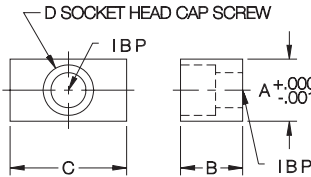
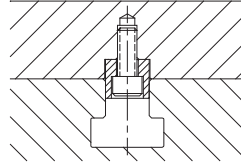


FIXTURE KEYS

1018 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH



Standard key for fixtures slotted to mount on one specific machine table. Depth of slot in fixture should be 1/2 of B dimension.



USA

PART NO.	TABLE SLOT SIZE	A	B	C	D
CL-1-FK	1/2	.5000	1/2	3/4	1/4-20
CL-2-FK	9/16	.5625		3/4	5/16-18
CL-3-FK	5/8	.6250			
CL-4-FK	11/16	.6875		1	
CL-5-FK	3/4	.7500		1-1/4	
CL-6-FK	13/16	.8125			
CL-7-FK	1-1/16	1.0625			

METRIC

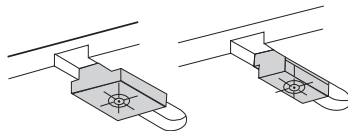
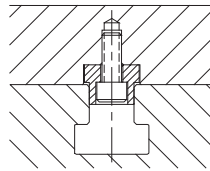
CLM-12-FK	12mm	.4724	.315	.787	M5
CLM-14-FK	14mm	.5512	.394	.866	M6
CLM-16-FK	16mm	.6299			
CLM-18-FK	18mm	.7087			
CLM-20-FK	20mm	.7874			

STEP FIXTURE KEYS

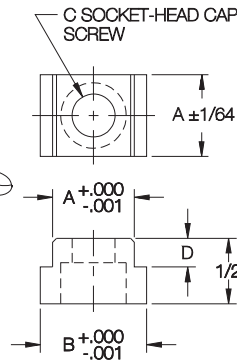
MILD STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH



Adapts a key-slotted fixture or vise to machine tables with a different slot size. Available for US or metric slots. Top and bottom of key are centered within .0005 of each other.



Step Fixture Keys are available for machine-table slots either larger or smaller than a given fixture slot. (Viewed from underside of fixture.)



USA FIXTURE SLOTS

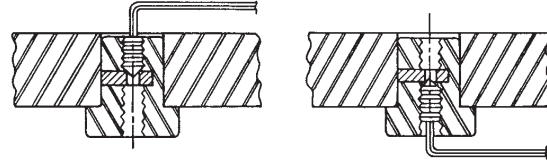
PART NO.	FIXTURE SLOT SIZE	A	TABLE SLOT SIZE	B	C	D
CL-8-SFK-437	1/2	.5000	7/16	.4375	1/4 or M6	9/32
CL-8-SFK-562			9/16	.5625		7/32
CL-8-SFK-625			5/8	.6250		
CL-8-SFK-687			11/16	.6875		9/32
CL-8-SFK-12			12mm	.4724		
CL-8-SFK-14			14mm	.5512		
CL-8-SFK-16			16mm	.6299		7/32
CL-8-SFK-18	18mm	.7087	9/16	.5625	1/4 or M6	9/32
CL-9-SFK-437	7/16	.4375				7/32
CL-9-SFK-500	1/2	.5000				
CL-9-SFK-625	5/8	.6250				9/32
CL-9-SFK-12	12mm	.4724				
CL-9-SFK-14	14mm	.5512				
CL-9-SFK-16	16mm	.6299				7/32
CL-10-SFK-500	5/8	.6250	1/2	.5000	5/16 or M8	9/32
CL-10-SFK-562			9/16	.5625		7/32
CL-10-SFK-687			11/16	.6875		
CL-10-SFK-750			3/4	.7500		9/32
CL-10-SFK-812			13/16	.8125		
CL-10-SFK-12			12mm	.4724		
CL-10-SFK-14			14mm	.5512		7/32
CL-10-SFK-16	16mm	.6299				
CL-10-SFK-18	18mm	.7087				
CL-10-SFK-20	20mm	.7874	11/16	.6875	5/16 or M8	9/32
CL-11-SFK-562	9/16	.5625				7/32
CL-11-SFK-625	5/8	.6250				
CL-11-SFK-750	3/4	.7500				9/32
CL-11-SFK-812	13/16	.8125				
CL-11-SFK-16	16mm	.6299				
CL-11-SFK-18	18mm	.7087				7/32
CL-11-SFK-20	20mm	.7874				
CL-12-SFK-625	3/4	.7500	5/8	.6250	5/16 or M8	
CL-12-SFK-687			11/16	.6875		7/32
CL-12-SFK-812			13/16	.8125		
CL-12-SFK-18			18mm	.7087		9/32
CL-12-SFK-20			20mm	.7874		
CL-13-SFK-687			11/16	.6875		
CL-13-SFK-750			3/4	.7500		
CL-13-SFK-18	18mm	.7087	9/32			
CL-13-SFK-20	20mm	.7874				

