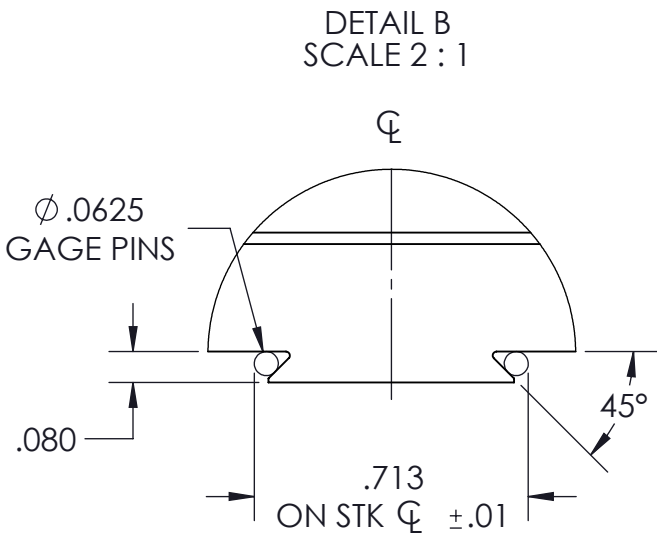
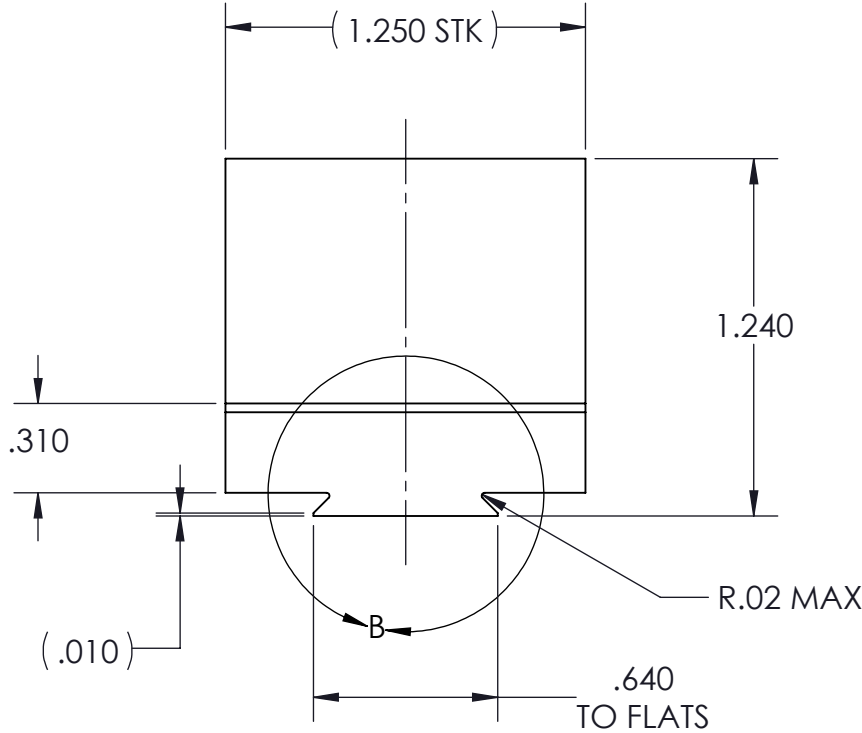
