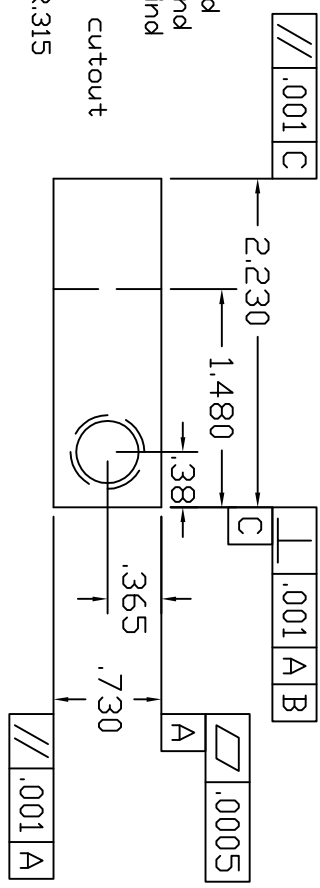
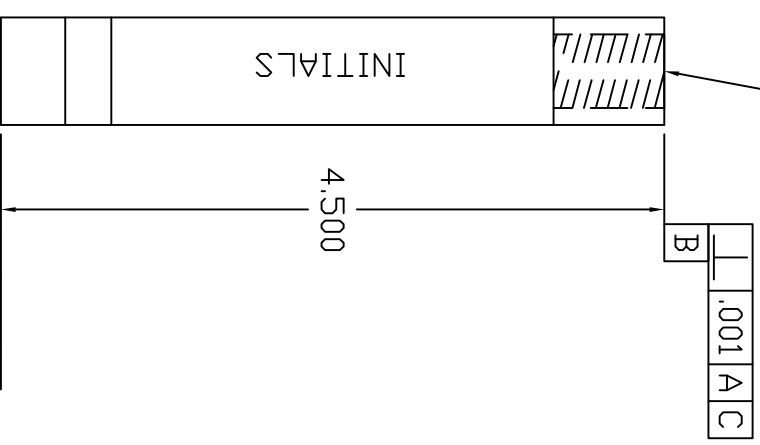
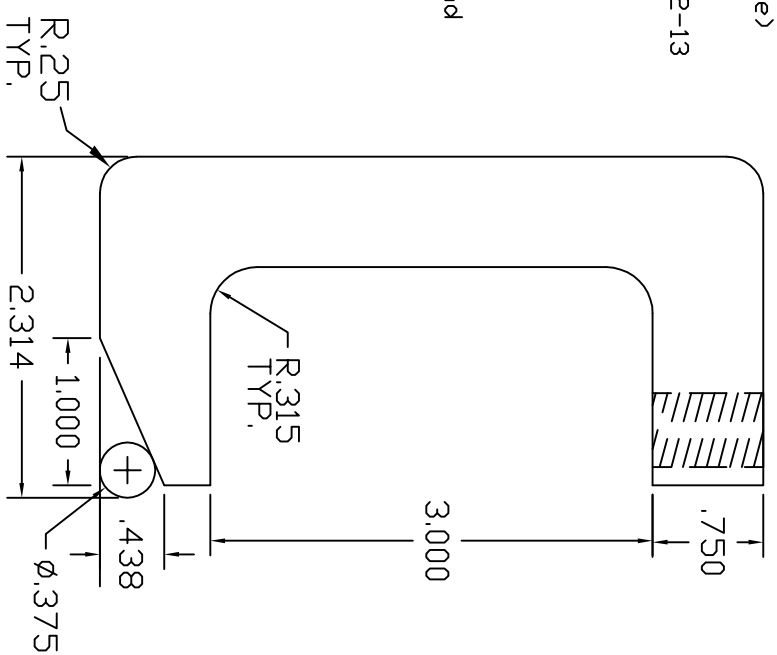


1. Vertical Mill
 - a. Tram Mill head and align vise
 - b. Square sides (.2,25) +.005/side for grind
 - c. Face Thickness (.73) +.005/side for grind
 - d. Square ends to size +.005/side for grind
2. Layout
 - a. Layout locations of holes, angles, and cutout
3. Vertical Mill
 - a. Edge Finder - Locate Center line of R.315
 - b. Drill for radius (ϕ .500)
4. Vertical Saw
 - a. Rough cut inside of "C" (8-12 pitch blade)
5. Vertical Milling Machine
 - a. Finish mill inside of "C"
 - b. C-Drill, Drill, Chamfer, and Power Tap 1/2-13 hole
6. Bench
 - a. Deburr part / Remove sharp corners
 - b. Run tap through by hand
7. Heat Treat
 - a. Case harden C-Clamp Body
8. Surface Grinder
 - a. Grind outside Dimensions Flat, Square and Parallel
9. Inspect



NOTE: All outside dimensions must be surface ground

1/2-13 UNC 2B Thru.



TOLERANCE BLOCK
 FRACTIONAL: +/- 1/64
 TWD PLACE: +/- .010
 THREE PLACE: +/- .005
 FOUR PLACE: +/- .0005
 ANGLES: +/- 1 deg.

South Adams
 Area 18
 Precision Machine
 Technology

C-CLAMP
 C-CLAMP BODY

MAT'L.
 1018 CR

SIZE CHECKED BY: DWG BY: J. DAILEY
 SCALE PART NO.: PMT1-2b SHEET