

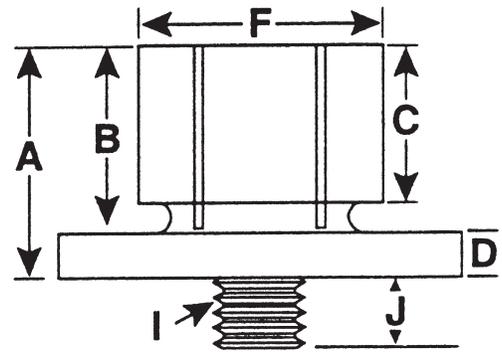
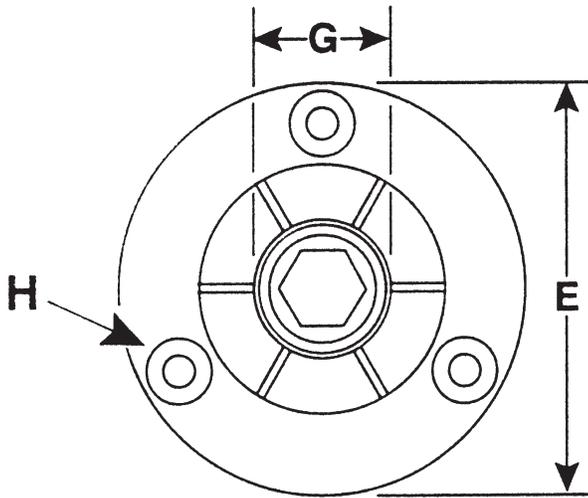
Machining and Installation

Expand clamp approximately .005 over relaxed diameter and machine to fit workpiece bore, either on lathe or mill.

If machining the clamp on a lathe use the nut provided, on the back of the clamp, to tighten the tapered screw. This nut is used only to machine the clamp.

Machine a pocket, in the fixture, for the close tolerance "E" dimension and drill and tap mounting holes per "H" column. Drill and tap a hole from the "I" column in the center of the pocket for the tapered screw.

A recessed dowel pin may be installed into the flange for additional rigidity if required.



Part Number	Model Number	A	B	C	D	+0.000 E -0.002	F	G†	H*	I	J
110200	#0	.86	.63	.59	.23	1.170	.49	.28	6-32 on .825 BHC	8-32	.30
110201	#1	.98	.75	.59	.23	1.240	.56	.48	6-32 on .910 BHC	1/4-20	.50
110202	#2	.98	.75	.59	.23	1.476	.79	.53	6-32 on 1.140 BHC	5/16-18	.56
110203	#3	1.13	.88	.69	.25	1.968	1.06	.71	8-32 on 1.550 BHC	3/8-16	.71
110204	#4	1.25	1.0	.81	.25	2.205	1.39	.90	8-32 on 1.790 BHC	1/2-13	.71
110205	#5	1.56	1.25	1.06	.31	2.736	1.65	1.15	10-32 on 2.200 BHC	5/8-11	.79
110206	#6	1.56	1.25	1.06	.31	2.972	2.03	1.15	10-32 on 2.515 BHC	5/8-11	.79
110207	#7	1.79	1.48	1.27	.31	4.232	3.06	1.15	1/4-20 on 3.646 BHC	5/8-11	.79

† - Minimum diameter the "F" dimension can be machined or turned down to.

H* - (3) Mounting Screws Included.

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