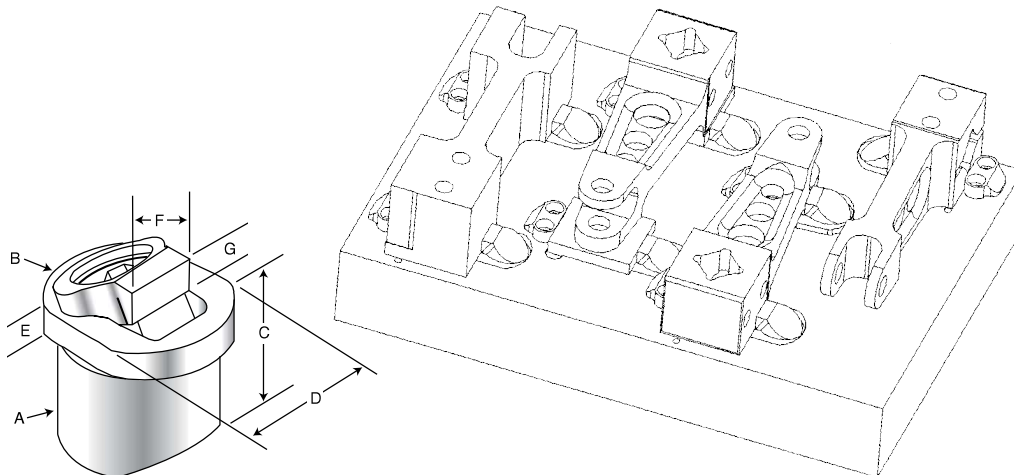


# Dyna-Force® Clamps



The majority of the Dyna-Force® clamp is below the surface of the fixture which provides excellent clamp support and makes for a very low profile. The clamp jaw slides on an angle for positive downforce.

- ▶ Incredible clamping and hold down power
- ▶ Low profile, compact design
- ▶ 17-4 PH stainless steel
- ▶ Smooth or serrated jaws
- ▶ Clamp comes assembled with alloy steel screw.
- ▶ Stainless steel screws and retaining rings are available for EDM applications.



Part Number	Replacement Insert*
28314	28480 (20mm smooth)
28318	28482 (20mm serrated)
28320	28484 (25mm smooth)
28322	28486 (25mm serrated)
28324	28488 (30mm smooth)
28328	28490 (30mm serrated)

\*Includes screw and retaining ring

Part Number	Clamp Jaw†	A*	B	C	D	E	F	G			Clamp Travel	Drive Screw	Key Size	Maximum Torque	Holding Force
								Min	Optimum	Max					
28314	Smooth 34RC	20.00	24.90	19.00	19.90	4.50	13.50	3.25	5.00	6.75	2.0	M6x12mm SHCS	5mm	7.3 (Ft/Lbs) - 9.9 (N.m)	2,000 (Lbs) - 8896 (N.)
28318	Serrated 44RC														
28320	Smooth 34RC	25.00	29.90	24.00	24.90	5.00	15.00	4.50	6.50	8.25	2.2	M8x16mm SHCS	6mm	17.6 (Ft/Lbs) - 23.9 (N.m)	2,600 (Lbs) - 11565 (N.)
28322	Serrated 44RC														
28324	Smooth 34RC	30.00	37.90	29.00	29.90	7.00	20.00	4.50	7.50	10.75	3.8	M10x18mm SHCS	8mm	35.3 (Ft/Lbs) - 41.9 (N.m)	3,200 (Lbs) - 14234 (N.)
28328	Serrated 44RC														

A\* - Body diameter      † - Smooth jaw only will have relief cut