

Firearm Workholding Solutions



Workholding Evolved.

Key Features

| Industry trusted workholding solutions

| Fit more parts on your machine

| Reduce setup and changeover time

| Solutions available for 3, 4 & 5 axis machines

| Repeatability less than 8 μ m

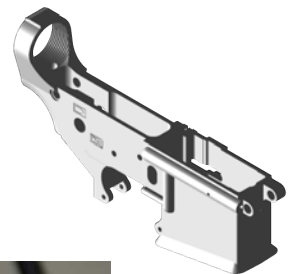
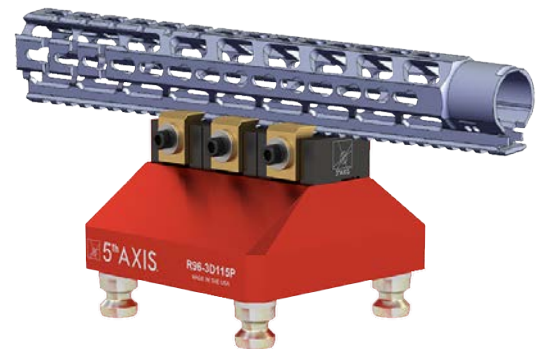
MORE PARTS. MORE PROFIT.

Fit more vises on your machine table and watch your parts per cycle soar.

5th Axis designs and manufactures workholding solutions trusted by the firearm industry. 5th Axis customers rely on our high-precision vises, fixtures, and quick-change systems for manufacturing handguards, upper receivers, lower receivers, rail sections, and more.

All 5th Axis vises feature 45° dovetails for superior workholding. 5th Axis provides double station vises, called the Deuce, for larger firearm components and dual station Pin Vises for smaller accessories.

5th Axis also supplies RockLock quick-change systems with standard mounting patterns that allow operators to easily move vises, fixtures, and tooling from machine to machine with no setup time.



Machinable jaws available for second operations.







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Technical Specifications

High precision, versatile visers reliably accommodate complex operations.

Our double station Deuce visers feature a low profile design and a small footprint. The compact design allows you to fit more visers on your table, making your existing equipment more efficient by running multiple parts per cycle. Outfitted with dovetail jaws, Deuce visers reliably clamp upper receivers, handguards, and other components on various machine models.

Part Number	DV75150X-J1	DV56-J1	DV510-J1	DV510-J4
				
Size	75mm x 150mm x 56mm [2.95" x 5.91" x 2.2"]	125.7mm x 152.4mm x 72.9mm [4.95" x 6" x 2.87"]	125.7mm x 258.3mm x 73.4mm [4.95" x 10.17" x 2.89"]	125.7mm x 258.3mm x 73.4mm [4.95" x 10.17" x 2.89"]
Jaw Type	Hardened Steel 3 Piece Master Jaw Set Serrated / 45° Dovetail	Hardened Steel 3 Piece Master Jaw Set Serrated / 45° Dovetail	Hardened Steel 3 Piece Master Jaw Set with 2" Center Serrated / 45° Dovetail	Hardened Steel 3 Piece Master Jaw Set with 1" Center Serrated / 45° Dovetail
Jaw Width	75mm [2.95"]	125.7mm [4.95"]	125.7mm [4.95"]	125.7mm [4.95"]
Clamping Force	13.5 kN @ 60 Nm	13.5 kN @ 60 Nm	13.5 kN @ 60 Nm	13.5 kN @ 60 Nm
Max Torque	60 Nm	75 Nm	75 Nm	75 Nm
Forward Clamping Range	0 - 37.02mm [0 - 1.46"]	0 - 28.5mm [0 - 1.12"]	0 - 66.7mm [0 - 2.63"]	0 - 79.4mm [0 - 3.13"]
Reverse Clamping Range	17.26mm - 55.02mm [.68" - 2.17"]	31.0mm - 64.2mm [1.22" - 2.53"]	30.9mm - 102.3mm [1.22" - 4.03"]	30.9mm - 115mm [1.22" - 4.53"]
Single Station Forward Clamping Range	N/A	0 - 75.9mm [0 - 2.99"]	0 - 177.5mm [0 - 6.99"]	0 - 177.5mm [0 - 6.99"]
Single Station Reverse Clamping Range	N/A	56.8mm - 147.3mm [2.24" - 5.8"]	56.8mm - 248.7mm [2.24" - 9.79"]	56.8mm - 248.7mm [2.24" - 9.79"]



DV75150X-J1 shown on the RL96A-3613S1 base plate.



