



Moxon Vise 77E48

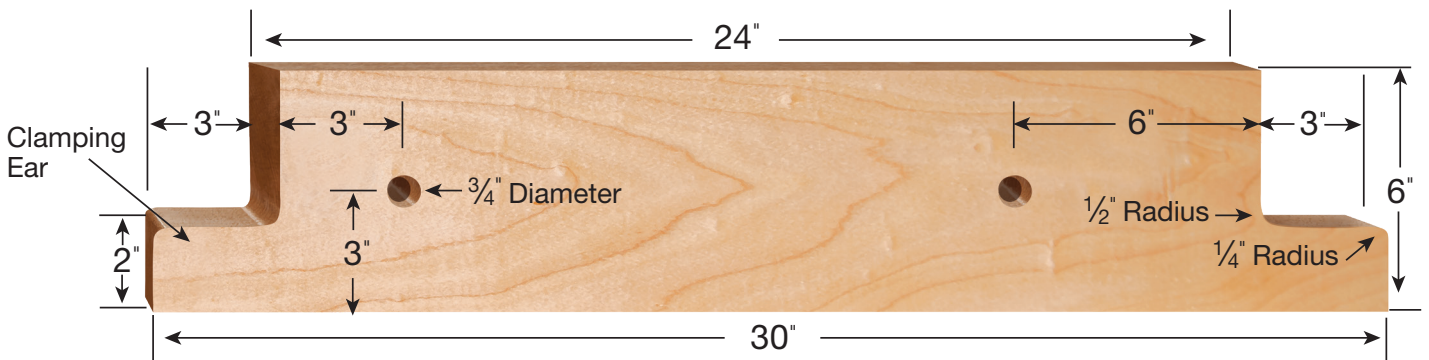
Parts List:

- (2) 5" Hand Wheels
- (2) $\frac{3}{4}$ " x 8" Acme Threaded Screws
- (4) Acme Threaded Nuts
- (4) Washers

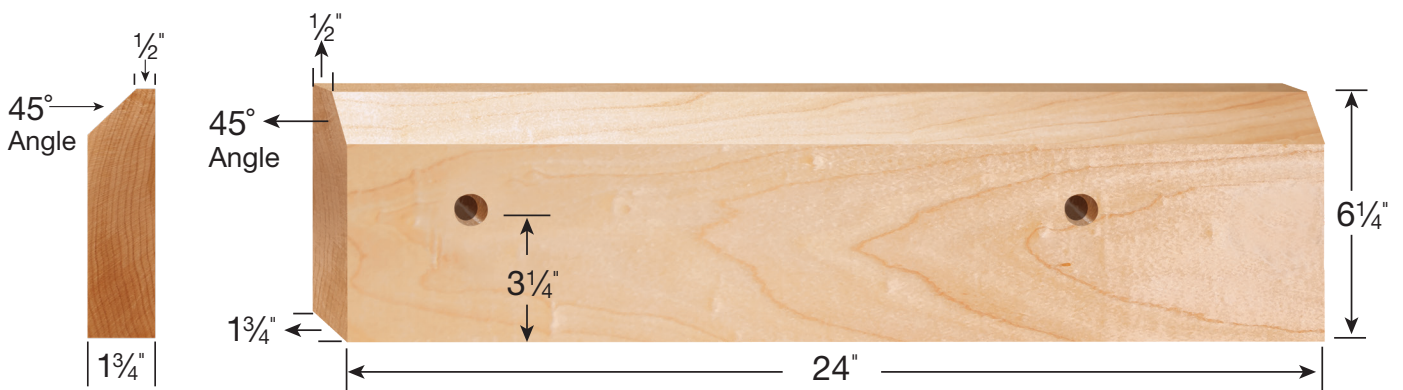


A Moxon vise can be designed many ways; this is just one example. Things to consider when building your vise are: overall length and height, distance between screws, how the vise will be used, and how the vise will be secured to your bench.

Rear Jaw



Front Jaw



Options For Securing The Vise To Your Bench:

- Clamping ears (as shown in our example) – You may also choose not to cut these ears out at all and leave the rear jaw the complete width.
- Clamping holes in the rear jaw – Leaving the rear jaw the complete width, don't cut out the ears and instead drill holes for the clamps you would like to use.
- Add another piece of wood to the back of the rear jaw for the bench dogs or holdfasts to clamp onto.

Bench Dogs



Holdfasts



Clamps



Example Details:

- The front jaw is $\frac{1}{4}$ " wider at the bottom than the rear jaw. This is so you can register the vise onto the edge of your bench. The front jaw should not sit on the bench.
- The $\frac{3}{4}$ " holes for the Acme screws are centered on the width of the rear jaw. One hole is 3" in from the left end of the front jaw, while the right hole is 6" in from the right end of the front jaw. Having the hole farther in from the end allows the user to insert a longer workpiece into the vise from the end rather than inserting it from the top. Drill the jaws one at a time, and use the holes of the first jaw to mark the location of the holes on the second jaw. Or drill them together if you can. The holes on the front jaw can be elongated to allow the clamping of tapered parts and to help eliminate binding when opening and closing the vise.




- The 8" Acme screws are held to the rear jaw with two nuts and two washers on the back side and two nuts mortised into the inside face of the rear jaw. This mortise can just be a counterbore with a

larger forstner bit, or you can scribe the hex shape of the nut and make a perfect fit. The hex shape mortise will make it easier to tighten the rear nut and secure the screws. Either way, be sure to mortise deep enough that the nut is completely below the surface.



- The top front edge of the front jaw is beveled at 45° to give clearance for handsaws.
- Final assembly is done by securing the rear jaw to your bench as it would be in use. Slide the front jaw onto the Acme screws. Place the remaining two washers onto the screws. Last, thread the two hand wheels onto the screws.

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