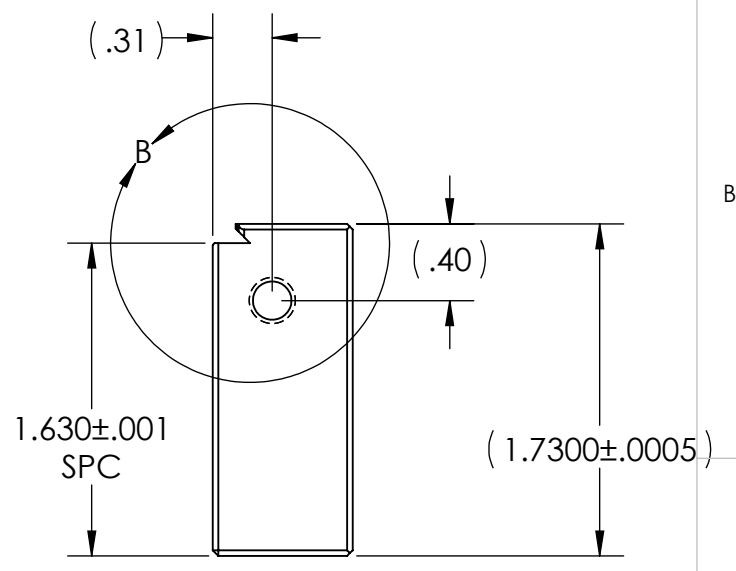
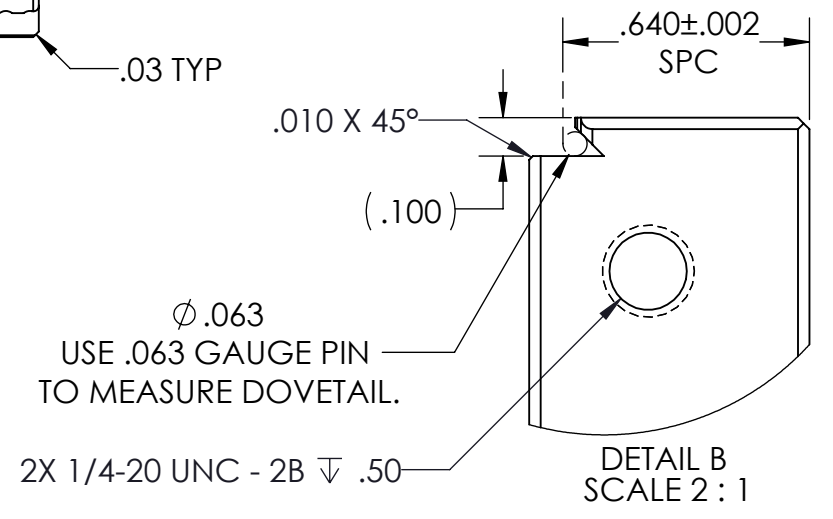
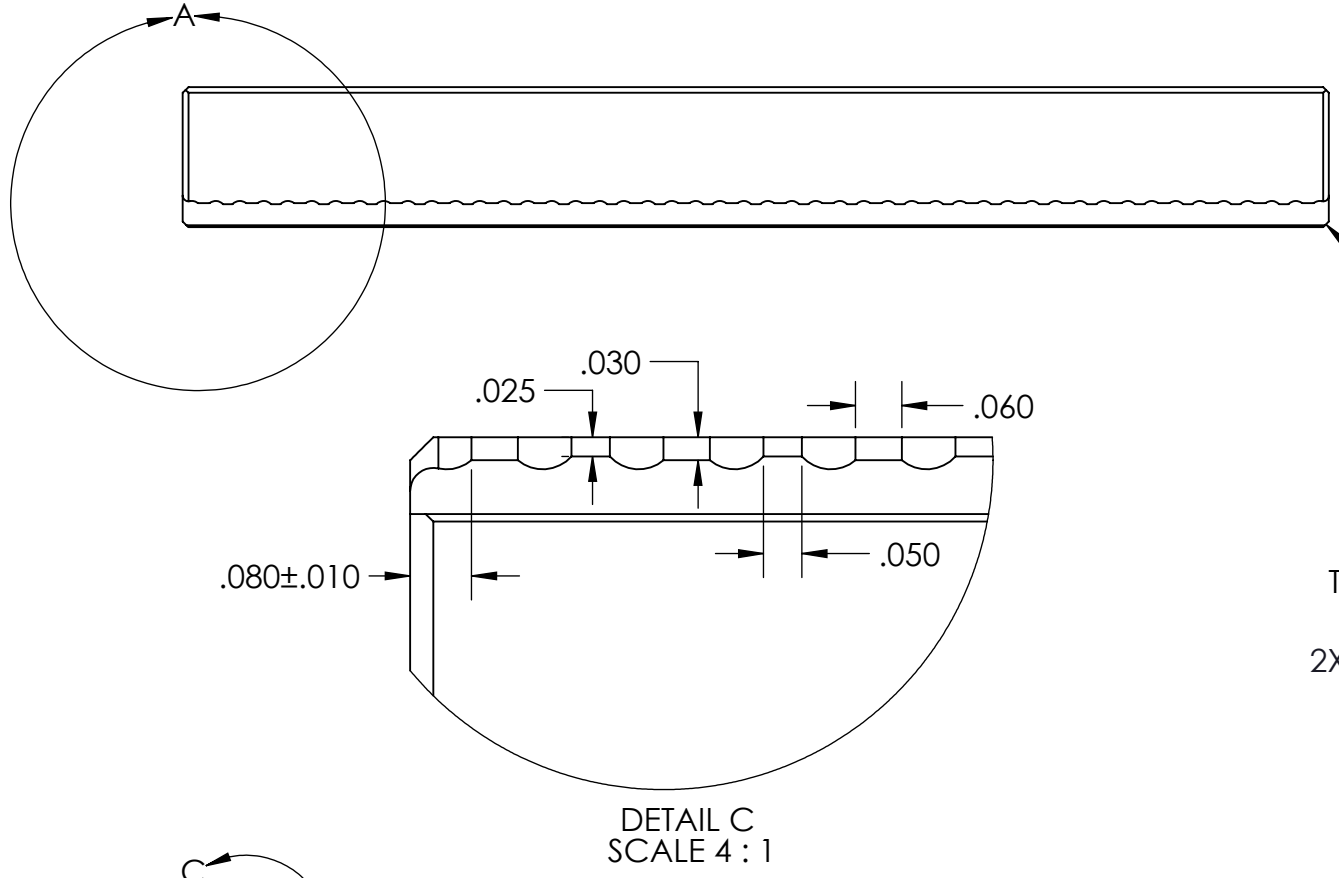
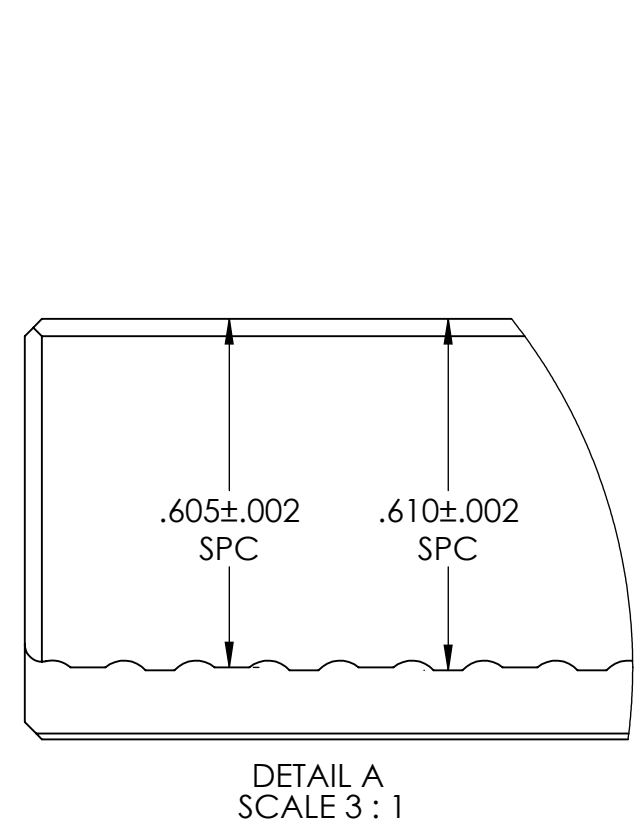


