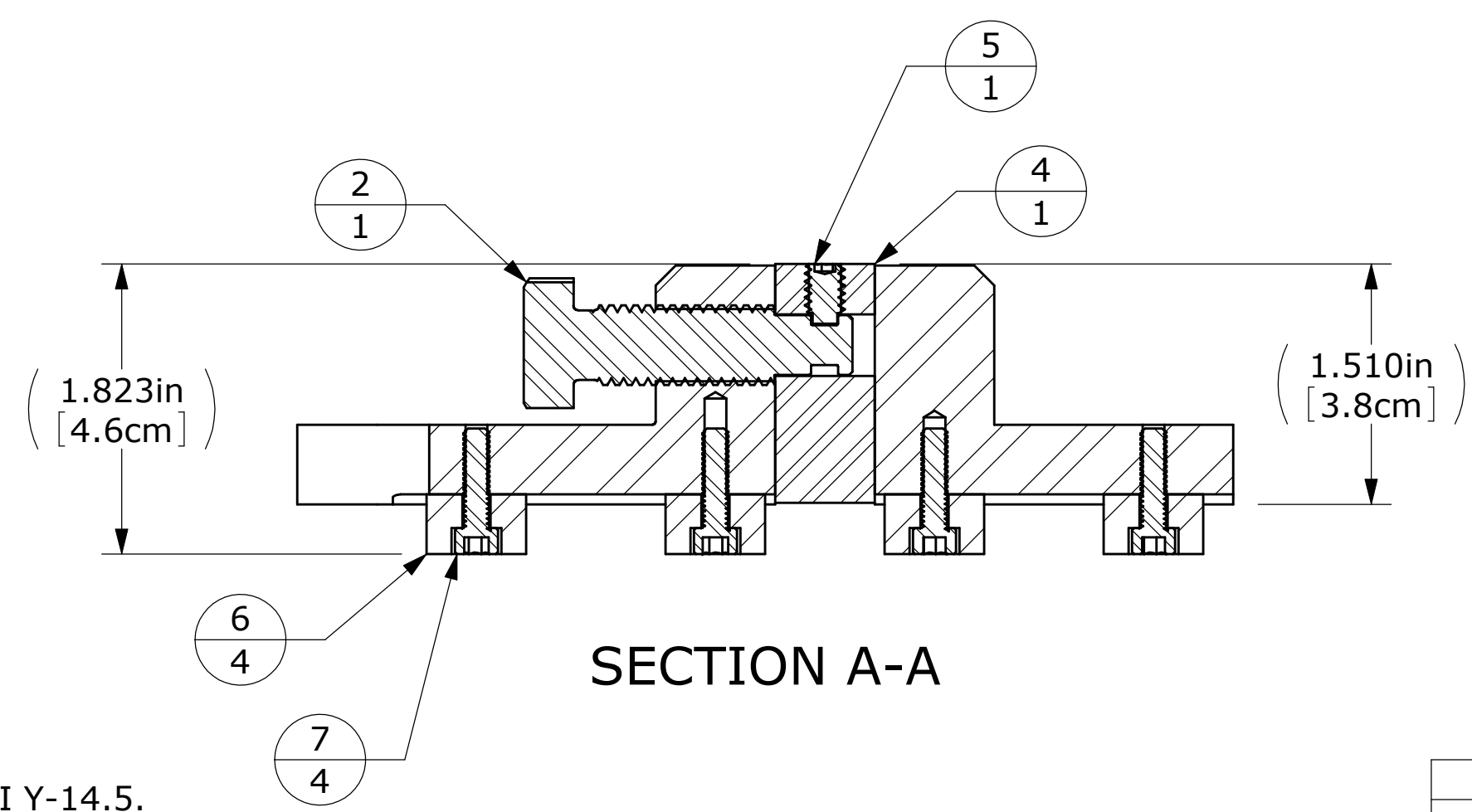
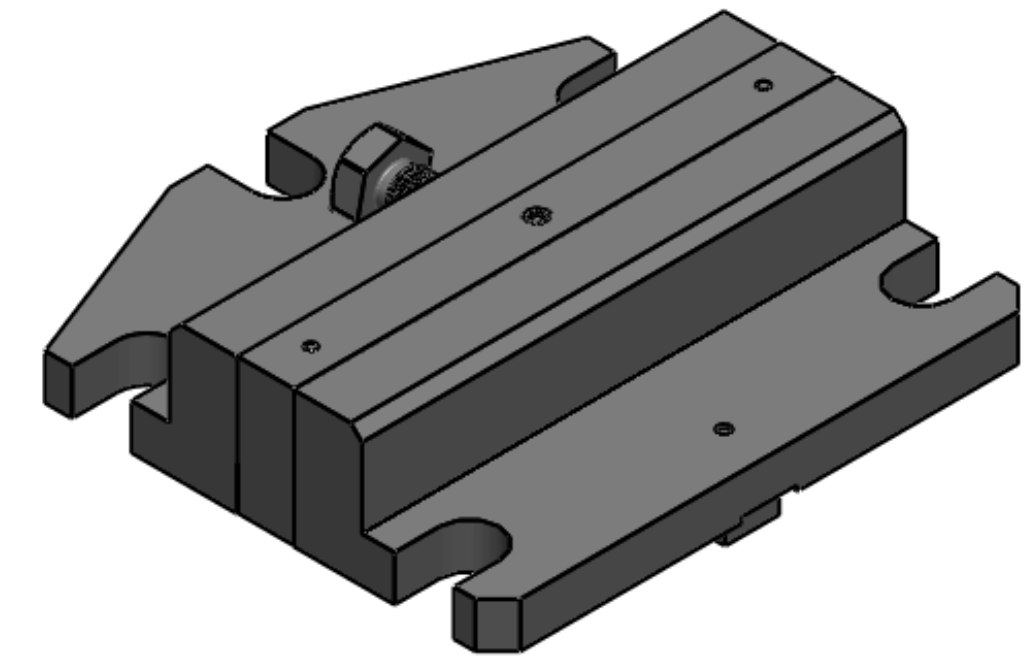
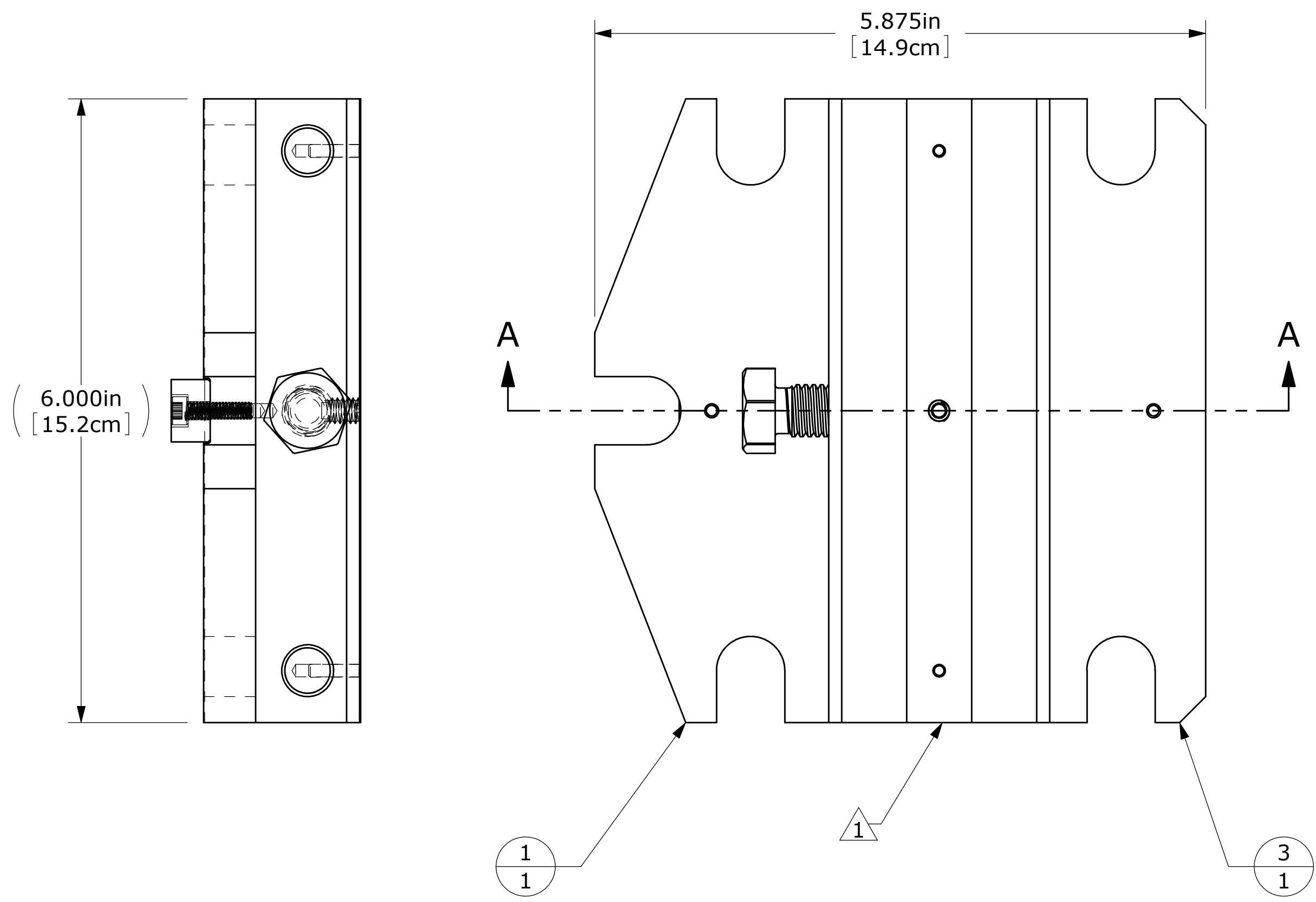


