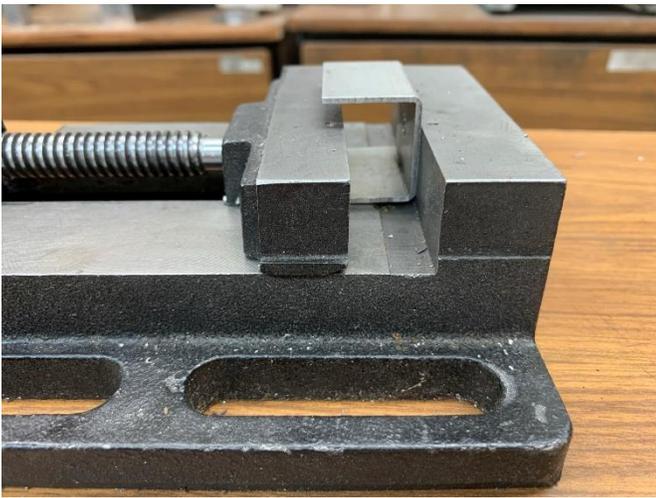


Drill Press Vise Attachment for Drilling Channel and Angle, Version 1.1

By **R. G. Sparber**

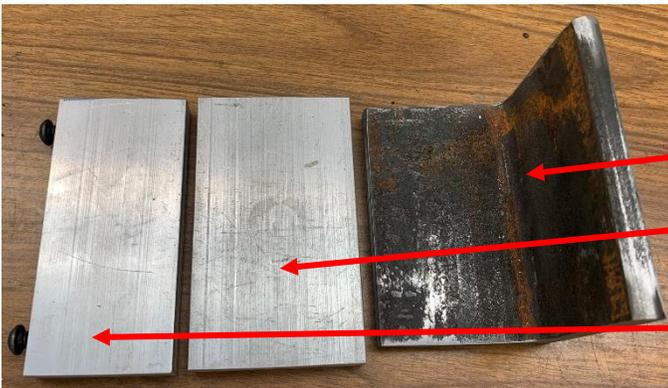
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A video demonstrating this attachment can be found [here](#).



Drilling the outside of a piece of channel can be difficult. The jaws barely clamp one side of the channel, and there is no support for the other side. Typically, the piece jumps out of the vise.

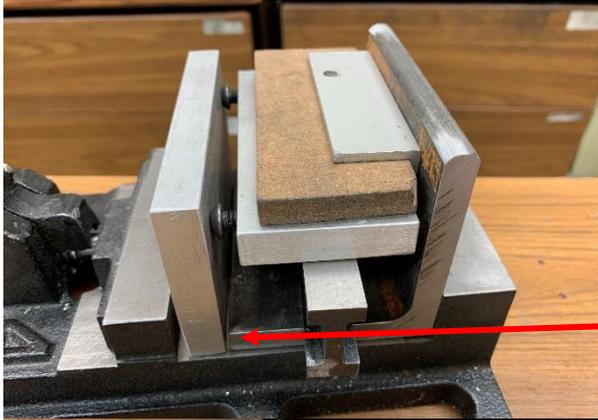
The attachment presented here securely holds a wide range of channels plus angle stock.



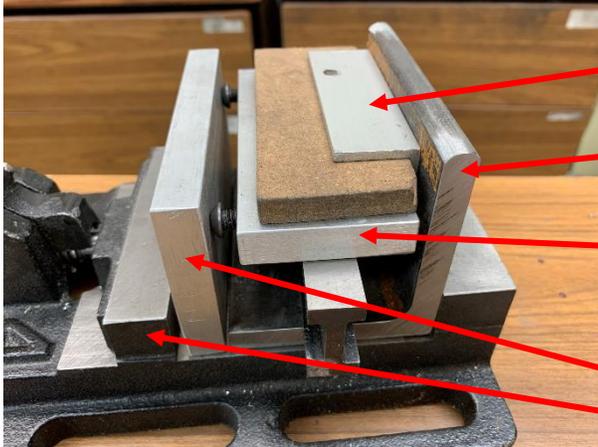
The attachment consists of three parts.

A fixed jaw,
a pivoting jaw,
and a plate that I call my horizontal jaw.

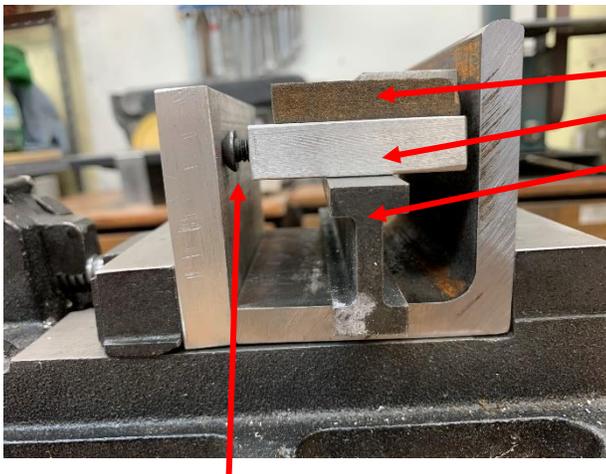
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The fixed jaw was trimmed down so it would fit in the vise when fully opened.



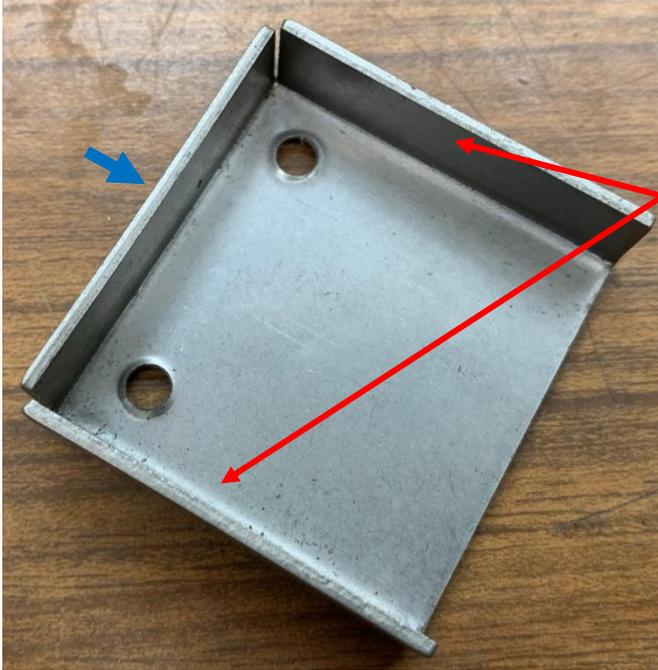
The stock is clamped between the fixed jaw and the horizontal jaw, which is backed up by the pivoting jaw, which, in turn, is pushed on by the vise's movable jaw.



The packing protects the Horizontal jaw and they are supported by a parallel.

Notice that there is no limitation on the length of the stock because the ends are open.

I have found that stock between 0.05 inches and 0.1 inches can be clamped with the same height of the two jackscrews. If the pivoting jaw tilts excessively, these screws can be turned in or out to accommodate.



Clamping parts like this is also possible. The horizontal jaw and packing go inside when drilling one of the flanks.

If drilling the end flap (blue arrow), I can just put it into my vise without the attachment.

I welcome your comments and questions.

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