

Bench Vice Soft Jaws Procedure and video link

<https://holbrooktech.weebly.com/soft-jaws.html>

Steps - See instructional video for complete directions for the how to use tools/machines to complete this simple sheet metal project

Video Link:

<https://youtu.be/ITSxgL2A5Kg>

Material Needed: Sheet metal 5.75" x 2.5" (2 pieces if you are making a set). The video shows using 24-gauge thick sheet metal.

- 1) Cut out sheet metal to size (5.75" x 2.5") on the foot shear.
- 2) Layout lines on your metal to match the drawings. You should use a scribe to 'scratch' the lines for the most accurate layout. No hand sketched lines. All should be straight and done with layout tools.
- 3) Punch small holes (1/8") on the whitney punch where the angles meet
- 4) Cut angles using tin snips or aviation snips
- 5) File edges or burs so there are no sharp edges. Use letter punches to add your initials to one of the outer tabs.
- 6) Set up the Di-Acro Finger Brake for bending
 - use the 3" and 1 1/4" fingers together to create a 4 1/4" wide finger (See demo for installation)
- 7) Bend tabs at 90 degrees first
- 8) Bend center line 90 degrees. Sand and finalize for marking.

