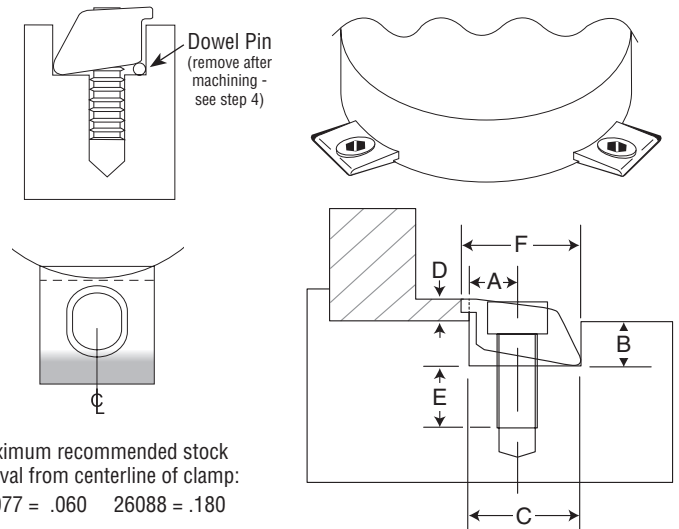


Machinable Pitbull® Instructions

1. Machine a pocket to locate workpiece and pockets for clamps.
2. If machining maximum amount from clamp use standard dimensions for "A" from chart. If machining less, adjust dimension accordingly.
3. Assemble clamp without O-ring and install in fixture with dowel pin, under front edge of clamp as shown in diagram. Tighten securely and machine clamps for a slip fit with workpiece.
4. Remove dowel pin, add O-ring and install clamp.
5. Clamp is at approximately 43RC, carbide tooling is recommended for machining.

NOTE: Clamp can be machined concave or convex. However maximum recommended stock removal should be adhered to at center line of clamp.



Number	Part Description	A	B	C	D*	E	F	Slot Width	Screw Size	Max. Torque (N.m)	Max. Holding Force (N.)	Total Throw	Dowel† Pin	Clamps Per Package
26077	Tool Steel, Machinable	.400	.450	1.00	.250	.710	1.060	1.00	3/8-16	6,000	360	.050	1/8	4
26088	Tool Steel, Machinable	.600	.640	1.50	.375	.770	1.68	1.50	1/2-13	12,000	1,300	.075	1/4	2

D* - Minimum clamping height † - Included

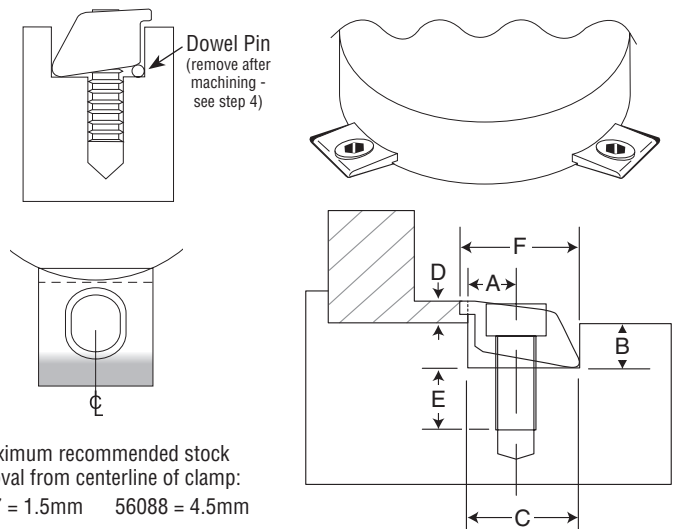


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 PATENT #6,435,496

Machinable Pitbull® Metric Instructions

1. Machine a pocket to locate workpiece and pockets for clamps.
2. If machining maximum amount from clamp use standard dimensions for "A" from chart. If machining less, adjust dimension accordingly.
3. Assemble clamp without O-ring and install in fixture with dowel pin, under front edge of clamp as shown in diagram. Tighten securely and machine clamps for a slip fit with workpiece.
4. Remove dowel pin, add O-ring and install clamp.
5. Clamp is at approximately 43RC, carbide tooling is recommended for machining.

NOTE: Clamp can be machined concave or convex. However maximum recommended stock removal should be adhered to at center line of clamp.



Number	Part Description	A	B	C	D*	E	F	Slot Width	Screw Size	Max. Torque (N.m)	Max. Holding Force (N.)	Total Throw	Dowel† Pin	Clamps Per Package
56077	Tool Steel, Machinable	10.16	11.43	25.4	6.35	18.0	26.9	25.4	M10	40.6	26,000	1.27	3.18	4
56088	Tool Steel, Machinable	15.24	16.26	38.1	9.52	19.6	42.6	38.1	M12	145.0	50,000	1.90	6.35	2

D* - Minimum clamping height † - Included



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 PATENT #6,435,496