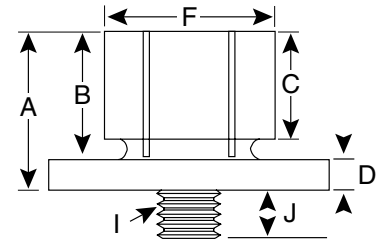
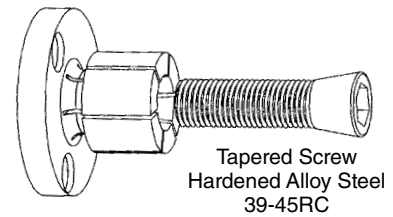


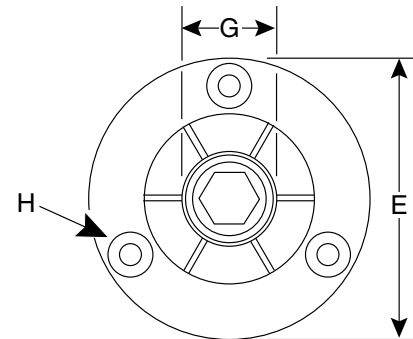
## Model #00 - #6 ID Xpansion™ Clamps

- ▶ Expand clamp approximately .002 to .003 (.1mm) 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 while machining 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.
- ▶ Custom screws available for blind hole applications.
- ▶ Range of expansion .005 to .025 (.13 to .64mm) depending upon size. See [MiteeBite.com](http://MiteeBite.com) for individual clamp expansion range.



## Model #7 - #10 ID Xpansion™ Clamps

- ▶ Locking ring provided to ensure segments remain rigid while machining clamps to size. #10 ID ships with 2 rings.
- ▶ Insert ring(s) and tighten drive screw, machine clamp to bore size. Remove ring(s) to clamp workpiece.
- ▶ Expand mandrel then machine to size.
- ▶ Aggressive material removal is not recommended when machining clamps to size.



Longer tapered screws are available for each ID size.

	Part No.	Model No.	A	B	C	D	E <sup>+0.000 -0.002</sup>	F	G†	H*	I	J	Max. Torque (Ft/Lbs)	Holding Force (Lbs)	Replacement Tapered Screw
INCH	31000	#00	.42	.30	.24	.12	.787	.29	.16	2-56 on .540 BHC	2-56 x 1/2	.16	0.5	250	31001
	31050	#0	.86	.63	.59	.23	1.170	.49	.28	6-32 on .825 BHC	8-32 x 1	.30	3.6	950	31002
	31100	#1	.98	.75	.59	.23	1.240	.56	.48	6-32 on .910 BHC	1/4-20 x 1 1/4	.50	13.3	1,900	31010
	31150	#2	.98	.75	.59	.23	1.476	.79	.53	6-32 on 1.140 BHC	5/16-18 x 1 1/4	.56	27.6	2,500	31020
	31200	#3	1.13	.88	.69	.25	1.968	1.06	.71	8-32 on 1.550 BHC	3/8-16 x 1 1/2	.71	49.3	4,500	31032
	31250	#4	1.25	1.00	.81	.25	2.205	1.39	.90	8-32 on 1.790 BHC	1/2-13 x 1 1/2	.71	120.0	5,900	31042
	31300	#5	1.56	1.25	1.06	.31	2.736	1.65	1.15	10-32 on 2.200 BHC	5/8-11 x 1 3/4	.79	224.0	10,000	31052
	31350	#6	1.56	1.25	1.06	.31	2.972	2.03	1.15	10-32 on 2.515 BHC	5/8-11 x 1 3/4	.79	224.0	10,000	31052
	31400	#7	1.79	1.48	1.27	.31	4.232	3.06	1.15	1/4-20 on 3.646 BHC	5/8-11 x 2	.79	224.0	10,000	31072
	31450	#8	1.79	1.48	1.27	.31	5.232	4.06	1.15	1/4-20 on 4.648 BHC	5/8-11 x 2	.79	224.0	10,000	31072
	31500	#9	1.79	1.48	1.27	.31	5.232	6.89	1.15	1/4-20 on 4.648 BHC	5/8-11 x 2	.79	224.0	10,000	31072
	31550	#10**	1.79	1.48	1.27	.31	6.000	9.85	1.15	1/4-20 on 5.250 BHC	5/8-11 x 2	.79	125.0	6,000	31072

	Part No.	Model No.	A	B	C	D	E <sup>+0.000 -0.050</sup>	F	G†	H*	I	J	Max. Torque (N.m.)	Holding Force (N)	Replacement Tapered Screw
METRIC	38000	#00	10.7	7.6	6.1	3.0	20.00	7.4	4.1	M2 on 13.7 BHC	M2x12	4.1	.70	1113	38001
	38050	#0	21.8	16.0	15.0	5.9	29.72	12.4	7.1	M3 on 20.95 BHC	M4x25	7.2	5.00	4228	38002
	38100	#1	24.9	19.0	15.0	5.9	31.50	14.2	12.2	M3 on 23.1 BHC	M6x30	11.2	17.00	8455	38010
	38150	#2	24.9	19.0	15.0	5.9	37.50	20.0	13.5	M3 on 29.0 BHC	M8x30	13.2	34.00	11125	38020
	38200	#3	28.6	22.2	17.5	6.4	50.00	27.0	18.0	M4 on 39.4 BHC	M10x35	16.3	60.00	20025	38032
	38250	#4	31.8	25.4	20.6	6.4	56.00	35.3	23.0	M4 on 45.5 BHC	M12x40	20.3	150.00	26255	38042
	38300	#5	39.6	31.8	27.0	7.9	69.50	42.0	29.3	M5 on 55.9 BHC	M16x45	21.4	280.00	44500	38052
	38350	#6	39.6	31.8	27.0	7.9	75.50	51.5	29.3	M5 on 63.9 BHC	M16x45	21.4	280.00	44500	38052
	38400	#7	45.5	37.6	32.3	7.9	107.50	77.7	29.3	M6 on 92.6 BHC	M16x50	19.3	280.00	44500	38072
	38450	#8	45.5	37.6	32.3	7.9	132.90	103.0	29.3	M6 on 118.06 BHC	M16x50	19.3	280.00	44500	38072
	38500	#9	45.5	37.6	32.3	7.9	132.90	175.0	29.3	M6 on 118.06 BHC	M16x50	19.3	280.00	44500	38072
	38550	#10**	45.5	37.6	32.3	7.9	152.40	250.2	29.3	M6 on 133.35 BHC	M16x50	19.3	170.00	26000	38072

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

H\* - (3) Mounting Screws included - (4) for model numbers #9 and #10.

\*\*Model #10 Made from 7075-T6 aluminum.