

TIP 22 — Magnetic Mill Vise Jaws/Steve Houtchen

Tired of your parallels falling over while you are trying to clamp a part in your mill vise? Steve Houtchen of Dayton, Ohio came up with a solution. He purchased four rare earth magnets at Radio Shack (P/N 64-1895, \$1.59 for 2). They have a specified size of .197" diameter by .059" thick. Steve bored two holes in each vise jaw directly under the existing screw mounting holes. He placed the bottom of the magnet hole 1/16" from the bottom of the jaw so they would be about centered on the parallel. He bored the holes to exact size and .0625" deep and pressed in the magnets. He now recommends using a little glue to make sure the magnets stay in the jaw. Now his parallels stay tight against the vise jaws during setup.