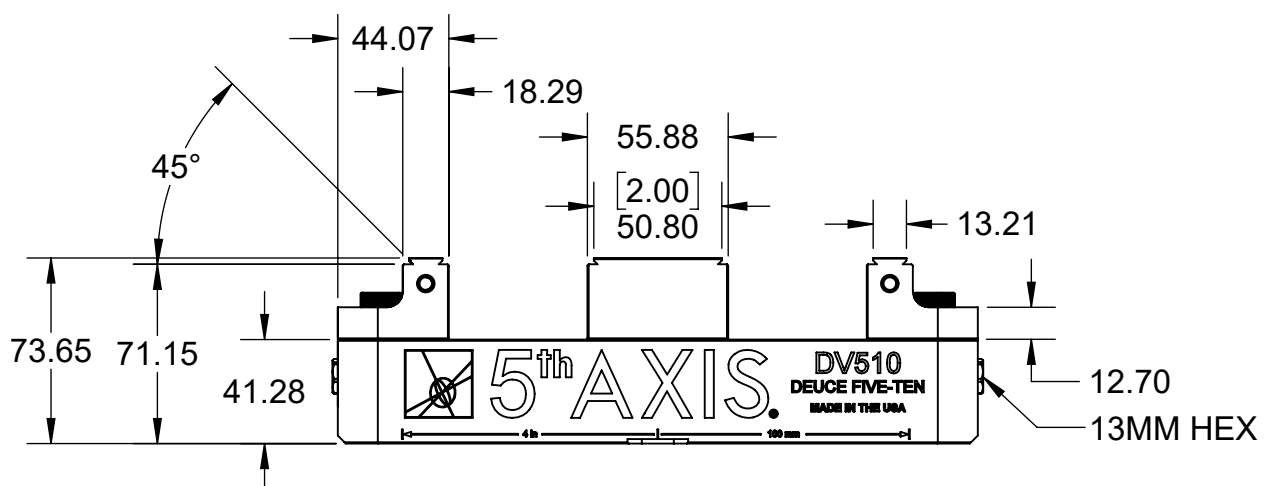
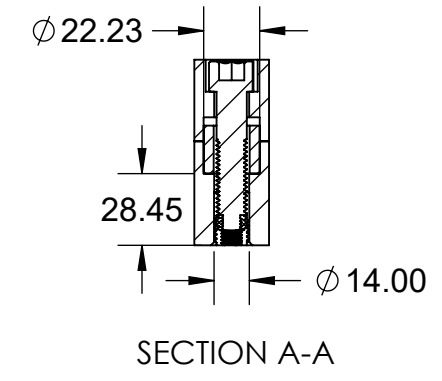
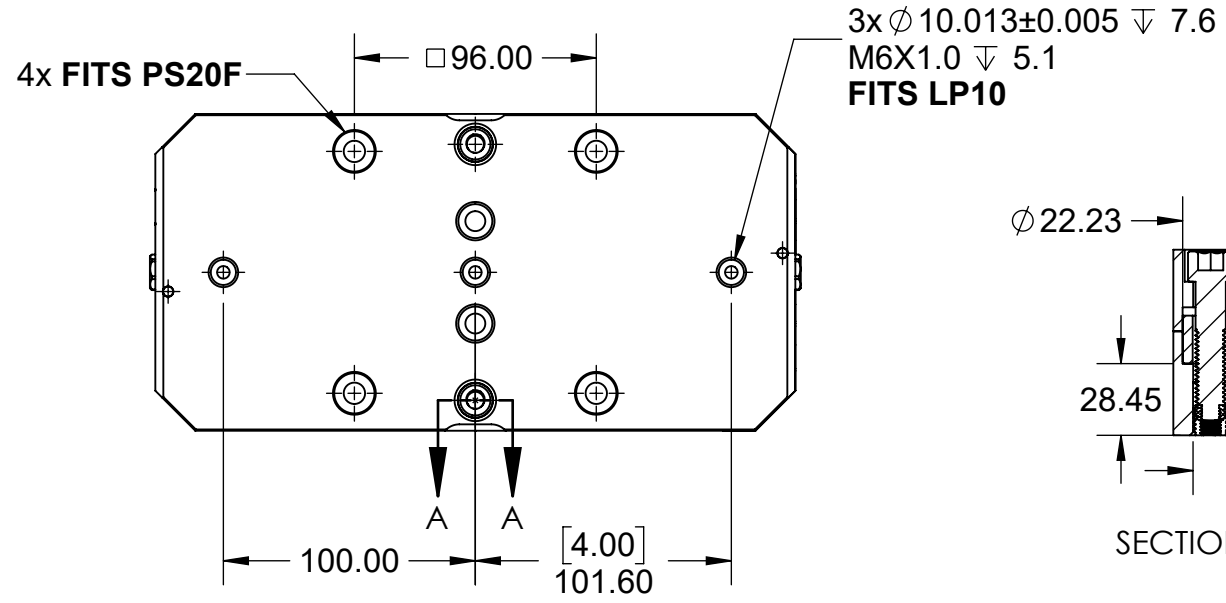
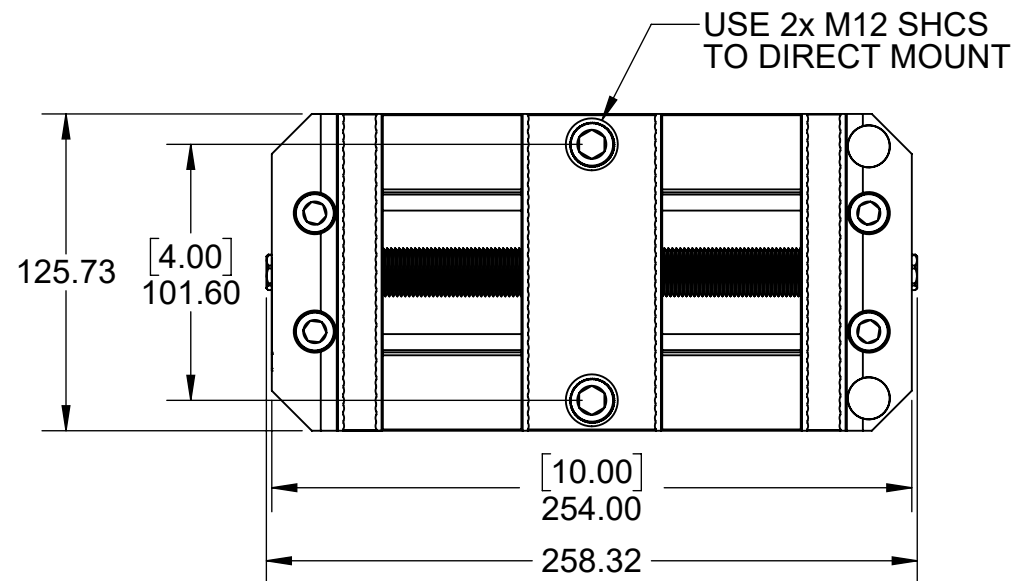
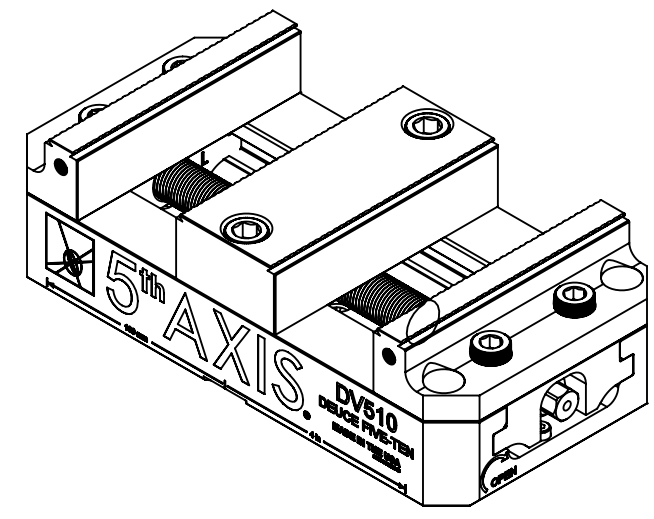


