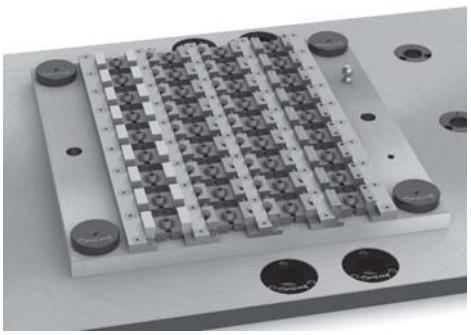
TINY VISE®
EDGE CLAMPS

BODY: 1018 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH
THRUST WASHER: 1144 STEEL, HEAT TREATED, BLACK OXIDE FINISH
FLAT-HEAD SOCKET SCREW: STEEL, BLACK OXIDE FINISH

Modular Jaw

M-series clamps have a 1/4”-thick modular jaw that can be easily extended to insert or remove spacers. Up to three 1/16” spacers can be inserted to provide adjustment.



PATENT PENDING

NEW! Our Tiny Vise® M-series incorporates a modular jaw design for greater adjustability. This new modular system allows adjusting your workpiece engagement point by adding or removing spacers. This is useful when using the same fixture for machining a family of parts, or when workpiece size can vary somewhat between batches.

The base M-series clamp is the same size as a standard Tiny Vise®, with the same reversible jaw faces (one serrated and one smooth). The 1/4”-thick serrated modular jaw mounts into the smooth face, and each spacer adds another 1/16”. Up to three spacers can be inserted to provide adjustment. The modular jaw assembly is held together securely by a tough, durable O-ring, recessed in a protective groove. The modular jaw can be easily extended to insert or remove the slotted spacers.

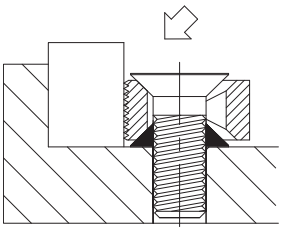
Just like our original Tiny Vise®, these mini edge clamps grip the side of a workpiece to keep the top clear for machining. Patented design features a slotted countersink to provide strong, reliable clamping force with the easy turn of a hex wrench. These compact clamps are ideal for fixturing multiple parts, small or large. Each clamp has both a serrated face (for maximum gripping) and a smooth face (to avoid marring finished parts). These clamps look so simple, but work amazingly well, with major advantages over earlier designs. Patent number 5,624,106. Made in USA.

Clamping force is applied by positive screw action with the easy turn of a hex wrench (not with an unreliable, unsafe eccentric cam as used in other designs). A high-strength Flat-Head Socket Screw engages a mating offset countersink to exert strong clamping force. Much more durable than other designs.

Only Tiny Vise® Edge Clamps truly exert down thrust force on the workpiece, to prevent it from lifting. A thrust washer underneath the clamp engages a mating offset countersink to provide downward action.

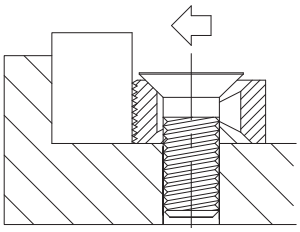
Available in two sizes, 5/16-18 thread size (240 lbs clamping force) and 1/2-13 thread size (800 lbs clamping force). Tiny Vise® clamps are designed to provide strong clamping force when tightened by hand. Do not exceed the recommended tightening torque.

TINY VISE®
EDGE CLAMPS



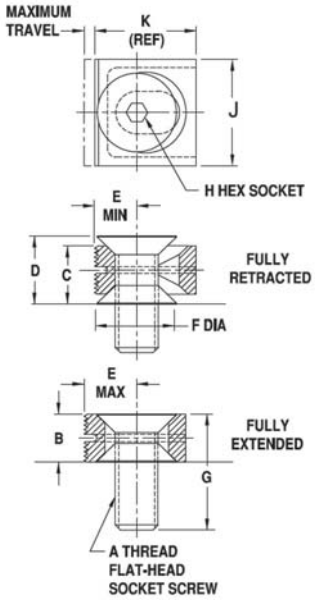
Setup for Downthrust Force
(with Bottom Thrust Washer)

All clamps are supplied with an optional Bottom Thrust Washer (shown in black). Installing this washer under the clamp will raise the clamp slightly and provide downthrust force during clamping.



Setup for Horizontal Force
(without Bottom Thrust Washer)

If no downthrust force is required, install the clamp without the Bottom Thrust Washer. Doing so will improve clamping speed because fewer screw turns are required.



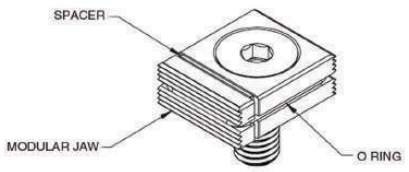
MODULAR JAW (INCH)
SETUP FOR DOWNTHRUST FORCE

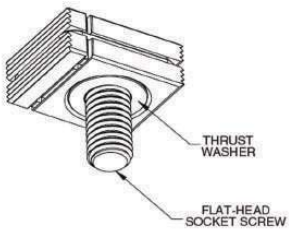
PART NO.	A	B	C	D	E MIN	E MID RANGE	E MAX	F DIA	G	H	J	K	MAXIMUM TRAVEL	RECOMMENDED TORQUE (FT-LBS)*	APPROX. HORIZONTAL CLAMPING FORCE AT RECOMMENDED TORQUE (LBS)*
CL-5-TVM	5/16-18	.438	.550	.652	.338	.386	.434	.640	1	3/16	1	.870	.096	1.2	240
CL-8-TVM	1/2-13	.562	.702	.833	.474	.534	.594	.897	1-3/8	5/16	1-1/4	1.187	.120	6.6	800

MODULAR JAW (INCH)
SETUP FOR HORIZONTAL FORCE

PART NO.	A	B	C	D	E MIN	E MID RANGE	E MAX	F DIA	G	H	J	K	MAXIMUM TRAVEL	RECOMMENDED TORQUE (FT-LBS)*	APPROX. HORIZONTAL CLAMPING FORCE AT RECOMMENDED TORQUE (LBS)*
CL-5-TVM	5/16-18	.438	.438	.540	.338	.386	.434	.640	1	3/16	1	.870	.096	2.4	240
CL-8-TVM	1/2-13	.562	.652	.693	.474	.534	.594	.897	1-3/8	5/16	1-1/4	1.187	.120	13	800

*Recommended torque and clamping force are at 1/3 of yield strength, leaving 2/3 of holding capacity to resist external cutting forces, etc.





