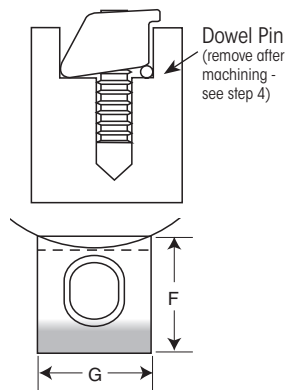


Machinable Pitbull® Metric Instructions

1. Machine a pocket to locate workpiece and pockets for clamps.
2. If machining maximum amount from clamp use standard dimensions for "A" from chart. If machining less, adjust dimension accordingly.
3. Assemble clamp without O-ring and install in fixture with dowel pin, under front edge of clamp as shown in diagram. Tighten securely and machine clamps for a slip fit with workpiece.
4. Remove dowel pin, add O-ring and install clamp.
5. Clamp is at approximately 43RC, carbide tooling is recommended for machining.

NOTES: Clamp can be machined concave or convex. However maximum recommended stock removal should be adhered to at center line of clamp.

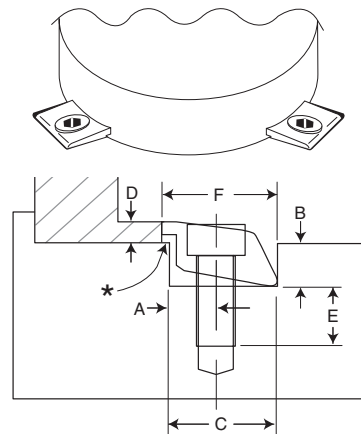


Maximum recommended stock removal from centerline of clamp:

56066 = 2.54mm

56077 = 1.5mm

56088 = 4.5mm



*Relieving the fixture under the clamping edge of the Pitbull® may be necessary if dimension "B" (Pitbull® pocket, or slot depth) is greater than the nominal dimension specified in column "B".

Part Number	Desc.	A	B	C	D*	E	F	G	Screw Size	Torque not to Exceed (N.m.)	Holding Force (N.)	Total Throw	Dowel Pin	Clamps Per Package	Repl. O-ring
56066	Tool Steel, Machinable	7.62	7.11	19.05	3.81	14.48	21.59	19.05	M6	22.5	16,000	.61	3.18	6	26058
56077	Tool Steel, Machinable	10.16	11.43	25.4	6.35	18.0	26.9	25.4	M10	40.6	26,000	1.27	3.18	4	26078
56088	Tool Steel, Machinable	15.24	16.26	38.1	9.52	19.6	42.6	38.1	M12	145.0	50,000	1.90	6.35	2	26083

D* - Minimum clamping height

PATENT #6,435,496