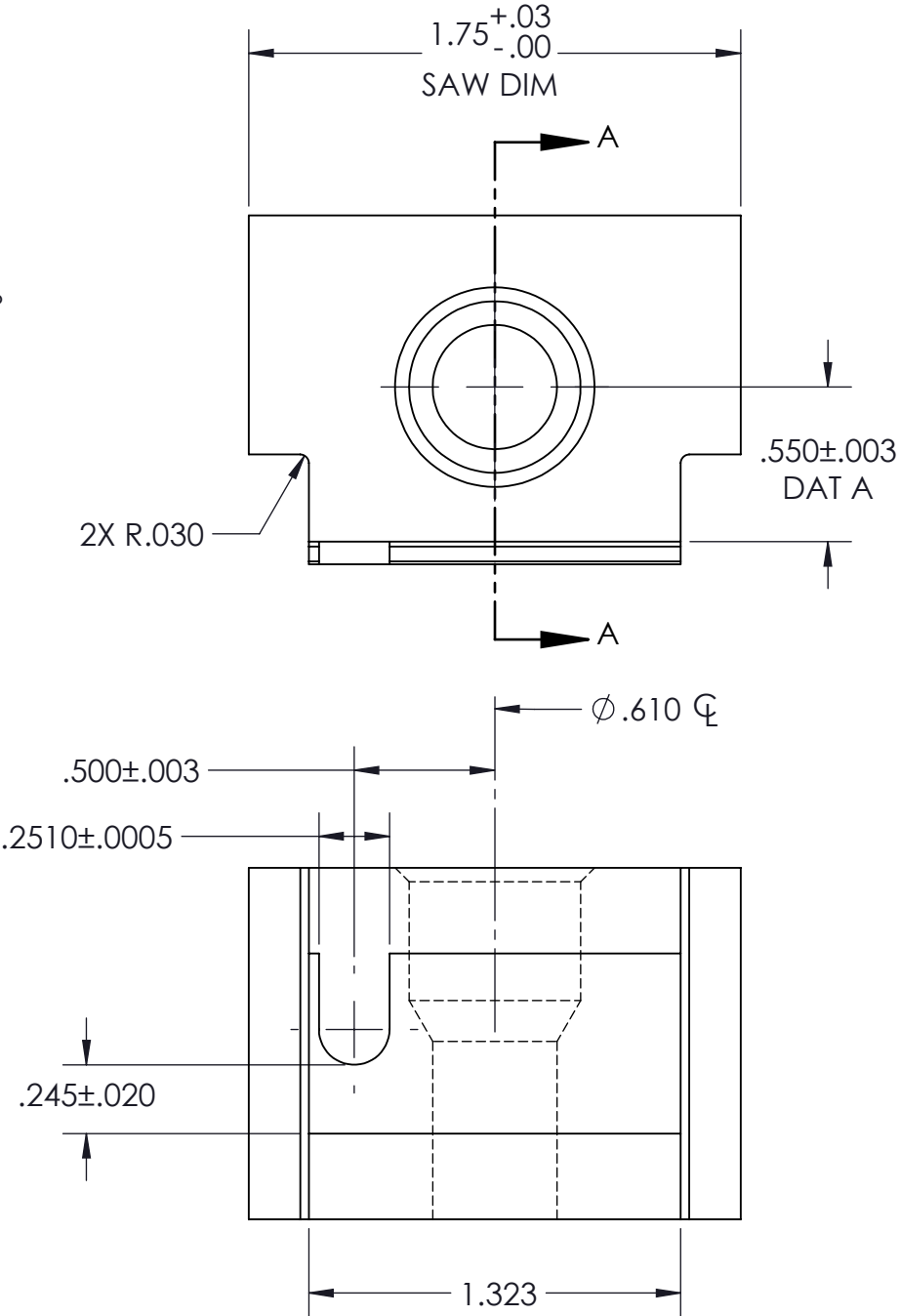
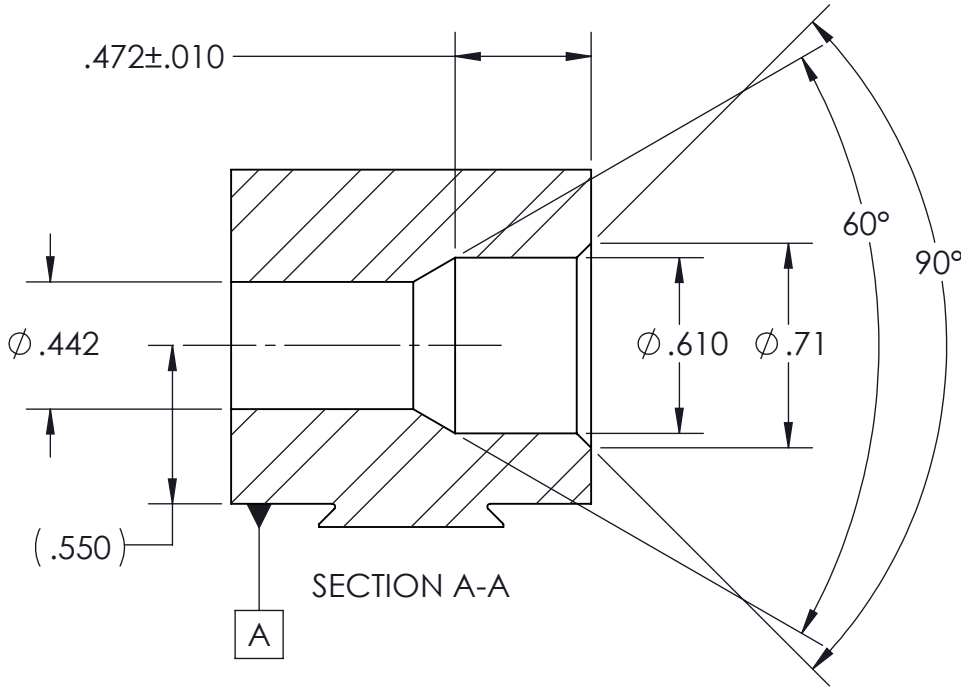


NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: 4140 STEEL CD HEAT TREAT TO 38-44 HRC
2. FINISH: N/A
3. DEBURR ALL SHARP EDGES
4. DIMENSIONS APPLY AFTER HEAT TREAT

REVISION	DESCRIPTION	APPROVAL
B	ADDED .03" CORNER RADIUS	A. LANE
C	COUNTERBORE DEPTH CHANGE	A. LANE

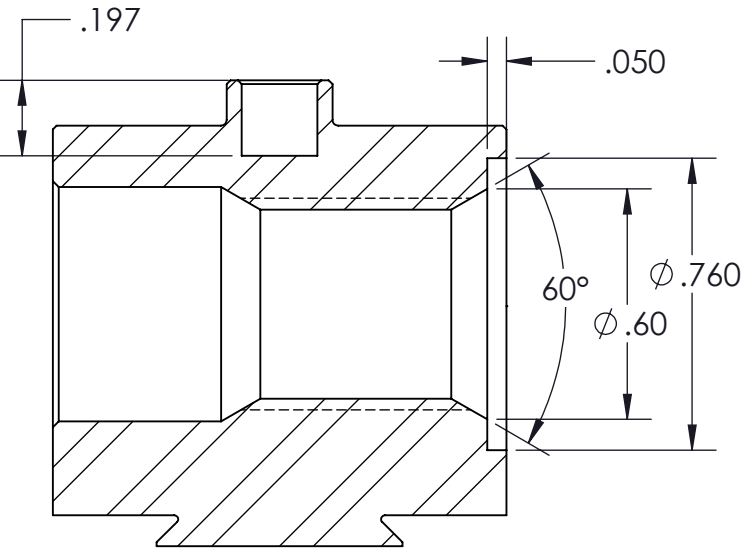
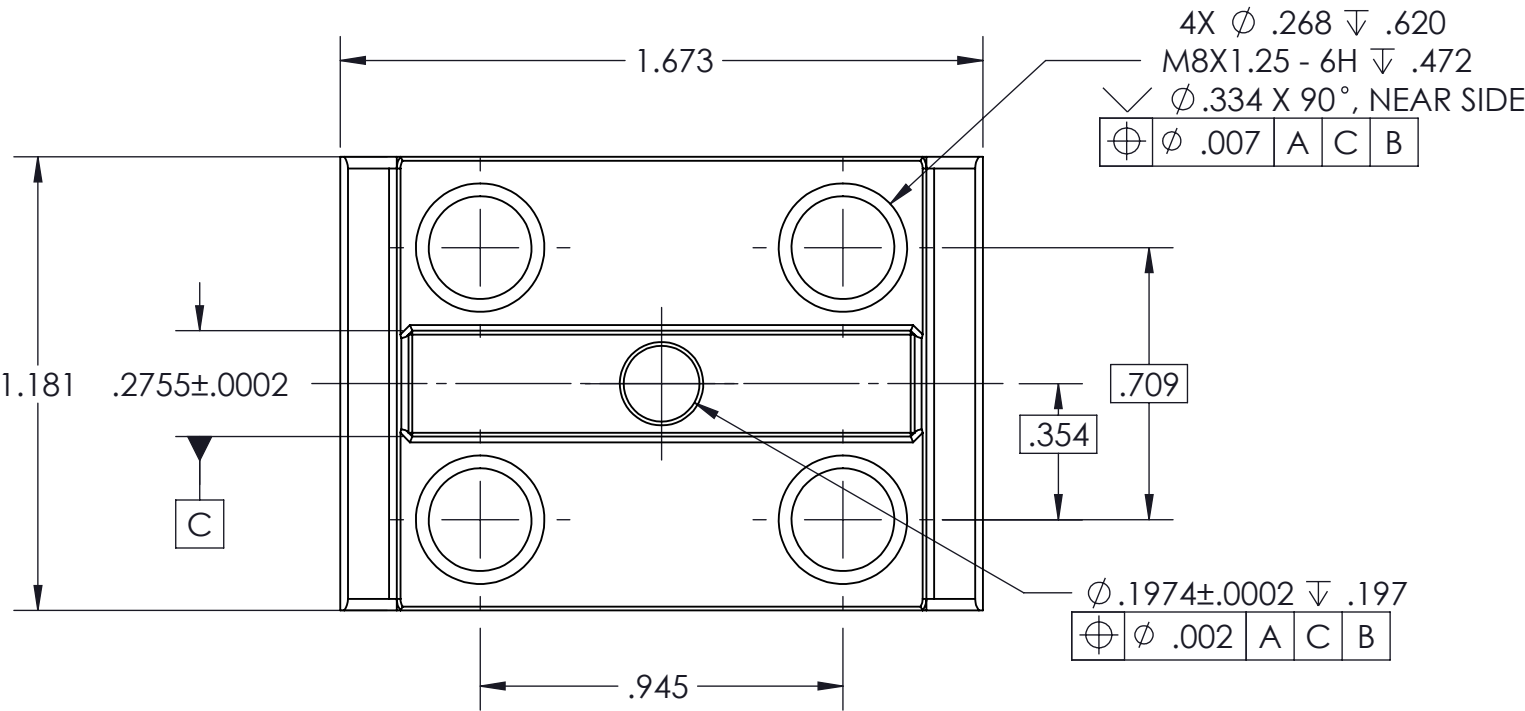


