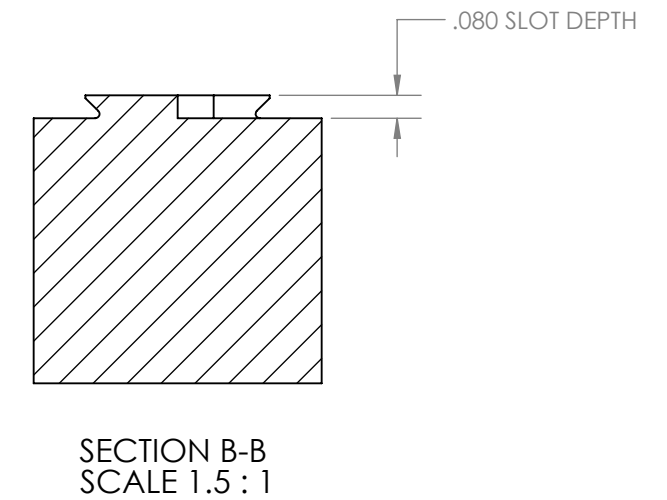
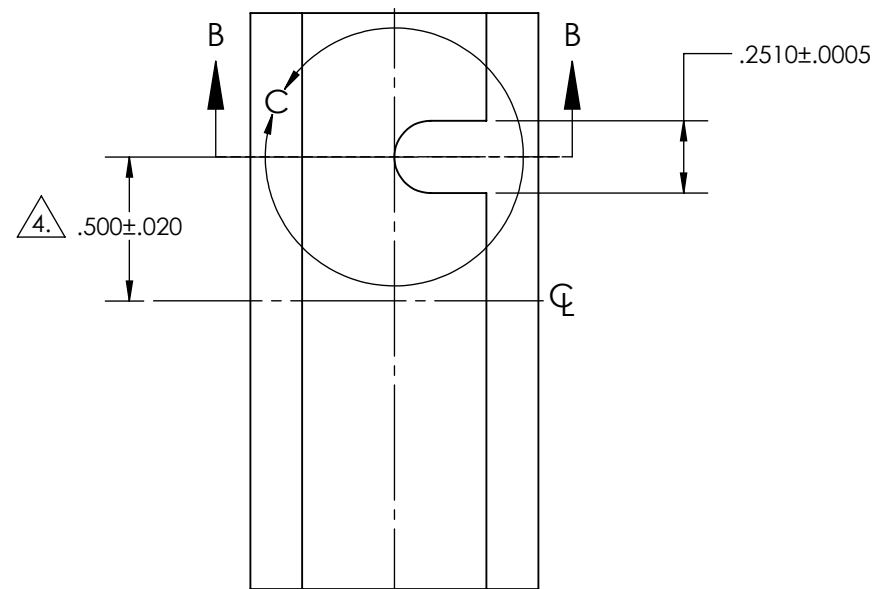
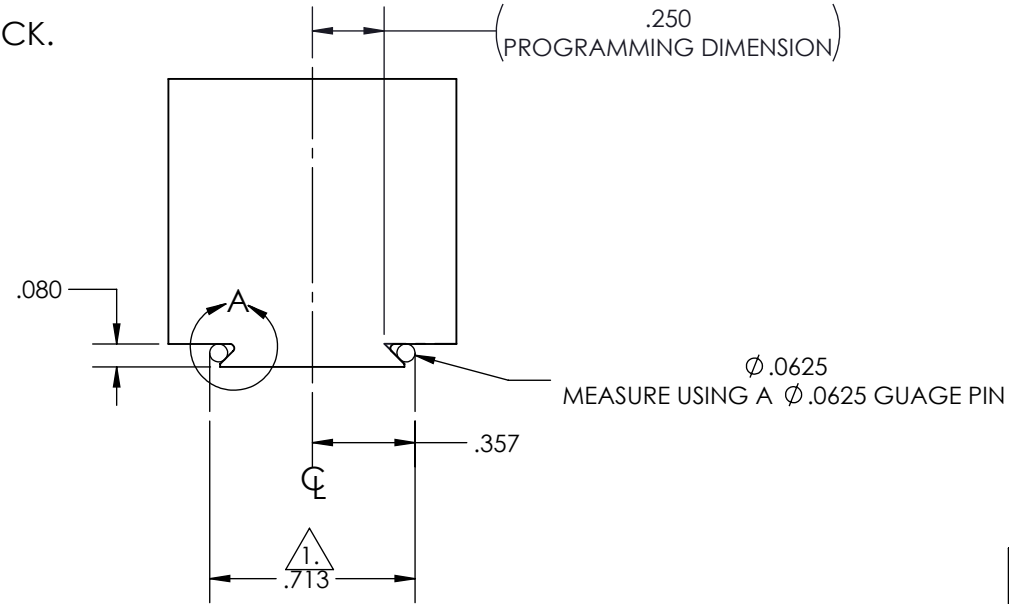
