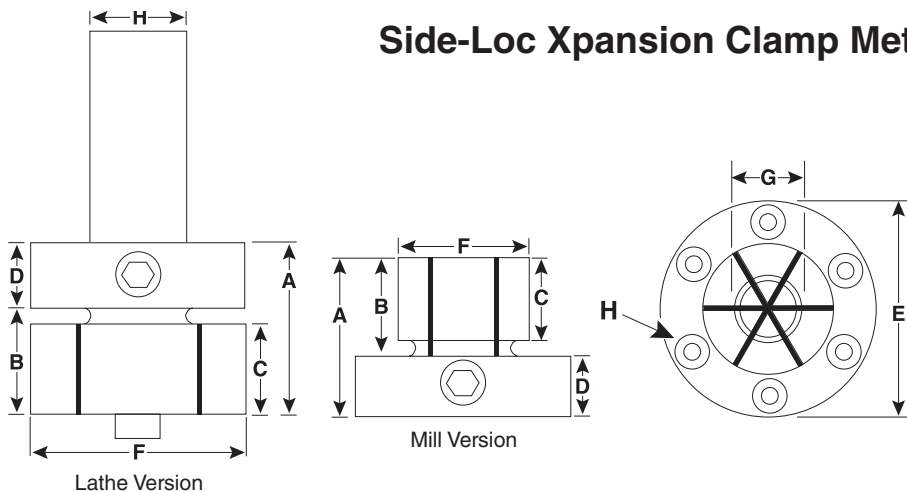


Side-Loc Xpansion Clamp Metric Instructions



- 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 .20mm to .30mm.

Part Number	Model No.	A	B	C	D	E ⁺ E ⁻	F	G†	H*	Hex Key	Max. Torque‡ (N.m.)	Holding Force (N.)	Replacement		
													Cam Shaft (M12x30MM)	Spring	Ring
38210	Mill #3	41.3	22.2	17.5	19.0	50.0	28.7	17.8	M4 on 39.4 BHC	M6	66**	20000	389001	31207	31202
38370	Lathe #6	44.4	25.0	21.3	19.0	N/A	53.3	17.8	25	M6	66**	20000	389001	31207	31202

G† - Minimum diameter the "F" dimension can be machined down to.
 ‡Maximum torque is not necessary. Normally half that value is sufficient.

H* - (6) mounting screws included.

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