| REVISIONS | | | | |
|-----------|------|----------------------|-----------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |
| | 1 | ITEM 5 WAS .375" THK | 2/15/2010 | DSLEE |



| ITEM NO. | PART NUMBER | DESCRIPTION | REV | QTY. |
|----------|-------------|--|-----|------|
| 1 | 13056 | BODY, CLAMP MILL VISE | 00 | 1 |
| 2 | 13058 | SCREW, CLAMPING | 00 | 1 |
| 3 | 13060 | BODY, CLAMP MILL VISE | 00 | 1 |
| 4 | 13066 | JAW ASSY, CLAMP MILL VISE | 00 | 1 |
| 5 | 13069.003 | SCREW, SET - DOG POINT HEX SOCKET HEAD, 1/4-20 THD 0.3750in LONG | | 1 |
| 6 | 13070 | KEY, VISE LOCK | 00 | 4 |
| 7 | 13071.008 | SCREW, SOCKET HD CAP 8-32 THD, ALLOY STEEL [BLACK OXIDE FINISH] 0.625in LONG | | 4 |

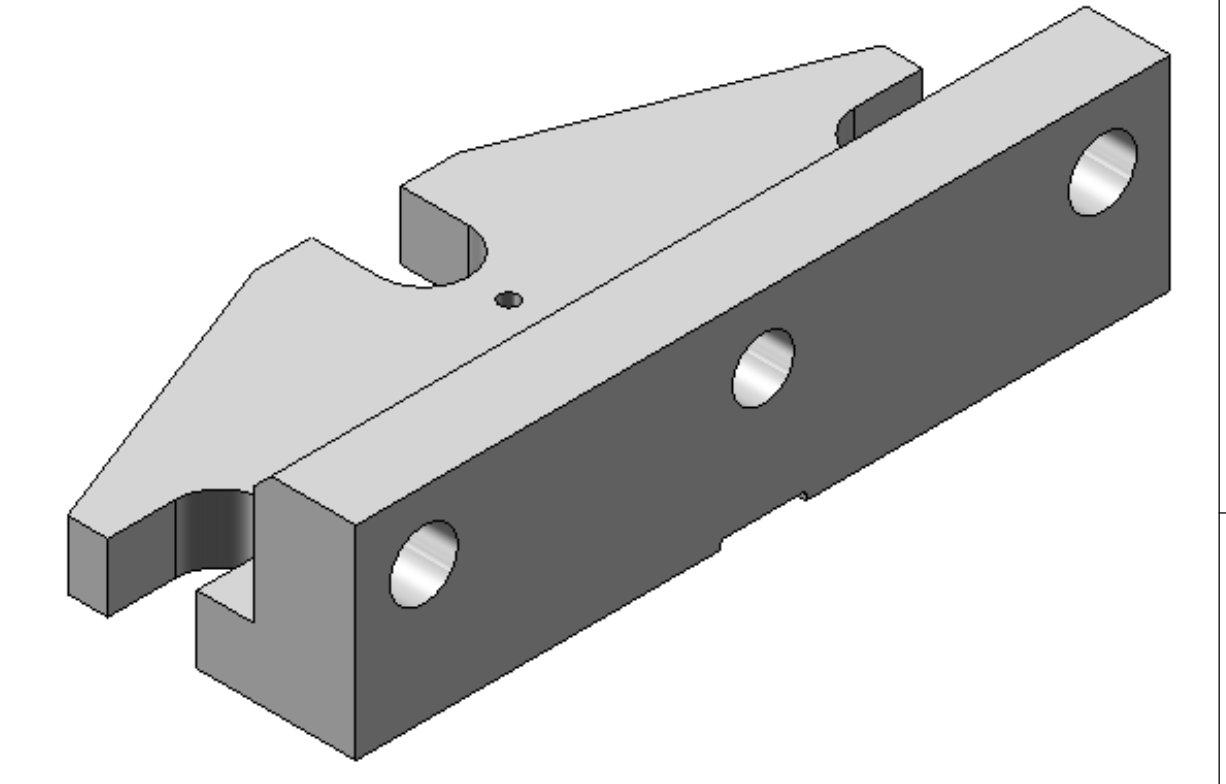
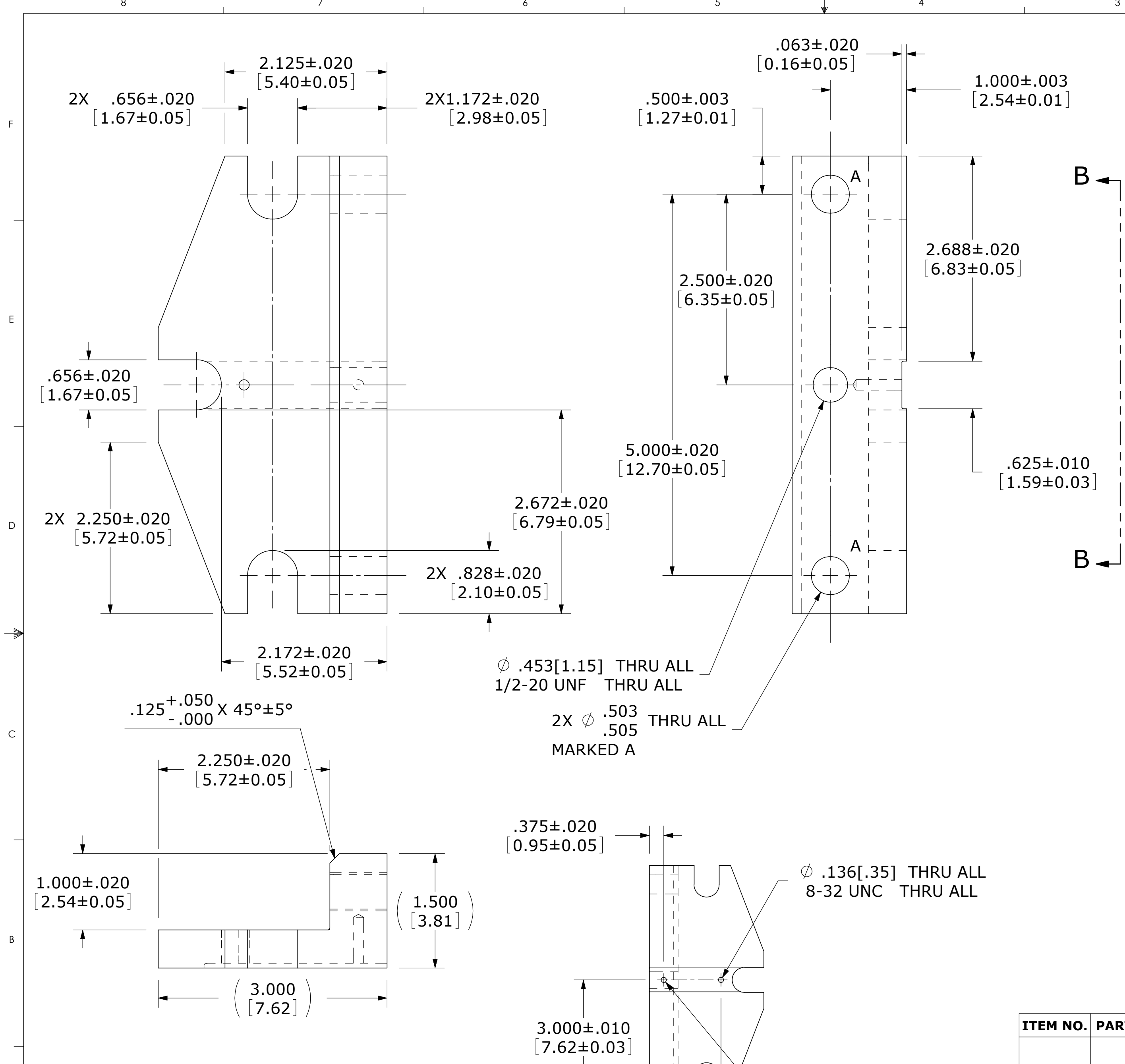
- NOTES:
1. INTERPRET DRAWING PER ANSI Y-14.5.
 2. BREAK ALL BURRS AND SHARP EDGES.
 3. MATERIAL: PER BOM.
 4. FINISH: NONE.