NOTES: UNLESS OTHERWISE SPECIFIED

# POST HEAT TREAT/FINISHED PART DIMENSIONS

1. APPLICABLE STANDARDS AND SPECIFICATIONS:
  - ASME.Y14.5.DIMENSIONING.AND.TOLERANCING.2009
2. MATERIAL: 4140 STEEL CD
3. FINISH: -
4. REMOVE ALL SHARP EDGES AND BURRS .005 TO .020.



(2X  $\phi$  .531  $\nabla$  .700)  
 $\phi$  .813  $\nabla$  .521  
 $\surd$   $\phi$  .87X90°

**5<sup>th</sup>AXIS**  
 7140 ENGINEER ROAD, SAN DIEGO, CA 92111  
 PH (858) 505-0432 FX (858) 505-0432

| TOLERANCES                |              | INCH  | APPROVALS         |                        |
|---------------------------|--------------|---|-------------------|------------------------|
| METRIC                    | INCH         |   | DRAWN BY          | DATE                   |
| X ± 1.0                   | X ± 0.1      | <b>PROPRIETARY AND CONFIDENTIAL</b>   | DANM.             | 2014/11/10             |
| .X ± 0.3                  | .X ± 0.05    | 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. | BOZ               | 2/5/2015               |
| .XX ± 0.13                | .XX ± 0.01   |   | JAMIE             | 2/6/2015               |
|                           | .XXX ± 0.005 |   | STEVE G.          | 2/6/2015               |
| UNLESS OTHERWISE NOTED    |              |   | MATERIAL:         | THIRD ANGLE PROJECTION |
| ANGULAR DIMENSIONS ± 0.5° |              |   | FINISH:           |                        |
|                           |              |   | WEIGHT: 1.988 LBS |                        |

|             |                          |
|-------------|--------------------------|
| CUSTOMER    |                          |
| DESCRIPTION | 6" KURT GRIPPER VISE JAW |
| SIZE        | B                        |
| PART NO.    | DJ6                      |
| SCALE       | SCALE 1:1                |
| SHEET       | SHEET 1 OF 6             |
| REV         | D                        |

