Torque Ft.-Lbs.	Clamping Force - Lbs
7	450
14	899
22	1124
29	1574
36	1798
43	2023
51	2473
57	3147
65	3372
72	4047
80	4496
87	4721
101	5395
116	6295
130	7194

[316]
12.441
MAX.

[86.5]
3.406

[66]
2.598

[18]
.709

[125]
4.921
MAX.

[125]
4.921
MAX.

[44.5]
1.752

[152]
5.984

[98.4]
3.874

[23.8]
.937

[124.05]
4.884

[82.55]
3.250

[19]
.748 HEX.

[18]
.709

[24]
.945

[154]
6.063

[520]
20.472

[605]
23.821
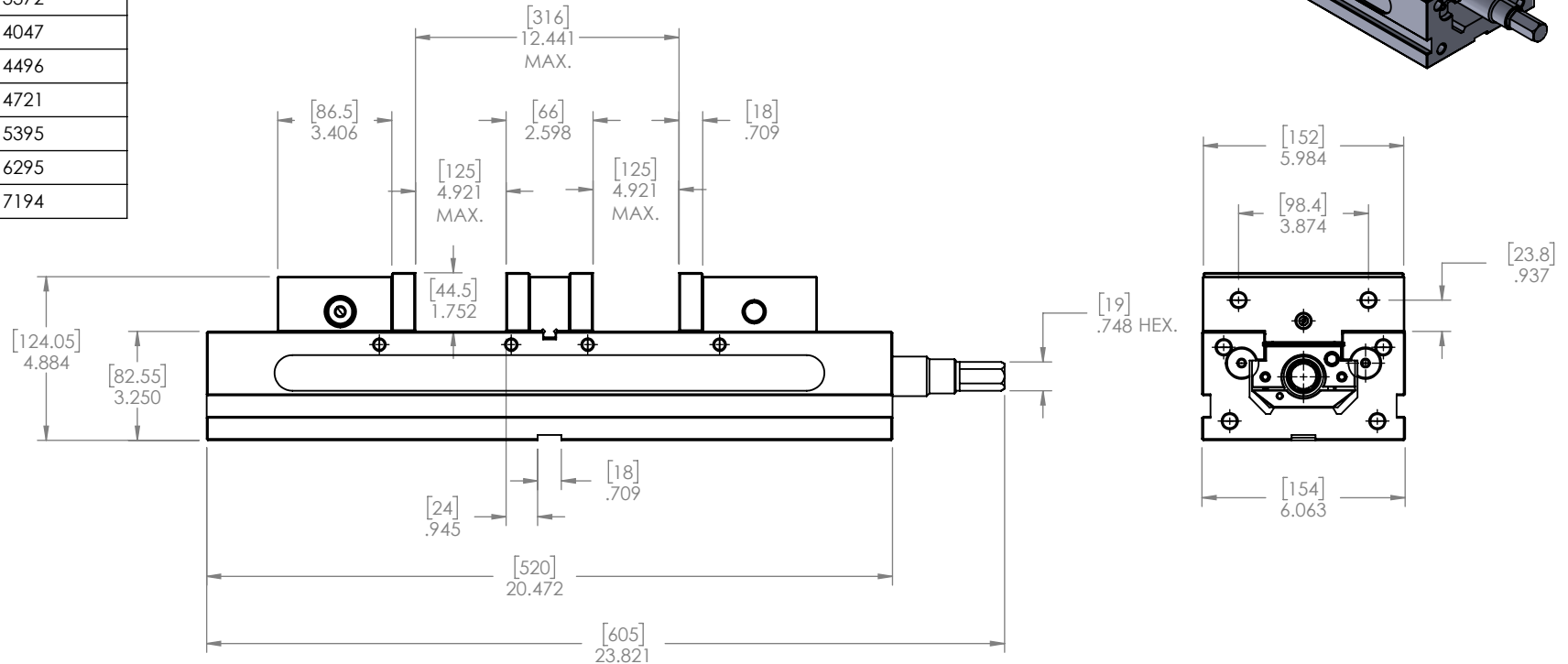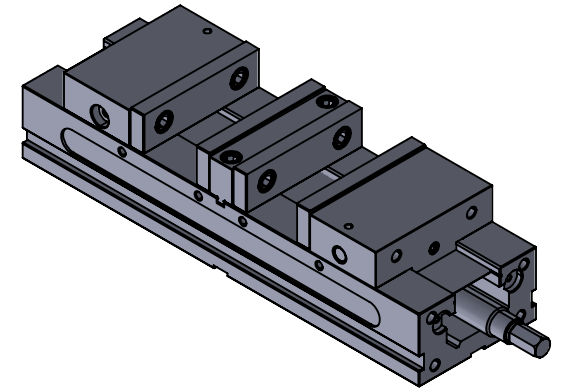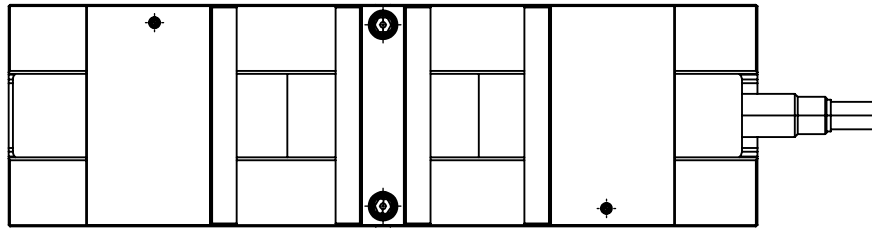
NOTES:
    MATERIAL:
        BODY: DUCTILE IRON
        JAWS: HARDENED STEEL
    WEIGHT: 114.6 LBS

    SEE SHEETS 2 AND 3 FOR PERDENDICULARITY, PARALLELISM AND SQUARENESS

MATERIAL:	SEE NOTES			NAME	DATE
HARDNESS:	54 HRC	FINISH:	DRAWN	T.T.	04-08-2020
			ENG APPR.	T.T.	04-08-2020
			MFG APPR.		
			Q.A. APPR.		
			SALES APPR.		

