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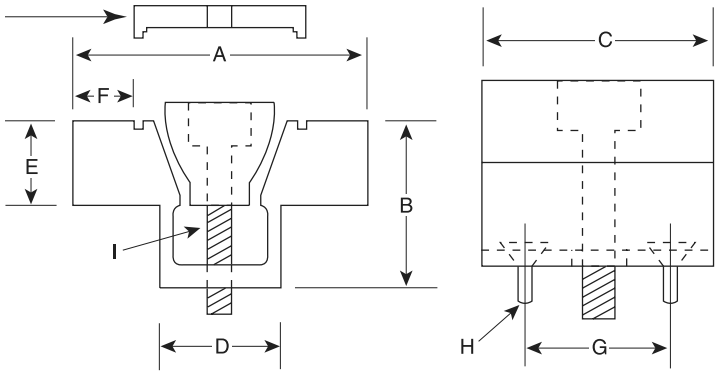

Machinable Uniforce® Clamp Metric Instructions

1. Determine the location of clamp using "A" column
2. Drill and tap per chart
3. Assemble clamp and slide lock plate over "I", screw and tighten
4. Machine clamp and stop at same time for precision fit
5. Remove lock-plate, install workpieces and machine as required

Note: Locking plate is used only to machine jaws, remove to clamp workpiece. When clamp is used to hold flat stock, use locking plate to machine faces parallel.

Model	Part No. with Locking Plate	Part No. Without Locking Plate	A*	B	C	D	E	F†	G	H**	I	Max. Torque (N.m.)	Holding Force (N.)
500	80050	80055	28.6	12.7	15.7	10.67	6.3	4.6	10.16	M2	M4	3.40	2225
750	80075	80080	38.1	19.1	23.9	16.05	9.4	6.6	15.87	M4	M6	14.30	6675
1000	80100	80105	50.8	25.4	31.8	20.83	12.7	9.9	20.62	M4	M8	14.50	8900
1500	80150	80155	76.2	38.1	47.5	30.86	19.1	15.7	30.48	M5	M12	38.40	15575
2000	80200	80205	101.6	50.8	63.5	41.28	25.4	20.3	41.28	M6	M16	74.60	26700

A* - The distance needed between workpieces for clamp clearance, drill and tap mounting holes on the center of "A" dimension.

F† - The amount of machinable stock on jaws.

H -** Mounting screws included.

REPLACEMENT PARTS

Model No.	Channel Part No.	Wedge Part No.	Locking Plate Part No.
500	60140	60310	60143
750	60125	60320	60145
1000	60135	60330	60155
1500	60160	60340	60165
2000	60180	60350	60185

Patent 6,126,159