

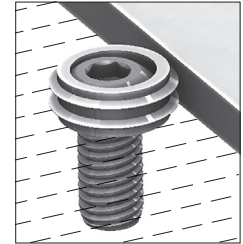
Knife Edge Clamp Inch Instruction

1. Drill and tap hole per drill chart.
2. Clear drill .060-.200 to account for a max. of 2 threads under the head.
3. Screw MITEE-BITE KNIFE EDGE CLAMP all the way down, then back off one turn. Can also be tightened counter clockwise.
4. Insert part and tighten MITEE-BITE screw.
5. CAUTION! Never assume clamp is tight, ALWAYS tighten clamp prior to machining.

DRILL CHART

Distance from Edge of Workpiece

Part Number	Model #	Thread Size	Distance
22584	MB-6	3/8-16	.400
22588B	MB-8	1/2-13	.500
22592	MB-10	5/8-11	.590



NOTE: NOTE: When using this style of clamp please ensure hard stop is recessed in slot or pinned and equal to or greater than height of clamp. This will prevent part from lifting.

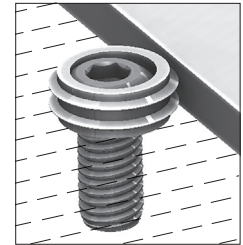
Knife Edge Clamp Metric Instruction

1. Drill and tap hole per drill chart.
2. Clear drill 1.5mm to account for a max. of 2 threads under the head.
3. Screw MITEE-BITE KNIFE EDGE CLAMP all the way down, then back off one turn. Can also be tightened counter clockwise.
4. Insert part and tighten MITEE-BITE screw.
5. CAUTION! Never assume clamp is tight, ALWAYS tighten clamp prior to machining.

DRILL CHART

Distance from Edge of Workpiece

Part Number	Model #	Thread Size	Distance
82584	MB-M10	M10-1.50	10.15mm
82588	MB-M12	M12-1.75	12.70mm
82592	MB-M16	M16-2.0	15.00mm



NOTE: When using this style of clamp please ensure hard stop is recessed in slot or pinned and equal to or greater than height of clamp. This will prevent part from lifting.

