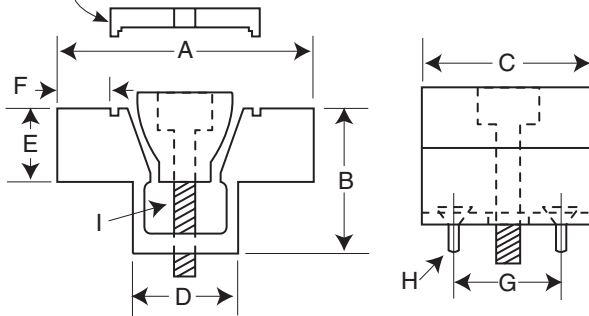


## Machinable Uniforce® Clamp Instructions

**NOTE:** When clamp is used to hold flat stock, use locking plate to machine faces parallel.



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.

Replacement Locking Plates	
Model	Part No.
500	60143
750	60145
1000	60155
1500	60165
2000	60185

INCH	Model	Part No. With Locking Plate	Part No. Without Locking Plate	A*	B	C	D	E	F†	G	H**	I	Torque not to Exceed (Ft/Lbs)	Holding Force (Lbs)	Max. Torque for Locking Plate (Ft/Lbs)	Replacement	
																Channel	Steel Wedge
INCH	500	60050	60055	1.125	.50	.62	.420	.25	.18	.400	2-56	8-32	2.5	500	.5	60140	60310
	750	60075	60080	1.500	.75	.94	.632	.37	.26	.625	6-32	1/4-20	10.0	1,500	2.0	60125	60320
	1000	60100	60105	2.000	1.00	1.25	.820	.50	.39	.812	6-32	5/16-18	19.0	2,500	4.0	60135	60330
	1500	60150	60153	3.000	1.50	1.87	1.215	.75	.62	1.200	10-32	1/2-13	28.3	3,500	6.0	60160	60340
	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	12.0	60180	60350
													(N.m.)	(N.)	(N.m.)		
METRIC	500	80050	80055	28.6	12.7	15.7	10.67	6.3	4.6	10.16	M2	M4	3.40	2,225	.70	60140	60310
	750	80075	80080	38.1	19.1	23.9	16.05	9.4	6.6	15.87	M4	M6	13.50	6,675	2.7	60125	60320
	1000	80100	80105	50.8	25.4	31.8	20.83	12.7	9.9	20.62	M4	M8	25.00	11,125	5.0	60135	60330
	1500	80150	80155	76.2	38.1	47.5	30.86	19.1	15.7	30.48	M5	M12	38.40	15,575	8.0	60160	60340
	2000	80200	80205	101.6	50.8	63.5	41.28	25.4	20.3	41.28	M6	M16	74.60	26,700	15.0	60180	60350

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.

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