TECHNICAL DATA	DV510-J1
JAW WIDTH	125.73mm
BASE LENGTH	254.00mm
MAXIMUM TORQUE (JAW BOLT)	47.45 Nm
CLAMPING FORCE	19.57kN @ 74.57 Nm
MAXIMUM TORQUE (LEADSCREW)	74.57 Nm
MAXIMUM TORQUE (MOUNTING BOLT)	47.45 Nm
SELF-CENTERING ACCURACY	± 12.7µm

# DV510-J1



<b>MILLIMETER</b> <small>DRAWN IN ACCORDANCE WITH ASME Y14.5-2009</small>  WWW.5THAXIS.COM  7140 ENGINEER ROAD SAN DIEGO, CA 92111  P (858) 505-0432 F (858) 505-9344	<b>TOLERANCES</b> <small>UNLESS OTHERWISE SPECIFIED</small> x ± 0.1 .xx ± 0.01 .x ± 0.05 .xxx ± 0.005 ANGULAR ± 0.5° THIRD ANGLE PROJECTION			
		<b>DESCRIPTION</b> LARGE DOUBLE STATION VISE WITH 2" CENTER		
		<b>SIZE</b> <b>B</b>	<b>PART NO.</b> DV510-J1	<b>REV</b> <b>A</b>
DO NOT SCALE DRAWING		SCALE 1:3	WEIGHT:	SHEET 1 OF 7