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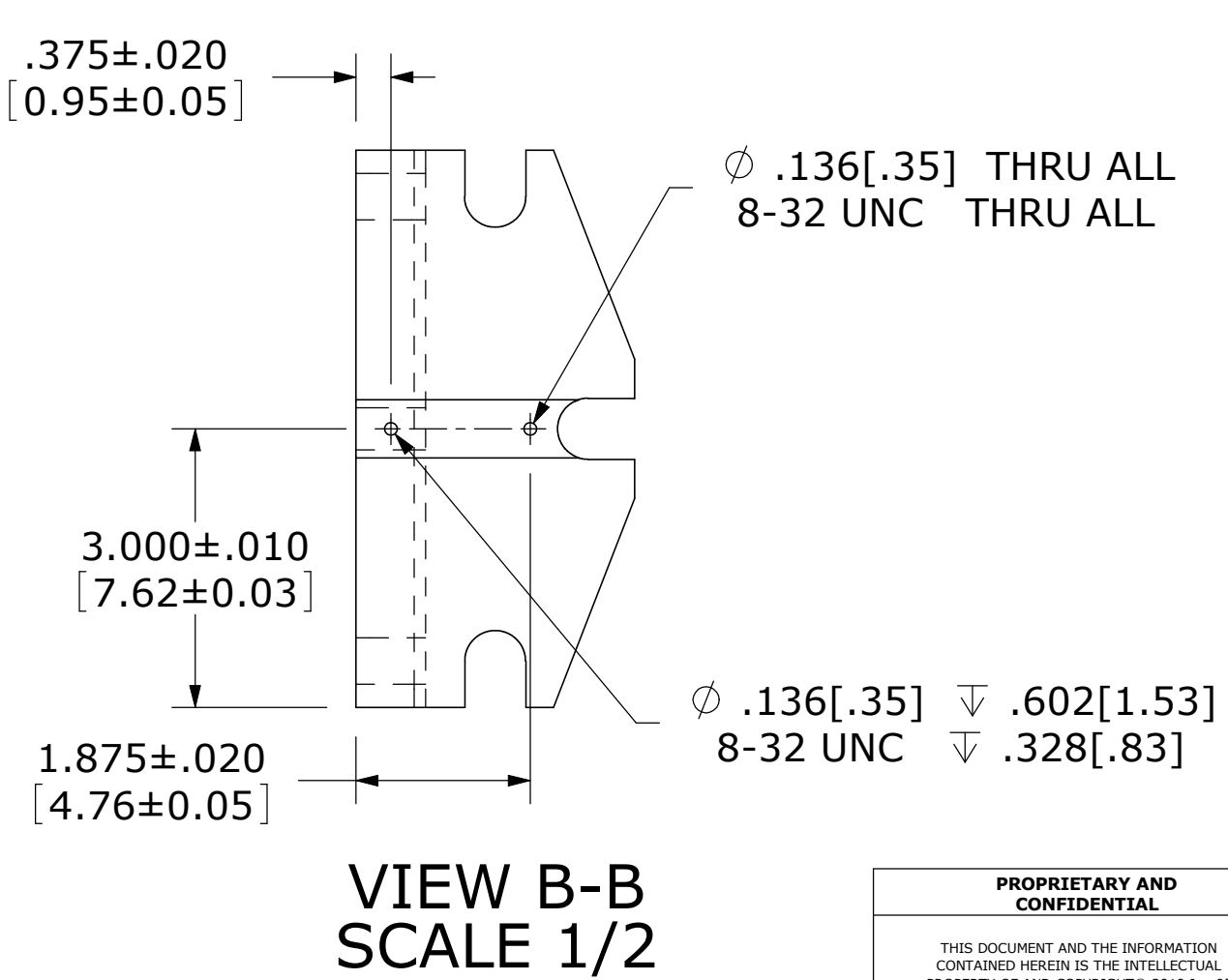
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| | | | | | | | |
|--------------------------------------|----------------------|--------------------------|--|-------|--|--------------------------------------|--|
| UNLESS OTHERWISE SPECIFIED: | | NAME | | DATE | | ACE Technology Company | |
| DIMENSIONS ARE IN INCHES | | DRAWN | | DSLee | | Franklin/Salisbury NH | |
| TOLERANCES: | | CHECKED | | | | TITLE: | |
| FRACTIONAL ± | | ENG APPR. | | | | VISE ASSEMBLY | |
| ANGULAR: MACH ± BEND ± | | MFG APPR. | | | | SIZE DWG. NO. REV | |
| THREE PLACE DECIMAL ± | | Q.A. | | | | C 13063 01 | |
| INTERPRET GEOMETRIC TOLERANCING PER: | | COMMENTS: | | | | SCALE: 1:1 WEIGHT: 8.12 SHEET 1 OF 1 | |
| MATERIAL | | Material <not specified> | | | | | |
| NEXT ASSY | USED ON | FINISH | | | | | |
| APPLICATION | DO NOT SCALE DRAWING | | | | | | |

| REVISIONS | | | | |
|-----------|------|-------------|------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |
| | | | | |



- NOTES:
1. INTERPRET DRAWING PER ANSI Y-14.5.
 2. BREAK ALL BURRS AND SHARP EDGES.
 3. MATERIAL: PER BOM.
 4. FINISH: NONE.



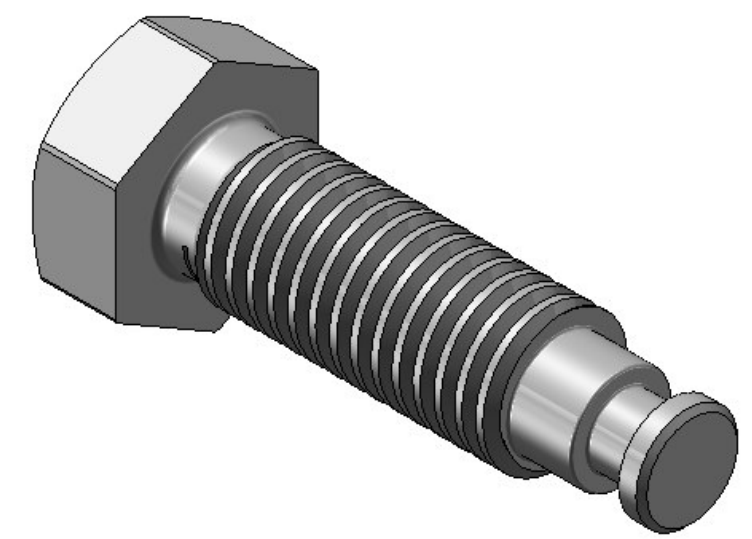
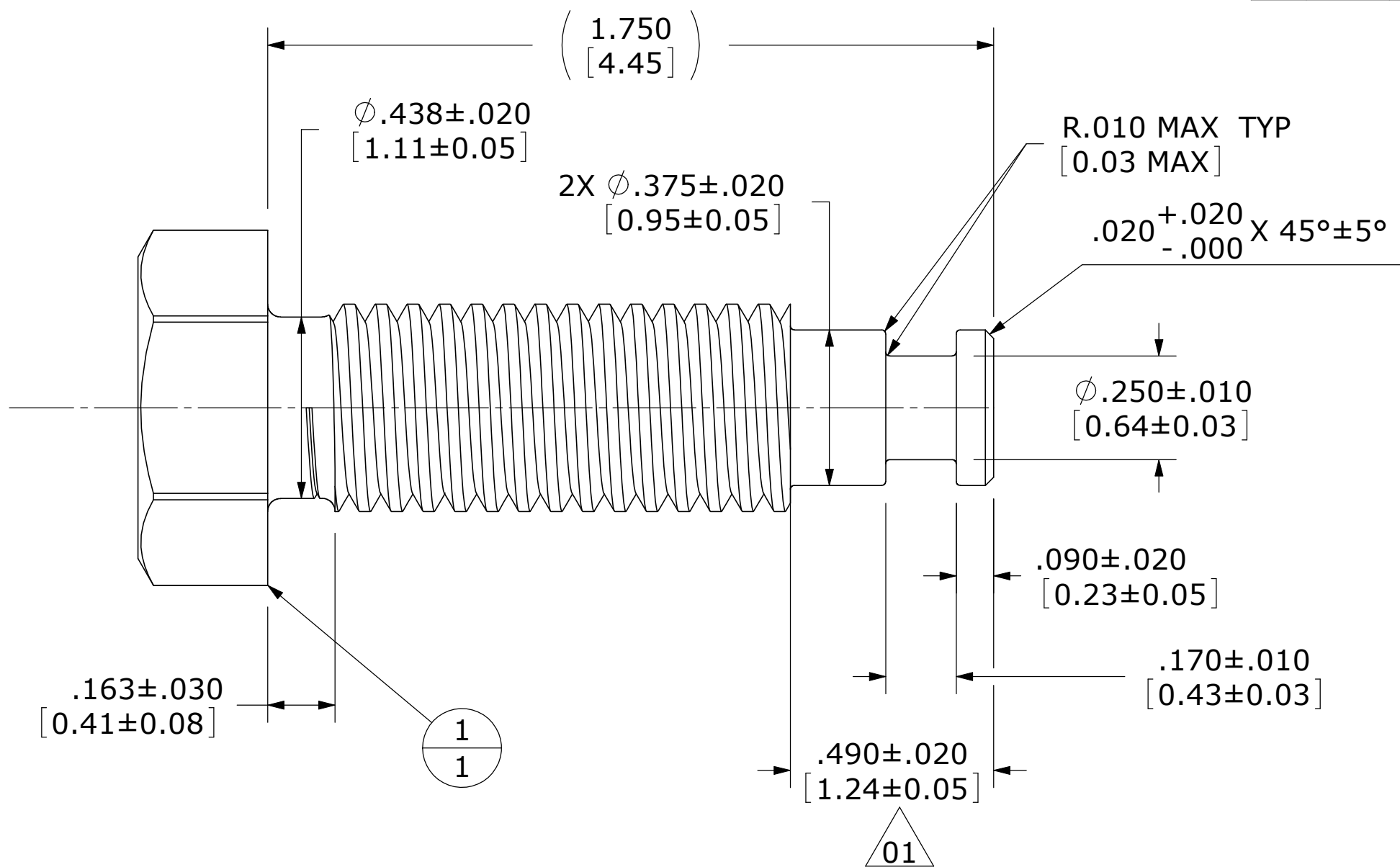
| ITEM NO. | PART NUMBER | DESCRIPTION | REV | QTY. |
|----------|-------------|---|-----|------|
| 1 | 13059.00701 | BAR, STEEL - COLD FINISHED ASTM 1018 1.500in THK X 3in WIDE X 6in LONG | | 1 |

