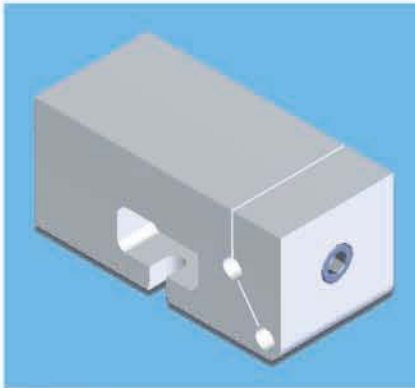


STEVENS INNOVATIONS

Soft-Brick™ Vise (patent pending)

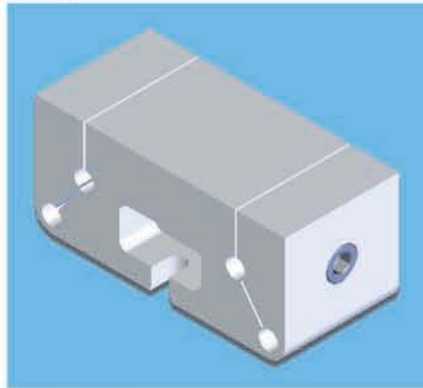
The machinable vise for powerful and versatile production workholding



1-Station
Soft-Brick Vise
Part No. 20222

\$185

Order tool kit and mounting kit separately



2-Station
Soft-Brick
Part No. 20223

\$195

Order tool kit and mounting kit separately

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.

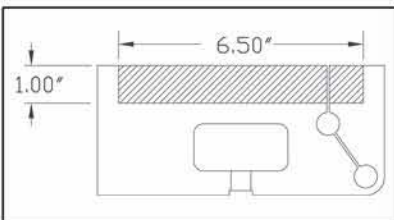
Design Features

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.

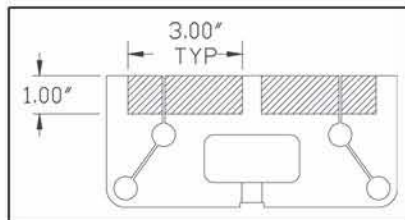
Compact and Easy to Mount

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.

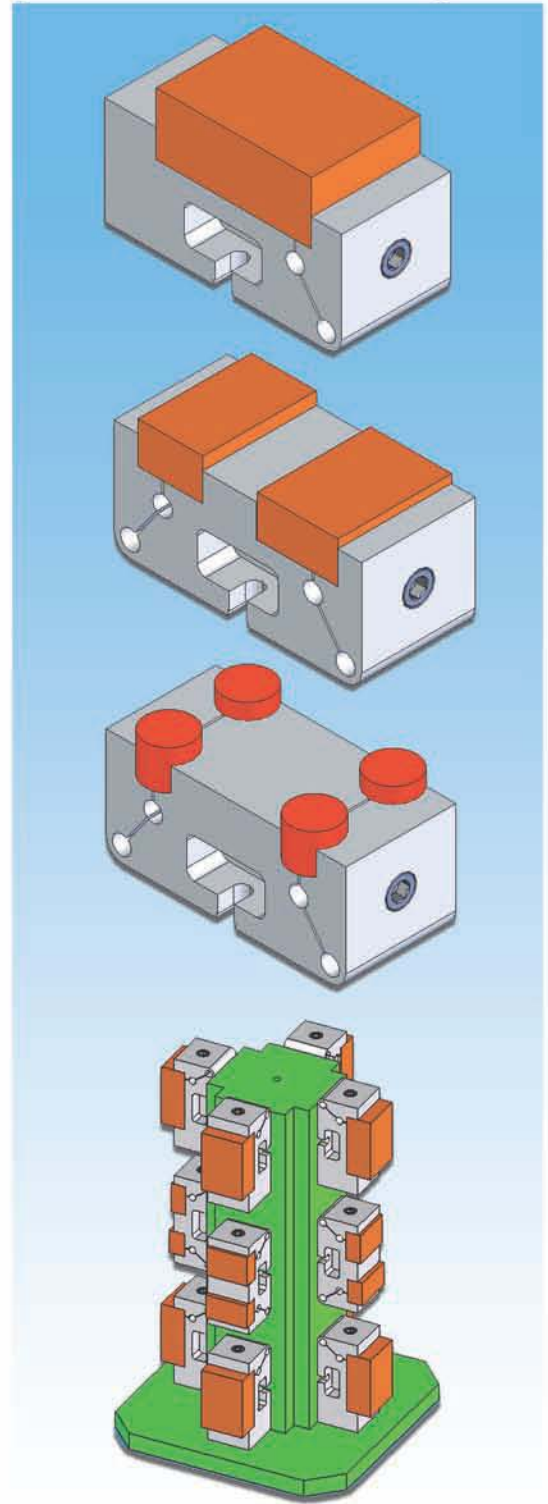
Machinable Area



1-Station Soft Brick



2-Station Soft Brick



STEVENS ENGINEERING, INC.