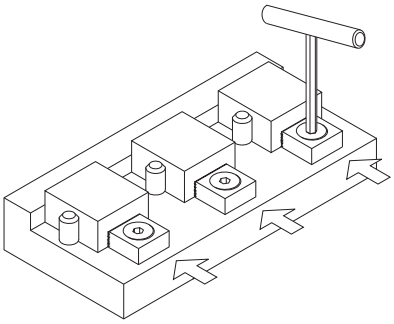
SPARE PARTS

COMPLETE CLAMP PART NO.	MODULAR JAW (SERRATED)	SPACER	O RING	THRUST WASHER	FLAT-HEAD SOCKET SCREW
CL-5-TVM	5-TVM-JAW-ASSY	5-TVM-SPAC	5-TVM-ORING	5-TV-WASH	CL-5/16-18X1.00-FHSS
CL-8-TVM	8-TVM-JAW-ASSY	8-TVM-SPAC	8-TVM-ORING	8-TV-WASH	CL-1/2-13X1.38-FHSS

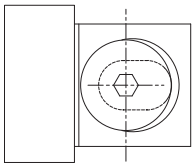
TINY VISE®
EDGE CLAMPS

BODY: 1018 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH
THRUST WASHER: 1144 STEEL, HEAT TREATED, BLACK OXIDE FINISH
FLAT-HEAD SOCKET SCREW: STEEL, BLACK OXIDE FINISH

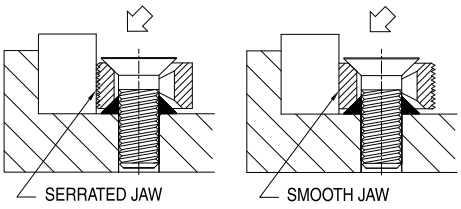
Flat Jaw
(Reversible, Serrated or Smooth)



Clamping force is applied by positive screw action with the easy turn of a hex wrench.



Patented design features a slotted countersink.



The serrated face provides maximum gripping, while the smooth face (turn 180°) helps avoid marring finished parts.

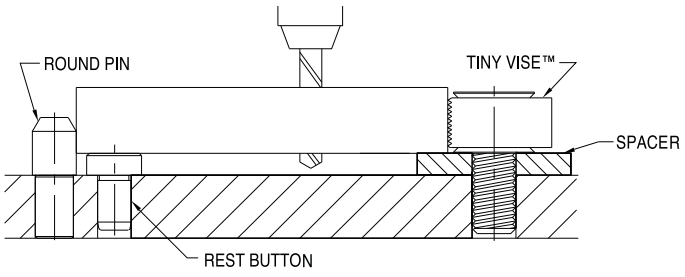
Perfect for high-density machining! These mini edge clamps grip the side of a workpiece to keep the top clear for machining. Patented design features a slotted countersink to provide strong, reliable clamping force with the easy turn of a hex wrench. These compact clamps are ideal for fixturing multiple parts, small or large. Each clamp has both a serrated face (for maximum gripping) and a smooth face (to avoid marring finished parts). These clamps look so simple, but work amazingly well, with major advantages over earlier designs. Patent number 5,624,106. Made in USA.

Clamping force is applied by positive screw action with the easy turn of a hex wrench (not with an unreliable, unsafe eccentric cam as used in other designs). A high-strength Flat-Head Socket Screw engages a mating offset countersink to exert strong clamping force. Much more durable than other designs.

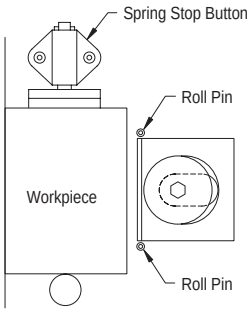
Only Tiny Vise® Edge Clamps truly exert down thrust force on the workpiece, to prevent it from lifting. A thrust washer underneath the clamp engages a mating offset countersink to provide downward action.

Available in a wide range of sizes, from a miniature #8-32 thread size, up to a powerful 1"-8 thread size with 2500 lbs clamping force.

Tiny Vise® clamps are designed to provide strong clamping force when tightened by hand. Do not exceed the recommended tightening torque.

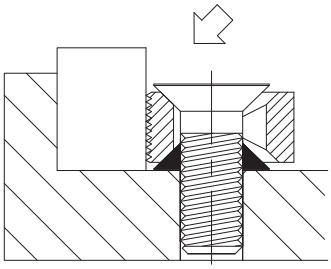


For a small amount of cutting-tool clearance, Tiny Vise® Edge Clamps can be mounted with a spacer underneath, using a longer screw. For greater clearance, clamps should be mounted into a tapped riser block fastened to the plate, to reduce bending stress on the screw.



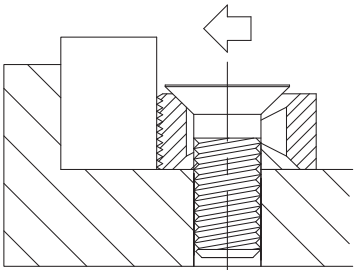
Roll pins can be installed to keep the Tiny Vise® perfectly aligned for workpiece loading (especially helpful on horizontal machining centers).

TINY VISE®
EDGE CLAMPS



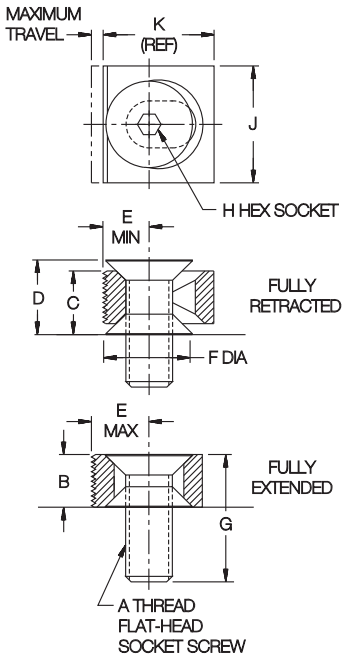
Setup for Downthrust Force
(with Bottom Thrust Washer)

All clamps are supplied with an optional Bottom Thrust Washer (shown in black). Installing this washer under the clamp will raise the clamp slightly and provide downthrust force during clamping.



Setup for Horizontal Force
(without Bottom Thrust Washer)

If no downthrust force is required, install the clamp without the Bottom Thrust Washer. Doing so will improve clamping speed because fewer screw turns are required.