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SIZE
A

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C

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SHEET 1 OF 3

1	**2** Parallelism 0.012	**3** ①～④ Ⓐ～Ⓑ Squareness 0.015	**4** G = X HV = 0
± 0.012 H			GB ⊥ 0.012
5 G = X HV = 0 ⊥ 0.02	**6** Parallelism 0.02 GB	**7** Squareness 0.02 GB	**8** L Size ± 0.02
9 $0.02/100$			
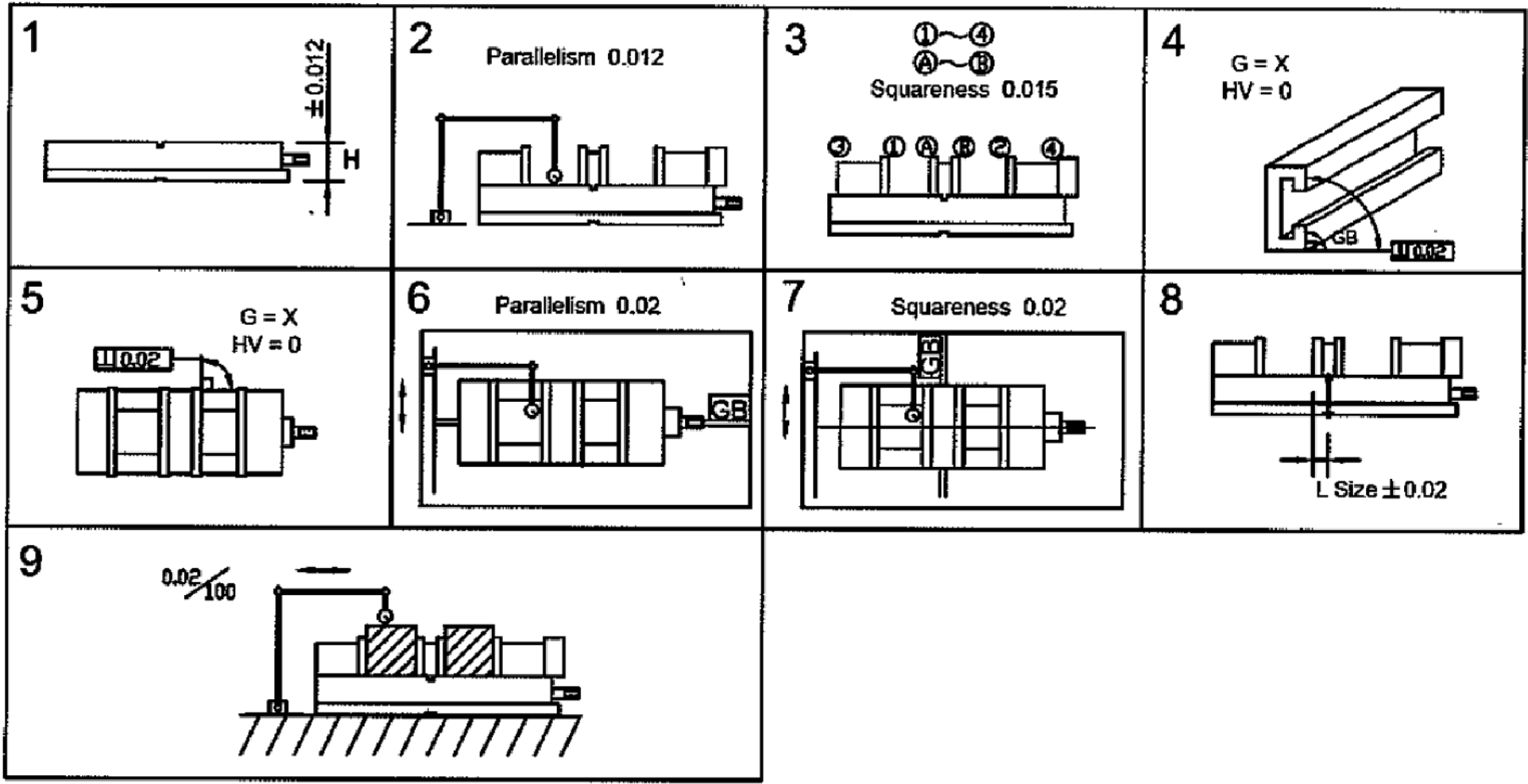
1	"H" tolerance: running face to bottom within	±0.0005" ±(0.012mm)
2	Parallelism: running face to bottom of bed	0.0005" (0.012mm)
3	Squareness: between running face and jaw plate	0.0006" (0.015mm)
4	Squareness: both sides to running face	0.0008" (0.02mm)
5	Squareness: both sides to fixed jaw plate	0.0008" (0.02mm)
6	Parallelism: keyways on bottom of bed to jaw plate	0.0008" (0.02mm)
7	Squareness: keyways on bottom of bed to jaw plate	0.0008" (0.02mm)
8	"L" tolerance: keyways on bottom of bed to jaw plate within	±0.0008" ±(0.02mm)
9	1. Parallelism: running face of the test block to bottom of bed	0.0008" (0.02mm)
	2. Jaw opening	4" (102mm)