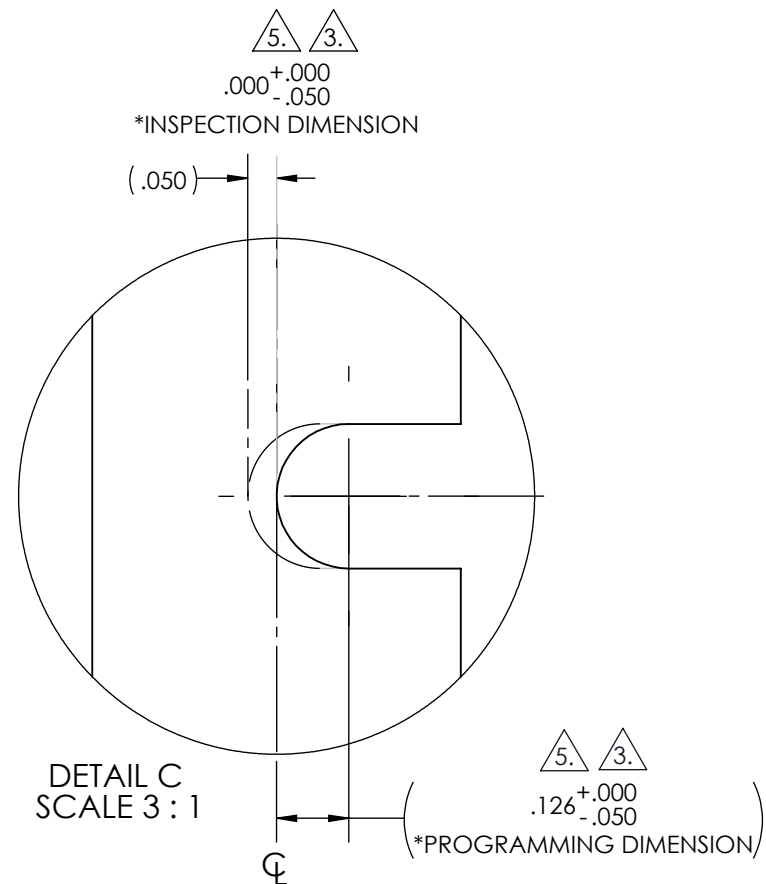
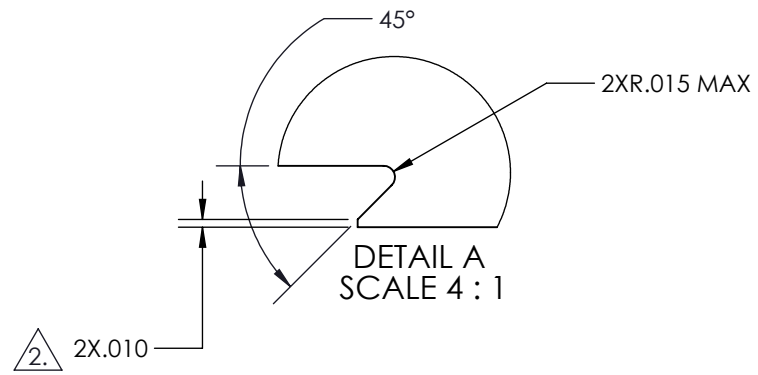