FLAT JAW (INCH)
SETUP FOR DOWNTHRUST FORCE

PART NO.	A	B	C	D	E MIN	E MID RANGE	E MAX	F DIA	G	H	J	K	MAXIMUM TRAVEL	RECOMMENDED TORQUE (FT-LBS)*	APPROX. HORIZONTAL CLAMPING FORCE AT RECOMMENDED TORQUE (LBS)*
CL-2-TV	#8-32	.250	.319	.382	.175	.205	.235	.335	5/8	3/32	9/16	.470	.060	.20	60
CL-3-TV	#10-32	.312	.390	.459	.208	.242	.274	.390	3/4	1/8	5/8	.550	.066	.25	75
CL-4-TV	1/4-20	.375	.467	.552	.280	.320	.360	.510	7/8	5/32	7/8	.720	.080	.50	130
CL-5-TV	5/16-18	.438	.550	.652	.338	.386	.434	.640	1	3/16	1	.870	.096	1.2	240
CL-6-TV	3/8-16	.500	.627	.746	.390	.445	.500	.742	1-1/8	7/32	1-1/8	1.000	.110	2.3	370
CL-8-TV	1/2-13	.562	.702	.833	.474	.534	.594	.897	1-3/8	5/16	1-1/4	1.187	.120	6.6	800
CL-10-TV	5/8-11	.750	.901	1.039	.620	.685	.750	1.148	1-5/8	3/8	1-5/8	1.500	.130	12	1,200
CL-12-TV	3/4-10	.875	1.059	1.234	.740	.820	.900	1.394	2	1/2	2	1.800	.160	23	1,800
CL-16-TV	1”-8	1.125	1.355	1.573	.988	1.088	1.188	1.890	2-1/2	5/8	2-1/2	2.375	.200	42	2,500

FLAT JAW (INCH)
SETUP FOR HORIZONTAL FORCE

CL-2-TV	#8-32	.250	.250	.313	.175	.205	.235	.335	5/8	3/32	9/16	.470	.060	.40	60
CL-3-TV	#10-32	.312	.312	.381	.208	.242	.274	.390	3/4	1/8	5/8	.550	.066	.50	75
CL-4-TV	1/4-20	.375	.375	.460	.280	.320	.360	.510	7/8	5/32	7/8	.720	.080	1.0	130
CL-5-TV	5/16-18	.438	.438	.540	.338	.386	.434	.640	1	3/16	1	.870	.096	2.4	240
CL-6-TV	3/8-16	.500	.500	.619	.390	.445	.500	.742	1-1/8	7/32	1-1/8	1.000	.110	4.6	370
CL-8-TV	1/2-13	.562	.652	.693	.474	.534	.594	.897	1-3/8	5/16	1-1/4	1.187	.120	13	800
CL-10-TV	5/8-11	.750	.750	.888	.620	.685	.750	1.148	1-5/8	3/8	1-5/8	1.500	.130	24	1,200
CL-12-TV	3/4-10	.875	.875	1.050	.740	.820	.900	1.394	2	1/2	2	1.800	.160	46	1,800
CL-16-TV	1”-8	1.125	1.125	1.343	.988	1.088	1.188	1.890	2-1/2	5/8	2-1/2	2.375	.200	84	2,500

*Recommended torque and clamping force are at 1/3 of yield strength, leaving 2/3 of holding capacity to resist external cutting forces, etc.

TINY VISE®
DOUBLE EDGE CLAMPS

BODY: 1018 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH. SPRINGS: 302 STAINLESS STEEL
GUIDE PINS: 17 4-PH STAINLESS STEEL. THRUST WASHER: 1144 STEEL, HEAT TREATED, BLACK OXIDE FINISH
SOCKET-HEAD CAP SCREW: STEEL, BLACK OXIDE FINISH

Two Serrated Flat Jaws

Two Smooth Flat Jaws

Double edge clamps allow clamping two workpieces at the same time with equal force. These mini edge clamps grip the side of a workpiece to keep the top clear for machining. Patented design provides strong, reliable clamping force with the easy turn of a hex wrench. These compact clamps are ideal for fixturing multiple parts, small or large. Available with serrated jaws (for maximum gripping) or smooth jaws (to avoid marring finished parts). These clamps look so simple, but work amazingly well, with major advantages over earlier designs. Patent number 5,961,108. Made in USA.

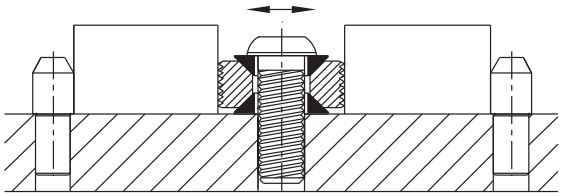
Clamping force is applied by positive screw action with the easy turn of a hex wrench (not with an unreliable, unsafe eccentric cam as used in other designs). A high-strength cap screw and Thrust Washer engage a mating offset countersink to exert strong clamping force. Much more durable than other designs.

Only Tiny Vise® Mini Edge Clamps truly exert down thrust force on the workpiece, to prevent it from lifting. A Thrust Washer underneath the clamp engages a mating offset countersink to provide downward action.

Only Tiny Vise® Double Edge Clamps compensate for size variation when clamping two workpieces. Thrust Washers have ID clearance to enable them to float horizontally, allowing both clamping jaws to contact their part simultaneously. This ensures that both parts are securely clamped with equal force.

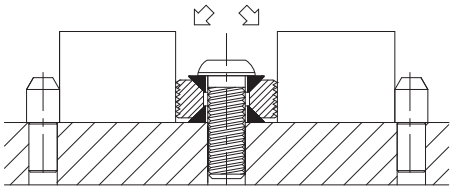
Available in four sizes, from 5/16-18 up to a powerful 1”-8 thread size with 4500 lbs clamping force (M8 to M24 in metric).

Please note: Tiny Vise® clamps are designed to provide strong clamping force when tightened by hand. Do not exceed the recommended tightening torque. Double edge clamps should always be used to hold two workpieces, not just one; otherwise recommended torque and clamping force will be significantly reduced.



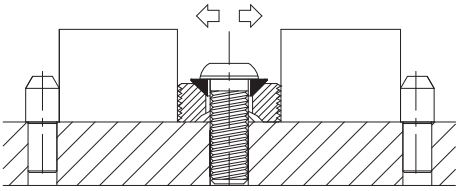
Thrust Washers have ID clearance to enable them to float horizontally, allowing both clamping jaws to contact their workpiece simultaneously even if parts are slightly different in size. This ensures that both parts are securely clamped with equal force.

