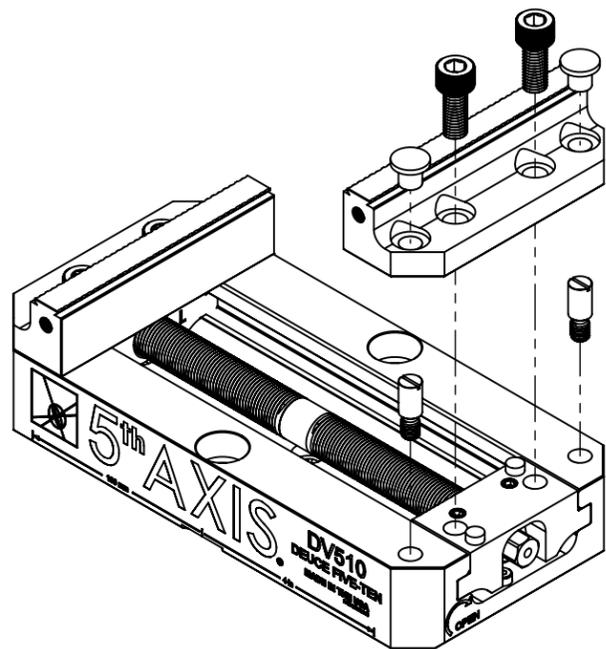
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# DV510-J4

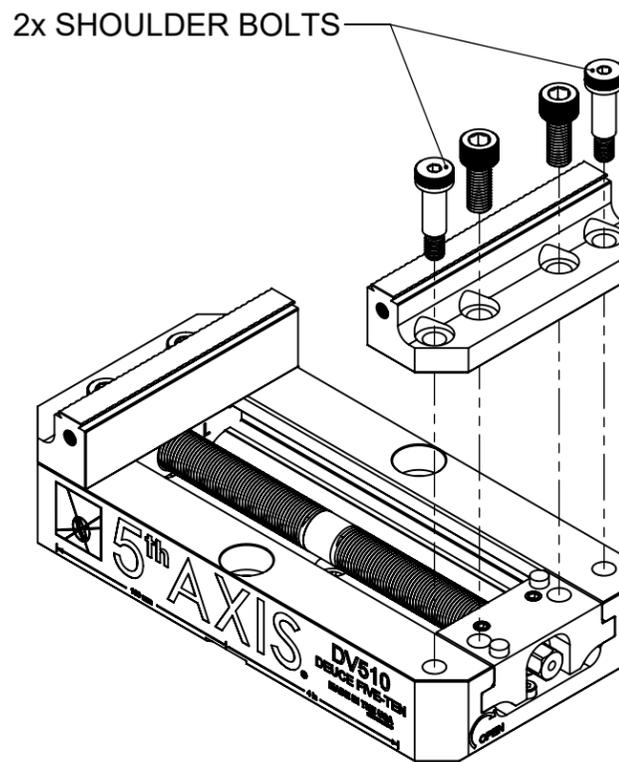
## CONVERTING DOUBLE STATION VISE TO FIXED JAW, SINGLE STATION VISE CONFIGURATION



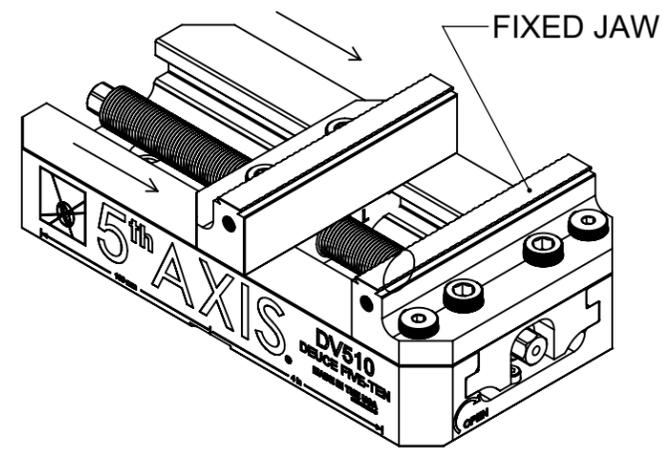
**STEP 1:**  
REMOVE CENTER JAW COMPONENTS



**STEP 2:**  
REMOVE RIGHT JAW, JAW PLUGS  
AND BASE PLUGS



**STEP 3:**  
REATTACH RIGHT JAW INTO RIGHT  
TRUCK AND BASE USING 2x SHCS  
AND 2x SHOULDER BOLTS



**STEP 4:**  
FIXED JAW CONFIGURATION COMPLETE  
(RIGHT JAW FIXED AND LEFT JAW MOVES)

|   |   |   |           |  |              |
|---|---|---|-----------|--|--------------|
| <b>MILLIMETER</b><br><small>DRAWN IN ACCORDANCE WITH<br/>ASME Y14.5-2009</small><br><br><small>WWW.5THAXIS.COM</small><br><br><small>7140 ENGINEER ROAD<br/>SAN DIEGO, CA 92111</small><br><br><small>P (858) 505-0432<br/>F (858) 505-9344</small> | <b>TOLERANCES</b><br><small>UNLESS OTHERWISE SPECIFIED</small><br>x ± 0.1    .xx ± 0.01<br>.x ± 0.05    .xxx ± 0.005<br>ANGULAR ± 0.5°<br><small>THIRD ANGLE PROJECTION</small> |  |           |  |              |
|   |   |   |           | DESCRIPTION<br><b>LARGE DOUBLE STATION VISE WITH 1" CENTER</b> |              |
| SIZE <b>B</b> PART NO. <b>DV510-J4</b> REV <b>A</b>   |   | DO NOT SCALE DRAWING  | SCALE 1:3 | WEIGHT:  | SHEET 7 OF 7 |

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