Deuce Visers



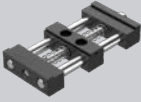
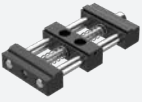


Double Station Pin Vises & Dovetail Fixtures

Technical Specifications

High precision, quality vises in a skeleton design make them lighter, more compact, and cost effective.

Ideal for high volume part production, Pin Vises have a small footprint, allowing more parts on a table for higher productivity. Pin Vises are also lightweight for automated applications using low payload robots. Pin Vises with picatinny jaws are used for smaller gun components such as rail sections, finger grips, hand grips, QD slings, etc.

Part Number	PV3X-4A	PV3X-4B	PV3X-6A	PV3X-6B
				
Size	75mm x 111.6mm x 25mm [2.95" x 4.39" x 0.98"]	75mm x 111.6mm x 25mm [2.95" x 4.39" x 0.98"]	75mm x 161.6mm x 25mm [2.95" x 6.36" x 0.98"]	75mm x 161.6mm x 25mm [2.95" x 6.36" x 0.98"]
Jaw Width	75mm [2.95"]	75mm [2.95"]	75mm [2.95"]	75mm [2.95"]
Clamping Range	19.05mm - 38.10 mm [0.75" - 1.50"]	6.35mm - 25.40mm [0.25" - 1.00"]	150: 44.45mm - 63.50mm [1.75" - 2.50"]	150: 31.75mm - 50.80mm [1.25" - 2.00"]
			130: 31.75mm - 50.80mm [1.25" - 2.00"]	130: 19.05mm - 38.10mm [0.75" - 1.50"]
			100: 19.05mm - 38.10mm [0.75" - 1.50"]	100: 6.35mm - 25.40mm [0.25" - 1.00"]

*PVX3-6A & PVX3-6B pin vises come with three different bolt lengths to provide different clamping range options.

Part Number	D115P	R96-3D115
		
Size	38.1mm x 58.4mm x 38.1mm [1.5" x 2.3" x 1.5"]	125.7mm x 125.7mm x 76.2mm [4.95" x 4.95" x 3"]
Material	4100 Series Steel	4100 Series Steel
Dovetail Depth Required	Picatinny	Picatinny

Compact dovetail holders with Picatinny interface.

5th Axis supplies dovetail holders specifically for the firearm industry. These compact units are ideal for running upper receivers or any accessory that features a Picatinny.

5th Axis D115P dovetail fixtures are designed for 3, 4 and 5 axis machines. They feature a low profile design to optimize tool clearance and minimize second operation cleanup: saving time, cost, and material.



Technical Specifications

5th Axis tombstones and fixture mounts use our patented RockLock quick-change systems.

RockLock quick-change systems from 5th Axis provide a standard mounting pattern that allows users to easily transfer fixtures holding firearm components between jobs with little to no setup time. Built to fit multiple machines, RockLock systems feature a patented free-float design that ensures equal force on all 4 pull studs, guaranteeing repeatability of less than .0003" (8 microns).

Part Number	R96-V75XT4	RL96A-3002 RL96S-3002	RL96A-3003 RL96S-3003	RL96A-4004	RL96A-90DEG
					
Size mm [in]	125.7 x 125.7 x 199.5 [4.95 x 4.95 x 7.85]	300.0 x 300.0 x 400.0 [11.81 x 11.81 x 15.75]	300.0 x 300.0 x 400.0 [11.81 x 11.81 x 15.75]	230mm x 230mm x 600mm [9 x 9 x 23.6]	149.4 x 156.0 x 200.0 [5.88 x 6.14 x 7.87]
Number of Positions	8 total, 2 per side	4 total, 2 per side	6 total, 2 per side	12 total, 3 per side	1 (Right Angle Plate)
Material	Aluminum	Aluminum (RL96A-3002) or 1018 Steel (RL96S-3002)	Aluminum (RL96A-3003) or 1018 Steel (RL96S-3003)	Aluminum	Aluminum (RL96A-90DEG)
Compatible Pull Studs	4x PS20F (Included)	Machine Specific*	Machine Specific*	Machine Specific*	4x PS20F (Included) or 2x M12 SHCS @ 100mm - 101.6mm (4")

*Submit table drawing upon inquiry.



Made in USA



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