TINY VISE®
DOUBLE EDGE CLAMPS



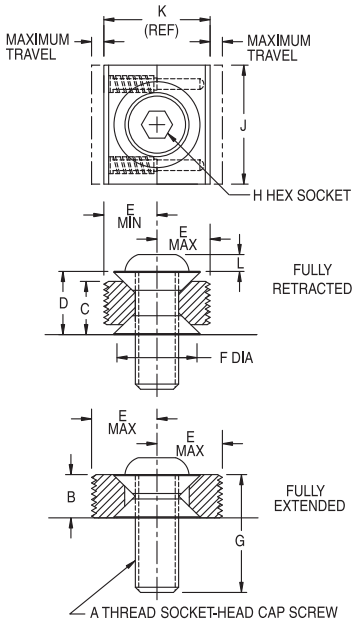
Setup for Downthrust Force
(with Bottom Thrust Washer)

All clamps are supplied with two Thrust Washers (shown in black). The Bottom Thrust Washer is optional. Installing this washer will raise the clamp slightly and provide downthrust force during clamping.



Setup for Horizontal Force
(without Bottom Thrust Washer)

If no downthrust force is required, install the clamp without the Bottom Thrust Washer. Doing so will improve clamping speed because fewer screw turns are required.



DOUBLE FLAT JAWS (INCH) — SETUP FOR DOWNTHRUST FORCE

PART NO. SERRATED JAWS	PART NO. SMOOTH JAWS	A	B	C	D	E MIN	E MID RANGE	E MAX	F DIA	G	H	J	K	L	ALLOWABLE WORKPIECE SIZE DIFFERENTIAL	MAXIMUM TRAVEL (WITH NO SIZE DIFFERENTIAL)	RECOM-MENDED TORQUE (FT-LBS)*	APPROX. HORIZONTAL CLAMPING FORCE AT RECOMMENDED TORQUE (LBS)*
CL-50-TV	CL-55-TV	5/16-18	.375	.486	.597	.422	.470	.518	.625	1	3/16	1	.844	.16	.048	.096	4.5	450
CL-60-TV	CL-65-TV	3/8-16	.438	.570	.684	.520	.572	.625	.750	1-1/8	7/32	1-1/4	1.250	.19	.052	.105	8	650
CL-80-TV	CL-85-TV	1/2-13	.500	.635	.770	.641	.698	.755	.875	1-1/4	5/16	1-3/8	1.282	.26	.060	.114	19	1200
CL-100-TV	CL-105-TV	5/8-11	.625	.765	.905	.690	.750	.810	1.125	1-1/2	3/8	1-1/2	1.380	.32	.078	.120	38	1800
CL-160-TV	CL-165-TV	1”-8	1.000	1.159	1.318	1.109	1.178	1.247	1.875	2-1/4	3/4	2-1/2	2.218	1.00	.094	.138	150	4500

DOUBLE FLAT JAWS (INCH) — SETUP FOR HORIZONTAL FORCE

CL-50-TV	CL-55-TV	5/16-18	.375	.375	.486	.422	.470	.518	.625	1	3/16	1	.844	.16	.048	.096	9	450
CL-60-TV	CL-65-TV	3/8-16	.438	.438	.552	.520	.572	.625	.750	1-1/8	7/32	1-1/4	1.250	.19	.052	.105	16	650
CL-80-TV	CL-85-TV	1/2-13	.500	.500	.635	.641	.698	.755	.875	1-1/4	5/16	1-3/8	1.282	.26	.060	.114	38	1200
CL-100-TV	CL-105-TV	5/8-11	.625	.625	.765	.690	.750	.810	1.125	1-1/2	3/8	1-1/2	1.380	.32	.078	.120	76	1800
CL-160-TV	CL-165-TV	1”-8	1.000	1.000	1.159	1.109	1.178	1.247	1.875	2-1/4	3/4	2-1/2	2.218	1.00	.094	.138	300	4500

DOUBLE FLAT JAWS (METRIC) — SETUP FOR DOWNTHRUST FORCE

CLM-50-TV	CLM-55-TV	M8	.375	.486	.597	.422	.470	.518	.625	1	5mm	1	.844	.16	.048	.096	4.5	450
CLM-60-TV	CLM-65-TV	M10	.438	.570	.684	.520	.572	.625	.750	1-1/8	6mm	1-1/4	1.250	.19	.052	.105	10	750
CLM-80-TV	CLM-85-TV	M12	.500	.635	.770	.641	.698	.755	.875	1-1/4	8mm	1-3/8	1.282	.26	.060	.114	18	1100
CLM-100-TV	CLM-105-TV	M16	.625	.765	.905	.690	.750	.810	1.125	1-1/2	10mm	1-1/2	1.380	.32	.078	.120	42	2000
CLM-160-TV	CLM-160-TV	M24	1.000	1.000	1.318	1.109	1.178	1.247	1.875	2-1/4	19mm	2-1/2	2.218	1.00	.094	.138	130	4000

DOUBLE FLAT JAWS (METRIC) — SETUP FOR HORIZONTAL FORCE

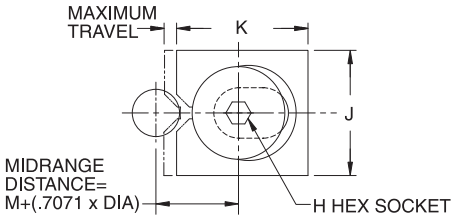
CLM-50-TV	CLM-55-TV	M8	.375	.375	.486	.422	.470	.518	.625	1	5mm	1	.844	.16	.048	.096	9	450
CLM-60-TV	CLM-65-TV	M10	.438	.438	.570	.520	.572	.625	.750	1-1/8	6mm	1-1/4	1.250	.19	.052	.105	20	750
CLM-80-TV	CLM-85-TV	M12	.500	.500	.635	.641	.698	.755	.875	1-1/4	8mm	1-3/8	1.282	.26	.060	.114	35	1100
CLM-100-TV	CLM-105-TV	M16	.625	.625	.765	.690	.750	.810	1.125	1-1/2	10mm	1-1/2	1.380	.32	.078	.120	84	2000
CLM-160-TV	CLM-160-TV	M24	1.000	1.000	1.159	1.109	1.178	1.247	1.875	2-1/4	19mm	2-1/2	2.218	1.00	.094	.138	260	4000

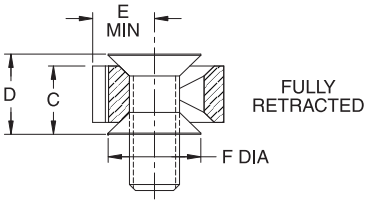
*Recommended torque and clamping force are at 1/3 of yield strength, leaving 2/3 of holding capacity to resist external cutting forces, etc.

