

# POWER CLAMP INDEX

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# POWER CLAMP INDEX

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<a href="#">G-27</a>	11/10/10	ACA013-ACA018	20 mm	Power Clamp Arms Blanks 60 Series (Inch and Metric Designs)	X
<a href="#">G-28</a>	11/10/10	ACA025-ACA030	60 mm	Power Clamp Arms Blanks 60 Series (Inch and Metric Designs)	X
<a href="#">G-29</a>	11/10/10	ACA037-ACA042	115 mm	Power Clamp Arms Blanks 60 Series (Inch and Metric Designs)	X
<a href="#">G-30</a>	11/10/10	ACA007-ACA012	Straight	Power Clamp Arms 60 Series (Machined)	X
<a href="#">G-31</a>	11/10/10	ACA007-ACA012	Straight	Power Clamp Arms 60 Series (Machined)	X
<a href="#">G-32</a>	11/10/10	ACA019-ACA024	25 mm	Power Clamp Arms 60 Series (Machined)	X
<a href="#">G-33</a>	11/10/10	ACA019-ACA024	25 mm	Power Clamp Arms 60 Series (Machined)	X
<a href="#">G-34</a>	11/10/10	ACA031-ACA036	70 mm	Power Clamp Arms 60 Series (Machined)	X
<a href="#">G-35</a>	11/10/10	ACA031-ACA036	70 mm	Power Clamp Arms 60 Series (Machined)	X
<a href="#">G-36</a>	11/10/10	ACA043-ACA048	120 mm	Power Clamp Arms 60 Series (Machined)	X
<a href="#">G-37</a>	11/10/10	ACA043-ACA048	120 mm	Power Clamp Arms 60 Series (Machined)	X
<a href="#">G-38</a>	11/10/10	ACA110-ACA118	Straight	Power Clamp Arms 80/90 Series (Machined)	X
<a href="#">G-39</a>	11/10/10	ACA110-ACA118	Straight	Power Clamp Arms 80/90 Series (Machined)	X
<a href="#">G-40</a>	11/10/10	ACA130-ACA138	25 mm	Power Clamp Arms 80/90 Series (Machined)	X
<a href="#">G-41</a>	11/10/10	ACA130-ACA138	25 mm	Power Clamp Arms 80/90 Series (Machined)	X
<a href="#">G-42</a>	11/10/10	ACA150-ACA158	70 mm	Power Clamp Arms 80/90 Series (Machined)	X
<a href="#">G-43</a>	11/10/10	ACA150-ACA158	70 mm	Power Clamp Arms 80/90 Series (Machined)	X
<a href="#">G-44</a>	11/10/10	ACA170-ACA178	120 mm	Power Clamp Arms 80/90 Series (Machined)	X
<a href="#">G-45</a>	11/10/10	ACA170-ACA178	120 mm	Power Clamp Arms 80/90 Series (Machined)	X
<a href="#">G-46</a>	11/10/10			Enclosed Clamp Hole 50 Series Pattern #1	
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<a href="#">G-49</a>	11/10/10	ACA201M-ACA203M	Straight	Power Clamp Arms Blanks 50 Series (Full Metric)	
<a href="#">G-50</a>	11/10/10	ACA211M-ACA213M	20 mm	Power Clamp Arms Blanks 50 Series (Full Metric)	
<a href="#">G-51</a>	11/10/10	ACA221M-ACA223M	45 mm	Power Clamp Arms Blanks 50 Series (Full Metric)	