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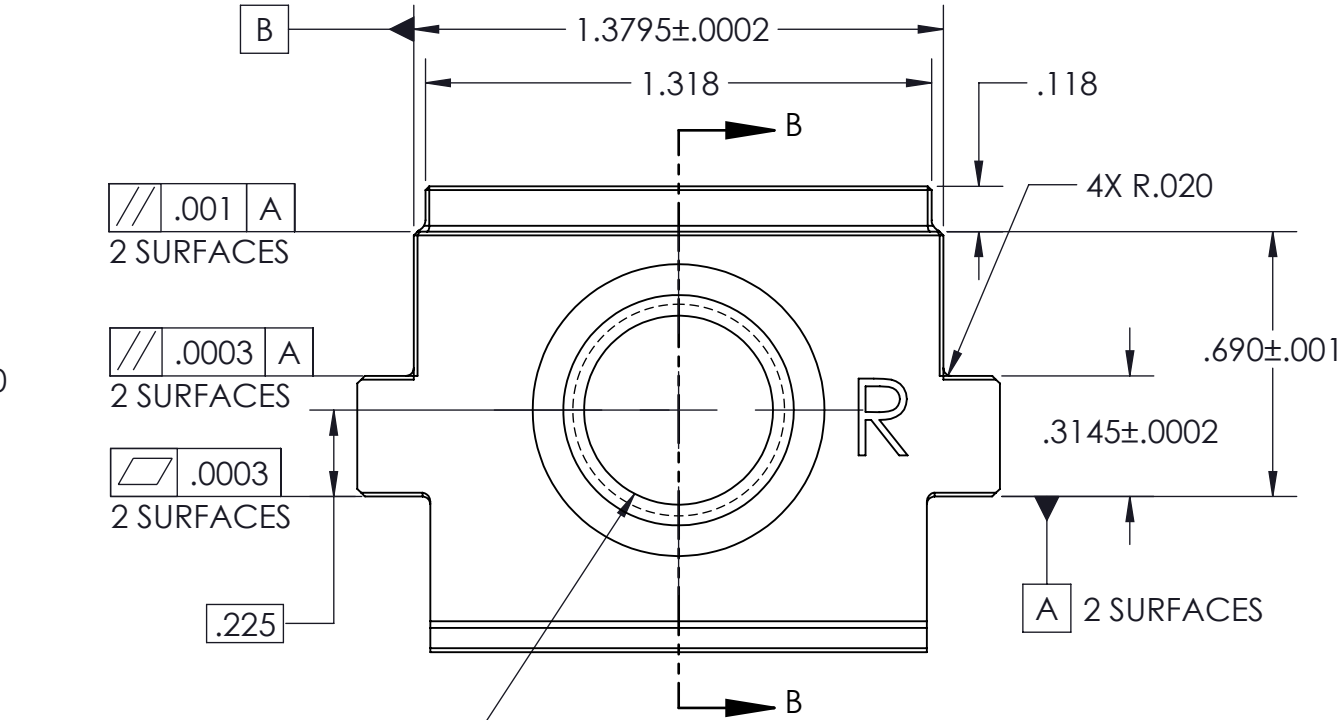
INCH		TOLERANCES		APPROVALS		5 th AXIS		WWW.FIFTHAXIS.COM	
DRAWN IN ACCORDANCE WITH ASME Y14.5-2009		UNLESS OTHERWISE SPECIFIED		DRAWN BY		A. LANE		7140 ENGINEER ROAD	
PROPRIETARY AND CONFIDENTIAL		X ± 0.1 .XX ± 0.01 .X ± 0.05 .XXX ± 0.005 ANGULAR ± 0.5°		MANUFACTURING		BRAD B.		SAN DIEGO, CA 92111	
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF FIFTH AXIS, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF FIFTH AXIS, INC. IS PROHIBITED.		THIRD ANGLE PROJECTION		QUALITY		BRENT B.		P (858) 505-0432 F (858) 505-9344	
				FINAL		CHRIS T.		DESCRIPTION	
								75MM VISE, TRUCK BLANK, X	
								SIZE PART NO.	
								V75100X-2	
								DO NOT SCALE DRAWING	
								SCALE 1.5:1	
								WEIGHT:	
								SHEET 3 OF 8	

NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: 4140 STEEL CD, HARDNESS: 38-42 HRC
2. FINISH: BLACK OXIDE
3. DEBURR ALL SHARP EDGES
4. OIL FINISH ALLOWED
5. ALL CHAMFER TOLERANCE $\pm .008$



SECTION B-B



M14X1.5 - 6H RH THRU ALL
RIGHT HAND THREAD

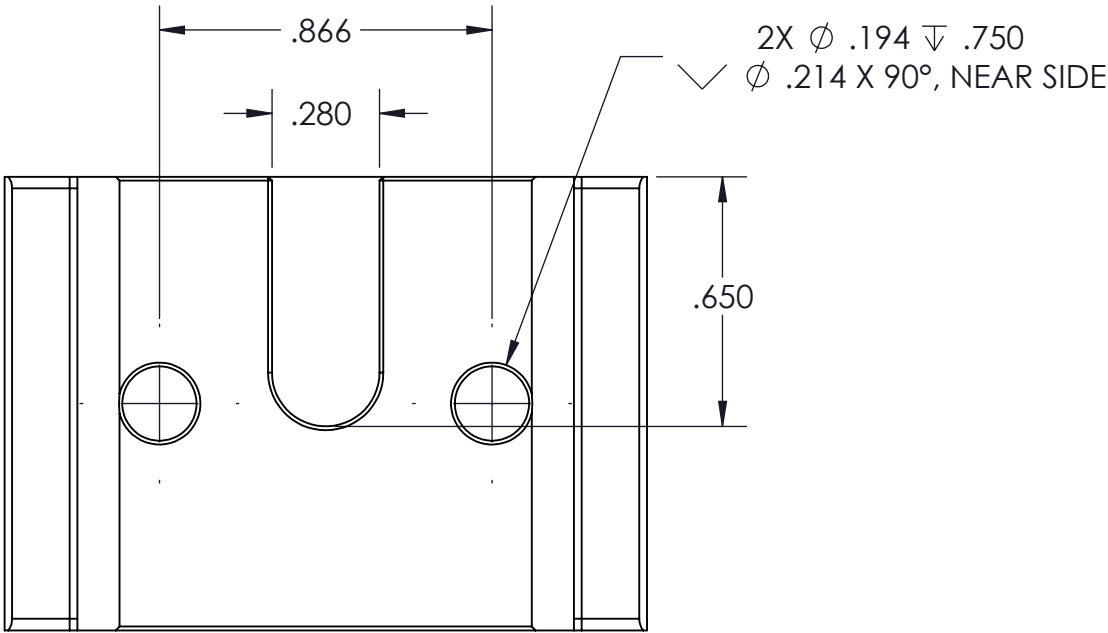
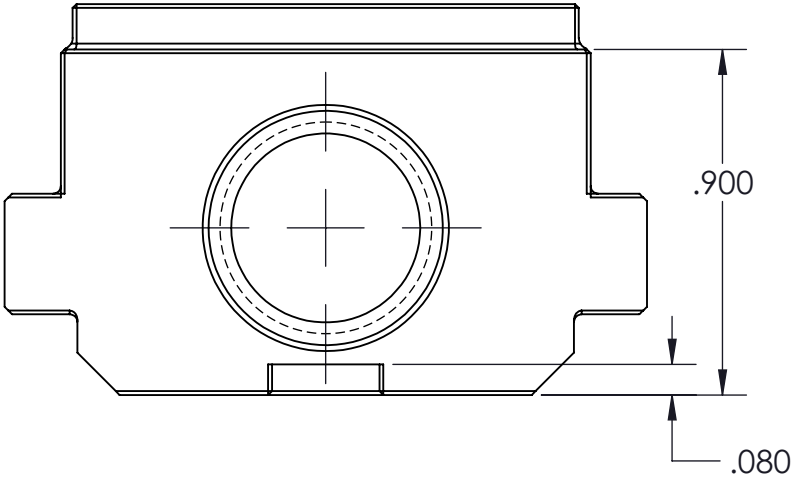
$\begin{matrix} \text{A} & \text{B} & \text{C} \end{matrix}$

