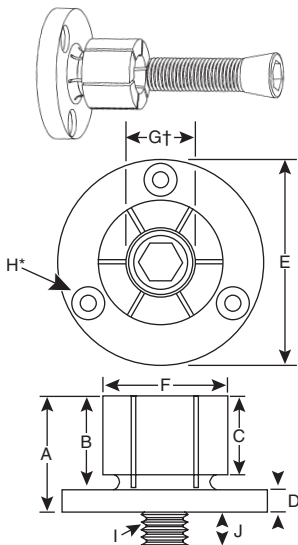


ID Xpansion™ Clamp Metric Instructions



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.

Model #00 - #6

- ▶ Expand clamp approximately .1mm 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 length screws available for sizes #0 thru #10. *For blind hole app's, see our Manual Actuators or call for custom screws/other options.*
- ▶ Range of expansion .13 to .64mm 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 55 N.m. and machine clamp diameter to +.08/.13mm over bore size. Remove ring(s) and test fitment with workpiece. If workpiece fitment is tight, repeat machining process and machine to achieve a close fit to workpiece MMC bore size.
- ▶ Aggressive material removal is not recommended when machining clamps to size. Suggested machining practice is to spiral down with a 12mm end mill by conventional milling .5mm off the desired clamp diameter at 2 m/s and 0.03mm per flute and .05mm depth per trip around.
- ▶ Finish final diameter at 3.6 m/s using same 0.04mm per flute feed and 6mm depth and climb mill.

Part No.	Model Number	A	B	C	D	E +.000 E -.050	F	G†	H*	I	J	Max. Torque (N.m.)	Holding Force (N.)	Repl. Tapered Screw
38000	#00	10.7	7.6	6.1	3.0	20.00	7.4	4.1	M2 on 13.7 BHC	M2x12	4.1	.70	1113	38001
38050	#0	21.8	16.0	15.0	5.9	29.72	12.4	7.1	M3 on 20.95 BHC	M4x25	7.2	5.00	4228	38002
38100	#1	24.9	19.0	15.0	5.9	31.50	14.2	12.2	M3 on 23.1 BHC	M6x30	11.2	17.00	8455	38010
38150	#2	24.9	19.0	15.0	5.9	37.50	20.0	13.5	M3 on 29.0 BHC	M8x30	13.2	34.00	11125	38020
38200	#3	28.6	22.2	17.5	6.4	50.00	27.0	18.0	M4 on 39.4 BHC	M10x35	16.3	60.00	20025	38032
38250	#4	31.8	25.4	20.6	6.4	56.00	35.3	23.0	M4 on 45.5 BHC	M12x40	20.3	150.00	26255	38042
38300	#5	39.6	31.8	27.0	7.9	69.50	42.0	29.3	M5 on 55.9 BHC	M16x45	21.4	280.00	44500	38052
38350	#6	39.6	31.8	27.0	7.9	75.50	51.5	29.3	M5 on 63.9 BHC	M16x45	21.4	280.00	44500	38052
38400	#7	45.5	37.6	32.3	7.9	107.50	77.7	29.3	M6 on 92.6 BHC	M16x50	19.3	280.00	44500	38072
38450	#8	45.5	37.6	32.3	7.9	132.90	103.0	29.3	M6 on 118.06 BHC	M16x50	19.3	280.00	44500	38072
38500	#9	45.5	37.6	32.3	7.9	132.90	175.0	29.3	M6 on 118.06 BHC	M16x50	19.3	280.00	44500	38072
38550	#10**	45.5	37.6	32.3	7.9	152.40	250.2	29.3	M6 on 133.35 BHC	M16x50	19.3	170.00	26000	38072