NOTES: UNLESS OTHERWISE SPECIFIED

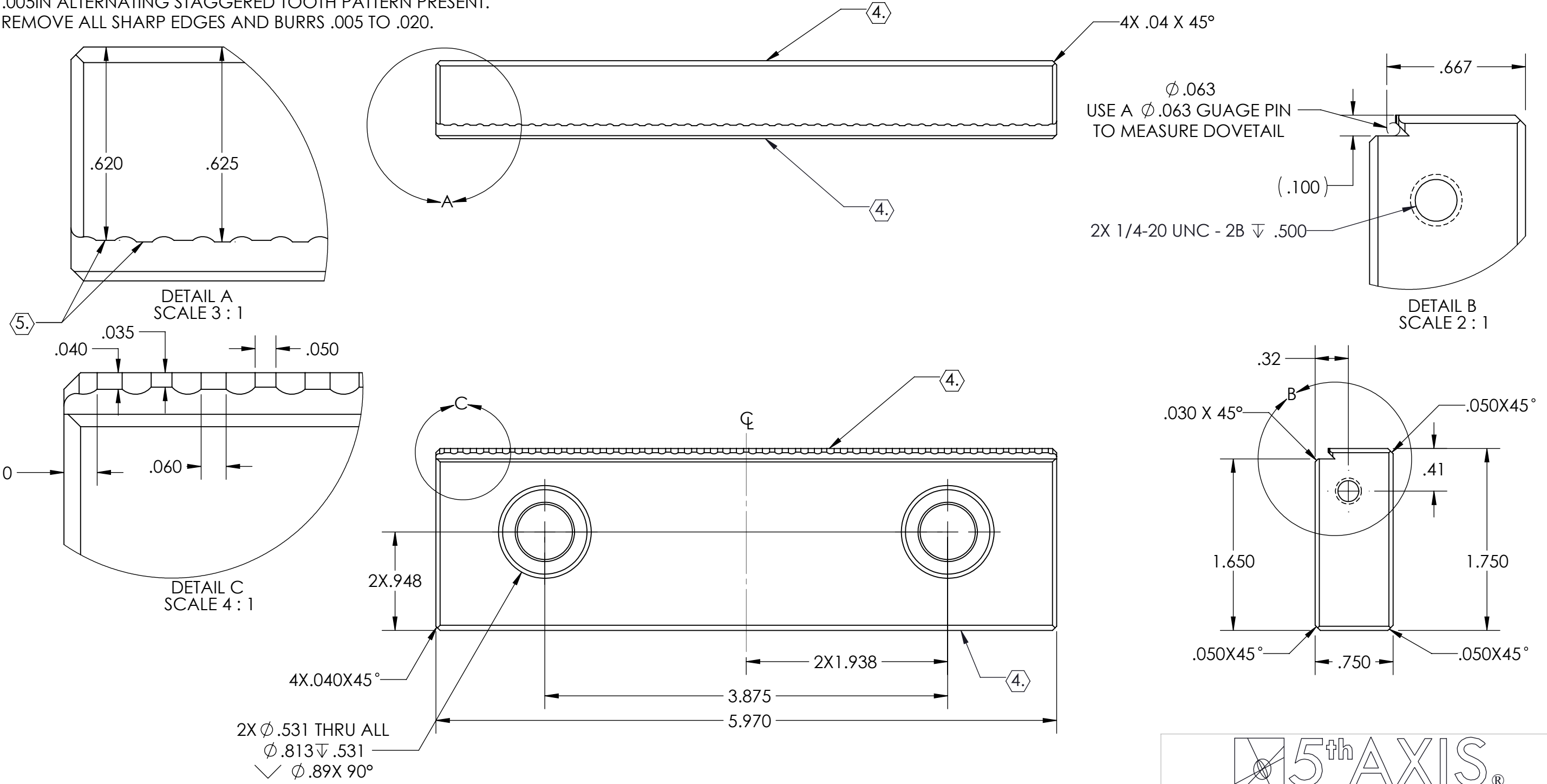
# PRE HEAT TREAT

| REVISIONS |      |  |            |          |
|-----------|------|--|------------|----------|
| ZONE      | REV. | DESCRIPTION  | DATE       | APPROVED |
| -         | -    | DELETED OLD REVISION HISTORY TO MAKE ROOM. PREVIOUS REVISION HISTORY IS ON REV C | 11/20/2013 |          |
| B2        | D    | ADDED 1/4-20 TAPPED HOLE TO EACH SIDE  | 11/20/2013 |          |

1. APPLICABLE STANDARDS AND SPECIFICATIONS:
  - ASME.Y14.5.DIMENSIONING.AND.TOLERANCING.2009
2. MATERIAL: 4140 STEEL CD
3. FINISH: -
4. PRE-HARDENING MACHINING SHOULD LEAVE MATERIAL FOR INDICATED SURFACES.
5. .005IN ALTERNATING STAGGERED TOOTH PATTERN PRESENT.
6. REMOVE ALL SHARP EDGES AND BURRS .005 TO .020.

D  
C  
B  
A

D  
C  
B  
A



2X  $\phi$ .531 THRU ALL  
 $\phi$ .813  $\nabla$  .531  
 $\checkmark$   $\phi$ .89X 90°