NOTES:

1. DOVETAIL WIDTH WILL NOT CHANGE WITH VARYING DOVETAIL DEPTH.
2. MACHINE EDGE BREAK ON DOVETAIL POINT.
3. SLOT DIMENSION TO THE CENTERLINE IS **CRITICAL**, IF DIMENSION IS TOO LARGE, STOCK MAY REST AGAINST LOCATING PIN INSTEAD OF DOVETAIL CUT SURFACES.
4. IF STOCK IS OVERSIZE, THIS TOLERANCE INCREASES BY HALF OF THE EXTRA STOCK.
5. PIN SLOT RADIUS SHOULD BE TANGENT TO CENTERLINE OR PAST CENTERLINE.

D115 DOVETAIL STOCK PREPARATION



TOLERANCES	
METRIC	INCH
X ± 1.0	X ± 0.1
.X ± 0.3	.X ± 0.05
.XX ± 0.13	.XX ± 0.01
	.XXX ± 0.005
UNLESS OTHERWISE NOTED	
ANGULAR DIMENSIONS ± 0.5°	

INCH
PROPRIETARY AND CONFIDENTIAL
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF FIFTH AXIS, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF FIFTH AXIS, INC. IS PROHIBITED.

APPROVALS	
DRAWN BY	C BANKS 5/3/2018
MFG. ENG.	
QA ENG.	
ENG. MGR.	
MATERIAL:	
FINISH:	
WEIGHT:	



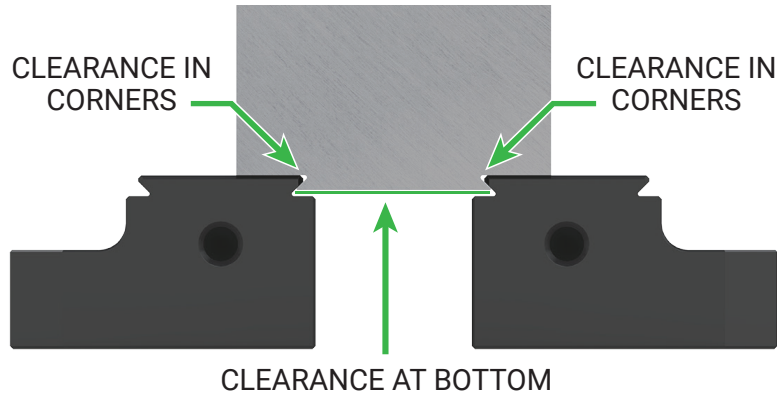
CUSTOMER	
DESCRIPTION	D115 DOVETAIL STOCK PREP
SIZE	B
PART NO.	DSP-D115
SCALE	SCALE 1:1
DO NOT SCALE DRAWING	
SHEET	1 OF 1

REV **A**



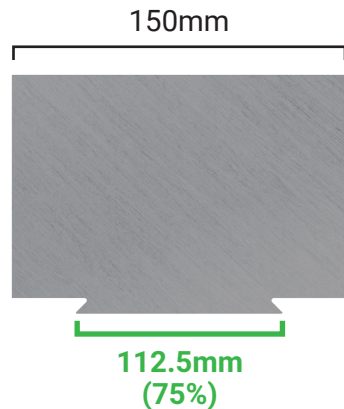
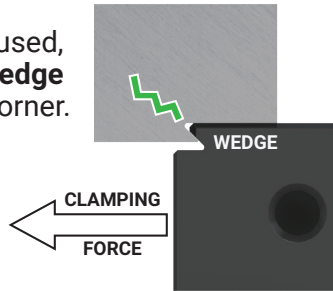
PROPER DOVETAIL

MATERIAL SHOULD REST ON TOP OF THE JAW / FIXTURE AND ON THE 45° FACE.



