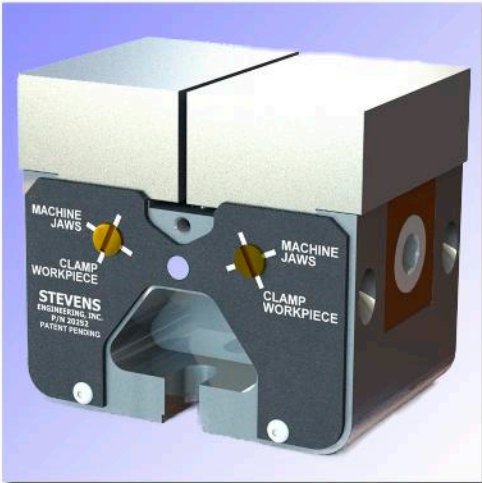


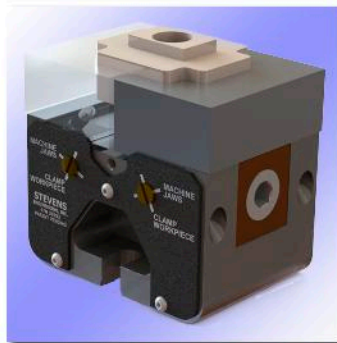
STEVENS INNOVATIONS

Precision Self-Centering Vise patent pending

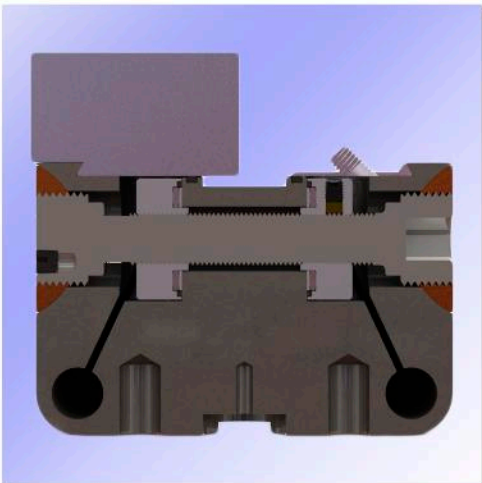
Powerful manual clamping with machinable jaws



WISE w/ JAWS P/N: 20252



The Stevens Precision Self-Centering Vise provides accurate centering action at any clamping force up to 5000 lbs. The vise is designed for long-term durability with several mounting options. Jaw-lock features for machining jaws makes setups fast and repeatable.



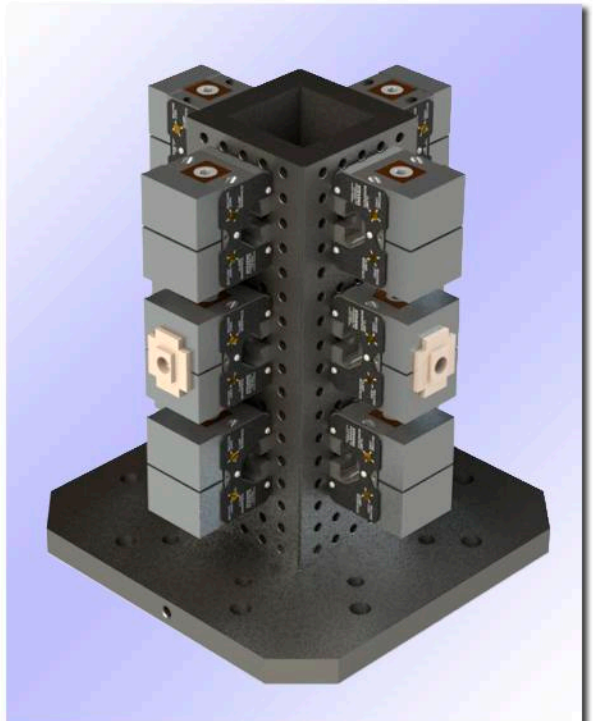
Standard & Custom Jaws:

Stevens Engineering offers design and build services for custom jaws and machining of jaw cavities to accommodate your workpiece for turnkey fixturing. U.S. manufacturing of all the components allows us to provide a complete solution. Workpiece models and drawings may be emailed to: sales@stevenseng.com.