**5<sup>th</sup>AXIS**  
 7140 ENGINEER ROAD, SAN DIEGO, CA 92111  
 PH (858) 505-0432 FX (858) 505-0432

| TOLERANCES                |              | INCH   | APPROVALS |            |
|---------------------------|--------------|--|-----------|------------|
| METRIC                    | INCH         |  | DRAWN BY  | DATE       |
| X ± 1.0                   | X ± 0.1      | <b>PROPRIETARY AND CONFIDENTIAL</b><br>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. | DANM.     | 2014/11/10 |
| .X ± 0.3                  | .X ± 0.05    |  | BOZ       | 2/5/2015   |
| .XX ± 0.13                | .XX ± 0.01   |  | JAMIE     | 2/6/2015   |
|                           | .XXX ± 0.005 |  | STEVE G.  | 2/6/2015   |
| UNLESS OTHERWISE NOTED    |              |  | MATERIAL: |            |
| ANGULAR DIMENSIONS ± 0.5° |              | FINISH:  |           |            |
|                           |              | WEIGHT: 1.988 LBS  |           |            |

|             |                          |
|-------------|--------------------------|
| CUSTOMER    |                          |
| DESCRIPTION | 6" KURT GRIPPER VISE JAW |
| SIZE        | B                        |
| PART NO.    | DJ6                      |
| SCALE       | SCALE 1:1                |
| SHEET       | 2 OF 6                   |
| REV         | D                        |

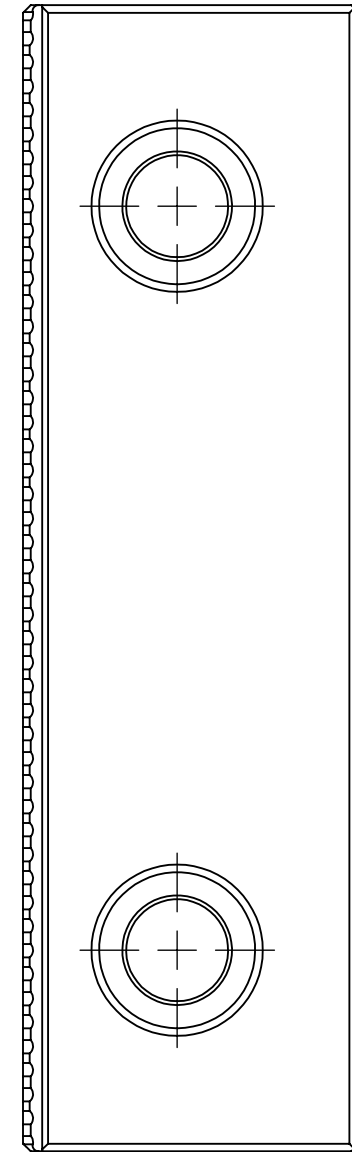
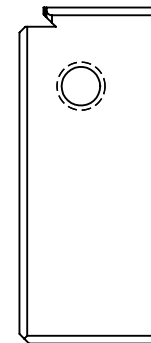
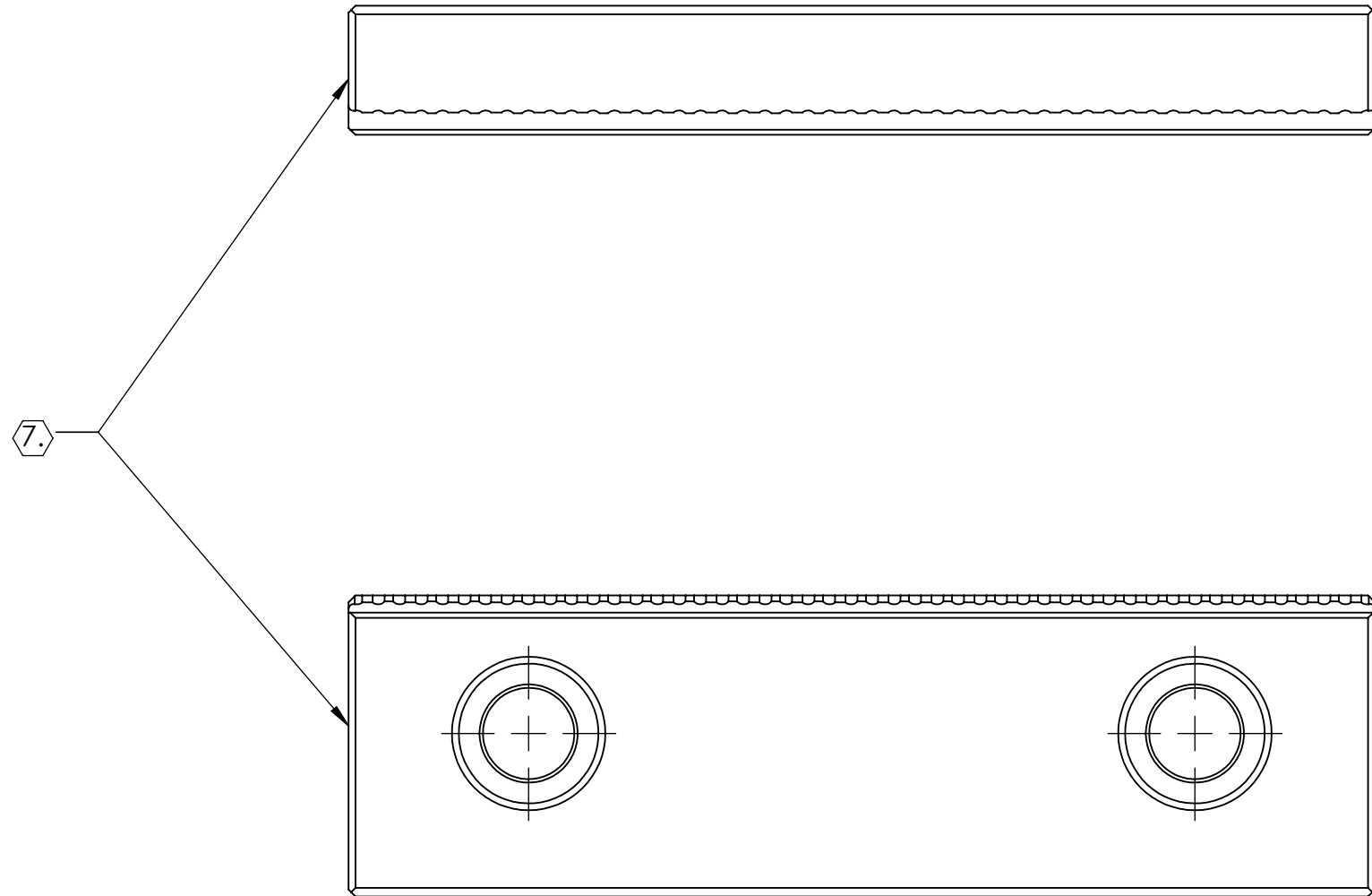
NOTES: UNLESS OTHERWISE SPECIFIED