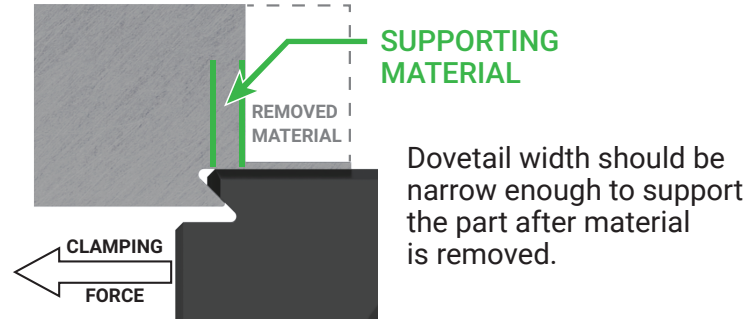
When a **proper** dovetail is used, jaw/dovetail fixture **acts as a wedge** trying to split the material in the corner.

Material is clamped only once or twice and is therefore resistant to fracturing.

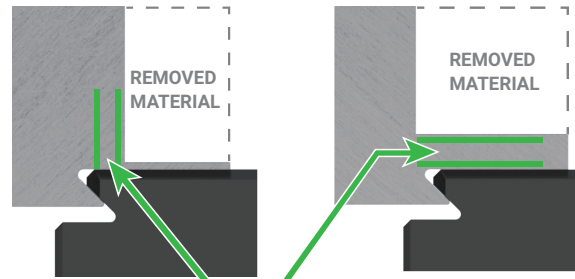


We recommend dovetail width should not be **less than** 75% of the width of the stock.

This is a **general ratio, not a rule.** If in doubt, stick to 75%.

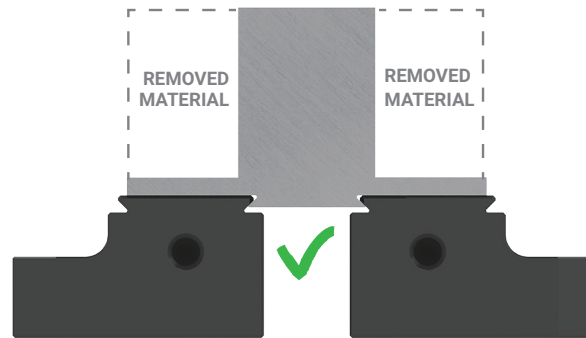


THERE IS NO SIMPLE ANSWER TO HOW MUCH SUPPORT IS NEEDED.



SUPPORTING MATERIAL

If more support is needed, **Decrease dovetail width or increase tab thickness**



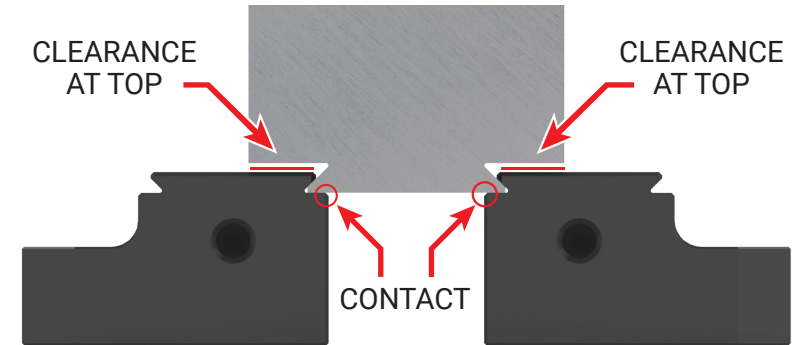
For narrow parts, position the dovetail as close as possible to the **finished part's** center of mass.