# POWER CLAMP INDEX

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<a href="#">G-53</a>	04/30/15	ACA216M-ACA218M	25 mm	Power Clamp Arms 50 Series (Machined) (Full Metric)	X
<a href="#">G-54</a>	11/10/10	ACA226M-ACA228M	50 mm	Power Clamp Arms 50 Series (Machined) (Full Metric)	X
<a href="#">G-55</a>	11/10/10	ACA226M-ACA228M	50 mm	Power Clamp Arms 50 Series (Machined) (Full Metric)	X
<a href="#">G-56</a>	09/05/12	ACA236M-ACA238M	Straight	Power Clamp Arms 50 Series (Machined) (Full Metric)	
<a href="#">G-57</a>	09/05/12	ACA246M-ACA248M	25 mm	Power Clamp Arms 50 Series (Machined) (Full Metric)	
<a href="#">G-58</a>	09/05/12	ACA256M-ACA258M	50 mm	Power Clamp Arms 50 Series (Machined) (Full Metric)	
<a href="#">G-59</a>	11/10/10	ACA256M-ACA258M	50 mm	Power Clamp Arms 50 Series (Machined) (Full Metric)	
<a href="#">G-60</a>	11/10/10			60 Series Power Clamp Envelope	
<a href="#">G-61</a>	11/10/10			60 Series Power Clamp Optional Mounting	
<a href="#">G-62</a>	11/10/10			50 Series Power Clamp Envelope	
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<a href="#">G-64</a>	11/10/10			80/90 Series Power Clamp Envelope	
<a href="#">G-65</a>	11/10/10			80/90 Series Power Clamp Optional Mounting	
<a href="#">G-66</a>	09/05/12	ACA301M-ACA303M	25mm	Wishbone Clamp Arms 50 Series	X
<a href="#">G-67</a>	11/10/10	ACA301M-ACA303M	25mm	Wishbone Clamp Arms 50 Series	X
<a href="#">G-68</a>	09/05/12	ACA311M-ACA313M	50mm	Wishbone Clamp Arms 50 Series	X
<a href="#">G-69</a>	11/10/10	ACA311M-ACA313M	50mm	Wishbone Clamp Arms 50 Series	X
<a href="#">G-70</a>	09/05/12	ACA320M-ACA325M	25mm	Wishbone Clamp Arms 60 Series	X
<a href="#">G-71</a>	11/10/10	ACA320M-ACA325M	25mm	Wishbone Clamp Arms 60 Series	X
<a href="#">G-72</a>	09/05/12	ACA330M-ACA335M	70mm	Wishbone Clamp Arms 60 Series	X
<a href="#">G-73</a>	11/10/10	ACA330M-ACA335M	70mm	Wishbone Clamp Arms 60 Series	X
<a href="#">G-74</a>	09/05/12	ACA401M-ACA403M	Straight	Power Clamp Arms 50 Series (Machined) (Full Metric)	
<a href="#">G-75</a>	09/05/12	ACA411M-ACA413M	25mm	Power Clamp Arms 50 Series (Machined) (Full Metric)	
<a href="#">G-76</a>	09/05/12	ACA421M-ACA423M	50mm	Power Clamp Arms 50 Series (Machined) (Full Metric)	
<a href="#">G-77</a>	11/10/10	ACA421M-ACA423M	50mm	Power Clamp Arms 50 Series (Machined) (Full Metric)	
<a href="#">G-78</a>	09/05/12	ACA431M-ACA433M	25mm	Wishbone Clamp Arms 50 Series	X
<a href="#">G-79</a>	11/10/10	ACA431M-ACA433M	25mm	Wishbone Clamp Arms 50 Series	X
<a href="#">G-80</a>	09/05/12	ACA441M-ACA443M	50mm	Wishbone Clamp Arms 50 Series	X

# POWER CLAMP INDEX

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<a href="#">G-81</a>	11/10/10	ACA441M-ACA443M	50mm	Wishbone Clamp Arms 50 Series	X
<a href="#">G-82</a>	09/05/12	ACA451M-ACA456M	25mm	Wishbone Clamp Arms 60 Series	X
<a href="#">G-83</a>	11/10/10	ACA451M-ACA456M	25mm	Wishbone Clamp Arms 60 Series	X
<a href="#">G-84</a>	09/05/12	ACA461M-ACA466M	70mm	Wishbone Clamp Arms 60 Series	X
<a href="#">G-85</a>	11/10/10	ACA461M-ACA466M	70mm	Wishbone Clamp Arms 60 Series	X
<a href="#">G-86</a>	09/05/12	ACA507M-ACA512M	Straight	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-87</a>	11/10/10	ACA507M-ACA512M	Straight	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-88</a>	09/05/12	ACA519M-ACA524M	25mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-89</a>	11/10/10	ACA519M-ACA524M	25mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-90</a>	09/05/12	ACA531M-ACA536M	70mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-91</a>	11/10/10	ACA531M-ACA536M	70mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-92</a>	09/05/12	ACA543M-ACA548M	120mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-93</a>	11/10/10	ACA543M-ACA548M	120mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-94</a>	09/05/12	ACA513M-ACA518M	Straight	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-95</a>	11/10/10	ACA513M-ACA518M	Straight	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-96</a>	09/05/12	ACA525M-ACA530M	25mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-97</a>	11/10/10	ACA525M-ACA530M	25mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-98</a>	09/05/12	ACA537M-ACA542M	70mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-99</a>	11/10/10	ACA537M-ACA542M	70mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-100</a>	09/05/12	ACA549M-ACA554M	120mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-101</a>	11/10/10	ACA549M-ACA554M	120mm	Power Clamp Arms 60 Series (Machined - 20 mm Wide)	
<a href="#">G-102</a>	04/30/15	ACA201G-ACA203G	Straight	Power Clamp Arms 50 Series Gripper Clamping Components (Machined - 20 mm Wide)	
<a href="#">G-103</a>	04/30/15	ACA211G-ACA213G	25mm	Power Clamp Arms 50 Series Gripper Clamping Components (Machined - 20 mm Wide)	
<a href="#">G-104</a>	04/30/15	ACA221G-ACA223G	50mm	Power Clamp Arms 50 Series Gripper Clamping Components (Machined - 20 mm Wide)	