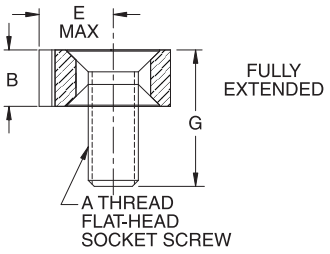
TINY VISE® EDGE CLAMPS

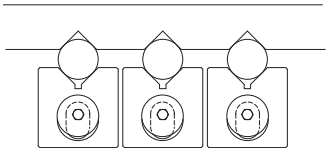
V-Jaw

The new V-Jaw version of our popular Tiny Vise® is ideal for clamping round workpieces. The 90° V-Jaw can also be used to clamp a rectangular workpiece from two directions with a single clamp at its corner.

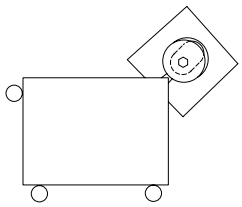








Multiple workpieces can be clamped extremely close together.



A rectangular workpiece can be clamped from two directions with a single clamp.

V-JAW (INCH)
SETUP FOR DOWNTHRUST FORCE

PART NO.	A	B	C	D	E MIN	E MID RANGE	E MAX	F DIA	G	H	J	K	M	MAXIMUM WORKPIECE DIAMETER	MAXIMUM TRAVEL	RECOM-MENDED TORQUE (FT-LBS)*	APPROX. HORIZONTAL CLAMPING FORCE AT RECOMMENDED TORQUE (LBS)*
CL-2-TVR	#8-32	.250	.319	.382	.292	.322	.352	.335	5/8	3/32	.625	.620	.212	3/8	.060	.20	60
CL-3-TVR	#10-32	.312	.390	.459	.375	.407	.940	.390	3/4	1/8	.750	.750	.253	1/2	.066	.25	75
CL-4-TVR	1/4-20	.375	.467	.552	.453	.493	.533	.510	7/8	5/32	.875	.900	.315	19/32	.080	.50	130
CL-5-TVR	5/16-18	.438	.550	.652	.562	.611	.660	.640	1	3/16	1.000	1.100	.410	11/16	.096	1.2	240
CL-6-TVR	3/8-16	.500	.627	.746	.687	.742	.797	.742	1-1/8	7/32	1.250	1.300	.454	15/16	.110	2.3	370
CL-8-TVR	1/2-13	.562	.702	.833	.812	.872	.932	.897	1-3/8	5/16	1.500	1.530	.557	1-1/32	.120	6.6	800
CL-10-TVR	5/8-11	.750	.901	1.039	1.124	1.157	1.254	1.148	1-5/8	3/8	2.000	2.100	.692	1-9/16	.130	12	1,200
CL-12-TVR	3/4-10	.875	1.059	1.234	1.344	1.424	1.504	1.394	2	1/2	2.500	2.500	.848	1-13/16	.160	23	1,800
CL-16-TVR	1"-8	1.125	1.355	1.573	1.687	1.782	1.887	1.890	2-1/2	5/8	3.000	3.200	1.137	2-1/16	.200	42	2,500

V-JAW (INCH)
SETUP FOR HORIZONTAL FORCE

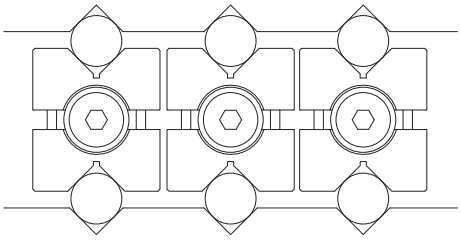
CL-2-TVR	#8-32	.250	.250	.313	.292	.322	.352	.335	5/8	3/32	.625	.620	.212	3/8	.060	.40	60
CL-3-TVR	#10-32	.312	.312	.381	.375	.407	.940	.390	3/4	1/8	.750	.750	.253	1/2	.066	.50	75
CL-4-TVR	1/4-20	.375	.375	.460	.453	.493	.533	.510	7/8	5/32	.875	.900	.315	19/32	.080	1.0	130
CL-5-TVR	5/16-18	.438	.438	.540	.562	.611	.660	.640	1	3/16	1.000	1.100	.410	11/16	.096	2.4	240
CL-6-TVR	3/8-16	.500	.500	.619	.687	.742	.797	.742	1-1/8	7/32	1.250	1.300	.454	15/16	.110	4.6	370
CL-8-TVR	1/2-13	.562	.652	.693	.812	.872	.932	.897	1-3/8	5/16	1.500	1.530	.557	1-1/32	.120	13	800
CL-10-TVR	5/8-11	.750	.750	.888	1.124	1.157	1.254	1.148	1-5/8	3/8	2.000	2.100	.692	1-9/16	.130	24	1,200
CL-12-TVR	3/4-10	.875	.875	1.050	1.344	1.424	1.504	1.394	2	1/2	2.500	2.500	.848	1-13/16	.160	46	1,800
CL-16-TVR	1"-8	1.125	1.125	1.343	1.687	1.782	1.887	1.890	2-1/2	5/8	3.000	3.200	1.137	2-1/16	.200	84	2,500

*Recommended torque and clamping force are at 1/3 of yield strength, leaving 2/3 of holding capacity to resist external cutting forces, etc.

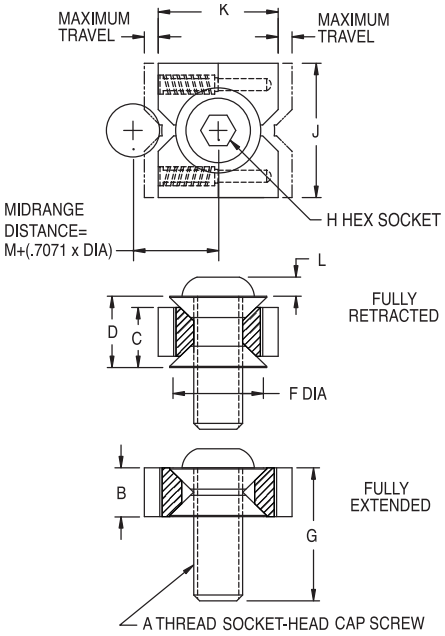
TINY VISE®
DOUBLE EDGE CLAMPS

Two V-Jaws

The new V-Jaw version of our popular Tiny Vise® is ideal for clamping round workpieces. The 90° V-Jaw can also be used to clamp a rectangular workpiece from two directions with a single clamp at its corner. Double edge clamps allow clamping two workpieces at the same time with equal force.



