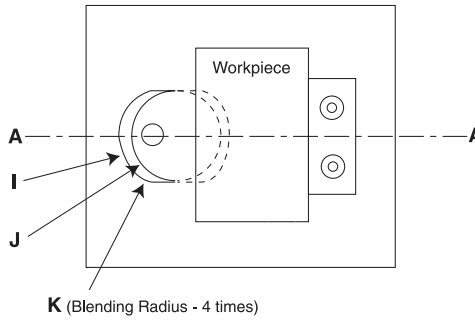
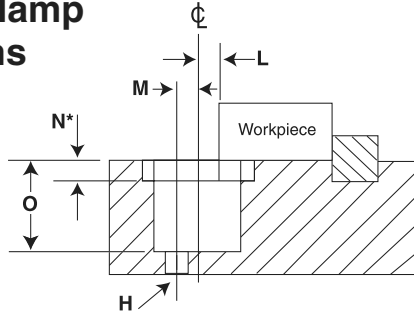


## Dyna-Force Clamp Instructions

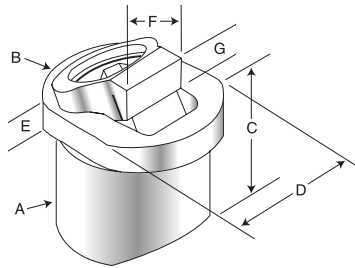
1. Bore  $\phi$  of the hole "L" distance from edge of workpiece.
2. Drill and tap "H" to mount clamp in pocket.
3. Machine counter bore if recessing clamp into fixture.
4. Provide a back stop to locate the part.



Height of jaw in relation to  $\phi$  of bore from edge of workpiece.

Height of Jaw	20mm		25mm		30mm	
	G	L	L	L	L	L
3.25	5.91					
3.50	5.77					
3.75	5.62					
4.00	5.48					
4.25	5.33					
4.50	5.19	6.81	8.78			
4.75	5.05	6.66	8.63			
5.00	4.90	6.52	8.49			
5.25	4.76	6.37	8.35			
5.50	5.61	6.23	8.20			
5.75	4.47	6.08	8.06			
6.00	4.32	5.94	7.91			
6.25	4.18	5.80	7.77			
6.50	4.03	5.65	7.62			
6.75	3.89	5.51	7.48			
7.00		5.36	7.34			
7.25		5.22	7.19			
7.50		5.07	7.05			
7.75		4.93	6.90			
8.00		4.78	6.76			
8.25		4.64	6.61			
8.50			6.47			
8.75			6.33			
9.00			6.18			
9.25			6.04			
9.50			5.89			
9.75			5.75			
10.00			5.60			
10.25			5.46			
10.50			5.31			
10.75			5.17			

- NOTES:**
1. "N\*" - To have rest pad flush with fixture, use the dimension provided. To have the rest pad above the fixture surface, reduce the depth accordingly.
  2. For dimensions I and J, use a tolerance of  $\pm 0.1$  mm. For dimension L and O, use  $\pm 0.1$  mm.



Part Number	H	I	J	K	L	M	N	O
28314	M5 or 10-24	25.00	20.00	6.00	4.90	5.00	4.50	20.00
28318	M5 or 10-24	25.00	20.00	6.00	4.90	5.00	4.50	20.00
28320	M6 or 1/4-20	30.00	25.00	6.50	5.65	6.00	5.00	25.00
28322	M6 or 1/4-20	30.00	25.00	6.50	5.65	6.00	5.00	25.00
28324	M8 or 5/16-18	38.00	30.00	8.00	7.05	7.50	7.00	30.00
28328	M8 or 5/16-18	38.00	30.00	8.00	7.05	7.50	7.00	30.00

Part Number	Replacement Replacement Insert*	Part Number	Replacement Insert*
28314	28480 (20mm smooth)	28318	28482 (20mm serrated)
28320	28484 (25mm smooth)	28322	28486 (25mm serrated)
28324	28488 (30mm smooth)	28328	28490 (30mm serrated)

\*Includes screw and retaining ring

Part Number	Clamp Jaw† & Hardness	A*	B	C	D	E	F	G			Clamp Travel	Drive Screw	Key Size	Maximum Torque	Holding Force
								Min	Optimum	Max					
28314	Smooth 34RC	20.00	24.90	19.00	19.90	4.50	13.50	3.25	5.00	6.75	2.0	M6x12mm SHCS	5mm	9.9 (N.m)	8896 (N.)
28318	Serrated 44RC														
28320	Smooth 34RC	25.00	29.90	24.00	24.90	5.00	15.00	4.50	6.50	8.25	2.2	M8x16mm SHCS	6mm	23.9 (N.m)	11565 (N.)
28322	Serrated 44RC														
28324	Smooth 34RC	30.00	37.90	29.00	29.90	7.00	20.00	4.50	7.50	10.75	3.8	M10x18mm SHCS	8mm	1.9 (N.m)	14234 (N.)
28328	Serrated 44RC														

A\* - Body diameter † - Smooth jaw only will have relief cut

**EXAMPLE:** 20mm clamp when  $\phi$  of bore is 4.90mm from edge of workpiece (L - see drawing on top); jaw height is 5.00mm (G - see drawing to left).