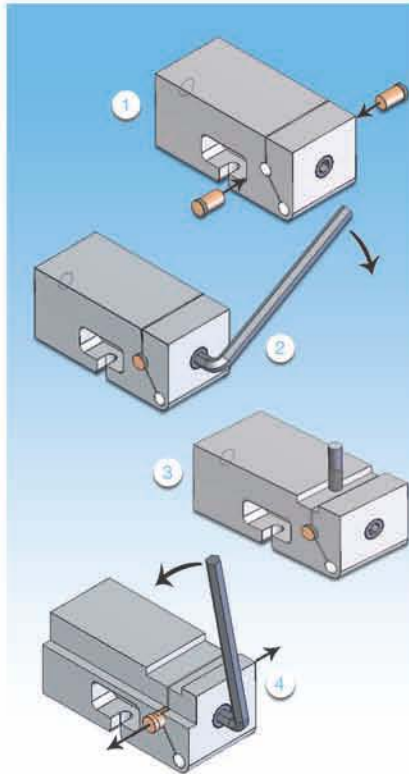
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2066GC092905

How to machine workpiece cavity in **Soft-Brick™ Vise**

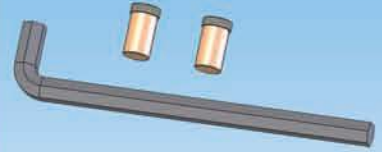
(patent pending)

- 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).
- 3 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.
- 4 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

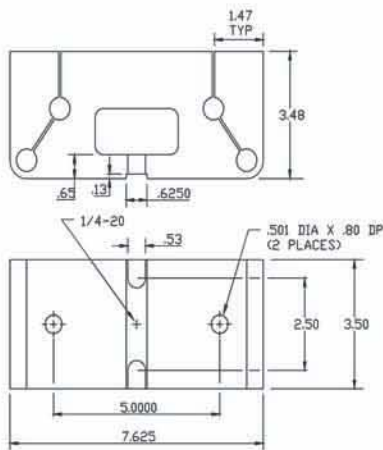


Tool Kit for 2-Station Soft-Brick Vise

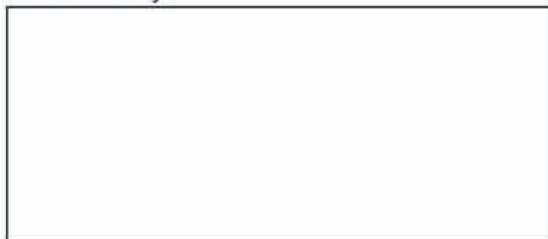
Part No. 20230 includes:
Qty. 1 Part No. 10543 Wrench
Qty. 4 Part No. 10539 Jaw-Lock Pin



Mounting **Soft-Brick™ Vises**



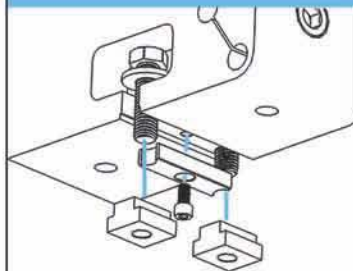
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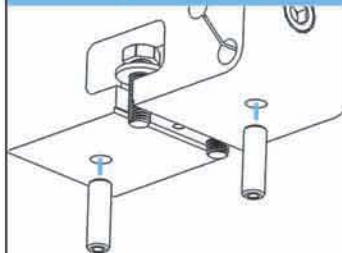
T-Slot Mounting



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)

Part No. for Mounting Kit	T-Slot Size
20224-5625	.5625
20224-6250	.6250
20224-6875	.6875
20224-7087	.7087

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

Side By Side Mounting

Soft-Brick™ Vises may be mounted side by side by changing the mounting screws from hex head to socket head and adding wrench clearance holes to the top of the vise.