Multiple workpieces can be clamped extremely close together.



DOUBLE V-JAWS (INCH) — SETUP FOR DOWNTHRUST FORCE

PART NO.	A	B	C	D	F DIA	G	H	J	K	L	M	MAXIMUM WORKPIECE DIAMETER	ALLOWABLE WORKPIECE SIZE DIFFERENTIAL	MAX. TRAVEL (WITH NO SIZE DIFFERENTIAL)	RECOM-MENDED TORQUE (FT-LBS)*	APPROX. HORIZONTAL CLAMPING FORCE AT RECOMMENDED TORQUE (LBS)*
CL-50-TVR	5/16-18	.375	.486	.597	.625	1	3/16	1-1/4	1.308	.16	.421	3/4	.048	.096	4.5	450
CL-60-TVR	3/8-16	.438	.570	.684	.750	1-1/8	7/32	1-3/8	1.478	.19	.482	27/32	.052	.105	8	650
CL-80-TVR	1/2-13	.500	.635	.770	.875	1-1/4	5/16	1-1/2	1.706	.26	.569	15/16	.060	.114	19	1200
CL-100-TVR	5/8-11	.625	.765	.905	1.125	1-1/2	3/8	1-3/4	2.104	.32	.706	1-1/8	.078	.120	38	1800
CL-160-TVR	1”-8	1.000	1.159	1.318	1.875	2-1/4	3/4	2-1/2	3.350	1.00	1.119	1-3/4	.094	.138	150	4500

DOUBLE V-JAWS (INCH) — SETUP FOR HORIZONTAL FORCE

CL-50-TVR	5/16-18	.375	.375	.486	.625	1	3/16	1-1/4	1.308	.16	.421	3/4	.048	.096	9	450
CL-60-TVR	3/8-16	.438	.438	.570	.750	1-1/8	7/32	1-3/8	1.478	.19	.482	27/32	.052	.105	16	650
CL-80-TVR	1/2-13	.500	.500	.635	.875	1-1/4	5/16	1-1/2	1.706	.26	.569	15/16	.060	.114	38	1200
CL-100-TVR	5/8-11	.625	.625	.765	1.125	1-1/2	3/8	1-3/4	2.104	.32	.706	1-1/8	.078	.120	76	1800
CL-160-TVR	1”-8	1.000	1.000	1.159	1.875	2-1/4	3/4	2-1/2	3.350	1.00	1.119	1-3/4	.094	.138	300	4500

DOUBLE V-JAWS (METRIC) — SETUP FOR DOWNTHRUST FORCE

CLM-50-TVR	M8	.375	.486	.597	.625	1	3/16	1-1/4	1.308	.16	.421	3/4	.048	.096	4.5	450
CLM-60-TVR	M10	.438	.570	.684	.750	1-1/8	7/32	1-3/8	1.478	.19	.482	27/32	.052	.105	10	750
CLM-80-TVR	M12	.500	.635	.770	.875	1-1/4	5/16	1-1/2	1.706	.26	.569	15/16	.060	.114	18	1100
CLM-100-TVR	M16	.625	.765	.905	1.125	1-1/2	3/8	1-3/4	2.104	.32	.706	1-1/8	.078	.120	42	2000
CLM-160-TVR	M24	1.000	1.159	1.318	1.875	2-1/4	3/4	2-1/2	3.350	1.00	1.119	1-3/4	.094	.138	130	4000

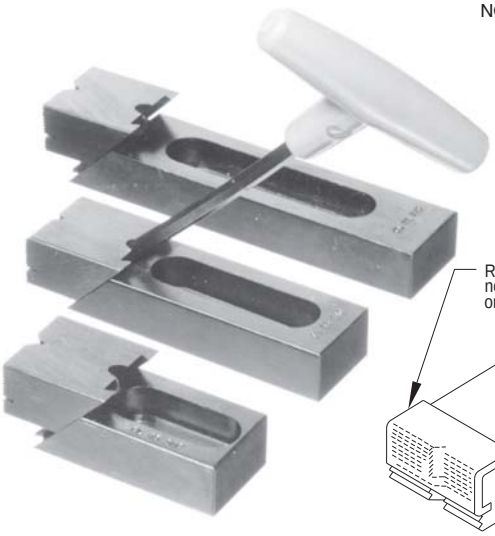
DOUBLE V-JAWS (METRIC) — SETUP FOR HORIZONTAL FORCE

CLM-50-TVR	M8	.375	.375	.486	.625	1	3/16	1-1/4	1.308	.16	.421	3/4	.048	.096	9	450
CLM-60-TVR	M10	.438	.438	.570	.750	1-1/8	7/32	1-3/8	1.478	.19	.482	27/32	.052	.105	20	750
CLM-80-TVR	M12	.500	.500	.635	.875	1-1/4	5/16	1-1/2	1.706	.26	.569	15/16	.060	.114	35	1100
CLM-100-TVR	M16	.625	.625	.765	1.125	1-1/2	3/8	1-3/4	2.104	.32	.706	1-1/8	.078	.120	84	2000
CLM-160-TVR	M24	1.000	1.000	1.159	1.875	2-1/4	3/4	2-1/2	3.350	1.00	1.119	1-3/4	.094	.138	260	4000

*Recommended torque and clamping force are at 1/3 of yield strength, leaving 2/3 of holding capacity to resist external cutting forces, etc.

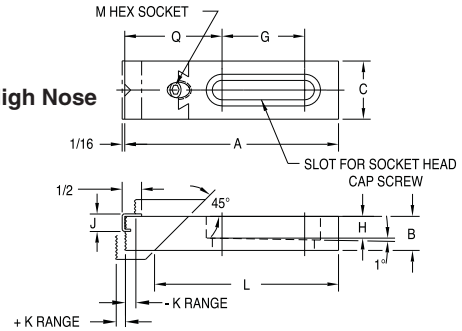
SERRATED EDGE CLAMPS

BODY AND NOSE: 1018 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH
CLAMPING SCREW: 4140 STEEL, HEAT TREATED RC 43-45, BLACK OXIDE FINISH
NOSE COVER: ALUMINUM

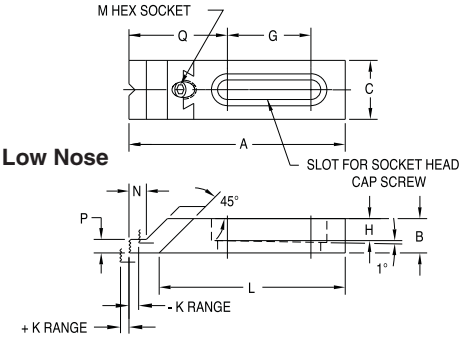


Serrated Adjustable Edge Clamp (High Nose)

