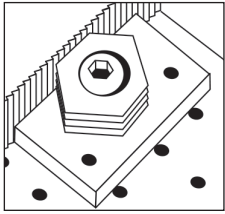
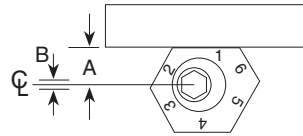


## Series-9 Inch Instructions



This clamp provides clamping of different size workpieces merely by rotating the clamp to one of its other edges. Each of the six clamping surfaces is a different distance from the centerline by .0394 as shown on charts (A). Clamp travel is .080 (.040 forward and aft from centerline B).

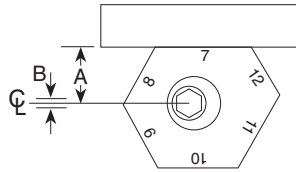
Part No. 90110 (1-6 Smooth)  
 Part No. 90115 (1-6 Serrated)



Face Number	A* - Distance from $\phi$ (metric)
1	.4724
2	.5118
3	.5512
4	.5906
5	.6299
6	.6693

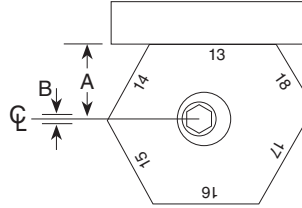
A\* - Location to drill and tap from edge of workpiece.

Part No. 90120 (7-12 Smooth)  
 Part No. 90125 (7-12 Serrated)



Face Number	A* - Distance from $\phi$ (metric)
7	.7086
8	.7480
9	.7874
10	.8268
11	.8661
12	.9055

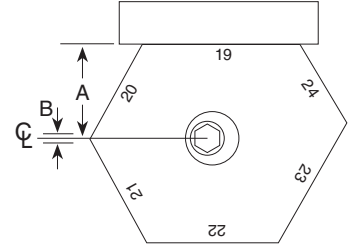
Part No. 90130 (13-18 Smooth)  
 Part No. 90135 (13-18 Serrated)



Face Number	A* - Distance from $\phi$ (metric)
13	.9449
14	.9842
15	1.0236
16	1.0630
17	1.1024
18	1.1417

A\* - Location to drill and tap from edge of workpiece.

Part No. 90140 (19-24 Smooth)  
 Part No. 90145 (19-24 Serrated)

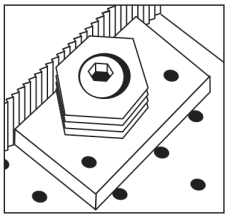


Face Number	A* - Distance from $\phi$ (metric)
19	1.1811
20	1.2205
21	1.2598
22	1.2992
23	1.3386
24	1.3780

### TORQUE VALUES AND HOLDING FORCE

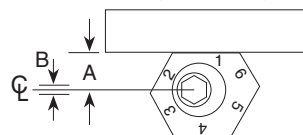
Part Numbers	Use Screw Size	Hex Key Size	Torque not to Exceed	Replacement Cam Screw
90110 - 90145	1/2 - 13	5/16	65 Ft Lbs / 4000 Lbs	10374

## Series-9 Metric Instructions



This clamp provides clamping of different size workpieces merely by rotating the clamp to one of its other edges. Each of the six clamping surfaces is a different distance from the centerline by 1mm as shown on charts (A). Clamp travel is 2.03mm (1.02mm forward and aft from centerline B).

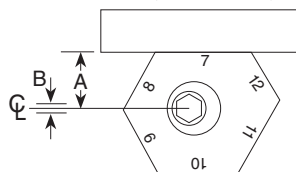
Part No. 95110 (1-6 Smooth)  
 Part No. 95115 (1-6 Serrated)



Face Number	A* - Distance from $\phi$ (metric)
1	12mm
2	13mm
3	14mm
4	15mm
5	16mm
6	17mm

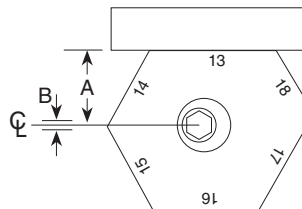
A\* - Location to drill and tap from edge of workpiece.

Part No. 95120 (7-12 Smooth)  
 Part No. 95125 (7-12 Serrated)



Face Number	A* - Distance from $\phi$ (metric)
7	18mm
8	19mm
9	20mm
10	21mm
11	22mm
12	23mm

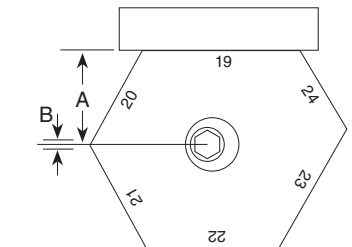
Part No. 95130 (13-18 Smooth)  
 Part No. 95135 (13-18 Serrated)



Face Number	A* - Distance from $\phi$ (metric)
13	24mm
14	25mm
15	26mm
16	27mm
17	28mm
18	29mm

A\* - Location to drill and tap from edge of workpiece.

Part No. 95140 (19-24 Smooth)  
 Part No. 95145 (19-24 Serrated)



Face Number	A* - Distance from $\phi$ (metric)
19	30mm
20	31mm
21	32mm
22	33mm
23	34mm
24	35mm

### TORQUE VALUES AND HOLDING FORCE

Part Numbers	Use Screw Size	Hex Key Size	Torque not to Exceed	Replacement Cam Screw
95110 - 95145	M12	8mm	88 N.m. / 17,800 N.	50371

