The machinable vise for powerful and versatile production workholding

A totally new concept in workholding, the Stevens Soft-Brick™ Vise eliminates the need for changing jaws on soft jaw vises. The vise needs no soft jaws because the vise itself is a soft jaw. Made from 6061 aluminum, the low-cost vise can be machined by users with cavities to fit specific workpieces.

**Design Features**

The patent-pending design incorporates a jaw-lock pin to clamp the empty vise while machining the cavity. Then, the jaw-lock pin is removed and the workpiece can be clamped with up to 5000 lbs of clamping pressure. Hardened steel male and female threads and thrust bearing provide durability.

**Compact and Easy to Mount**

The compact design weighs 9 lbs and may be used for small workpieces or ganged together for larger workpieces. A universal mounting pattern will fit onto the Stevens subplate grid pattern, any T-slotted machine table, or onto the faces of tombstones.

**Machinable Area**

<table>
<thead>
<tr>
<th>1-Station Soft Brick</th>
<th>2-Station Soft Brick</th>
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</thead>
<tbody>
<tr>
<td>$185</td>
<td>$195</td>
</tr>
</tbody>
</table>

Order tool kit and mounting kit separately.

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**STEVENS INNOVATIONS**

**Soft-Brick™ Vise**

*The machinable vise for powerful and versatile production workholding*

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**STEVENS ENGINEERING, INC.**

3946 W. Clarendon Avenue, Phoenix, AZ 85019 • 800.635.0657 • 602.272.6766 • Fax 602.272.0717 • www.stevenseng.com
How to machine workpiece cavity in Soft-Brick™ Vise

1. Insert Jaw-Lock Pins in upper holes (Note: Jaw-Lock Pins are smaller than holes. This ensures that cavity will open up slightly larger than workpiece for easy workpiece loading and unloading).

2. Tighten Clamp Screw (The Soft-Brick Vise cavity must be machined while Jaw-Lock Pins are clamped in the upper hole).

Machine cavity
- The 6061 aluminum vise body is fully machinable on its top and sides.
- The 3-1/2" vise width may be machined to narrower widths for better side access to workpiece.
- Jaw-Lock Pins are 6061 aluminum; knurled heads of pins may also be machined away if final cavity shape requires this.
- Previously used Soft-Brick Vises can be re-machined for a new workpiece by machining off the top layer.

Loosen Clamp Screw and remove Jaw-Lock Pins; the workpiece may now be loaded, and the Soft-Brick Vise is ready for production.

Tool Kit for 1-Station Soft-Brick Vise
Part No. 20229 includes:
Qty. 1 Part No. 10543 Wrench
Qty. 2 Part No. 10539 Jaw-Lock Pin

Tool Kit for 2-Station Soft-Brick Vise
Part No. 20230 includes:
Qty. 1 Part No. 10543 Wrench
Qty. 4 Part No. 10539 Jaw-Lock Pin

Mounting Soft-Brick™ Vises

T-Slot Mounting
T-Slot Mounting Kits include:
(1) Alignment Key
(2) T-Nuts
(2) 1/2 - 13 Hex Head Screws
(2) Tooling Washers
(1) 1/4 - 20 Screw (for key)

<table>
<thead>
<tr>
<th>Part No. for Mounting Kit</th>
<th>T-Slot Size</th>
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<tr>
<td>20224-5625</td>
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<tr>
<td>20224-7087</td>
<td>.7067</td>
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</tbody>
</table>

Subplate Mounting
Soft-Brick™ Vises are designed to mount directly onto the industry standard Stevens Grid Pattern.

Subplate Mounting Kit (part no. 20225) includes:
(2) 10062 Pull Dowels (.5006" diameter)
(2) 1/2 - 13 Hex Head Screws
(2) Tooling Washers

Distributed by

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