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# DV510-J1

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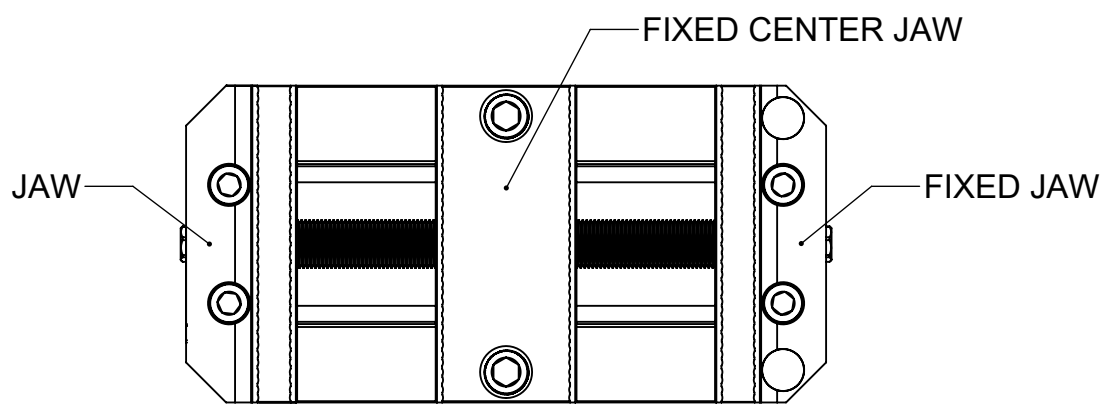
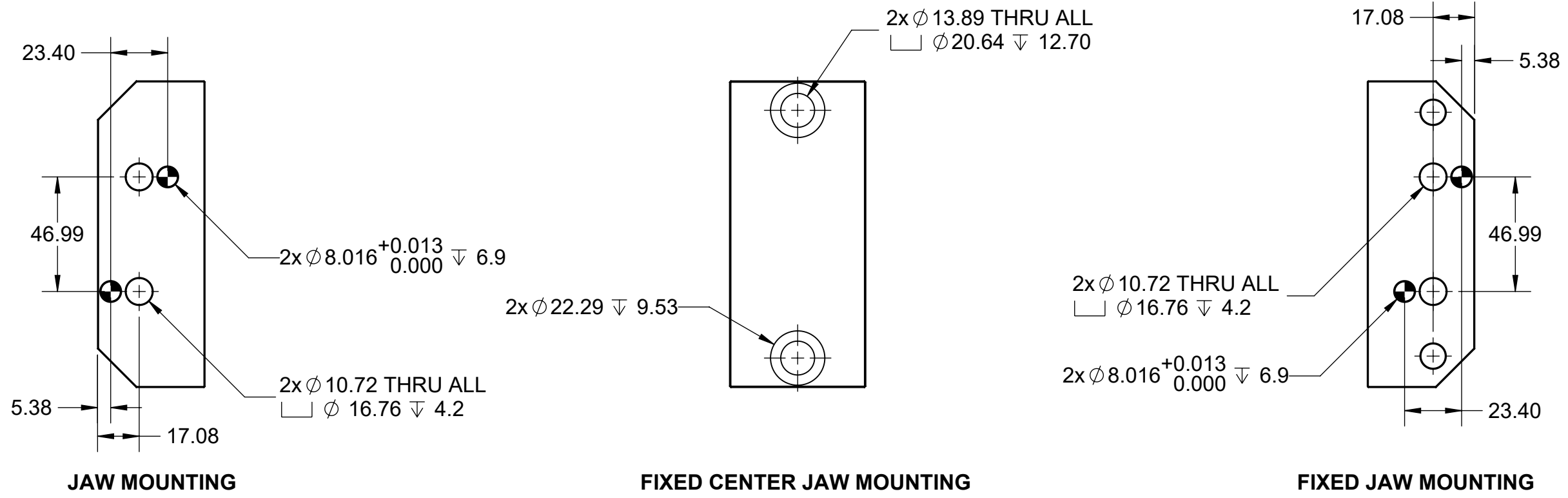
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<b>MILLIMETER</b>		<b>TOLERANCES</b> UNLESS OTHERWISE SPECIFIED			
DRAWN IN ACCORDANCE WITH ASME Y14.5-2009		x ± 0.1    .xx ± 0.01 .x ± 0.05    .xxx ± 0.005 ANGULAR ± 0.5° THIRD ANGLE PROJECTION			
WWW.5THAXIS.COM		DESCRIPTION <b>LARGE DOUBLE STATION VISE WITH 2" CENTER</b>			
7140 ENGINEER ROAD SAN DIEGO, CA 92111		SIZE <b>B</b>	PART NO. <b>DV510-J1</b>		REV <b>A</b>
P (858) 505-0432 F (858) 505-9344		DO NOT SCALE DRAWING		SCALE 1:2	WEIGHT:
				SHEET 2 OF 7	

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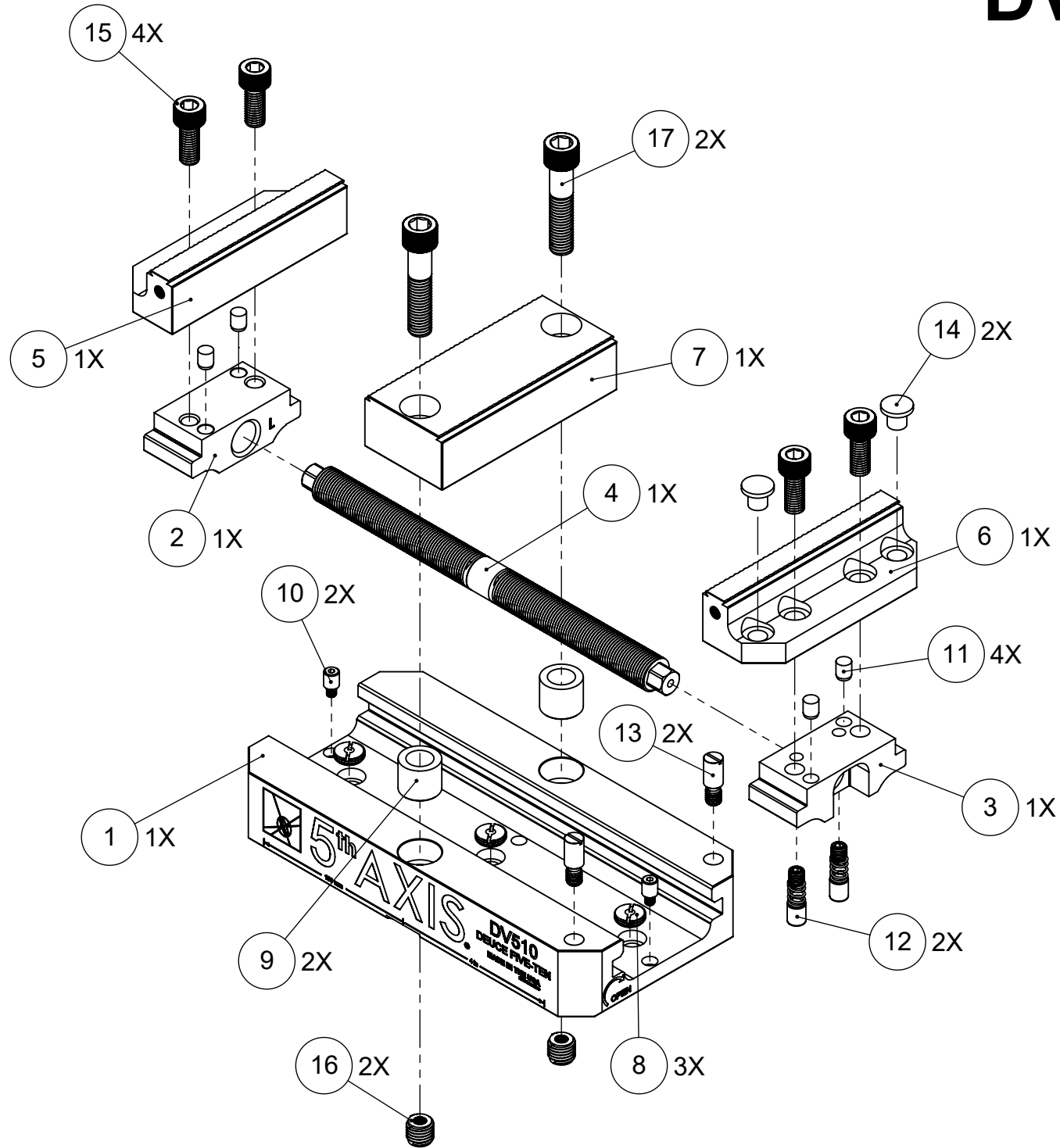
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# DV510-J1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	V5104-1	BASE	1
2	V562M-2L	LEFT TRUCK	1
3	V562M-2RDV	RIGHT TRUCK	1
4	V56124-4	LEAD SCREW	1
5	V562M-5	JAW	1
6	V562M-5F	FIXED JAW	1
7	V5104-5CDV	FIXED CENTER JAW	1
8	M6X1.0	THREADED INSERT	3
9	.0875X.75	BUSHING DRILL	2
10	LP8	LOCATING PIN	2
11	M8X12.DP	DOWEL PIN, M8 X 12mm	4
12	DV5	FRICTION PIN	2
13	HW.BASE.PLUG	BASE PLUG	2
14	HW.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