MILL OP 3

INCH		TOLERANCES		APPROVALS		5 th AXIS		WWW.FIFTHAXIS.COM	
DRAWN IN ACCORDANCE WITH ASME Y14.5-2009		UNLESS OTHERWISE SPECIFIED		DRAWN BY Y. RHEE		08/26/21		7140 ENGINEER ROAD SAN DIEGO, CA 92111	
PROPRIETARY AND CONFIDENTIAL		X $\pm$ 0.1 .XX $\pm$ 0.01 .X $\pm$ 0.05 .XXX $\pm$ 0.005 ANGULAR $\pm$ 0.5°		MANUFACTURING				P (858) 505-0432 F (858) 505-9344	
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF FIFTH AXIS, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF FIFTH AXIS, INC. IS PROHIBITED.		THIRD ANGLE PROJECTION		QUALITY				DESCRIPTION	
				FINAL		A. LANE		75MM VISE, RIGHT TRUCK, X	
								SIZE PART NO.	
								B V75100X-2R	
								DO NOT SCALE DRAWING	
								SCALE 2:1	
								WEIGHT:	
								SHEET 4 OF 8	

NOTES: UNLESS OTHERWISE SPECIFIED

- 1. MATERIAL: 4140 STEEL CD, HARDNESS: 38-42 HRC
- 2. FINISH: BLACK OXIDE
- 3. DEBURR ALL SHARP EDGES
- 4. OIL FINISH ALLOWED

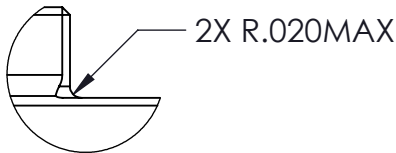


MILL OP 4

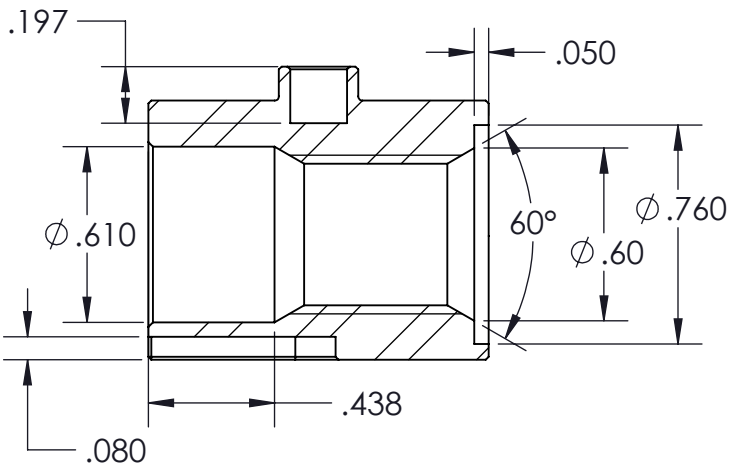
INCH DRAWN IN ACCORDANCE WITH ASME Y14.5-2009 PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF FIFTH AXIS, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF FIFTH AXIS, INC. IS PROHIBITED.	TOLERANCES UNLESS OTHERWISE SPECIFIED X ± 0.1 .XX ± 0.01 .X ± 0.05 .XXX ± 0.005 ANGULAR ± 0.5° THIRD ANGLE PROJECTION 	APPROVALS DRAWN BY Y. RHEE 08/26/21 MANUFACTURING QUALITY FINAL A. LANE		 5thAXIS WWW.FIFTHAXIS.COM 7140 ENGINEER ROAD SAN DIEGO, CA 92111 P (858) 505-0432 F (858) 505-9344		
					DESCRIPTION	
					75MM VISE, TRUCK, X	
					SIZE B PART NO. V75100X-2R AND V75100X-2L	
		DO NOT SCALE DRAWING		SCALE 2:1	WEIGHT:	SHEET 6 OF 8

