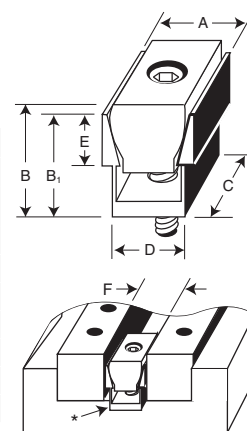
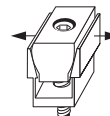


Uniforce Clamp Inch Instructions

1. Mill a slot in fixture plate wider than dimension D.
2. Drill and tap a hole according to chart on package.
3. Insert steel slug into aluminum channel and tighten screw.



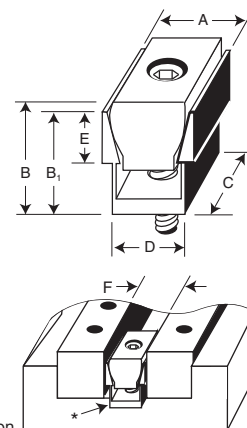
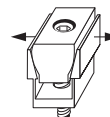
Part Number	Model	A	B	B1	C	D*	E	F†	Thread Size	Max. Spread	Torque not to Exceed (Ft/Lbs)	Holding Force (Lbs)	No. of Clamps Per Pack	Hex Key Size	Replacement	
															Channel	Steel Wedge
60250	250	.240	.27	.250	.320	.210	.140	.250	2 - 56	.260	.5	200	6	5/64	60205	60305
60375	375	.360	.38	.375	.470	.310	.185	.375	4 - 40	.390	1.1	310	6	3/32	60207	60307
60500	500	.485	.58	.500	.625	.410	.220	.500	8 - 32	.530	2.5	500	8	9/64	60210	60310
60750	750	.735	.77	.750	.940	.635	.375	.750	1/4 - 20	.785	10.0	1,500	6	3/16	60220	60320
61000	1000	.980	1.02	1.000	1.250	.820	.500	1.000	5/16-18	1.050	19.0	2,500	4	1/4	60230	60330
61500	1500	1.470	1.52	1.500	1.875	1.215	.750	1.500	1/2 -13	1.560	28.3	3,500	2	3/8	60240	60340
62000	2000	1.960	2.03	2.000	2.500	1.625	1.000	2.000	5/8 -11	2.080	55.0	6,000	2	1/2	60245	60350

D* - A milled slot wider than D dimension will insure clamp remains in line with workpiece. Clamp sides should not come in contact with slot walls during expansion.

F† - The distance needed between workpieces for clamp clearance. Drill and tap mounting hole on the center of F dimension.

Uniforce Clamp Metric Instructions

1. Mill a slot in fixture plate wider than dimension D.
2. Drill and tap a hole according to chart on package.
3. Insert steel slug into aluminum channel and tighten screw.



Part Number	Model	A	B	B1	C	D*	E	F†	Thread Size	Maximum Spread	Torque not to Exceed (N.m.)	Holding Force (N.)	Number of Clamps Per Pack	Hex Key Size	Replacement	
															Channel	Steel Wedge
80250	250	6.1	6.9	6.40	8.1	5.3	3.6	6.4	M2	6.7	0.70	880	6	1.5	60205	60305
80375	375	9.1	9.7	9.50	11.9	7.9	4.7	9.5	M2.5	10.0	1.50	1,350	6	2	60207	60307
80500	500	12.3	14.5	12.70	15.9	10.4	5.6	12.7	M4	13.2	3.40	2,225	8	3	60210	60310
80750	750	18.6	19.0	19.05	23.8	16.1	9.5	19.0	M6	20.3	13.50	6,675	6	5	60220	60320
81000	1000	24.8	25.9	25.40	31.7	20.8	12.7	25.4	M8	26.9	25.00	11,125	4	6	60230	60330
81500	1500	37.3	38.6	38.10	47.6	30.8	19.0	38.1	M12	39.9	38.40	15,575	2	10	60240	60340
82000	2000	49.7	51.5	50.80	63.5	41.2	25.4	50.8	M16	53.0	74.60	26,700	2	14	60245	60350

D* - A milled slot wider than D dimension will insure clamp remains in line with workpiece. Clamp sides should not come in contact with slot walls during expansion.

F† - The distance needed between workpieces for clamp clearance. Drill and tap mounting hole on the center of F dimension.