# HEAT TREAT

1. APPLICABLE STANDARDS AND SPECIFICATIONS:
  - ASME.Y14.5.DIMENSIONING.AND.TOLERANCING.2009
2. MATERIAL: 4140 STEEL CD
3. FINISH: -
4. NO CERTIFICATES REQUIRED.
5. HEAT TREAT TO HRC 53-57.
6. PARTS ARE TO BE RACKED VERTICALLY FOR QUENCH.
7. TEST HARDNESS ON INDICATED SURFACE ONLY.

D  
C  
B  
A

D  
C  
B  
A



**5<sup>th</sup>AXIS**  
 7140 ENGINEER ROAD, SAN DIEGO, CA 92111  
 PH (858) 505-0432 FX (858) 505-0432

| TOLERANCES                |              |
|---------------------------|--------------|
| METRIC                    | INCH         |
| X ± 1.0                   | X ± 0.1      |
| .X ± 0.3                  | .X ± 0.05    |
| .XX ± 0.13                | .XX ± 0.01   |
|                           | .XXX ± 0.005 |
| UNLESS OTHERWISE NOTED    |              |
| ANGULAR DIMENSIONS ± 0.5° |              |

**INCH**  
**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.

**APPROVALS**  
 DRAWN BY: DANM. 2014/11/10  
 MFG. ENG.: BOZ 2/5/2015  
 QA ENG.: JAMIE 2/6/2015  
 ENG. MGR.: STEVE G. 2/6/2015  
 MATERIAL: 2  
 FINISH: 3  
 WEIGHT: 1.988 LBS

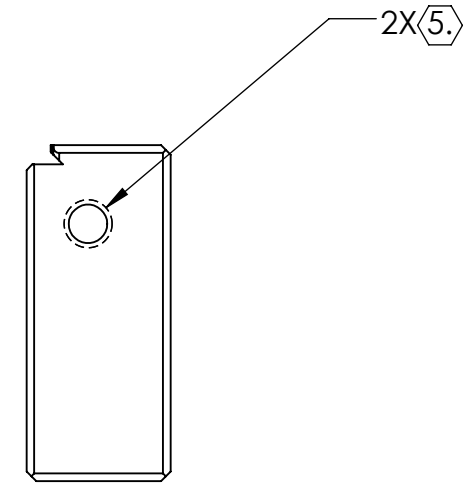
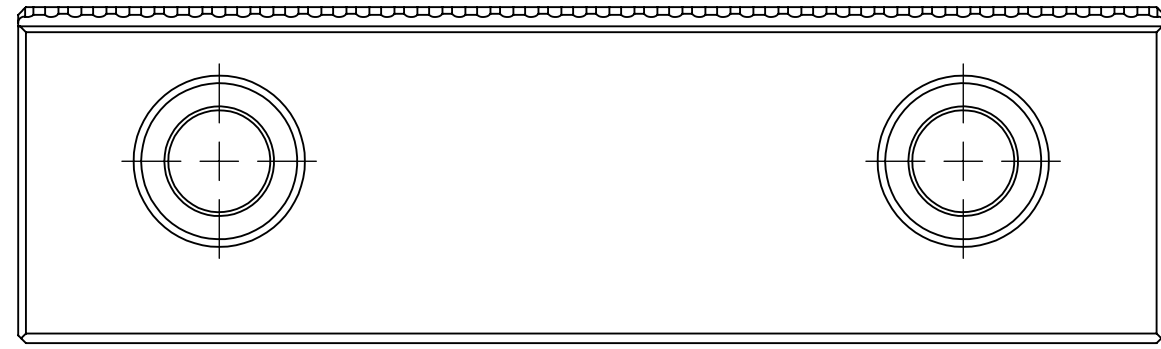
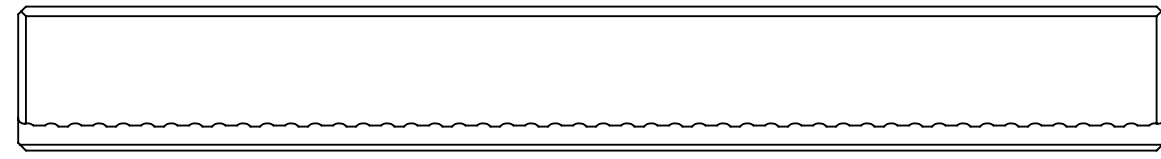
CUSTOMER: \_\_\_\_\_  
 DESCRIPTION: **6" KURT GRIPPER VISE JAW**  
 SIZE: **B** PART NO.: **DJ6**  
 DO NOT SCALE DRAWING SCALE 1:1 SHEET 3 OF 6

REV **D**

NOTES: UNLESS OTHERWISE SPECIFIED

# GLASS MEDIA BLASTING

1. APPLICABLE STANDARDS AND SPECIFICATIONS:
  - ASME.Y14.5.DIMENSIONING.AND.TOLERANCING.2009
2. MATERIAL: 4140 STEEL CD
3. FINISH: -
4. BLAST GLASS MEDIA 60-120 MESH 40PSI ON ALL SURFACES UNLESS OTHERWISE SPECIFIED.
5. PLUG ALL THREADED HOLES PRIOR TO BEAD BLAST.