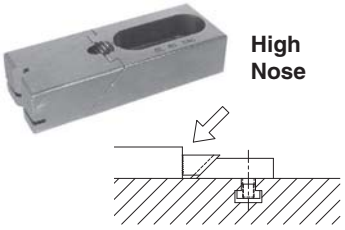
High Nose



Low Nose



This low-profile clamp is ideal for gripping the side of a workpiece to keep the top clear for machining. Clamps both forward and down simultaneously, by tightening the socket-head screw in the sliding nose with a hex wrench. V-groove in nose is excellent for clamping round parts or corners. Choice of five sizes, each available in several slot lengths. Slot is tapered to prevent the clamp from backing off under heavy forces. Use two mounting screws on longer clamps.

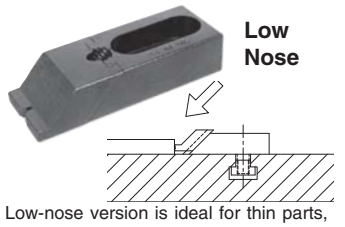


High Nose

High-nose version is best for most applications. Gripping high up on the workpiece, close to the machining plane, provides maximum clamping rigidity. A removable aluminum nose cover is furnished for clamping soft or machined parts without damage.

ADJUSTABLE — HIGH NOSE

PART NO.	MOUNTING SCREW SIZE	A	B	C	G	H	J	K	L	M	N	P	Q
CL-1-SAC	5/16-18 or M8	2	5/8	1	1/4	9/32	7/16	1/4	1-1/2	5/32	—	—	1-3/8
CL-5-SAC		3			1-1/4				2-1/2				
CL-15-SAC	3/8-16 or M10	3	5/8	1-1/4	13/16	3/8	7/16	1/4	2-3/8	3/16	—	—	1-11/16
CL-25-SAC		4-1/4			1-7/16				3-5/8				2-1/16
CL-35-SAC		5			2-1/8				4-3/8				1-7/8
CL-45-SAC	1/2-13 or M12	4	7/8	1-1/2	1-1/4	1/2	5/8	5/16	3-3/16	1/4	—	—	2-1/4
CL-55-SAC		5-1/2			2-1/8				4-11/16				2-1/2
CL-65-SAC		7-1/8			3				6-5/16				2-9/16
CL-75-SAC	5/8-11 or M16	5-1/2	1-1/4	1-3/4	1-3/8	5/8	3/4	5/16	4-1/2	5/16	—	—	3-9/32
CL-95-SAC		8-1/4			4				7-1/4				3
CL-105-SAC	3/4-10 or M20	5-1/2	1-1/4	1-3/4	1-3/8	3/4	3/4	5/16	4-1/2	5/16	—	—	3-9/32
CL-125-SAC		8-1/4			4				7-1/4				3



Low Nose

Low-nose version is ideal for thin parts, with its extra machining clearance.

ADJUSTABLE — LOW NOSE

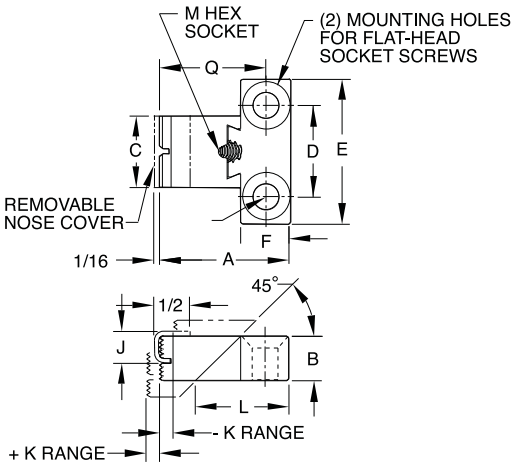
CL-0-SAC	5/16-18 or M8	2	5/8	1	1/4	9/32	—	1/4	1-1/2	5/32	1/8	1/8	1-3/8
CL-00-SAC		3			1-1/4				2-1/2				
CL-10-SAC	3/8-16 or M10	3	5/8	1-1/4	13/16	3/8	—	1/4	2-3/8	3/16	1/4	1/4	1-11/16
CL-20-SAC		4-1/4			1-7/16				3-5/8				2-1/16
CL-30-SAC		5			2-1/8				4-3/8				1-7/8
CL-40-SAC	1/2-13 or M12	4	7/8	1-1/2	1-1/4	1/2	—	5/16	3-3/16	1/4	1/4	1/4	2-1/4
CL-50-SAC		5-1/2			2-1/8				4-11/16				2-1/2
CL-60-SAC		7-1/8			3				6-5/16				2-9/16
CL-70-SAC	5/8-11 or M16	5-1/2	1-1/4	1-3/4	1-3/8	5/8	—	5/16	4-1/2	5/16	5/16	3/8	3-9/32
CL-90-SAC		8-1/4			4				7-1/4				3
CL-100-SAC	3/4-10 or M20	5-1/2	1-1/4	1-3/4	1-3/8	3/4	—	5/16	4-1/2	5/16	5/16	3/8	3-9/32
CL-120-SAC		8-1/4			4				7-1/4				3

SERRATED EDGE CLAMPS

BODY AND NOSE: 1018 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH
CLAMPING SCREW: 4140 STEEL, HEAT TREATED RC 43-45, BLACK OXIDE FINISH
NOSE COVER: ALUMINUM

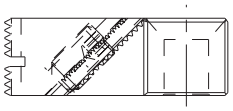
Serrated Fixed Edge Clamp (High Nose)

Serrated Fixed Edge Clamp (Low Nose)

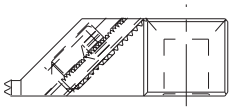


High Nose

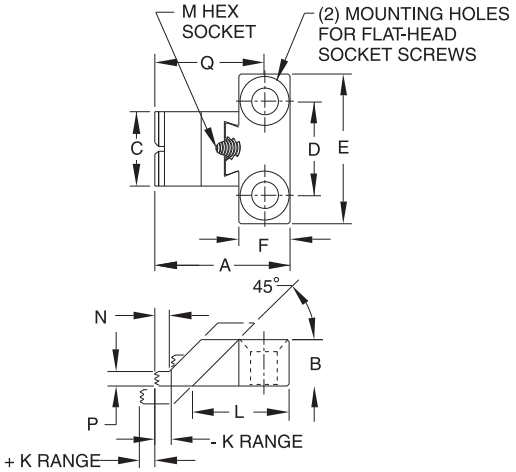
Serrated Fixed Edge Clamps mount in a fixed position, rather than having a slot for adjustment. This makes the clamps more compact and ensures that they are mounted in the correct location without requiring adjustment. The fixed version is usually better for permanent fixtures, while the adjustable version is better for machine-table mounting. The Flat-Head Socket Screws used for mounting absolutely hold proper location (order separately). Choice of three clamp sizes, with either a high nose or low nose.



