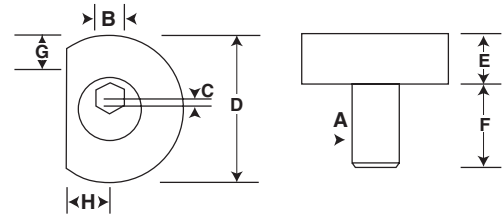


## Machinable Fixture Clamp Inch Instruction

Using Machinable Fixture Clamps is easy - Simply...

1. Drill and tap hole in proper location.
2. Clear drill .060-.200 deep.
3. Insert machining screw, tighten down on steel washer.
4. Machine steel washer to conform to workpiece.
5. Exchange machining screw for cam screw.
6. CAUTION! Never assume clamp is tight, ALWAYS tighten clamp prior to machining.

**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.



Part Number	Description	A	B	C	D	E	F	G*	H†	Holding Force (Lbs)
10504	MB-4	1/4 - 20	1/8	.040	.980	.250	.470	.250	.312	800
10506	MB-6	3/8 - 16	3/16	.050	1.230	.350	.710	.275	.406	2,000
10508	MB-8	1/2 - 13	5/16	.100	1.480	.450	.900	.300	.500	4,000
10510	MB-10	5/8 - 11	3/8	.100	1.730	.550	1.125	.350	.593	6,000

Every package includes one machining screw.

G\* - The amount of machinable stock.

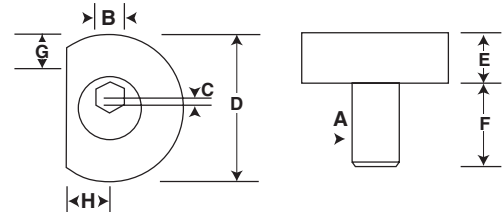
H† - The distance to drill & tap hole from edge of workpiece to use flat face.

## Machinable Fixture Clamp Metric Instruction

Using Machinable Fixture Clamps is easy - Simply...

1. Drill and tap hole in proper location.
2. Clear drill 1.5mm deep.
3. Insert machining screw, tighten down on steel washer.
4. Machine steel washer to conform to workpiece.
5. Exchange machining screw for cam screw.
6. CAUTION! Never assume clamp is tight, ALWAYS tighten clamp prior to machining.

**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.



Part Number	Description	A	B	C	D	E	F	G*	H†	Holding Force (N.)
50506	MB-6M	M6	4M	1.01	24.9	6.4	11.9	6.4	7.8	3358
50510	MB-10M	M10	7M	1.52	31.2	8.9	18.0	7.0	10.2	8900
50512	MB-12M	M12	8M	2.03	37.6	11.4	22.9	7.6	12.7	17800
50516	MB-16M	M16	12M	2.54	43.9	14.0	28.6	8.9	15.0	26700

Every package includes one machining screw.

G\* - The amount of machinable stock.

H† - The distance to drill & tap hole from edge of workpiece to use flat face.