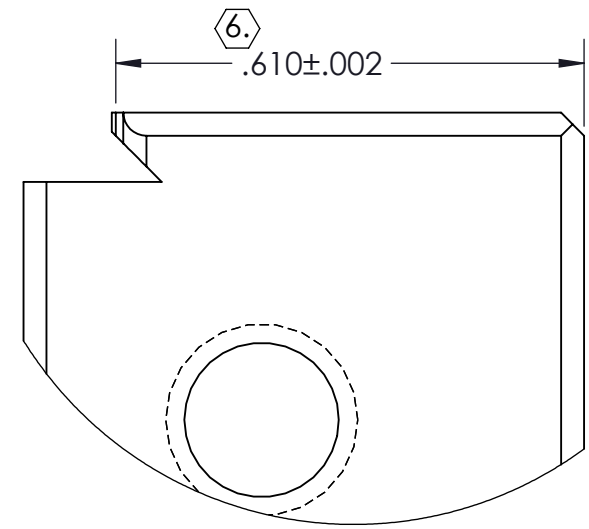
| TOLERANCES                |              | INCH   | APPROVALS |                   |
|---------------------------|--------------|--|-----------|-------------------|
| METRIC                    | INCH         |  | DRAWN BY  | DATE              |
| X ± 1.0                   | X ± 0.1      | <b>PROPRIETARY AND CONFIDENTIAL</b><br>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. | DANM.     | 2014/11/10        |
| .X ± 0.3                  | .X ± 0.05    |  | MFG. ENG. | BOZ 2/5/2015      |
| .XX ± 0.13                | .XX ± 0.01   |  | QA ENG.   | JAMIE 2/6/2015    |
|                           | .XXX ± 0.005 |  | ENG. MGR. | STEVE G. 2/6/2015 |
| UNLESS OTHERWISE NOTED    |              |  | MATERIAL: | (2)               |
| ANGULAR DIMENSIONS ± 0.5° |              | FINISH:  | (3)       |                   |
|                           |              | WEIGHT:  | 1.988 LBS |                   |

|                      |          |                          |              |
|----------------------|----------|--------------------------|--------------|
| CUSTOMER             |          | DESCRIPTION              |              |
|                      |          | 6" KURT GRIPPER VISE JAW |              |
| SIZE                 | PART NO. | REV                      |              |
| B                    | DJ6      | D                        |              |
| DO NOT SCALE DRAWING |          | SCALE 1:1                | SHEET 4 OF 6 |