| | | | | | |
|--------------------------------------|--------------------------|-------|-------------|--|--|
| UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | ACE Technology Company Franklin, NH - USA | |
| DIMENSIONS ARE IN INCHES | DRAWN | DSLee | 2010 Jan 05 | TITLE: BODY, CLAMP MILL VISE | |
| TOLERANCES: | CHECKED | | | SIZE DWG. NO. REV | |
| FRACTIONAL ± | ENG APPR. | | | C 13056 | |
| ANGULAR: MACH ± BEND ± | MFG APPR. | | | SCALE: 1:2 WEIGHT: 3.20 SHEET 1 OF 1 | |
| TWO PLACE DECIMAL ± | Q.A. | | | | |
| THREE PLACE DECIMAL ± | COMMENTS: | | | | |
| INTERPRET GEOMETRIC TOLERANCING PER: | Material <not specified> | | | | |
| MATERIAL: | | | | | |
| FINISH: | | | | | |
| APPLICATION: | DO NOT SCALE DRAWING | | | | |

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| REVISIONS | | | | |
|-----------|------|---|-----------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |
| | 01 | CHG, CONFIGURATION TO CORRECT ENGINEERING ERROR | 2/15/2010 | DSLEE |



- NOTES:
1. INTERPRET DRAWING PER ANSI Y-14.5.
 2. BREAK ALL BURRS AND SHARP EDGES.
 3. MATERIAL: PER BOM.
 4. FINISH: NONE.