High Nose



Low Nose



Low Nose

FIXED POSITION — HIGH NOSE

PART NO.	MOUNTING SCREW SIZE	A	B	C	D	E	F	J	K	L	M	N	P	Q	FLAT-HEAD SOCKET SCREWS (2 REQ'D) ORDER SEPARATELY
CL-5-SFC	5/16-18	1-13/16	5/8	1	1	1-3/4	11/16	7/16	1/4	1-5/16	5/32	—	—	1-15/32	CL-5/16-18x1.00-FHSS
CL-45-SFC	1/2-13	2-11/16	7/8	1-1/2	2	3	1	5/8	5/16	1-7/8	1/4	—	—	2-3/16	CL-1/2-13x1.38-FHSS
CL-75-SFC	5/8-11	3-1/2	1-1/4	1-3/4	2	3-1/4	1-1/4	3/4	5/16	2-1/2	5/16	—	—	2-7/8	CL-5/8-11x2.00-FHSS

FIXED POSITION — LOW NOSE

CL-0-SFC	5/16-18	1-13/16	5/8	1	1	1-3/4	11/16	7/16	1/4	1-5/16	5/32	1/8	1/8	1-15/32	CL-5/16-18x1.00-FHSS
CL-40-SFC	1/2-13	2-11/16	7/8	1-1/2	2	3	1	5/8	5/16	1-7/8	1/4	1/4	1/4	2-3/16	CL-1/2-13x1.38-FHSS
CL-70-SFC	5/8-11	3-1/2	1-1/4	1-3/4	2	3-1/4	1-1/4	3/4	5/16	2-1/2	5/16	5/16	3/8	2-7/8	CL-5/8-11x2.00-FHSS

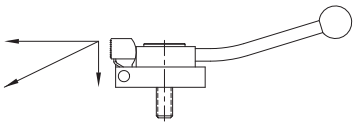
CAM EDGE CLAMPS

BODY: STEEL, WEAR SURFACES HARDENED, BLACK OXIDE FINISH
BALL HANDLE: BLACK PHENOLIC PLASTIC

Fixed Base

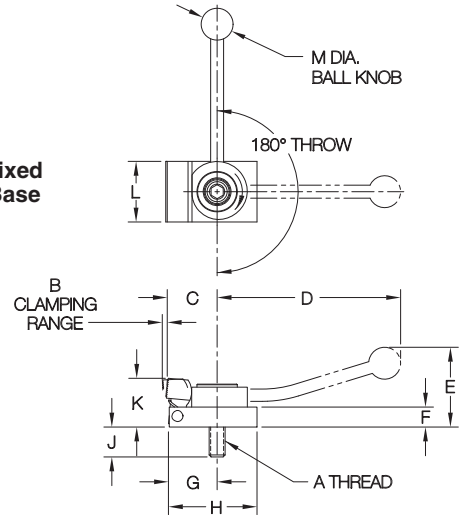
Slotted Base

Pivoting-nose edge clamp operated by a cam handle for fast action. Smooth spiral cam locks positively anywhere within its 180° throw. Choice of two sizes. Available with either a standard base for fixed-position mounting, or a slotted base for adjustable mounting. Choice of clockwise or counter-clockwise handle rotation to clamp.

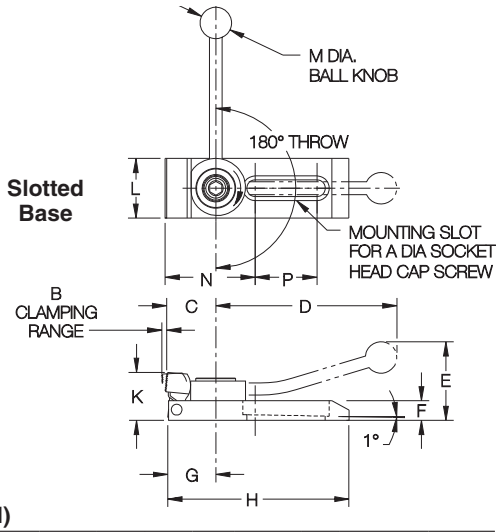


Nose pivots to exert clamping force forward and downward at the same time.

Fixed Base



Slotted Base



FIXED BASE (INCH)

PART NO.																	MAX CLAMPING FORCE (LBS)	
CLOCKWISE CLAMPING	CCW CLAMPING	A	B	C	D	E	F	G	H	J	K MIN	K MAX	L	M	N	P	HORIZONTAL	VERTICAL
CL-MF25-5601	CL-MF25-5602	5/16-18	5/32	1-1/8	3-15/16	1-5/8	7/16	15/16	1-3/4	11/16	7/8	1	1-1/4	3/4	—	—	750	50
CL-MF40-5601	CL-MF40-5602	1/2-13	7/32	1-9/16	5-3/4	2-1/2	5/8	1-1/2	2-3/4	15/16	1-5/16	1-1/2	1-7/8	1	—	—	1500	100

FIXED BASE (METRIC)

CL-MF08-5601	CL-MF08-5602	M8	5/32	1-1/8	3-15/16	1-5/8	7/16	15/16	1-3/4	.31	7/8	1	1-1/4	3/4	—	—	750	50
CL-MF12-5601	CL-MF12-5602	M12	7/32	1-9/16	5-3/4	2-1/2	5/8	1-1/2	2-3/4	.47	1-5/16	1-1/2	1-7/8	1	—	—	1500	100

SLOTTED BASE

CL-MF25-5611	CL-MF25-5612	5/16-18 or M8	5/32	1-1/8	3-15/16	1-5/8	7/16	15/16	3-1/2	—	7/8	1	1-1/4	3/4	2	1	750	50
CL-MF40-5611	CL-MF40-5612	1/2-13 or M12	7/32	1-9/16	5-3/4	2-1/2	5/8	1-1/2	6	—	1-5/16	1-1/2	1-7/8	1	2-15/16	2	1500	100