WWW.5THAXIS.COM

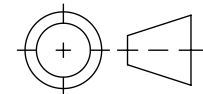
7140 ENGINEER ROAD  
SAN DIEGO, CA 92111

P (858) 505-0432  
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 2" CENTER**

SIZE **B** PART NO. **DV510-J1** REV **A**

DO NOT SCALE DRAWING

SCALE 1:3

WEIGHT:

SHEET 3 OF 7

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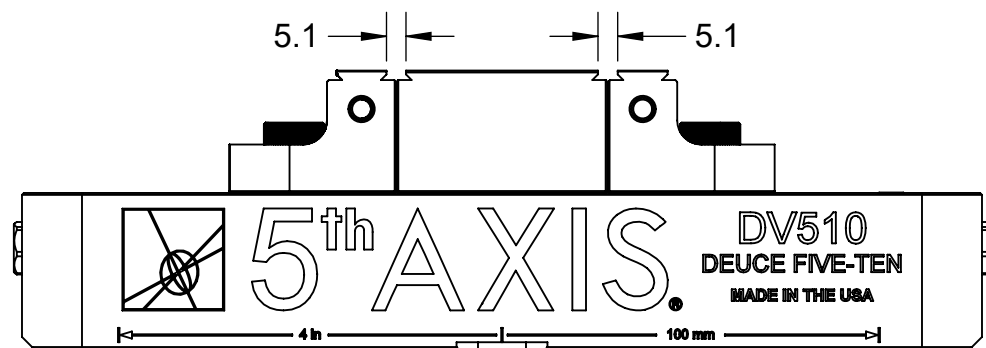
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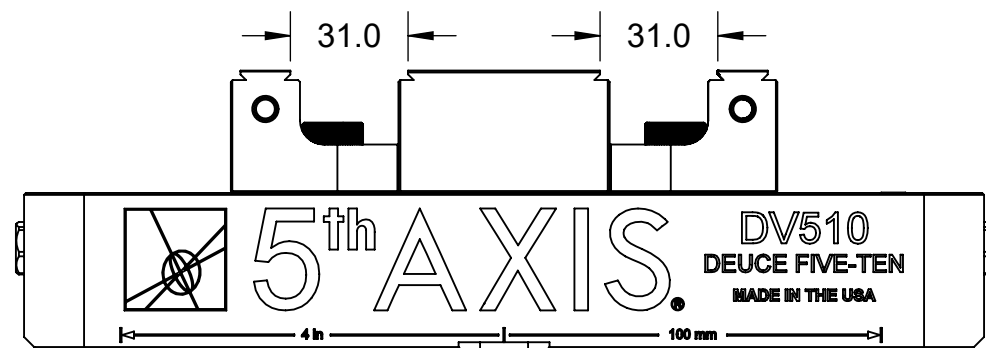
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**NOTE:** USING DOVETAIL ALLOWS VISE TO CLAMP LARGER PART.  
BELOW CLAMPING RANGE ONLY SHOWS THE CAPABILITY OF THE GRIPPER TEETH.