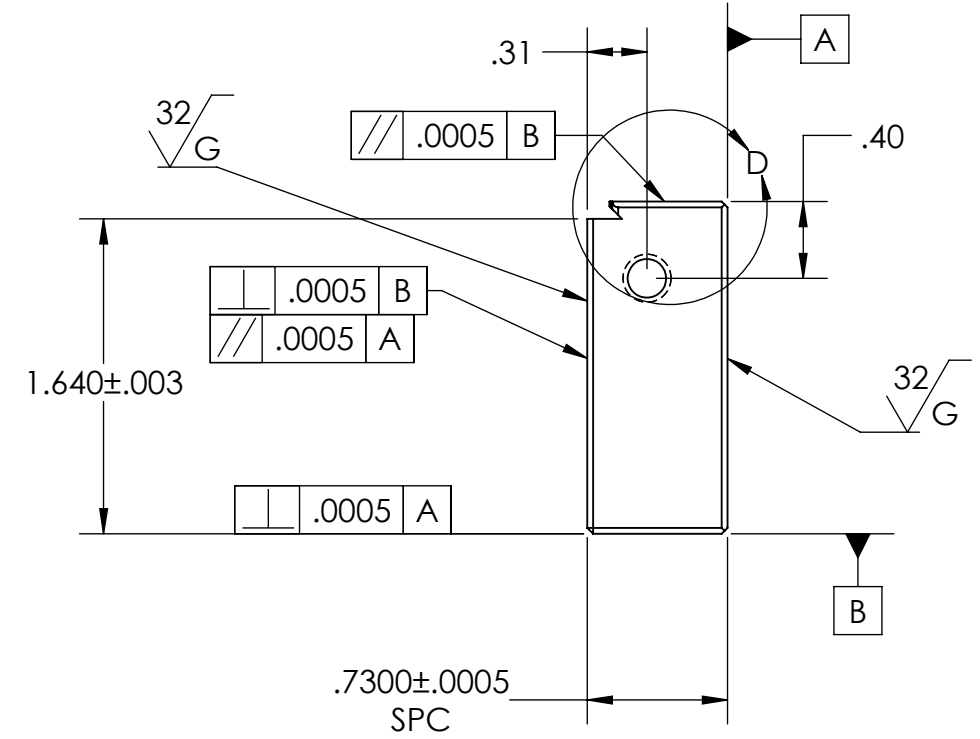
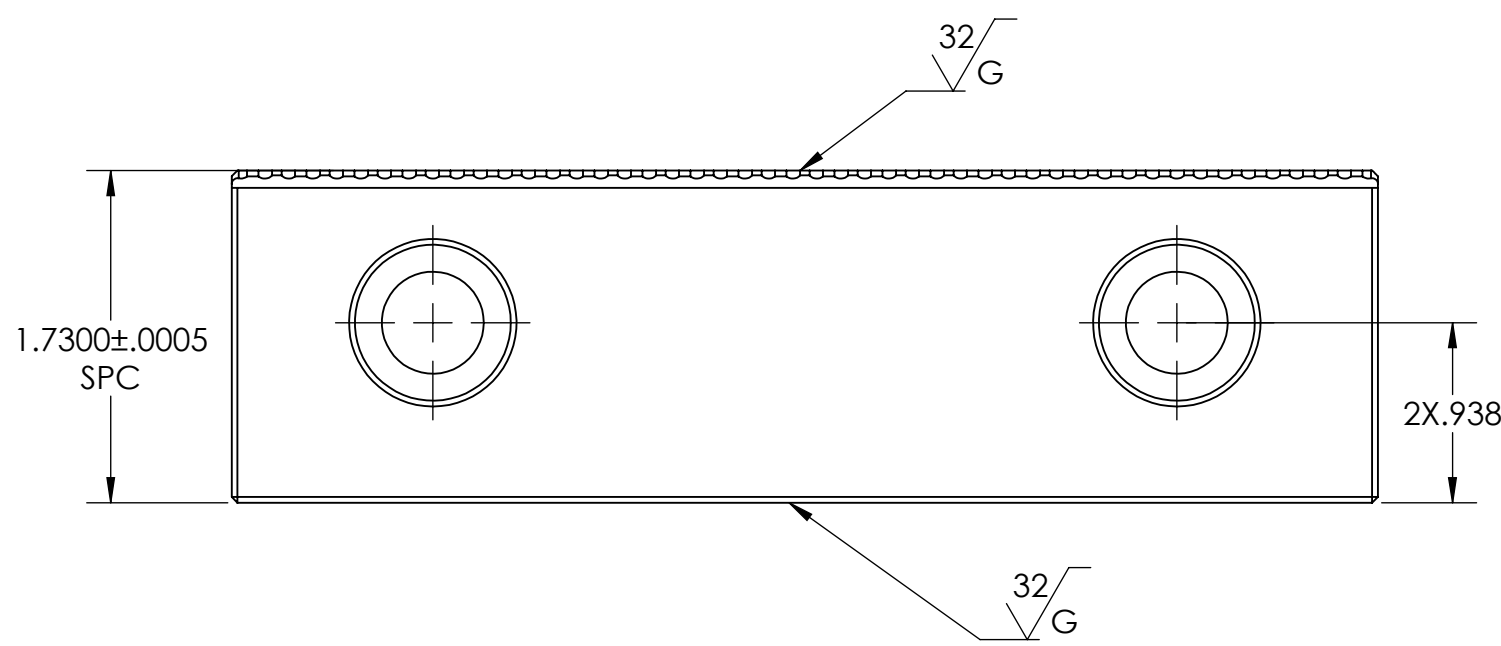
NOTES: UNLESS OTHERWISE SPECIFIED

# GRIND OP 1-4

1. APPLICABLE STANDARDS AND SPECIFICATIONS:
  - ASME.Y14.5.DIMENSIONING.AND.TOLERANCING.2009
- ② MATERIAL: 4140 STEEL CD
- ③ FINISH: -
4. GRIND INDICATED SURFACES.
5. DESIGNED FOR NOMINAL REMOVAL OF .01IN PER SURFACE DURING GRIND OP.
- ⑥ DIMENSION SHOULD BE TAKEN FROM THE FURTHEST STAGGERED TOOTH.



DETAIL D  
SCALE 4 : 1



| TOLERANCES                |              | INCH  | APPROVALS |            |
|---------------------------|--------------|---|-----------|------------|
| METRIC                    | INCH         |   | DRAWN BY  | DATE       |
| X ± 1.0                   | X ± 0.1      | <b>PROPRIETARY AND CONFIDENTIAL</b>   | DANM.     | 2014/10/10 |
| .X ± 0.3                  | .X ± 0.05    | 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. | BOZ       | 2/5/2015   |
| .XX ± 0.13                | .XX ± 0.01   |   | JAMIE     | 2/6/2015   |
|                           | .XXX ± 0.005 |   | STEVE G.  | 2/6/2015   |
| UNLESS OTHERWISE NOTED    |              |   | MATERIAL: | ②          |
| ANGULAR DIMENSIONS ± 0.5° |              |   | FINISH:   | ③          |
|                           |              |   | WEIGHT:   | 1.988 LBS  |

|             |                          |
|-------------|--------------------------|
| CUSTOMER    |                          |
| DESCRIPTION | 6" KURT GRIPPER VISE JAW |
| SIZE        | B                        |
| PART NO.    | DJ6                      |
| SCALE       | 1:1                      |
| SHEET       | 5 OF 6                   |

