



Machinable Uniforce® Clamp Instructions

1. Determine the location of clamp using "A" column
2. Drill and tap per chart
3. Assemble clamp and slide lock plate over "I", screw and tighten
4. Machine clamp and stop at same time for precision fit
5. Remove lock-plate, install workpieces and machine as required

Note: Locking plate is used only to machine jaws, remove to clamp workpiece. When clamp is used to hold flat stock, use locking plate to machine faces parallel.

Model	Part No. with Locking Plate	Part No. Without Locking Plate	A*	B	C	D	E	F†	G	H**	I	Max. Torque (Ft/Lbs)	Holding Force (Lbs)
500	60050	60055	1.125	.50	.62	.420	.25	.18	.400	2-56	8-32	2.5	500
750	60075	60080	1.500	.75	.94	.632	.37	.26	.625	6-32	1/4-20	10.0	1,500
1000	60100	60105	2.000	1.00	1.25	.820	.50	.39	.812	6-32	5/16-18	19.0	2,500
1500	60150	60153	3.000	1.50	1.87	1.215	.75	.62	1.200	10-32	1/2-13	28.3	3,500
2000	60200	60203	4.000	2.00	2.50	1.625	1.00	.80	1.625	1/4-20	5/8-11	55.0	6,000

REPLACEMENT PARTS

Model No.	Channel Part No.	Wedge Part No.	Locking Plate Part No.
500	60140	60310	60143
750	60125	60320	60145
1000	60135	60330	60155
1500	60160	60340	60165
2000	60180	60350	60185

A* - The distance needed between workpieces for clamp clearance, drill and tap mounting holes on the center of "A" dimension.

F† - The amount of machinable stock on jaws.

H** - Mounting screws included.

Patent 6,126,159