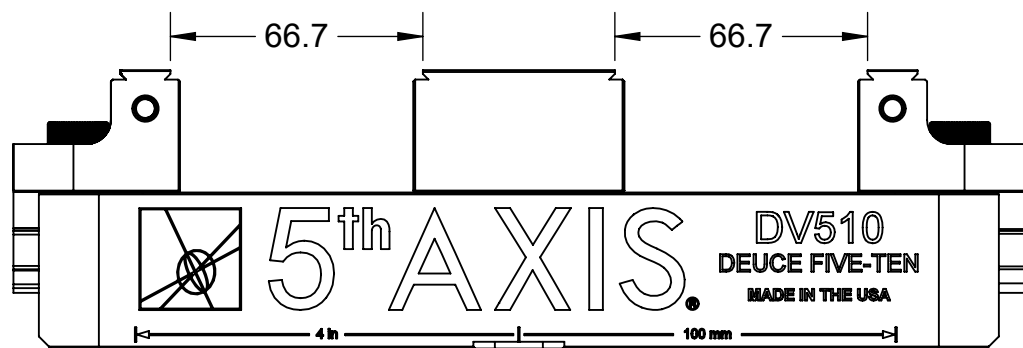
# DV510-J1



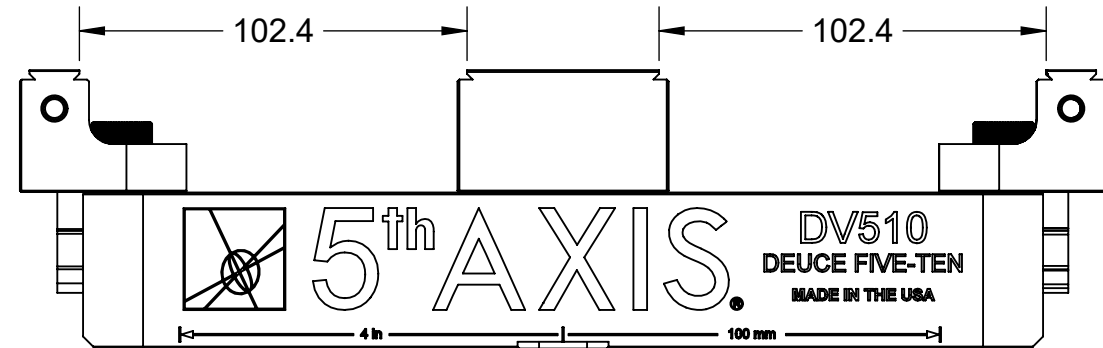
FORWARD JAWS (MINIMUM CLAMPING RANGE)




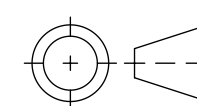
REVERSE JAWS (MINIMUM CLAMPING RANGE)



FORWARD JAWS (MAXIMUM CLAMPING RANGE)



REVERSE JAWS (MAXIMUM CLAMPING RANGE)

<b>MILLIMETER</b> <small>DRAWN IN ACCORDANCE WITH ASME Y14.5-2009</small>	<b>TOLERANCES</b> <small>UNLESS OTHERWISE SPECIFIED</small> x ± 0.1    .xx ± 0.01 .x ± 0.05    .xxx ± 0.005 ANGULAR ± 0.5° <small>THIRD ANGLE PROJECTION</small>			
		<b>DESCRIPTION</b> <b>LARGE DOUBLE STATION VISE WITH 2" CENTER</b>		
WWW.5THAXIS.COM  7140 ENGINEER ROAD SAN DIEGO, CA 92111  P (858) 505-0432 F (858) 505-9344		<b>SIZE</b> <b>B</b>	<b>PART NO.</b> <b>DV510-J1</b>	<b>REV</b> <b>A</b>
		DO NOT SCALE DRAWING	SCALE 1:2	WEIGHT:

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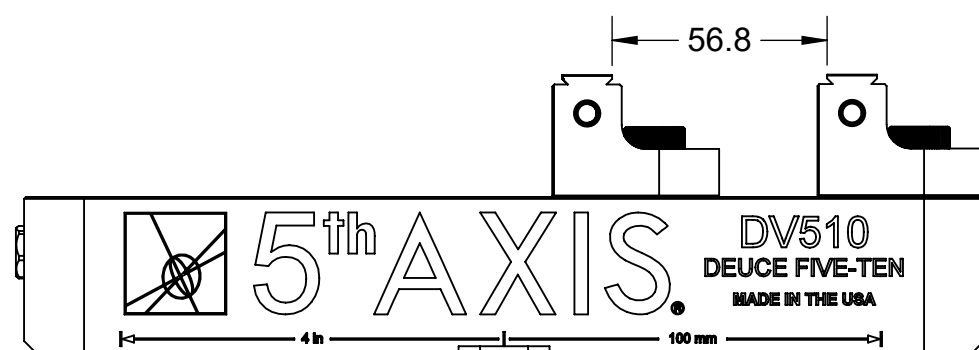
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**NOTE:** USING DOVETAIL ALLOWS VISE TO CLAMP LARGER PART.  
BELOW CLAMPING RANGE ONLY SHOWS THE CAPABILITY OF THE GRIPPER TEETH.