NOTES: UNLESS OTHERWISE SPECIFIED

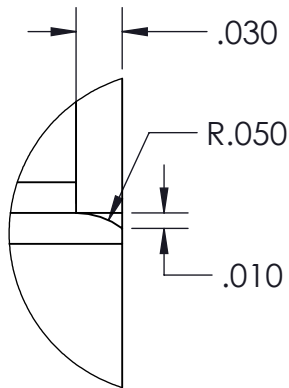
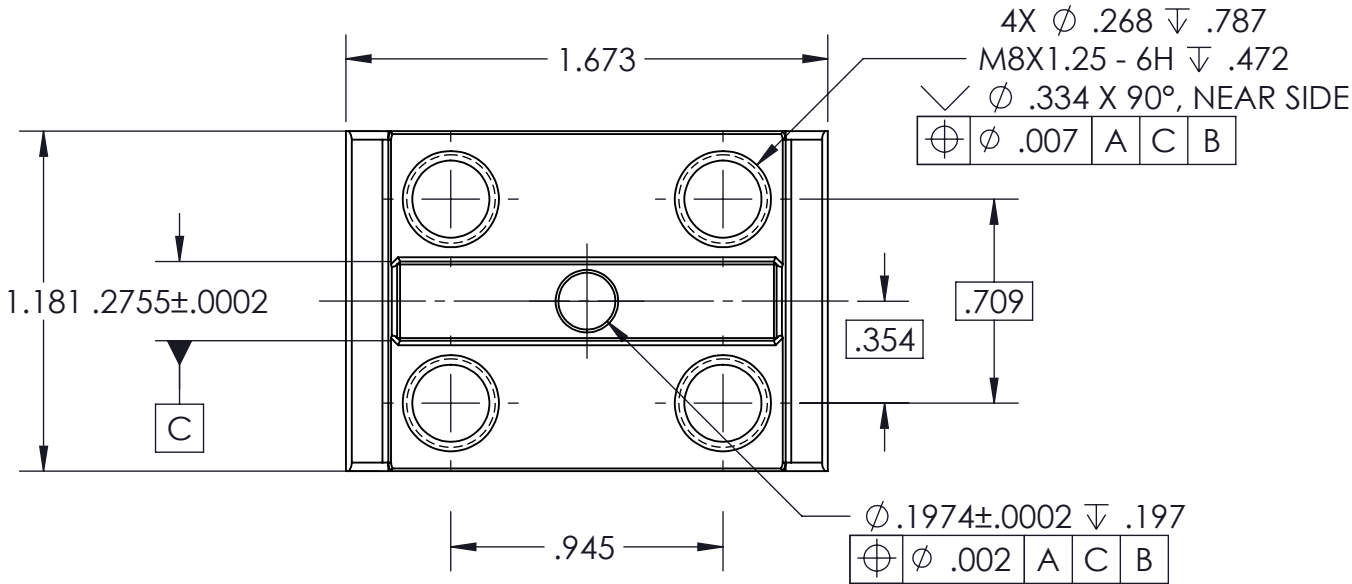
1. MATERIAL: 4140 STEEL CD, HARDNESS: 38-42 HRC
2. FINISH: BLACK OXIDE
3. DEBURR ALL SHARP EDGES
4. OIL FINISH REQUIRED