# POWER CLAMP ARMS BLANKS 60 SERIES

(STRAIGHT) (FULL METRIC)

GLOBAL STANDARD COMPONENTS



Assembly

11/10/10

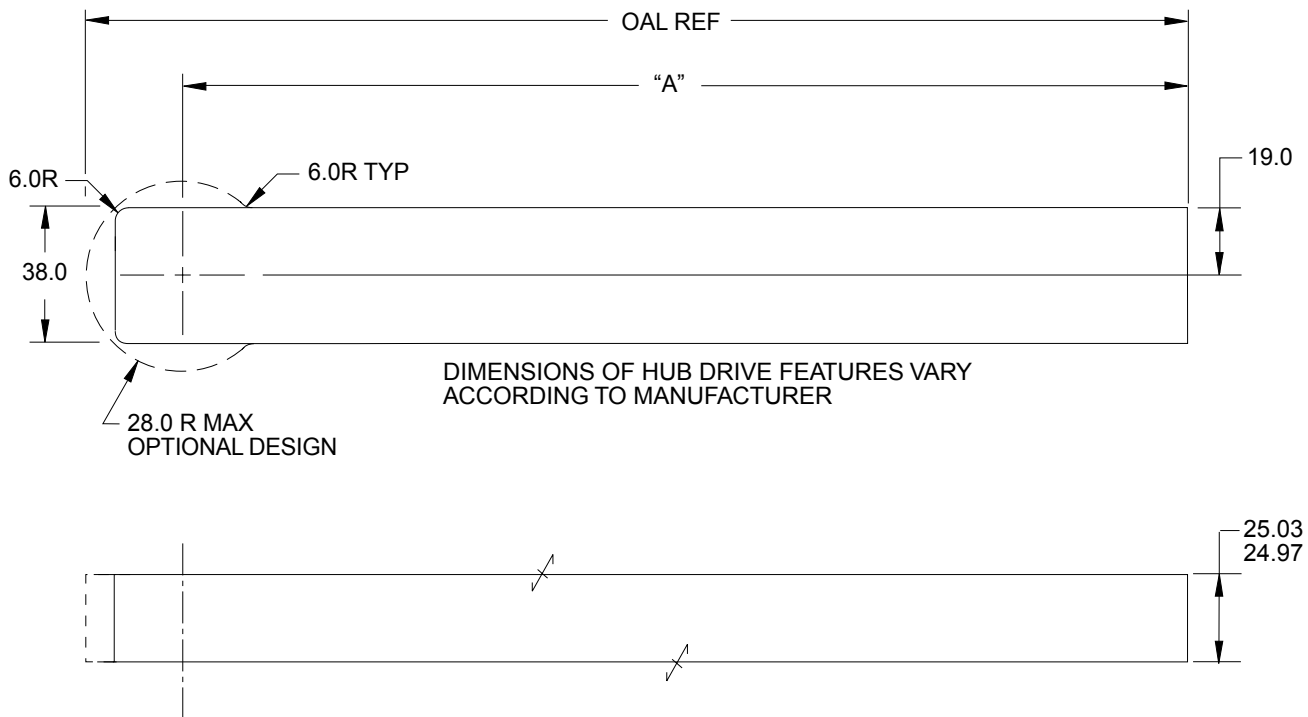
E

A

B

D

C



STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

EXCEPT AS NOTED TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$

MATERIAL: SAE 4140 or SAE 1045

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