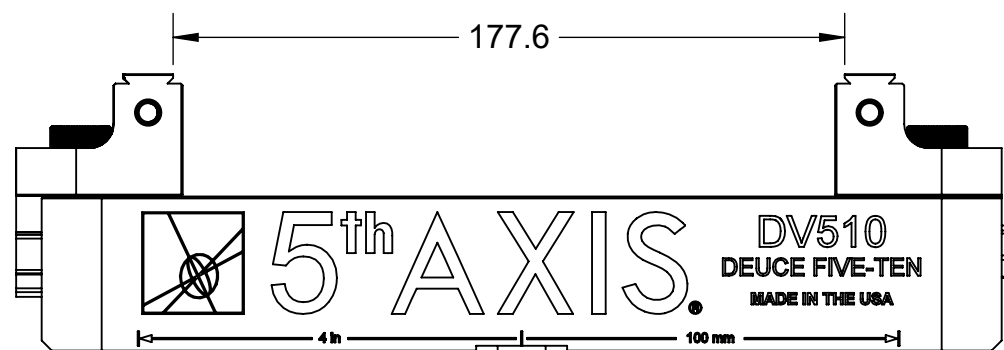
# DV510-J1



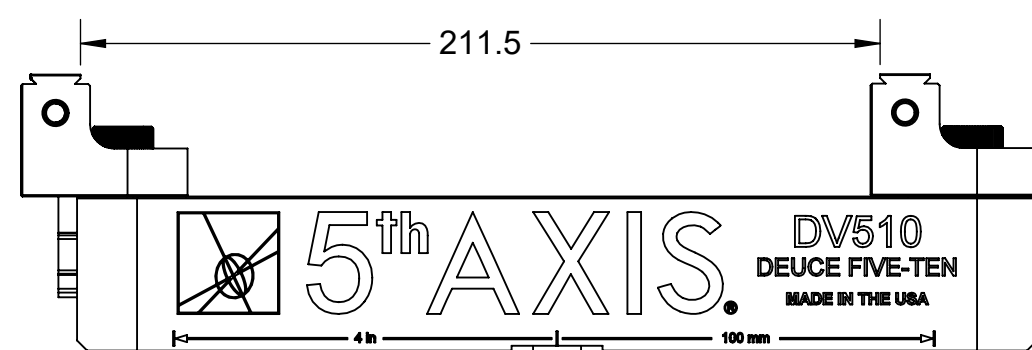
FORWARD JAWS (MINIMUM CLAMPING RANGE)  
FIXED JAW CONFIGURATION




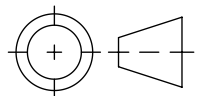
REVERSE JAWS (MINIMUM CLAMPING RANGE)  
FIXED JAW CONFIGURATION



FORWARD JAWS (MAXIMUM CLAMPING RANGE)  
FIXED JAW CONFIGURATION



REVERSE JAWS (MAXIMUM CLAMPING RANGE)  
FIXED JAW CONFIGURATION

<b>MILLIMETER</b> <small>DRAWN IN ACCORDANCE WITH ASME Y14.5-2009</small>	<b>TOLERANCES</b> <small>UNLESS OTHERWISE SPECIFIED</small> x ± 0.1    .xx ± 0.01 .x ± 0.05    .xxx ± 0.005 ANGULAR ± 0.5° <small>THIRD ANGLE PROJECTION</small>			