METRIC FIXTURE SLOTS

PART NO.	FIXTURE SLOT SIZE	A	TABLE SLOT SIZE	B	C	D
CL-20-SFK-500	20mm	.7874	1/2	.5000	1/4 or M6	9/32
CL-20-SFK-562			9/16	.5625		
CL-20-SFK-625			5/8	.6250		
CL-20-SFK-687			11/16	.6875		7/32
CL-20-SFK-750			3/4	.7500		
CL-20-SFK-812			13/16	.8125		9/32
CL-20-SFK-16			16mm	.6299		
CL-20-SFK-18			18mm	.7087		

SURE-LOCK™ FIXTURE KEYS

12L14 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH

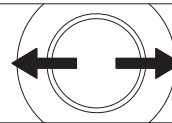


Lock in place from above or below using a hex wrench.

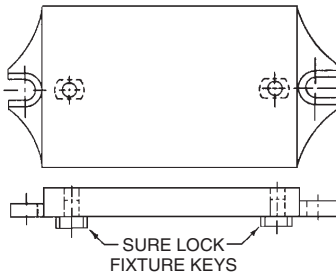
Perfect fixture key for most applications. Keys are interchangeable because they all fit in a 5/8 reamed hole. Allows mounting any fixture on any machine simply by switching keys. Eliminates the need to slot fixtures. Concentricity .0005 TIR or better. Available for US or metric machine-table slots.

USA

PART NO.	TABLE SLOT SIZE	A	B	C	D
CL-375-SLFK	3/8	.3750			
CL-437-SLFK	7/16	.4375	1/2	3/8	.23
CL-500-SLFK	1/2	.5000			
CL-5000-SLFK			3/4	7/16	.41
CL-562-SLFK	9/16	.5625	1/2	3/8	.23
CL-5625-SLFK			3/4	7/16	.41
CL-625-SLFK	5/8	.6250	1/2	3/8	.23
CL-6250-SLFK			3/4	7/16	.41
CL-687-SLFK	11/16	.6875	1/2	3/8	.23
CL-6875-SLFK					
CL-7500-SLFK	3/4	.7500	3/4	7/16	.41
CL-8125-SLFK	13/16	.8125			

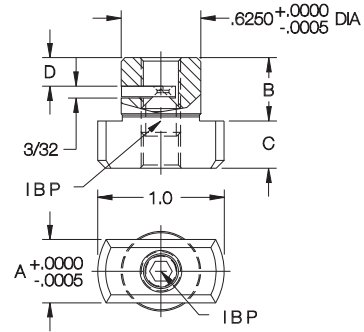


Patented locking action aligns fixture key perfectly with slot axis.