NAAMS CODE	DIM. "A"	MAX OAL (REF)	WEIGHT kg
ACA001M	135.0	163.0	1.2
ACA002M	165.0	193.0	1.4
ACA003M	195.0	223.0	1.6
ACA004M	225.0	253.0	1.9
ACA005M	255.0	283.0	2.1
ACA006M	285.0	313.0	2.3

# POWER CLAMP ARMS 60 SERIES

(STRAIGHT - MACHINED) (FULL METRIC)

G

E

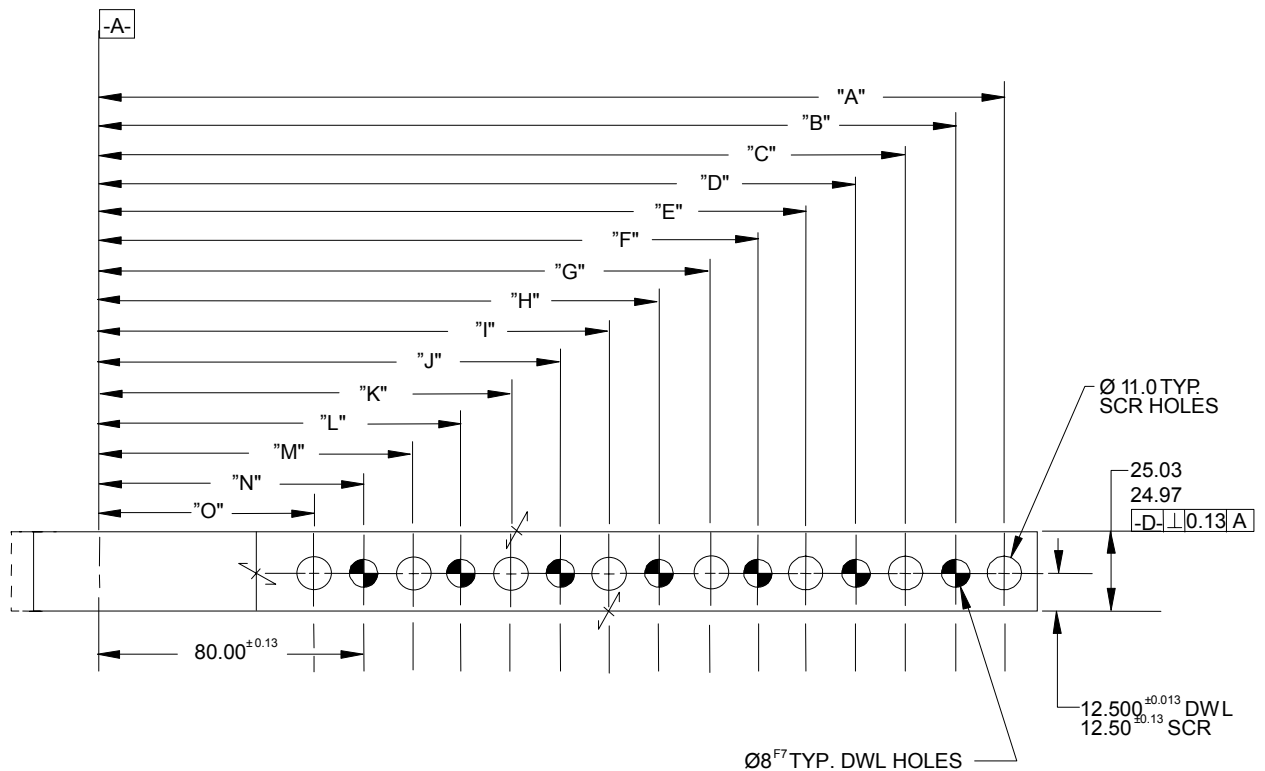
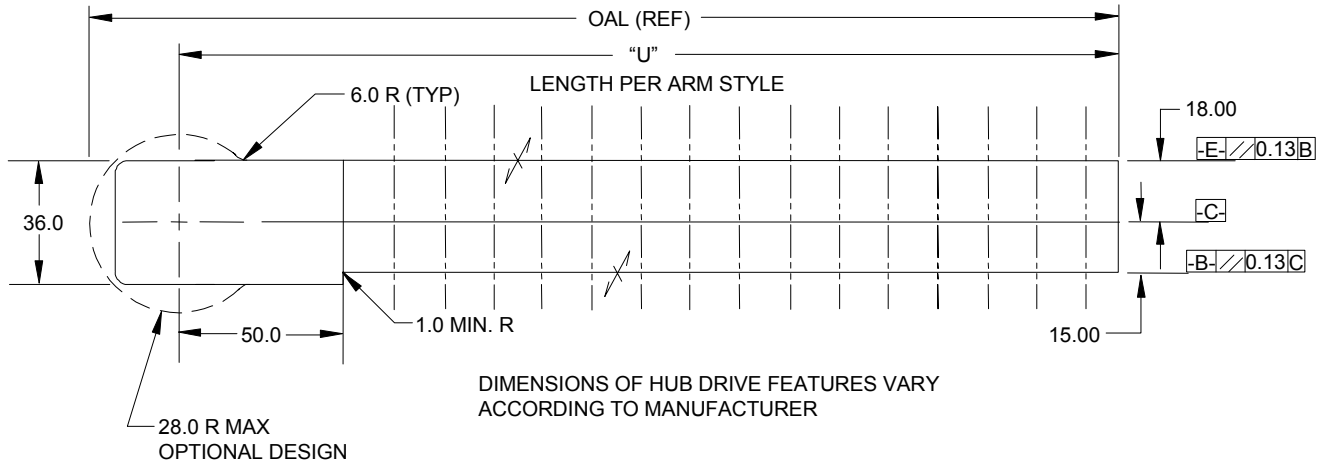
A

