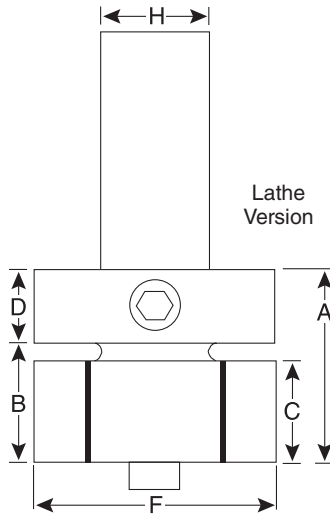
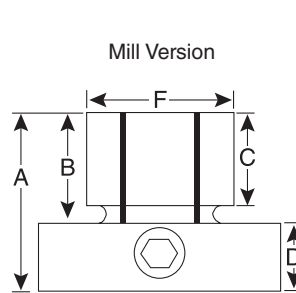


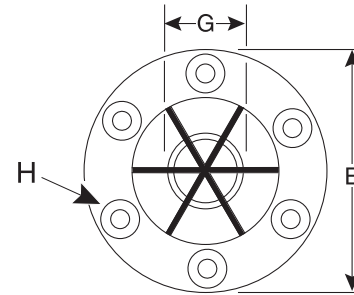
Side-Loc Xpansion Clamp Instructions



Lathe Version



Mill Version



- ▶ Expand Side-Loc to tighten ring. Machine it to fit workpiece bore, either on lathe or mill. *Aggressive material removal is not recommended when machining clamps to size.*
- ▶ For mill version, machine a pocket in the fixture plate for the "E" diameter and drill and tap mounting holes per the "H" column.
- ▶ A recessed dowel pin may be installed into the flange for additional rigidity if required.
- ▶ Range of expansion is .008 to .012/.20mm to .30mm (.20mm to .30mm).

	Part Number	Model No.	A	B	C	D	E ^{+0.000} -0.002	F	G*	H**	Hex Key	Torque not to Exceed (Ft/Lbs)	Holding Force (Lbs)	Replacement		
														Cam Shaft (M12x30MM)	Spring	Ring
INCH	31210	Mill #3	1.625	.875	.69	.75	1.968	1.12	.71	8-32 on 1.550 BHC	M6	49†	4,000	389001	31207	31202
	31370	Lathe #6	1.750	1.000	.84	.75	NA	2.09	.71	1.0	M6	49†	4,000	389001	31207	31202
							E ^{+0.000} -0.050					(N.m.)	(N.)			
METRIC	38210	Mill #3	41.3	22.2	17.5	19.0	50.0	28.7	17.8	M4 on 39.4 BHC	M6	66†	20000	389001	31207	31202
	38370	Lathe #6	44.4	25.4	21.3	19.0	N/A	53.3	17.8	25	M6	66†	20000	389001	31207	31202

G* - Minimum diameter the "F" dimension can be machined down to.

H** - (6) mounting screws included.

† - If high cycles, run max. torque 40 Ft/Lbs or 62 N.m.

