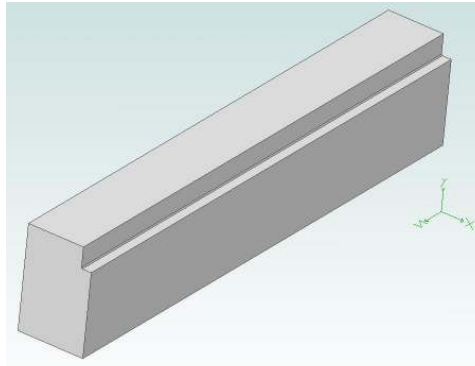


# Softjaw with Pad Separation

By R. G. Sparber

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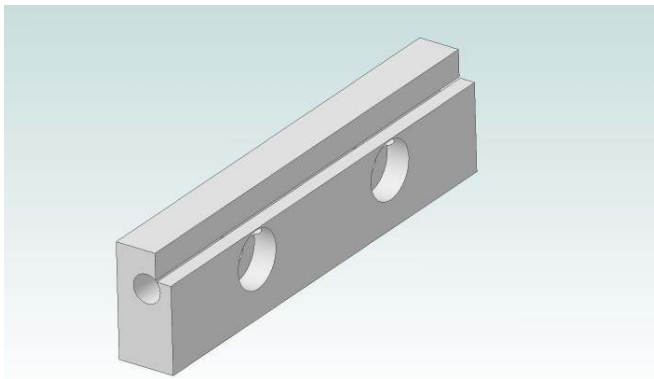
I usually align my vise jaw mounted softjaws by taking a light clean up cut with an end mill. I mill across the horizontal and vertical surfaces at the same time. The problem with just doing this is that the inside corner has no relief.



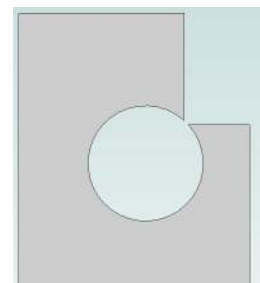
If I then clamp a block with a square corner, it will hang up in

the softjaw's inside corner and not properly contact my reference surfaces.

One solution is to use a hacksaw to cut into the inside corner to create relief. This works but is awkward. Depending on how deep you cut, you may have to do more sawing after future clean up cuts.



A solution I used on my new vise's softjaws was to first drill a hole in the end that goes the length of the block. Then I milled my horizontal and vertical



surfaces. Repeated clean up cuts cause the corner relief to get larger, rather than smaller as with the saw cut.

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