**Clamp Instructions**

Model #00 - #6

- Expand clamp approximately .003" over relaxed diameter and machine to fit workpiece bore, either on lathe or mill.
- If machining the clamp on a lathe use the nut provided, on the back of the clamp, to tighten the tapered screw. This nut is used only while machining the clamp.
- A recessed dowel pin may be installed into the flange for additional rigidity if required.
- Long lengths screws available for sizes #00 thru #10. For blind hole app’s, see our Manual Actuators or call for custom screws/other options.
- Range of expansion .005 to .025 depending upon size. See MiteeBite.com for individual clamp expansion range.

Model #7 - #10

- Locking rings are provided to ensure segments remain rigid while machining clamps to size (#9 and #10 ID's ship with 2 rings).
- Insert supplied ring(s) and tighten drive screw to 40 Ft/Lbs and machine clamp diameter to +.003/.005" over bore size. Remove ring(s) and test fitment with workpiece.
- Aggressive material removal is not recommended when machining clamps to size. Suggested machining practice is to spiral down with a .500" end mill by conventional milling .020" off the desired clamp diameter at 400 SFPM and .001" per flute feed and .250" depth per trip around.
- Finish final diameter at 700 SFPM using same .001" per flute feed and .250" depth and climb mill.

**ID Xpansion TM Clamp Instructions**

**Model #00 - #6**

- Expand clamp approximately .003" over relaxed diameter and machine to fit workpiece bore, either on lathe or mill.
- If machining the clamp on a lathe use the nut provided, on the back of the clamp, to tighten the tapered screw. This nut is used only while machining the clamp.
- Machine a pocket in the fixture. For close tolerance "E" dimension and drill and tap mounting holes per "H" column. Drill and tap a hole from the "I" column in the center of the pocket for the tapered screw.
- A recessed dowel pin may be installed into the flange for additional rigidity if required.
- Long lengths screws available for sizes #00 thru #10. For blind hole app’s, see our Manual Actuators or call for custom screws/other options.
- Range of expansion .005 to .025 depending upon size. See MiteeBite.com for individual clamp expansion range.

**Model #7 - #10**

- Locking rings are provided to ensure segments remain rigid while machining clamps to size (#9 and #10 ID's ship with 2 rings).
- Insert supplied ring(s) and tighten drive screw to 40 Ft/Lbs and machine clamp diameter to +.003/.005" over bore size. Remove ring(s) and test fitment with workpiece.
- Aggressive material removal is not recommended when machining clamps to size. Suggested machining practice is to spiral down with a .500" end mill by conventional milling .020" off the desired clamp diameter at 400 SFPM and .001" per flute feed and .250" depth per trip around.
- Finish final diameter at 700 SFPM using same .001" per flute feed and .250" depth and climb mill.

**ID Xpansion TM Clamp Instructions**

**Model #00 - #6**

- Expand clamp approximately .003" over relaxed diameter and machine to fit workpiece bore, either on lathe or mill.
- If machining the clamp on a lathe use the nut provided, on the back of the clamp, to tighten the tapered screw. This nut is used only while machining the clamp.
- A recessed dowel pin may be installed into the flange for additional rigidity if required.
- Long lengths screws available for sizes #00 thru #10. For blind hole app’s, see our Manual Actuators or call for custom screws/other options.
- Range of expansion .005 to .025 depending upon size. See MiteeBite.com for individual clamp expansion range.

**Model #7 - #10**

- Locking rings are provided to ensure segments remain rigid while machining clamps to size (#9 and #10 ID's ship with 2 rings).
- Insert supplied ring(s) and tighten drive screw to 40 Ft/Lbs and machine clamp diameter to +.003/.005" over bore size. Remove ring(s) and test fitment with workpiece.
- Aggressive material removal is not recommended when machining clamps to size. Suggested machining practice is to spiral down with a .500" end mill by conventional milling .020" off the desired clamp diameter at 400 SFPM and .001" per flute feed and .250" depth per trip around.
- Finish final diameter at 700 SFPM using same .001" per flute feed and .250" depth and climb mill.

**G† - Minimum diameter the "F" dimension can be machined or turned down to.**

**H* - (3) Mounting Screws included - (4) for model numbers #9 and #10.**

**†Model #10 Made from 7075-T6 aluminum.**