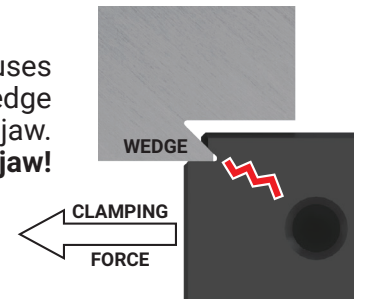
COMMON MISTAKES

❌ 1. DOVETAIL TOO DEEP

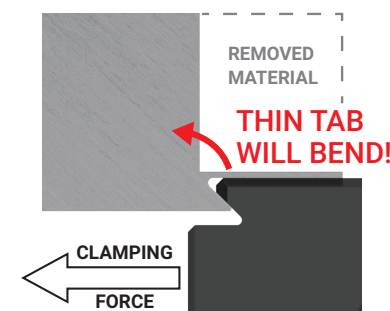
Clamping with a dovetail should **never** cause the material to locate on the bottom step of the jaw.



Locating on bottom step causes material to become a wedge trying to split the jaw. **This can break the jaw!**

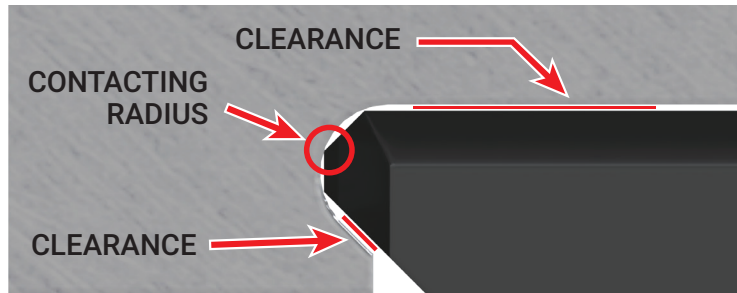


❌ 2. FINISHED PART UNSUPPORTED



A thin tab and/or insufficient material on the top locating surface will allow the part to move during machining.

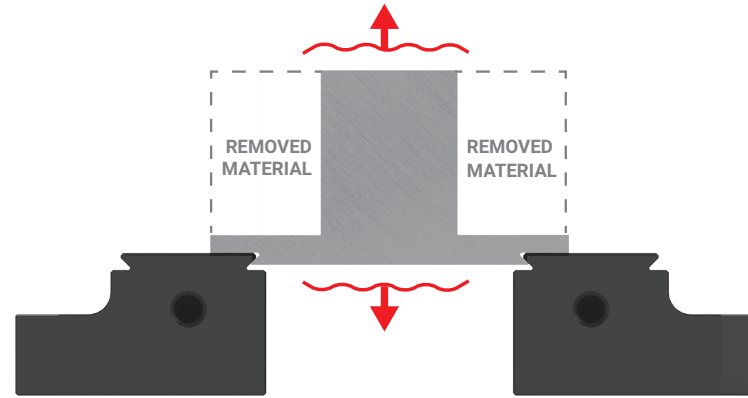
✘ 3. OVERSIZED CORNER RADIUS



An overly wide inside corner radius allows material to contact the corner of the jaw, preventing it from locating correctly.

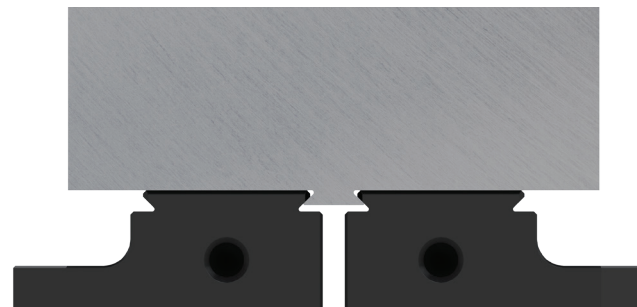
This will call excessive vibration during machining.

✘ 4. EXCESSIVELY WIDE DOVETAIL



Even though this part has tabs thick enough to prevent breaking, the dovetail is not properly positioned under the part. This may result in excessive vertical vibration.

✘ 5. EXCESSIVELY NARROW DOVETAIL



Excessively narrow dovetail will concentrate support at the center of the stock and potentially cause chatter.

Keep in mind how and where force is applied to stock during machining.



DOVETAIL TROUBLESHOOTING GUIDE



The information in this document is applicable to ALL 5th Axis™ products with a dovetail feature.

Both vises AND dovetail fixtures should follow these rules.