**2 JAWS
P/N 10594**

How it works:

During clamping, the vise body (alloy steel 30Rc) is designed to flex in a controlled movement (like a collet) to accommodate the .125" combined jaw travel. The 6061 aluminum jaws locate solidly into dovetail nests. The alloy steel lead screw is pre-loaded with dual roller thrust bearings. hardened RH and LH threads engage self-aligning brass segments. The vise internals are well sealed from metal chips, but may be disassembled if cleaning or calibration is required after long exposure to harsh environments.



STEVENS ENGINEERING, INC.

3649 W. Clarendon Avenue, Phoenix, AZ 85019 800.635.0657 602.272.6766 Fax 602.272.0717 www.stevenseng.com

2070MC0612

How to machine workpiece cavity

- 1) Rotate (4) jaw-lock pins with flat-head screwdriver to "machine jaws" orientation
- 2) Tighten vise with 1/2" hex key wrench
- 3) Machine cavity to match workpiece
- 4) Rotate (4) jaw-lock pins to "clamp workpiece" orientation



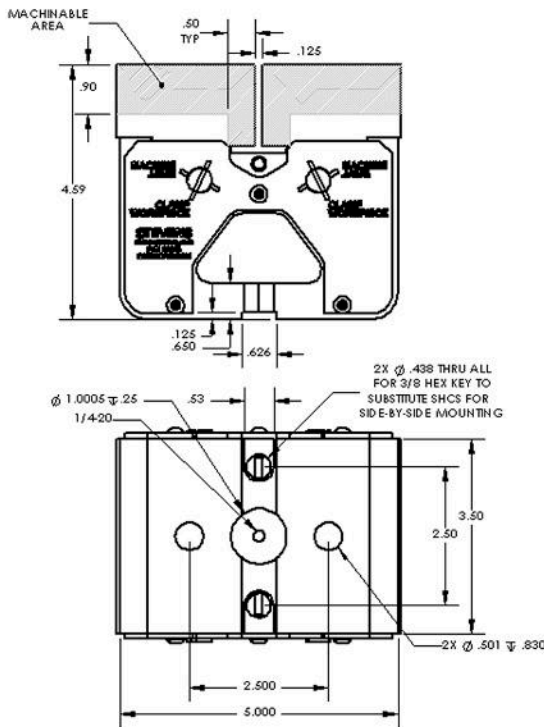
4-axis and 5-axis Applications



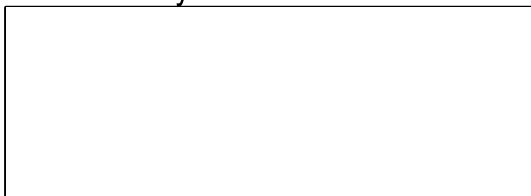
Stevens self-centering vises are ideal for many 5-axis applications. Maintaining workpiece centerline improves machining accuracy and simplifies programming.

Standard and custom risers are available to elevate vises for better tool access.

* 10607 riser for self-centering vise shown



Distributed by



Mounting Self-Centering Vise

T-Slot Mounting



T-Slot Mounting Kit include:

- (1) Alignment key
- (1) 1/4-20 SHCS
- (2) T-Nuts
- (2) 1/2-13 Hex Head Screws
- (2) Tooling Washers

P/N for Mounting Kit	T-Slot Size
20224-5625	.5625
20224-6250	.6250
20224-6875	.6875
20224-7087	.7087

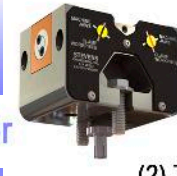
Subplate Mounting

Directly onto standard Stevens Grid Pattern

2-Pin Mounting Kit P/N 20225:



- (2) Tooling Washers
- (2) 10062 pull dowels
- (2) 1/2-13 Hex Head Screws



Center Mounting Kit P/N 20260

- (2) Tooling Washers
- (2) 1/2-13 Hex Head Screws
- (1) 20124-1.00 Center Locator

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