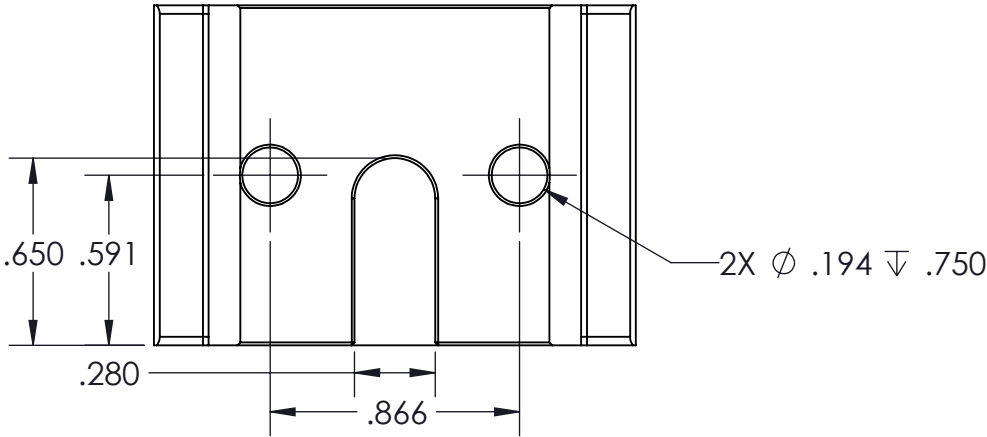
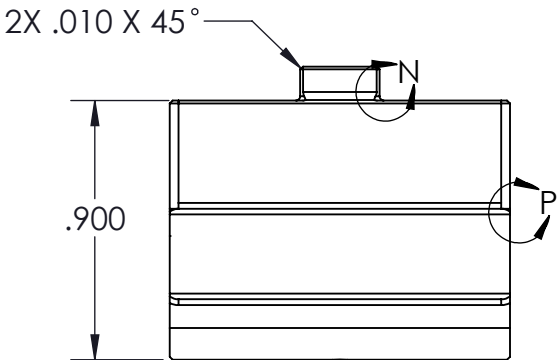
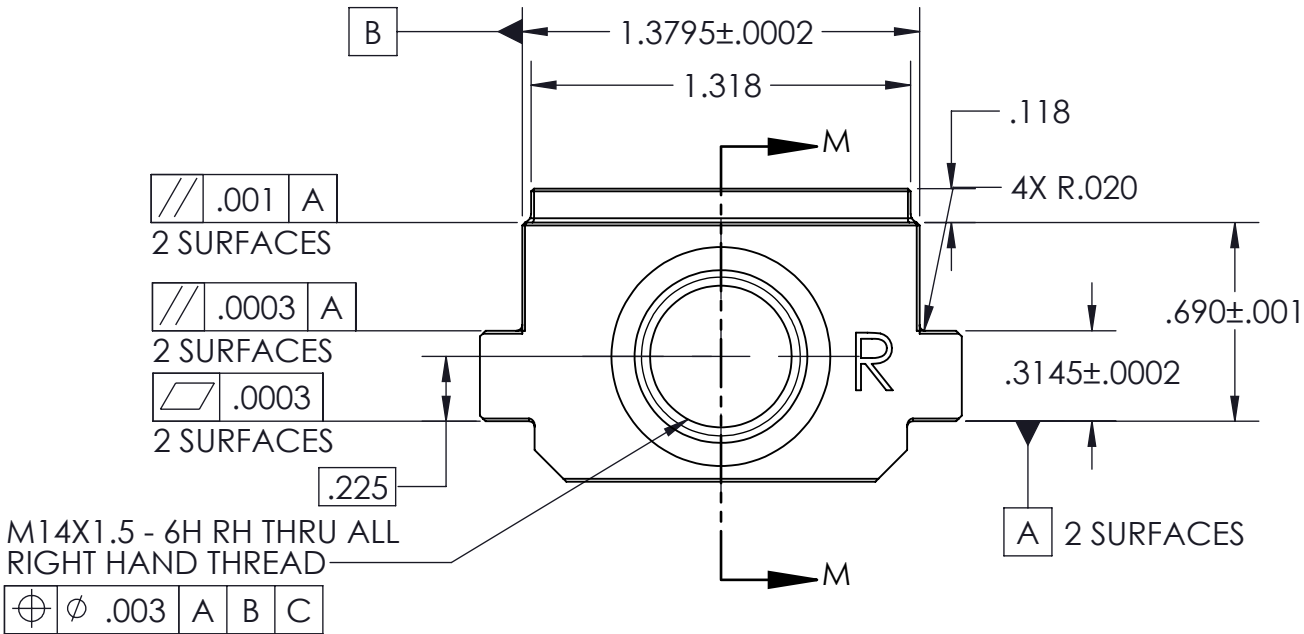
DETAIL N
SCALE 4 : 1



SECTION M-M



DETAIL P
SCALE 8 : 1
12X TYP



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
B8	C	SOCKET COUNTERBORE DEPTH CHANGE	8/31/22	A. LANE

INCH

DRAWN IN ACCORDANCE
WITH ASME Y14.5-2009

PROPRIETARY AND
CONFIDENTIAL

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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

APPROVALS

DRAWN BY Y. RHEE	08/26/21
MANUFACTURING	
QUALITY	
FINAL A. LANE	

WWW.FIFTHAXIS.COM
7140 ENGINEER ROAD
SAN DIEGO, CA 92111
P (858) 505-0432 F (858) 505-9344

DESCRIPTION 75MM VISE, RIGHT TRUCK, X	
SIZE B	PART NO. V75100X-2R
DO NOT SCALE DRAWING	SCALE 1:5:1
WEIGHT:	SHEET 7 OF 8

REV
C