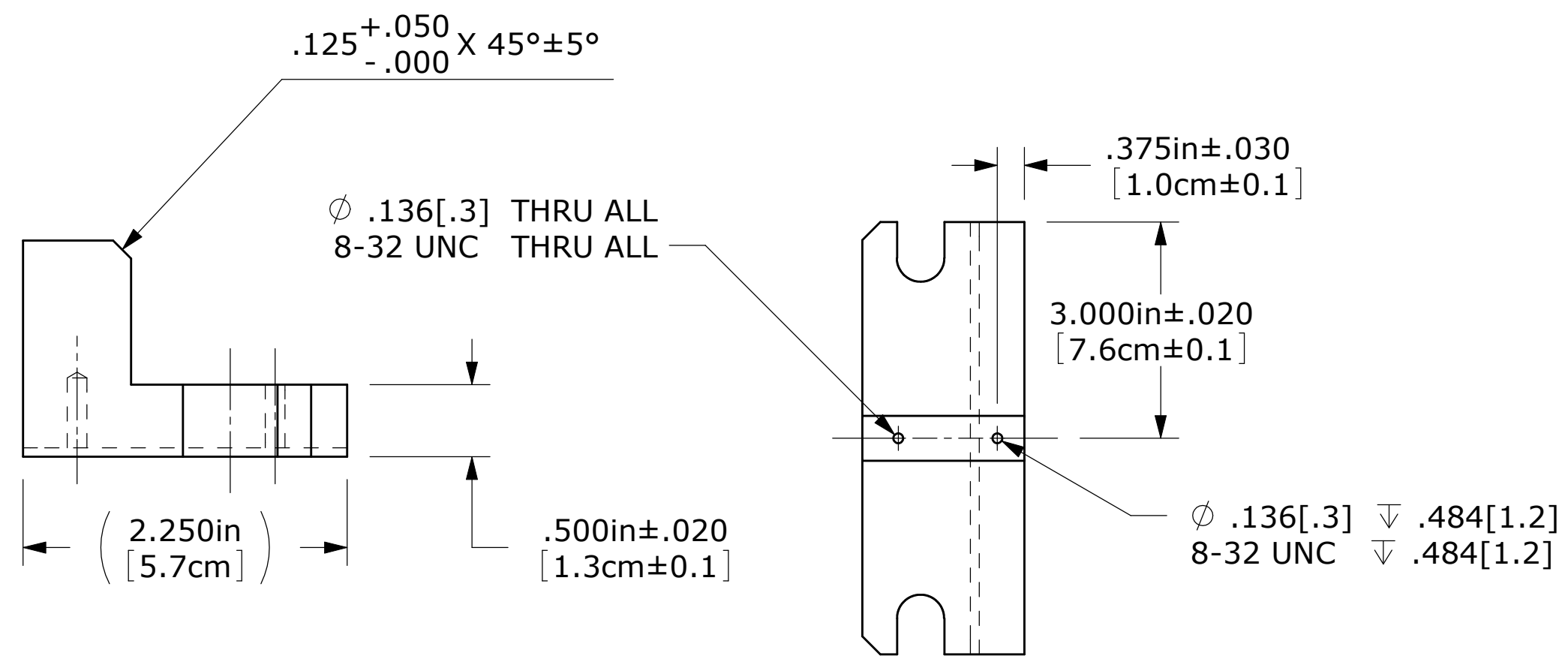
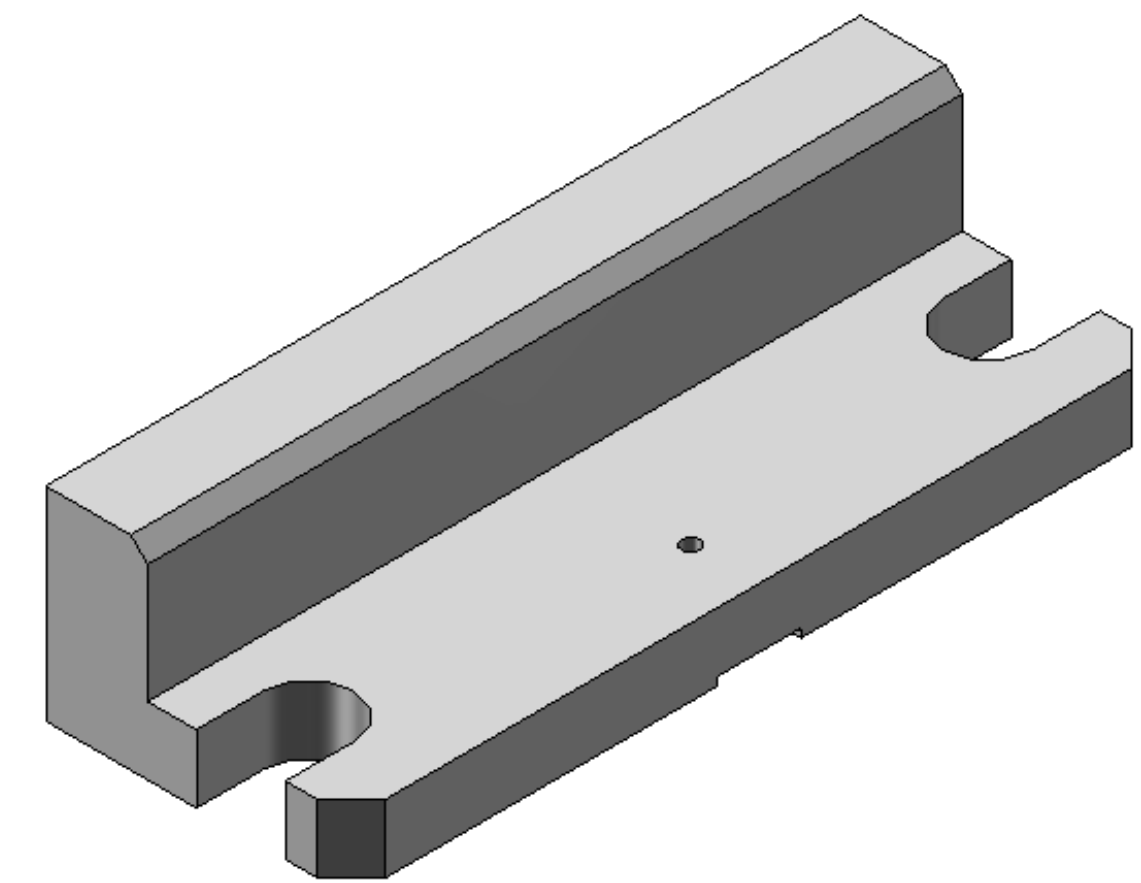
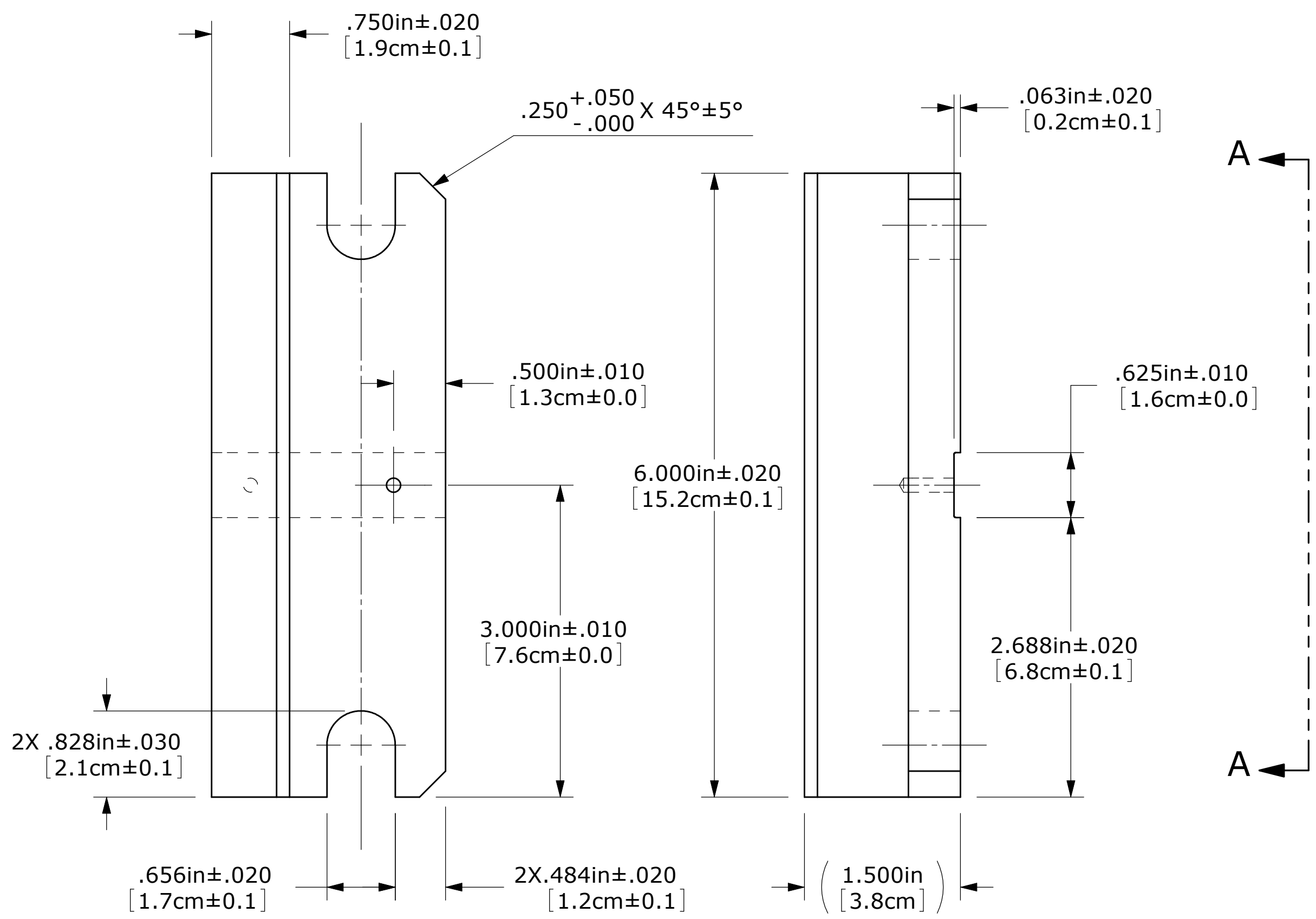
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| ITEM NO. | PART NUMBER | DESCRIPTION | REV | QTY. |
|----------|-------------|--|-----|------|
| 1 | 10066.007 | SCREW, HEX HEAD CAP CBNSTL - .500-20 THD GRADE 5, 1-3/4" IN LONG | | 1 |

| | | | | | |
|--------------------------------------|---------|--------------------------|-------|-------------------------------|--------------|
| UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | ACE Technology Company | |
| DIMENSIONS ARE IN INCHES | | DRAWN | DSLee | Franklin, NH - USA | |
| TOLERANCES: | | CHECKED | | TITLE: | |
| FRACTIONAL ± | | ENG APPR. | | SCREW, CLAMPING | |
| ANGULAR: MACH ± BEND ± | | MFG APPR. | | SIZE | DWG. NO. |
| TWO PLACE DECIMAL ± | | Q.A. | | B | 13058 |
| THREE PLACE DECIMAL ± | | COMMENTS: | | REV | 01 |
| INTERPRET GEOMETRIC TOLERANCING PER: | | Material <not specified> | | SCALE: 2:1 | WEIGHT: 0.11 |
| MATERIAL | | | | SHEET 1 OF 1 | |
| FINISH | | | | | |
| NEXT ASSY | USED ON | | | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | |

| REVISIONS | | | | |
|-----------|------|-------------|------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |
| | | | | |