METRIC

PART NO.	TABLE SLOT SIZE	A	B	C	D
CL-12-SLFK	12mm	.4724	1/2	3/8	.23
CL-14-SLFK	14mm	.5512			
CL-16-SLFK	16mm	.6299			
CL-18-SLFK	18mm	.7087	3/4	7/16	.41
CL-20-SLFK	20mm	.7874			
CL-22-SLFK	22mm	.8661			

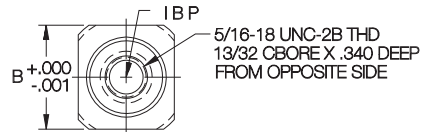


REAMED-HOLE FIXTURE KEYS

12L14 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH

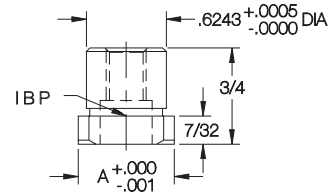


Each key fits two different table slots by turning 90°. Install in a 5/8 reamed hole. Fasten from above with a 5/16-18 socket-head cap screw, or from below with a 1/4-20 socket-head cap screw. Concentricity .0005 or better.



USA

PART NO.	TABLE SLOT SIZES	A	B
CL-1-RFK	5/8 and 11/16	.6875	.6875
CL-2-RFK	5/8 and 3/4	.6250	.7500
CL-3-RFK	5/8 and 13/16		.8125
CL-4-RFK	11/16 and 3/4	.6875	.7500
CL-5-RFK	11/16 and 13/16		.8125
CL-6-RFK	3/4 and 13/16	.7500	.8125

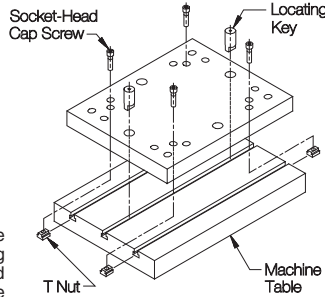
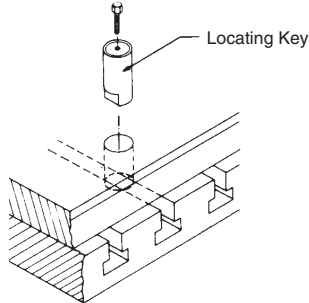


LOCATING KEYS

1144 OR 1045 STEEL, HEAT TREATED, BLACK OXIDE FINISH



Standard removable-type fixture key for large fixtures. Can be inserted from above after placing fixture on machine, then removed again if desired after the fixture is fastened. Keeps bottom of fixture free of obstructions. Install in a 1-3/16" reamed hole. True position within .0005 or better.

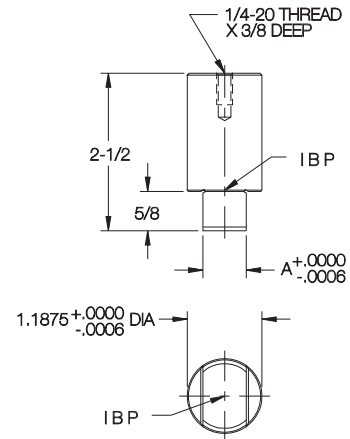


USA

PART NO.	TABLE SLOT SIZE	A
CL-MF10-4406	9/16	.5625
CL-MF10-4407	5/8	.6250
CL-MF10-4408	11/16	.6875
CL-MF10-4409	3/4	.7500
CL-MF10-4411	13/16	.8125
CL-MF10-4410	7/8	.8750

METRIC

CL-MF10-4401	14mm	.5512
CL-MF10-4402	16mm	.6299
CL-MF10-4403	18mm	.7087
CL-MF10-4404	20mm	.7874
CL-MF10-4405	22mm	.8661



SUBPLATE LOCATING KEYS

1144 STEEL, HEAT TREATED, BLACK OXIDE FINISH

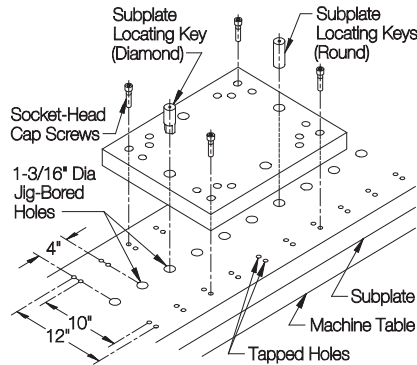


Round



Diamond

Subplate Locating Keys are the new standard for mounting quick-change fixture plates on a subplate. A Round Key and a Diamond (relieved) Key are used together for precise location without binding. Diamond Keys are marked on top to ensure proper orientation in the hole. Two standard diameters match standard fixture-key holes. This allows mounting the same fixture plate either on a subplate (3-axis location) or directly on a machine table (2-axis location). The 5/8"-diameter key fits in the same hole as a Sure-Lock™ Fixture Key, while the 1-3/16"-diameter key fits in the same hole as the Locating Keys shown above. The subplate hole pattern shown above allows mounting any size and combination of Rectangular Tooling Plates, either lengthwise or widthwise.