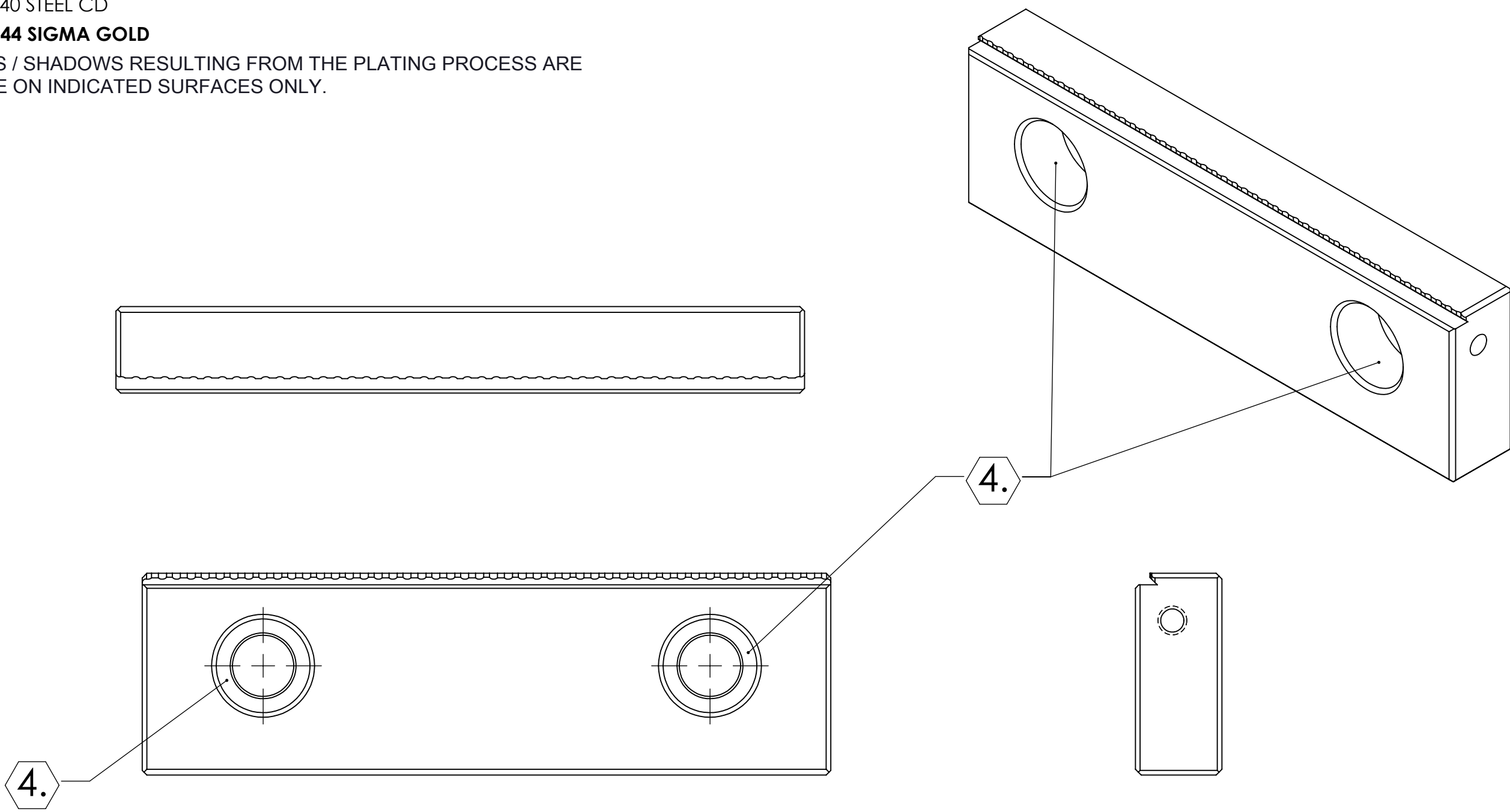
NOTES: UNLESS OTHERWISE SPECIFIED

# PLATING PRINT

1. APPLICABLE STANDARDS AND SPECIFICATIONS:
  - ASME.Y14.5.DIMENSIONING.AND.TOLERANCING.2009
2. MATERIAL: 4140 STEEL CD
3. FINISH: PVD #44 SIGMA GOLD
4. RACK MARKS / SHADOWS RESULTING FROM THE PLATING PROCESS ARE PERMISSIBLE ON INDICATED SURFACES ONLY.

D  
C  
B  
A

D  
C  
B  
A



| TOLERANCES                |              | INCH  | APPROVALS                   |                        |
|---------------------------|--------------|---|-----------------------------|------------------------|
| METRIC                    | INCH         |   | DRAWN BY                    | CUSTOMER               |
| X ± 1.0                   | X ± 0.1      | <b>PROPRIETARY AND CONFIDENTIAL</b>   | DANM. 2014/11/10            |                        |
| .X ± 0.3                  | .X ± 0.05    | 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. | MFG. ENG. BOZ 2/5/2015      |                        |
| .XX ± 0.13                | .XX ± 0.01   |   | QA ENG. JAMIE 2/6/2015      |                        |
|                           | .XXX ± 0.005 |   | ENG. MGR. STEVE G. 2/6/2015 |                        |
| UNLESS OTHERWISE NOTED    |              |   | MATERIAL: 2                 | THIRD ANGLE PROJECTION |
| ANGULAR DIMENSIONS ± 0.5° |              |   | FINISH: 3                   |                        |
|                           |              |   | WEIGHT: 1.988 LBS           |                        |

|             |                          |
|-------------|--------------------------|
| DESCRIPTION | 6" KURT GRIPPER VISE JAW |
| SIZE        | B                        |
| PART NO.    | DJ6                      |
| SCALE       | DO NOT SCALE DRAWING     |
| SCALE       | SCALE 1:1                |
| SHEET       | SHEET 6 OF 6             |
| REV         | D                        |