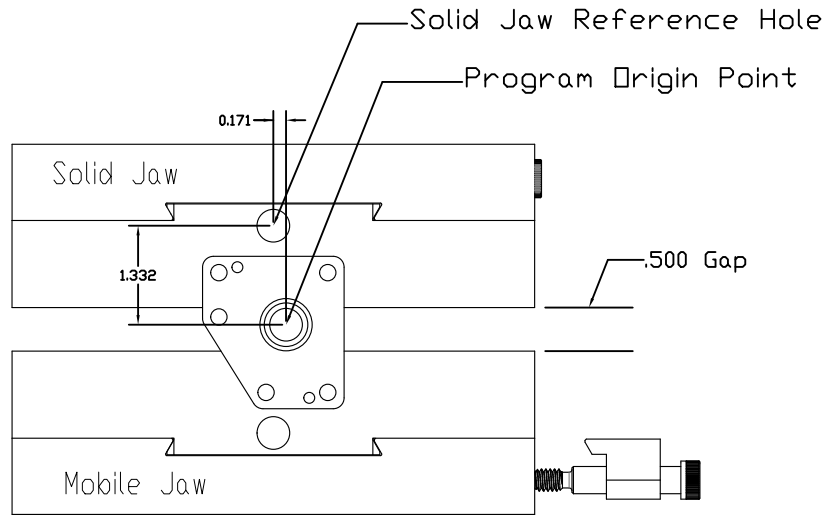
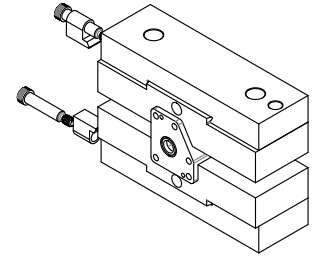


## Using the Drop-N-Go Vise Jaw

1. Lay out the part in the center of the jaw space.
2. Determine a correct gap between the jaw faces (shown here as .5")
3. Choose an Origin for the program from a prominent feature.
4. Dimension the offset values in "X" and "Y" from the Jaw reference Hole.  
(In this case  $X=.171"$  and  $Y=-1.332"$ )  
-  
(take the dimensions from the Solid Jaw side)
5. Create a CNC program for cutting the pocket for the part.
6. Set your "Z" offset from the bottom of the pocket and begin machining.
7. Save the Jaws for the next time you need to run this same part.



Drop-N-Go Jaw Assembly w-Pocket for Part DP 2

<small>PROPRIETARY AND CONFIDENTIAL</small> <small>THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MICHAEL A. NEAR. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF MICHAEL A. NEAR IS PROHIBITED.</small>		UNLESS OTHERWISE SPECIFIED		DATE	TITLE:
		<small>DIMENSIONS ARE IN INCHES</small> <small>FRACTIONS 1/16</small> <small>ANGULAR TOLERANCES ±</small> <small>THREE PLACE DECIMAL ±</small>	<small>DRAWN</small> <small>CHECKED</small> <small>ENG APPR.</small> <small>MFG APPR.</small>	<small>DATE</small> <small>DATE</small> <small>DATE</small> <small>DATE</small>	
<small>INTERPRET GEOMETRIC TOLERANCING FOR:</small> <small>FEATURES</small>		<small>COMMENTS:</small>			
<small>NEXT ASSY</small> <small>USED ON</small>	<small>FINISH</small>	<small>DO NOT SCALE DRAWING</small>			