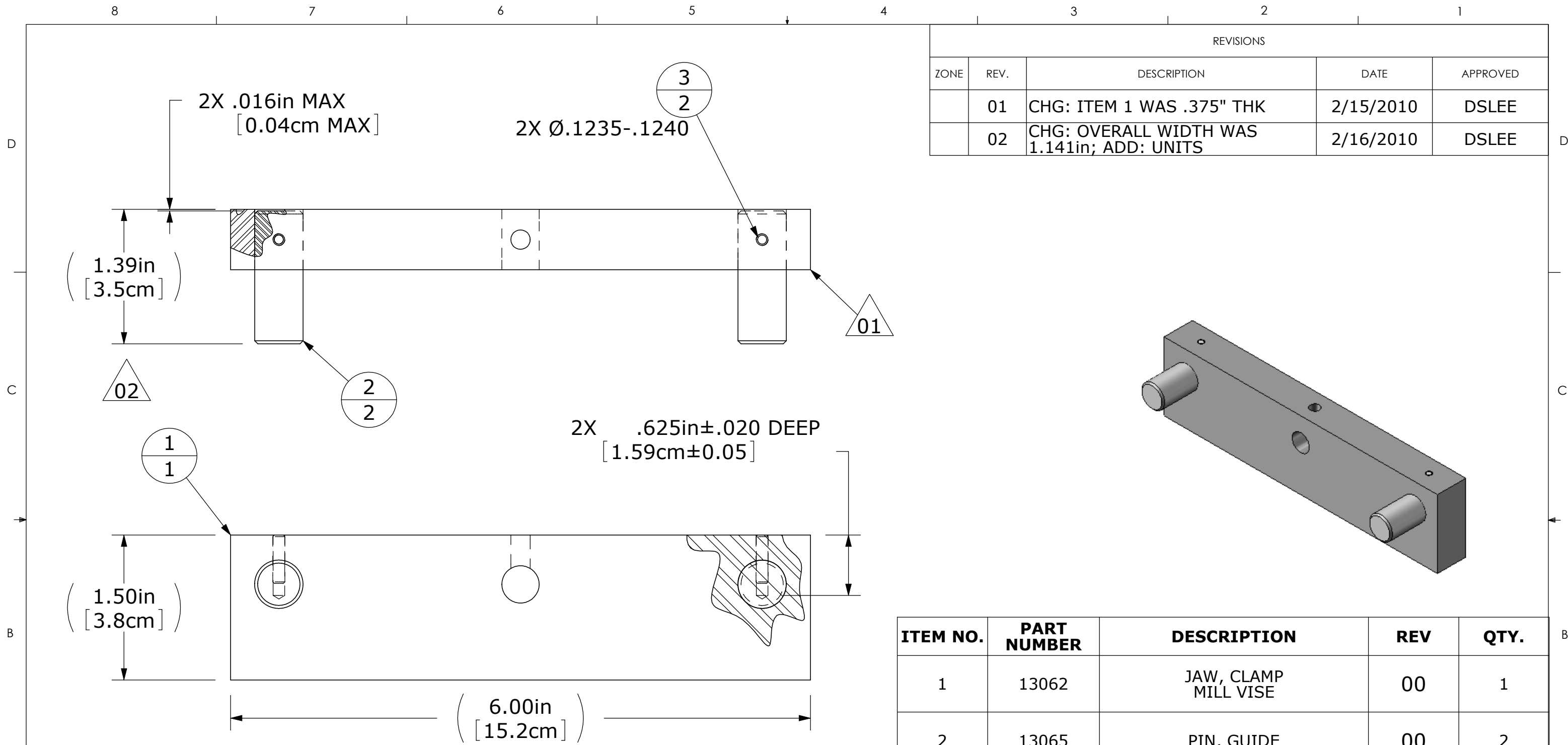
- NOTES:
1. INTERPRET DRAWING PER ANSI Y-14.5.
 2. BREAK ALL BURRS AND SHARP EDGES.
 3. MATERIAL: PER BOM
 4. FINISH: NONE.

VIEW A-A
SCALE 1 : 2

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| ITEM NO. | PART NUMBER | DESCRIPTION | REV | QTY. |
|----------|-------------|--|-----|------|
| 1 | 13059.00401 | BAR, STEEL - COLD FINISHED ASTM 1018 1.500in THK X 2.25in WIDE X 6in LONG | | 1 |

| UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | ACE Technology Company Franklin/Salisbury NH | |
|--------------------------------------|--------------------------|--------------|-------|---|-----|
| DIMENSIONS ARE IN INCHES | TOLERANCES: | DRAWN | DSLee | 2010 Feb | 07 |
| FRACTIONAL ± | ANGULAR: MACH ± BEND ± | CHECKED | | | |
| TWO PLACE DECIMAL ± | THREE PLACE DECIMAL ± | ENG APPR. | | | |
| INTERPRET GEOMETRIC TOLERANCING PER: | MATERIAL | MFG APPR. | | | |
| | Material <not specified> | Q.A. | | | |
| | | COMMENTS: | | | |
| NEXT ASSY | USED ON | | | | |
| APPLICATION | DO NOT SCALE DRAWING | | | | |
| TITLE: | | SIZE | | DWG. NO. | REV |
| BODY, CLAMP MILL VISE | | C | | 13060 | |
| SCALE: 1:1 | | WEIGHT: 3.02 | | SHEET 1 OF 1 | |



| REVISIONS | | | | |
|-----------|------|--|-----------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |
| | 01 | CHG: ITEM 1 WAS .375" THK | 2/15/2010 | DSLEE |
| | 02 | CHG: OVERALL WIDTH WAS 1.141in; ADD: UNITS | 2/16/2010 | DSLEE |

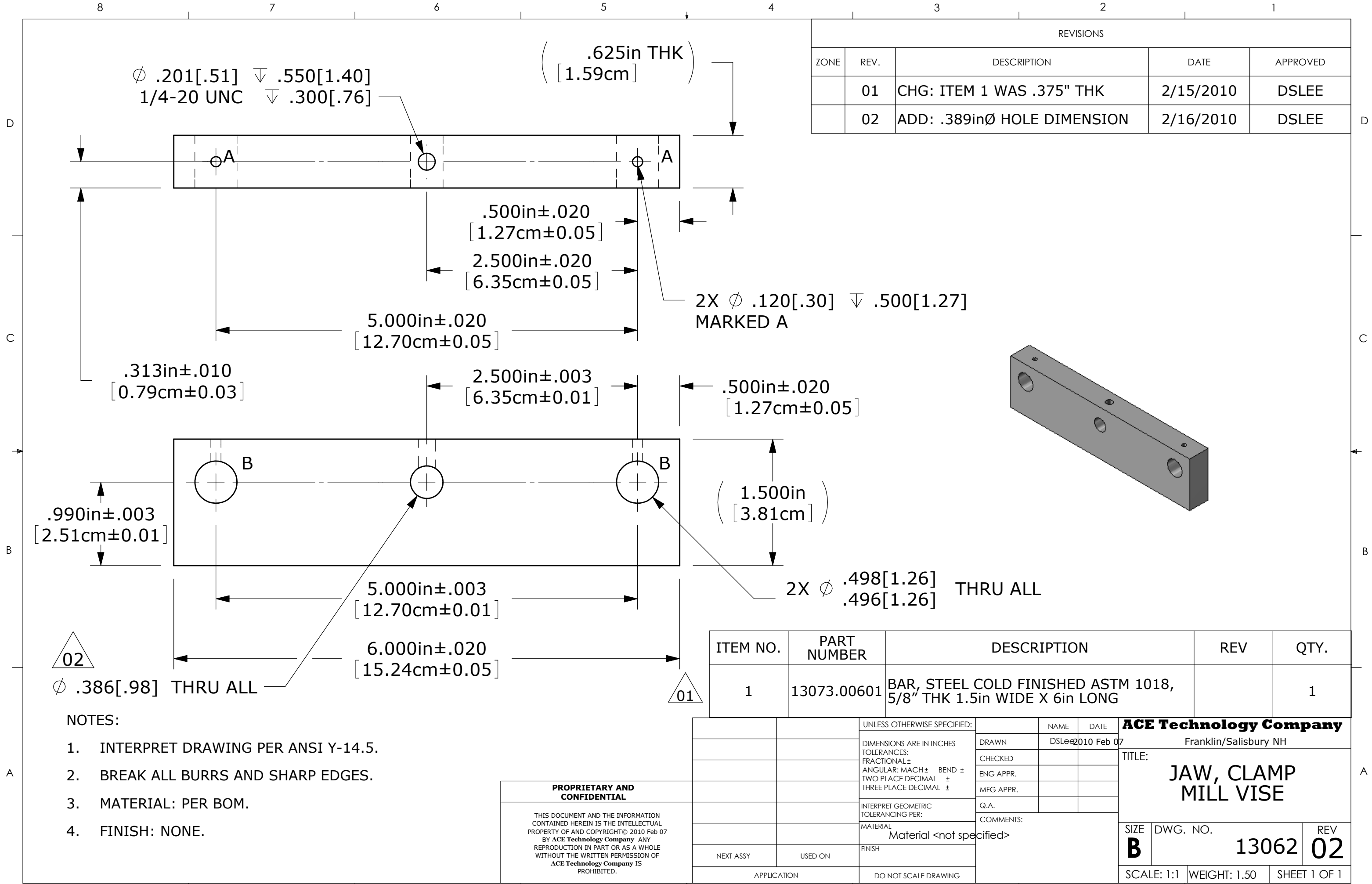
| ITEM NO. | PART NUMBER | DESCRIPTION | REV | QTY. |
|----------|-------------|----------------------|-----|------|
| 1 | 13062 | JAW, CLAMP MILL VISE | 00 | 1 |
| 2 | 13065 | PIN, GUIDE | 00 | 2 |
| 3 | 13068 | PIN, RETAINING | 00 | 2 |

- NOTES:
1. INTERPRET DRAWING PER ANSI Y-14.5.
 2. BREAK ALL BURRS AND SHARP EDGES.
 3. MATERIAL: PER BOM.
 4. FINISH: NONE.