		<b>DESCRIPTION</b> <b>LARGE DOUBLE STATION VISE WITH 2" CENTER</b>		
WWW.5THAXIS.COM  7140 ENGINEER ROAD SAN DIEGO, CA 92111  P (858) 505-0432 F (858) 505-9344		<b>SIZE</b> <b>B</b>	<b>PART NO.</b> <b>DV510-J1</b>	<b>REV</b> <b>A</b>
		DO NOT SCALE DRAWING	SCALE 1:2	WEIGHT:

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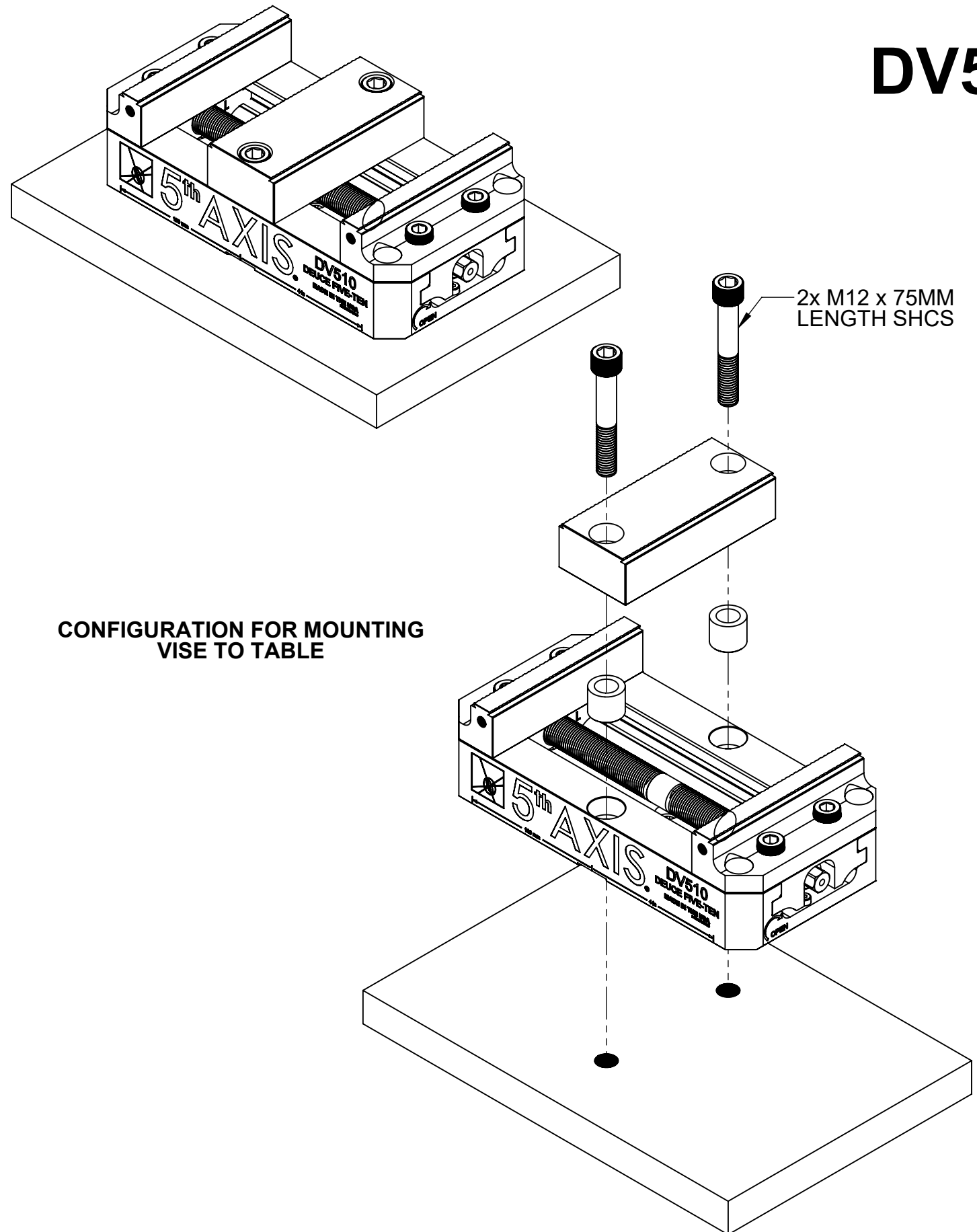
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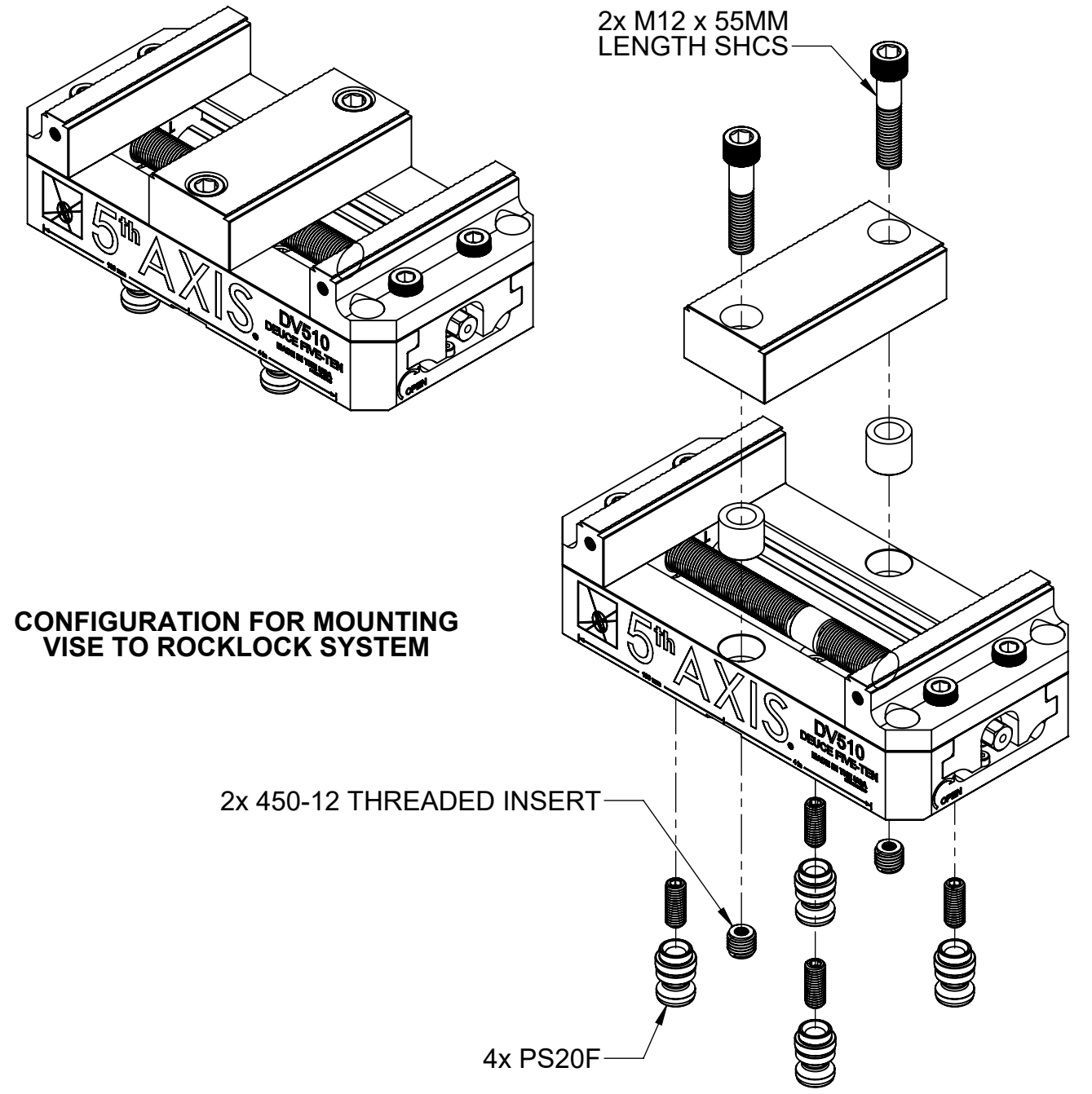
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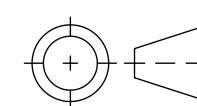
# DV510-J1