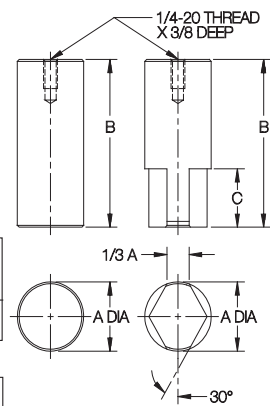


ROUND

PART NO.	A DIA		B	C
	NOMINAL	ACTUAL		
CL-10-SLKR	5/8	.6250/.6244	2-1/4	—
CL-19-SLKR	1-3/16	1.1875/1.1869	2-7/8	—

DIAMOND

CL-10-SLKD	5/8	.6250/.6244	2-1/4	1
CL-19-SLKD	1-3/16	1.1875/1.1869	2-7/8	1



PALLET FIXTURE KEYS

12L14 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH

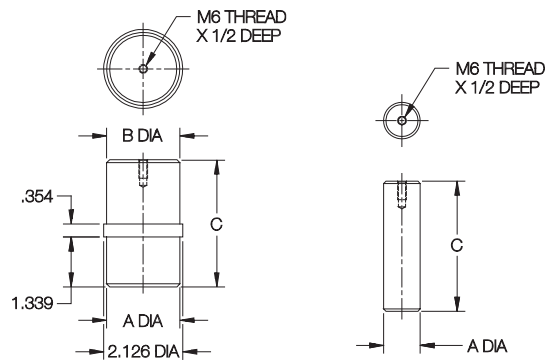


Center Pin



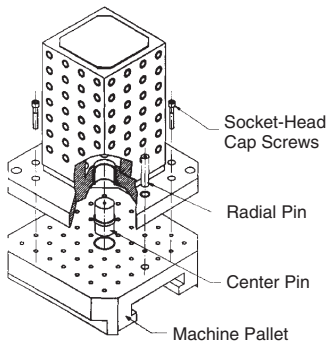
Radial Pin

Fixture keys for mounting tooling plates and blocks on standard DIN pallets. Each pallet requires one Center Pin and one Radial Pin (for orientation). The Radial Pin is usually removed after fastening the pallet to the machine table.



Center Pin

Radial Pin



CENTER PINS

PART NO.	A DIA		B DIA		C
	NOMINAL	ACTUAL	NOMINAL	ACTUAL	
CLM-25-PFKC	50mm	1.9681/1.9676	25mm	.9839/.9835	2.87
CLM-30-PFKC			30mm	1.1808/1.1804	3.42
CLM-50-PFKC			50mm	1.9681/1.9676	

RADIAL PINS

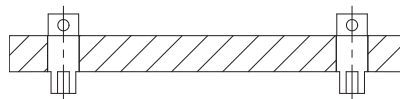
PART NO.	A DIA		C
	NOMINAL	ACTUAL	
CLM-20-PFKR	20mm	.7871/.7867	3.50
CLM-25-PFKR	25mm	.9839/.9835	4.92

MILL FIXTURE KEYS

12L14 STEEL, CARBURIZED-HARDENED, BLACK OXIDE FINISH



Can be removed from above after mounting fixture on machine. Fits either 11/16 or 13/16 table slots by turning 90°. Install in a 7/8 reamed hole. Concentricity .0005 or better.



USA

PART NO.	TABLE SLOT SIZES	A	C	E	F
CL-1-MFK-1	11/16 or 13/16	.6873	.8123	1.00	2.20
CL-1-MFK-2				3.20	4.40

