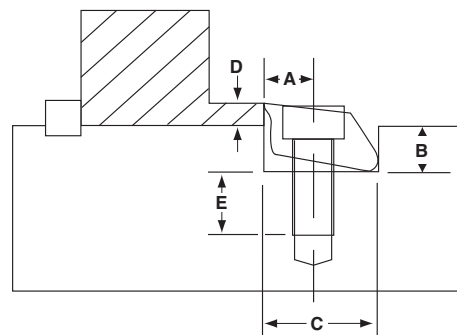


Creating Fixtures is Easy... Simply:

1. Machine a slot for the Pitbull® Clamp
2. Drill and tap a hole for the cap screw
3. Assemble the clamp as shown in diagram below
4. Position clamp as shown in diagram and loosely screw to fixture
5. Insert workpiece and tighten cap screw

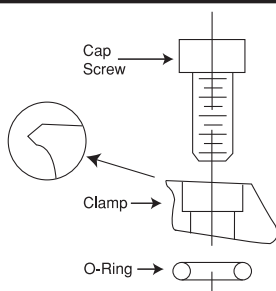
See Locating Rails page 28.



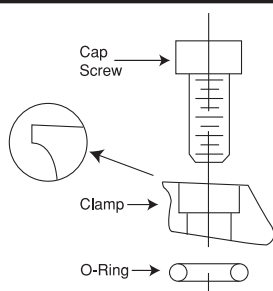
Part Number	Description	A	B	Clamp Width C	D*	E	Screw Size	Max. Torque (Ft/Lbs)	Holding Force (Lbs)	Total Throw	No. Clamps Per Package
INCH											
26000	Tool Steel, Knife Edge	.150	.140	.375	.075	.260	4-40	1.30	650	.0075	8
26010	Tool Steel, Blunt Edge	.150	.140	.375	.075	.260	4-40	1.30	650	.0075	8
26015	Brass, Blunt Edge	.150	.140	.375	.075	.220	4-40	.41	200	.0075	8
26020	Tool Steel, Knife Edge	.200	.187	.500	.100	.390	8-32	3.70	1,500	.0160	8
26030	Tool Steel, Blunt Edge	.200	.187	.500	.100	.390	8-32	3.70	1,500	.0160	8
26040	Brass, Blunt Edge	.200	.187	.500	.100	.340	8-32	2.00	400	.0160	8
26050	Tool Steel, Knife Edge	.300	.280	.750	.150	.570	1/4-20	14.50	3,600	.0240	6
26060	Tool Steel, Blunt Edge	.300	.280	.750	.150	.570	1/4-20	14.50	3,600	.0240	6
26065	Brass, Blunt Edge	.300	.280	.750	.150	.440	1/4-20	4.10	950	.0240	6
26070	Tool Steel, Knife Edge	.400	.450	1.000	.250	.710	3/8-16	30.00	6,000	.0500	4
26075	Tool Steel, Blunt Edge	.400	.450	1.000	.250	.710	3/8-16	30.00	6,000	.0500	4
26080	Tool Steel, Knife Edge	.600	.640	1.500	.375	.770	1/2-13	108.30	12,000	.0750	2
26085	Tool Steel, Blunt Edge	.600	.640	1.500	.375	.770	1/2-13	108.30	12,000	.0750	2
								(N.m.)	(N.)		
METRIC											
56000	Tool Steel, Knife Edge	3.81	3.55	9.52	1.90	6.60	M2.5	1.8	2800	.190	8
56010	Tool Steel, Blunt Edge	3.81	3.55	9.52	1.90	6.60	M2.5	1.8	2800	.190	8
56015	Brass, Blunt Edge	3.81	3.55	9.52	1.90	5.59	M2.5	.56	875	.190	8
56020	Tool Steel, Knife Edge	5.08	4.75	12.70	2.54	9.90	M4	5.6	6600	.406	8
56030	Tool Steel, Blunt Edge	5.08	4.75	12.70	2.54	9.90	M4	5.6	6600	.406	8
56040	Brass, Blunt Edge	5.08	4.75	12.70	2.54	8.64	M4	2.8	1750	.406	8
56050	Tool Steel, Knife Edge	7.62	7.11	19.05	3.81	14.48	M6	22.5	16000	.610	6
56060	Tool Steel, Blunt Edge	7.62	7.11	19.05	3.81	14.48	M6	22.5	16000	.610	6
56065	Brass, Blunt Edge	7.62	7.11	19.05	3.81	11.18	M6	5.6	4200	.610	6
56070	Tool Steel, Knife Edge	10.16	11.43	25.40	6.35	18.03	M10	40.6	26000	1.270	4
56075	Tool Steel, Blunt Edge	10.16	11.43	25.40	6.35	18.03	M10	40.6	26000	1.270	4
56080	Tool Steel, Knife Edge	15.24	16.26	38.10	9.52	19.56	M12	145.0	50000	1.900	2
56085	Tool Steel, Blunt Edge	15.24	16.26	38.10	9.52	19.56	M12	145.0	50000	1.900	2

D* - Minimum clamp height

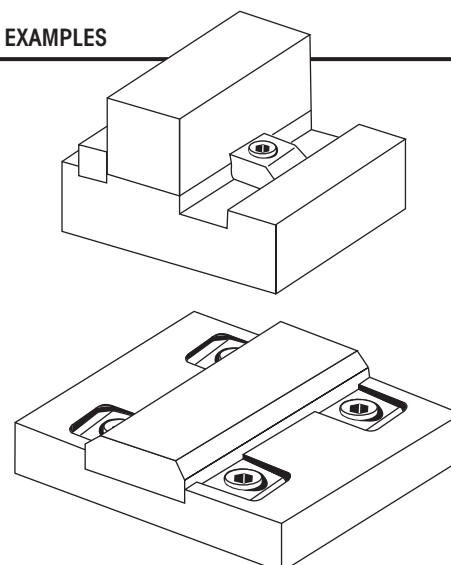
KNIFE EDGE



BLUNT EDGE



FIXTURE EXAMPLES



Both versions of the tool steel clamps generate the same clamping pressure. However, the Knife Edge clamps bite into the material for more aggressive machining, while the Blunt Edge is less likely to mark the workpiece.