CONFIGURATION FOR MOUNTING VISE TO TABLE



CONFIGURATION FOR MOUNTING VISE TO ROCKLOCK SYSTEM



<b>MILLIMETER</b>		<b>TOLERANCES</b> UNLESS OTHERWISE SPECIFIED			
DRAWN IN ACCORDANCE WITH ASME Y14.5-2009		x ± 0.1    .xx ± 0.01 .x ± 0.05    .xxx ± 0.005 ANGULAR ± 0.5° THIRD ANGLE PROJECTION			
WWW.5THAXIS.COM				DESCRIPTION <b>LARGE DOUBLE STATION VISE WITH 2" CENTER</b>	
7140 ENGINEER ROAD SAN DIEGO, CA 92111				SIZE <b>B</b>	PART NO. <b>DV510-J1</b>
P (858) 505-0432 F (858) 505-9344		DO NOT SCALE DRAWING		SCALE 1:3	WEIGHT:
				SHEET 6 OF 7	



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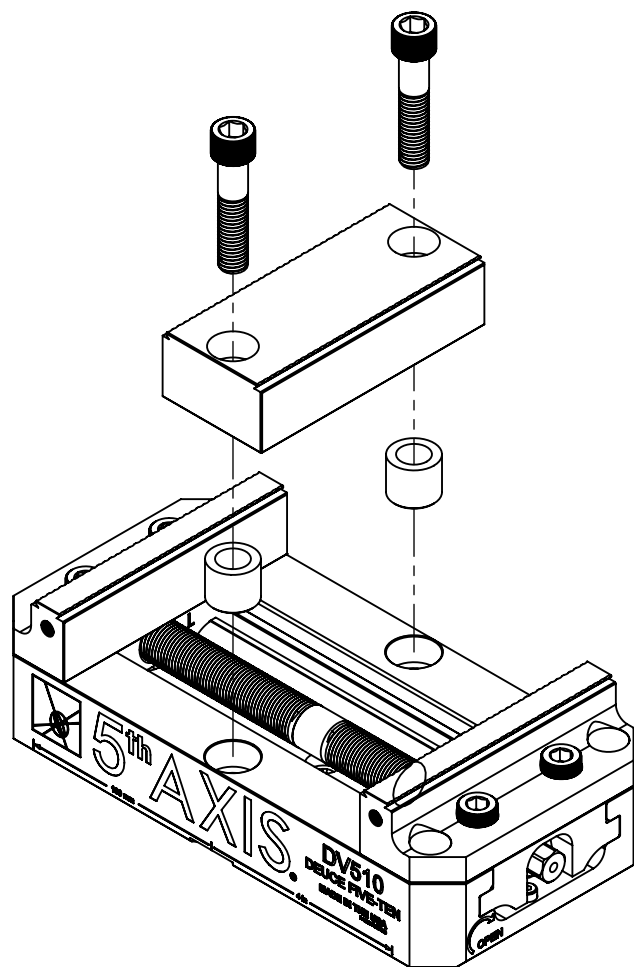
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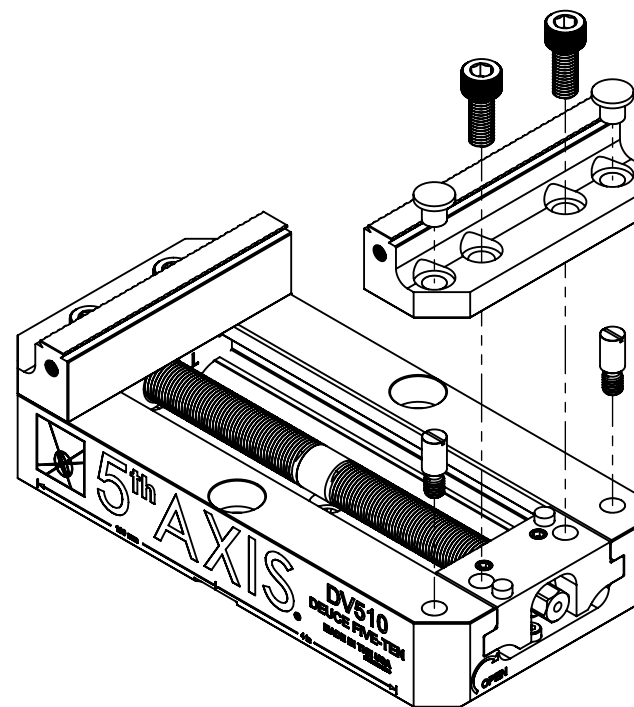
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# DV510-J1

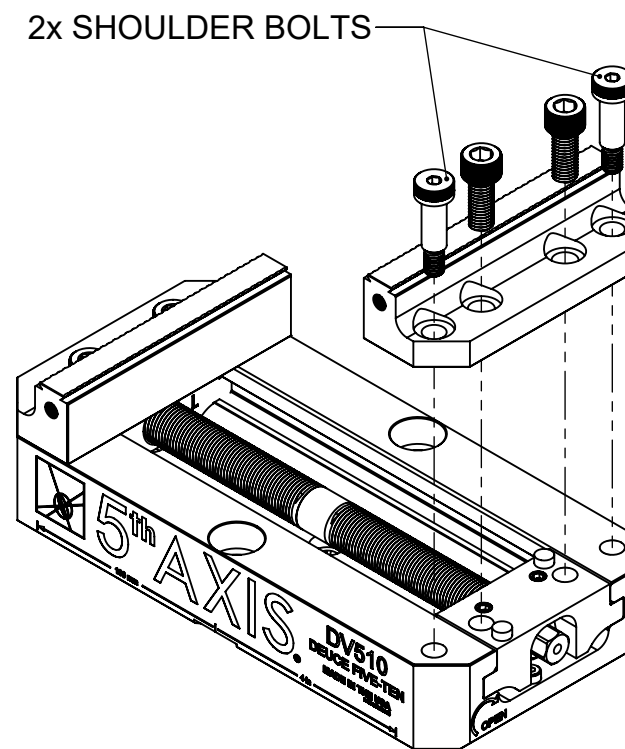
## CONVERTING DOUBLE STATION VISE TO FIXED JAW, SINGLE STATION VISE CONFIGURATION



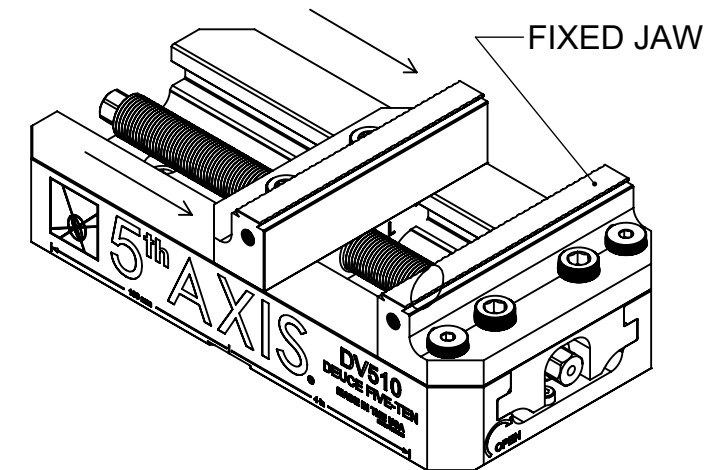
**STEP 1:**  
REMOVE CENTER JAW COMPONENTS




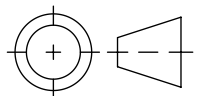
**STEP 2:**  
REMOVE RIGHT JAW, JAW PLUGS  
AND BASE PLUGS



**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>		<b>TOLERANCES</b> UNLESS OTHERWISE SPECIFIED			
DRAWN IN ACCORDANCE WITH ASME Y14.5-2009		x ± 0.1    .xx ± 0.01 .x ± 0.05    .xxx ± 0.005 ANGULAR ± 0.5° THIRD ANGLE PROJECTION			
WWW.5THAXIS.COM		THIRD ANGLE PROJECTION		DESCRIPTION <b>LARGE DOUBLE STATION VISE WITH 2" CENTER</b>	
7140 ENGINEER ROAD SAN DIEGO, CA 92111				SIZE <b>B</b>	PART NO. <b>DV510-J1</b>
P (858) 505-0432 F (858) 505-9344				DO NOT SCALE DRAWING	SCALE 1:3
				WEIGHT:	REV <b>A</b>
				SHEET 7 OF 7	

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