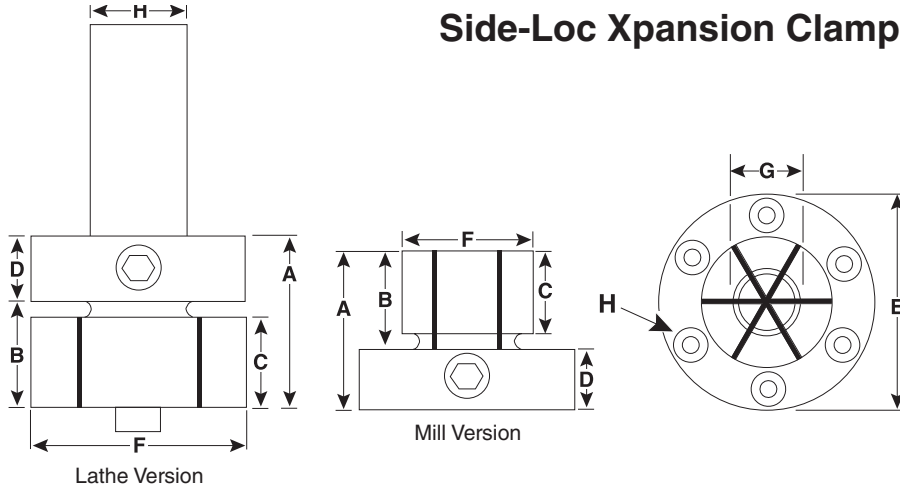


## Side-Loc Xpansion Clamp Instructions



- Expand Side-Loc to tighten ring. Machine it to fit workpiece bore, either on lathe or mill. *Aggressive material removal is not recommended when machining clamps to size.*
- For mill version, machine a pocket in the fixture plate for the “E” diameter and drill and tap mounting holes per the “H” column.
- A recessed dowel pin may be installed into the flange for additional rigidity if required.
- Range of expansion is .008 to .012.

Part Number	Model No.	A	B	C	D	E <sup>+0.000</sup> <sub>-.050</sub>	F	G†	H*	Hex Key	Max, Torque (Ft/Lbs)	Holding Force (Lbs)	Replacement		
													Cam Shaft (M12x30MM)	Spring	Ring
31210	Mill #3	1.625	.875	.69	.75	1.968	1.12	.71	8-32 on 1.550 BHC	M6	49**	4,000	389001	31207	31202
31370	Lathe #6	1.750	1.000	.84	.75	NA	2.09	.71	1.0	M6	49**	4,000	389001	31207	31202

G† - Minimum diameter the “F” dimension can be machined down to.

H\* - (6) mounting screws included.

\*\* - If high cycles, run max. torque 40 Ft/Lbs or 62 N.m.