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|--------------------------------------|---------|--------------------------|-------|----------------------------------|--------------|
| UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | ACE Technology Company | |
| DIMENSIONS ARE IN INCHES | | DRAWN | DSLee | Franklin, NH - USA | |
| TOLERANCES: | | CHECKED | | TITLE: | |
| FRACTIONAL ± | | ENG APPR. | | JAW ASSY, CLAMP MILL VISE | |
| ANGULAR: MACH ± BEND ± | | MFG APPR. | | SIZE | DWG. NO. |
| TWO PLACE DECIMAL ± | | Q.A. | | B | 13066 |
| THREE PLACE DECIMAL ± | | COMMENTS: | | REV | 02 |
| INTERPRET GEOMETRIC TOLERANCING PER: | | Material <not specified> | | SCALE: 1:1 | WEIGHT: 1.66 |
| NEXT ASSY | USED ON | FINISH | | SHEET 1 OF 1 | |
| APPLICATION | | DO NOT SCALE DRAWING | | | |



| REVISIONS | | | | |
|-----------|------|-----------------------------|-----------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |
| | 01 | CHG: ITEM 1 WAS .375" THK | 2/15/2010 | DSLEE |
| | 02 | ADD: .389inØ HOLE DIMENSION | 2/16/2010 | DSLEE |

| ITEM NO. | PART NUMBER | DESCRIPTION | REV | QTY. |
|----------|-------------|--|-----|------|
| 1 | 13073.00601 | BAR, STEEL COLD FINISHED ASTM 1018, 5/8" THK 1.5in WIDE X 6in LONG | | 1 |

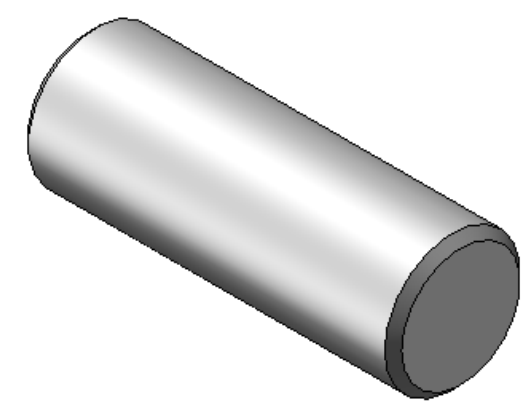
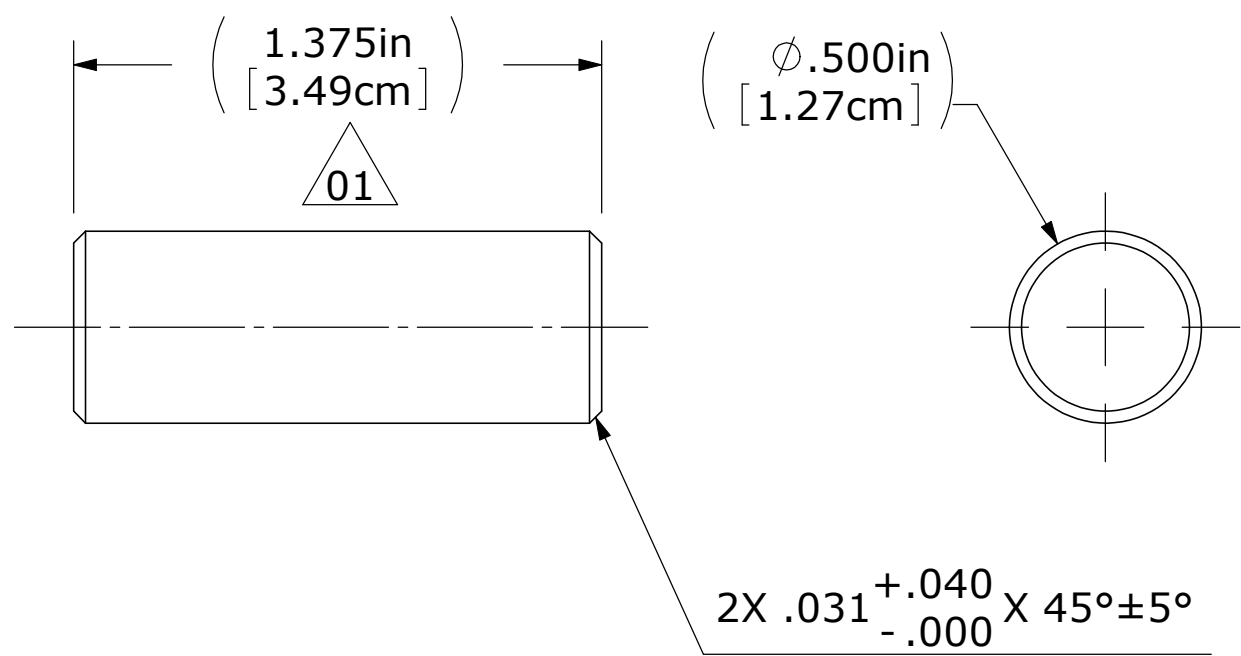
| | | | | |
|---|---------|-----------|-------------------|--|
| UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | ACE Technology Company Franklin/Salisbury NH |
| DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ± | | DRAWN | DSLee 2010 Feb 07 | |
| INTERPRET GEOMETRIC TOLERANCING PER: | | CHECKED | | TITLE: JAW, CLAMP MILL VISE |
| MATERIAL Material <not specified> | | ENG APPR. | | |
| FINISH | | MFG APPR. | | SIZE B DWG. NO. 13062 REV 02 |
| NEXT ASSY | USED ON | Q.A. | | SCALE: 1:1 WEIGHT: 1.50 SHEET 1 OF 1 |
| APPLICATION | | COMMENTS: | | |
| DO NOT SCALE DRAWING | | | | |

- NOTES:
1. INTERPRET DRAWING PER ANSI Y-14.5.
 2. BREAK ALL BURRS AND SHARP EDGES.
 3. MATERIAL: PER BOM.
 4. FINISH: NONE.

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| REVISIONS | | | | |
|-----------|---------------------------------|-----------|----------|------|
| REV. | DESCRIPTION | DATE | APPROVED | ZONE |
| 01 | CHG: OVERALL LENGTH WAS 1.125in | 2/16/2010 | DSLEE | |



NOTES:

1. INTERPRET DRAWING PER ANSI Y-14.5.
2. BREAK ALL BURRS AND SHARP EDGES.
3. MATERIAL: PER BOM
4. FINISH: NONE

01

| ITEM NO. | PART NUMBER | DESCRIPTION | REV | QTY. |
|----------|-------------|---|-----|------|
| 1 | 13064.004 | A-2 Drill Rod, .500 ±.001inØ X 1.375in LONG | | 1 |

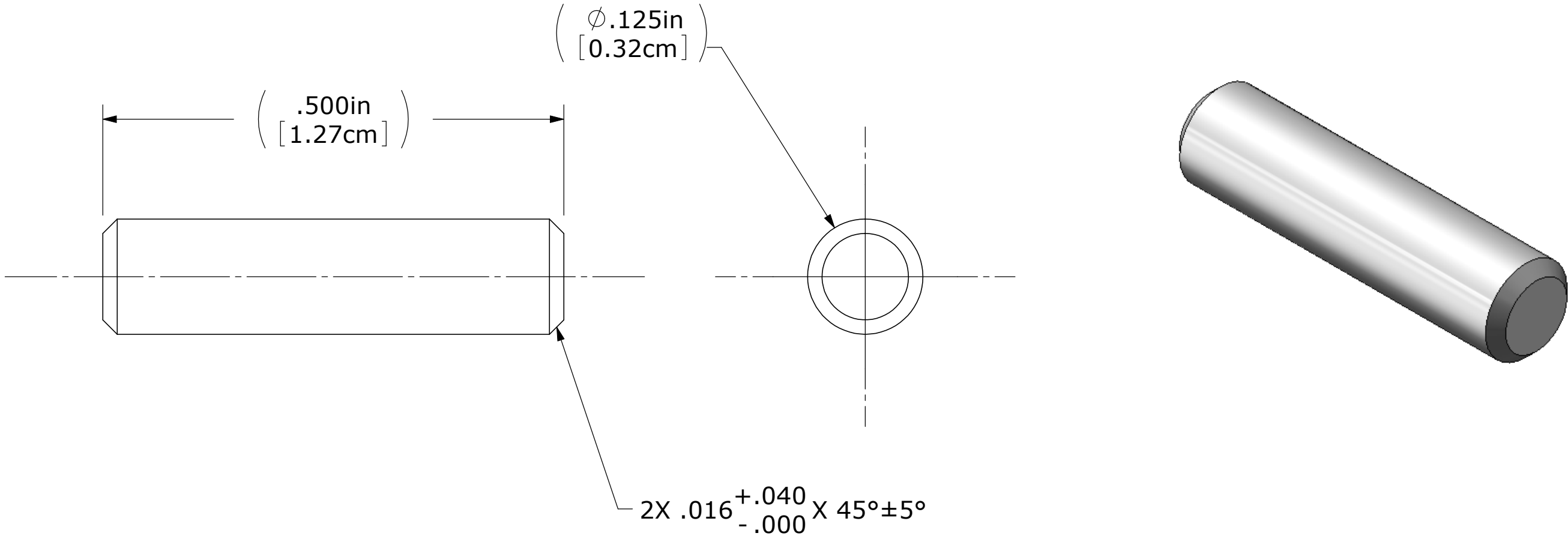
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|--------------------------------------|---------|--------------------------|-------|-------------------------------|--|
| UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | ACE Technology Company | |
| DIMENSIONS ARE IN INCHES | | DRAWN | DSLee | Franklin, NH - USA | |
| TOLERANCES: | | CHECKED | | TITLE: PIN, GUIDE | |
| FRACTIONAL ± | | ENG APPR. | | SIZE B | |
| ANGULAR: MACH ± BEND ± | | MFG APPR. | | DWG. NO. 13065 | |
| TWO PLACE DECIMAL ± | | Q.A. | | REV 01 | |
| THREE PLACE DECIMAL ± | | COMMENTS: | | SCALE: 2:1 | |
| INTERPRET GEOMETRIC TOLERANCING PER: | | Material <not specified> | | WEIGHT: 0.08 | |
| MATERIAL | | | | SHEET 1 OF 1 | |
| FINISH | | | | | |
| NEXT ASSY | USED ON | | | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | |

8 7 6 5 4 3 2 1

| REVISIONS | | | | |
|-----------|------|-------------|------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |



NOTES:

1. INTERPRET DRAWING PER ANSI Y-14.5.
2. BREAK ALL BURRS AND SHARP EDGES.
3. MATERIAL: PER BOM.
4. FINISH: NONE.

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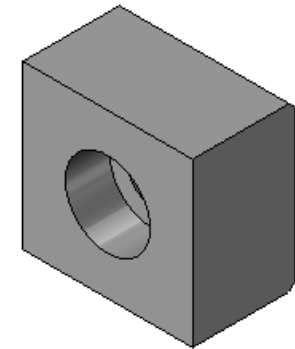
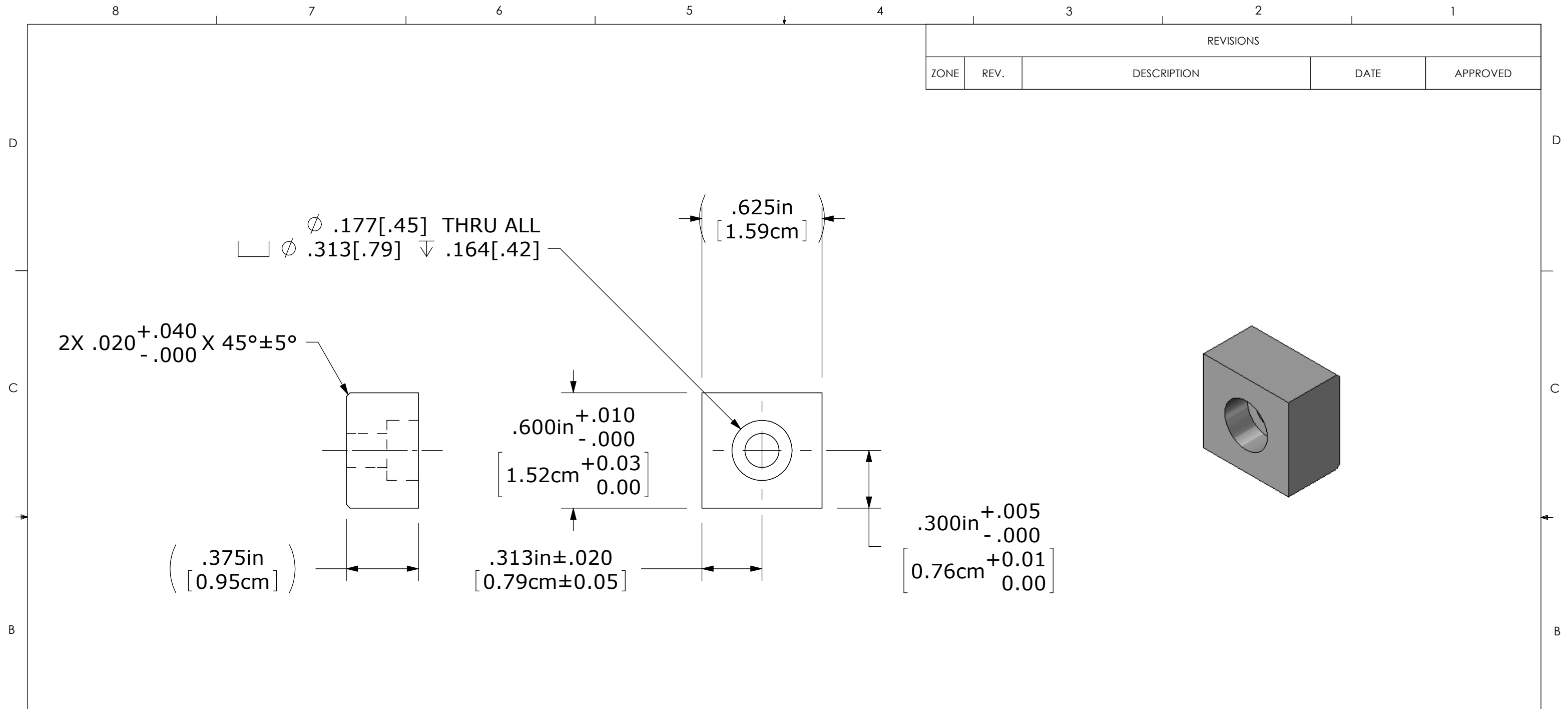
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| ITEM NO. | PART NUMBER | DESCRIPTION | REV | QTY. |
|----------|-------------|--|-----|------|
| 1 | 13067.004 | BAR, A2 DRILL ROD .125in ±.0005Ø X 0.5in LONG | | 1 |

| | | | | |
|--------------------------------------|---------|--------------------------|-------------|---|
| UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | ACE Technology Company Franklin, NH - USA TITLE: PIN, RETAINING SIZE B DWG. NO. 13068 REV SCALE: 8:1 WEIGHT: 0.00 SHEET 1 OF 1 |
| DIMENSIONS ARE IN INCHES | | DRAWN | DSLee | |
| TOLERANCES: | | CHECKED | 2010 Feb 08 | |
| FRACTIONAL ± | | ENG APPR. | | |
| ANGULAR: MACH ± BEND ± | | MFG APPR. | | |
| TWO PLACE DECIMAL ± | | Q.A. | | |
| THREE PLACE DECIMAL ± | | COMMENTS: | | |
| INTERPRET GEOMETRIC TOLERANCING PER: | | Material <not specified> | | |
| MATERIAL | | | | |
| FINISH | | | | |
| NEXT ASSY | USED ON | | | |
| APPLICATION | | DO NOT SCALE DRAWING | | |

8 7 6 5 4 3 2 1

| REVISIONS | | | | |
|-----------|------|-------------|------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |
| | | | | |



NOTES:

1. INTERPRET DRAWING PER ANSI Y-14.5.
2. BREAK ALL BURRS AND SHARP EDGES.
3. MATERIAL: PER BOM
4. FINISH: NONE

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| ITEM NO. | PART NUMBER | DESCRIPTION | REV | QTY. |
|----------|-------------|--|-----|------|
| 1 | 13061.00301 | BAR, STEEL COLD FINISHED ASTM 1018, 3/8" THK 0.625in WIDE X 0.625in LONG | | 1 |

| | | | | | |
|--------------------------------------|---------|----------------------|-------|-------------------------------|--------------|
| UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | ACE Technology Company | |
| DIMENSIONS ARE IN INCHES | | DRAWN | DSLee | Franklin, NH - USA | |
| TOLERANCES: | | CHECKED | | TITLE: | |
| FRACTIONAL ± | | ENG APPR. | | KEY, VISE LOCK | |
| ANGULAR: MACH ± BEND ± | | MFG APPR. | | SIZE | DWG. NO. |
| TWO PLACE DECIMAL ± | | Q.A. | | B | 13070 |
| THREE PLACE DECIMAL ± | | COMMENTS: | | REV | |
| INTERPRET GEOMETRIC TOLERANCING PER: | | | | SCALE: 4:1 | WEIGHT: 0.03 |
| MATERIAL | | | | SHEET 1 OF 1 | |
| FINISH | | | | | |
| NEXT ASSY | USED ON | | | | |
| APPLICATION | | DO NOT SCALE DRAWING | | | |