

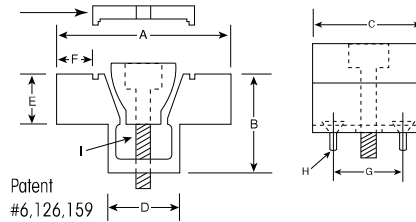
Machinable Uniforce® Clamps



The compact Mitee-Bite Uniforce® clamp is available with extra material on the clamping jaws so it can be machined to conform to the shape of your workpiece - enabling you to fixture unusual applications easily. The specially designed steel wedge spreads the clamping force uniformly on both sides of the 7075-T6 aluminum channel.

The locking plate properly expands the clamp, while making it rigid for machining. Machine to a slip fit of workpiece. Remove locking plate before clamping workpiece.

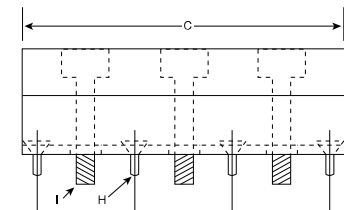
NOTE: When clamp is used to hold flat stock, use locking plate to machine faces parallel.



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

Model	Part No. with Locking Plate	Part No. Without Locking Plate	A*	B	C	D	E	F†	G	H**	I	Max. Torque (Ft/Lbs)	Holding Force (Lbs)	--Replacement-- Steel	
														Channel	Wedge
INCH															
500	60050	60055	1.125	.50	.62	.420	.25	.18	.400	2-56	8-32	2.5	500	60140	60310
750	60075	60080	1.500	.75	.94	.632	.37	.26	.625	6-32	1/4-20	10.0	1,500	60125	60320
1000	60100	60105	2.000	1.00	1.25	.820	.50	.39	.812	6-32	5/16-18	19.0	2,500	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	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	60180	60350
METRIC															
500	80050	80055	28.6	12.7	15.7	10.67	6.3	4.6	10.16	M2	M4	3.40	2,225	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	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	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	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	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.



LONG LENGTH MACHINABLE UNIFORCE® CLAMPS

Locking plate is required to machine channel without vibration. (See chart above)



This material is available in 7 1/2" (190mm) lengths. Custom clamps can be fabricated in different lengths to fit specific requirements. Channel and steel wedge are not drilled or plated.

Part Number	Model	A*	B	C	D	E	F†	H	I	Max. Torque (Ft/Lbs)	Holding Force (Lbs)
INCH											
60051	500 Channel	1.125	.50	7.50	.420	.25	.18	2-56	8-32	2.5	500
60052	500 Steel Wedge			7.50							
60071	750 Channel	1.500	.75	7.50	.632	.37	.26	6-32	1/4-20	10.8	1,500
60072	750 Steel Wedge			7.50							
60101	1000 Channel	2.000	1.00	7.50	.820	.50	.39	6-32	5/16-18	10.4	2,000
60102	1000 Steel Wedge			7.50							
60151	1500 Channel	3.000	1.50	7.50	1.215	.75	.62	10-32	1/2-13	28.3	3,500
60152	1500 Steel Wedge			7.50							
METRIC											
80051	500 Channel	28.6	12.7	190mm	10.67	6.3	4.6	M2	M4	3.40	2225
80071	750 Channel	38.1	19.1	190mm	16.05	9.4	6.6	M4	M6	14.30	6675
80101	1000 Channel	50.8	25.4	190mm	20.83	12.7	9.9	M4	M8	14.50	8900
80151	1500 Channel	76.2	38.1	190mm	30.86	19.1	15.7	M5	M12	38.40	15575

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. (3) Drive Screws and (4) Mounting Screws included.