C

D

F

B



STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

PAINT AS PRESCRIBED ON PAGE G-1.2

CLEARANCE HOLES G, I, K, M AND O ARE OPTIONAL UNTIL FEBRUARY 1, 2006 AND MANDATORY THEREAFTER.

TABULATED INFORMATION ON FOLLOWING PAGE

# POWER CLAMP ARMS 60 SERIES

(STRAIGHT - MACHINED) (FULL METRIC)

F

EXCEPT AS NOTED TOLERANCES SHALL BE:

- 1 PLACE MACHINING ±0.3
- 1 PLACE FABRICATION ±1.5
- 2 PLACE ±0.03 GENERAL
- ±0.03 BETWEEN DOWELS
- ±0.13 TO SCREW HOLES

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

MATERIAL: SAE 4140 or SAE 1045

E

NAAMS CODE	DIM "U" +1.5/-0.0	MAX OAL (REF)	Weight kg*	Dim. "A"	Dim. "B"	Dim. "C"	Dim. "D"	Dim. "E"	Dim. "F"	Dim. "G"	Dim. "H"	Dim. "I"	Dim. "J"	Dim. "K"	Dim. "L"	Dim. "M"
ACA007M	135.0	163.0	1.0	125.00	110.00	95.00	80.00	65.00								
ACA008M	165.0	193.0	1.2	155.00	140.00	125.00	110.00	95.00	80.00	65.00						
ACA009M	195.0	223.0	1.3	185.00	170.00	155.00	140.00	125.00	110.00	95.00	80.00	65.00				
ACA010M	225.0	253.0	1.4	215.00	200.00	185.00	170.00	155.00	140.00	125.00	110.00	95.00	80.00	65.00		
ACA011M	255.0	283.0	1.6	245.00	230.00	215.00	200.00	185.00	170.00	155.00	140.00	125.00	110.00	95.00	80.00	65.00
ACA012M	285.0	313.0	1.8	275.00	260.00	245.00	230.00	215.00	200.00	185.00	170.00	155.00	140.00	125.00	110.00	95.00

A

B

C



D

NAAMS CODE	Dim. "N"	Dim. "O"
ACA012M	80.00	65.00



\* Weight of arm as shown. Actual weight may vary due to variations in mounting details.

SEE DRAWING ON PREVIOUS PAGE

# POWER CLAMP ARMS BLANKS 80/90 SERIES

(STRAIGHT) (INCH AND METRIC DESIGNS)

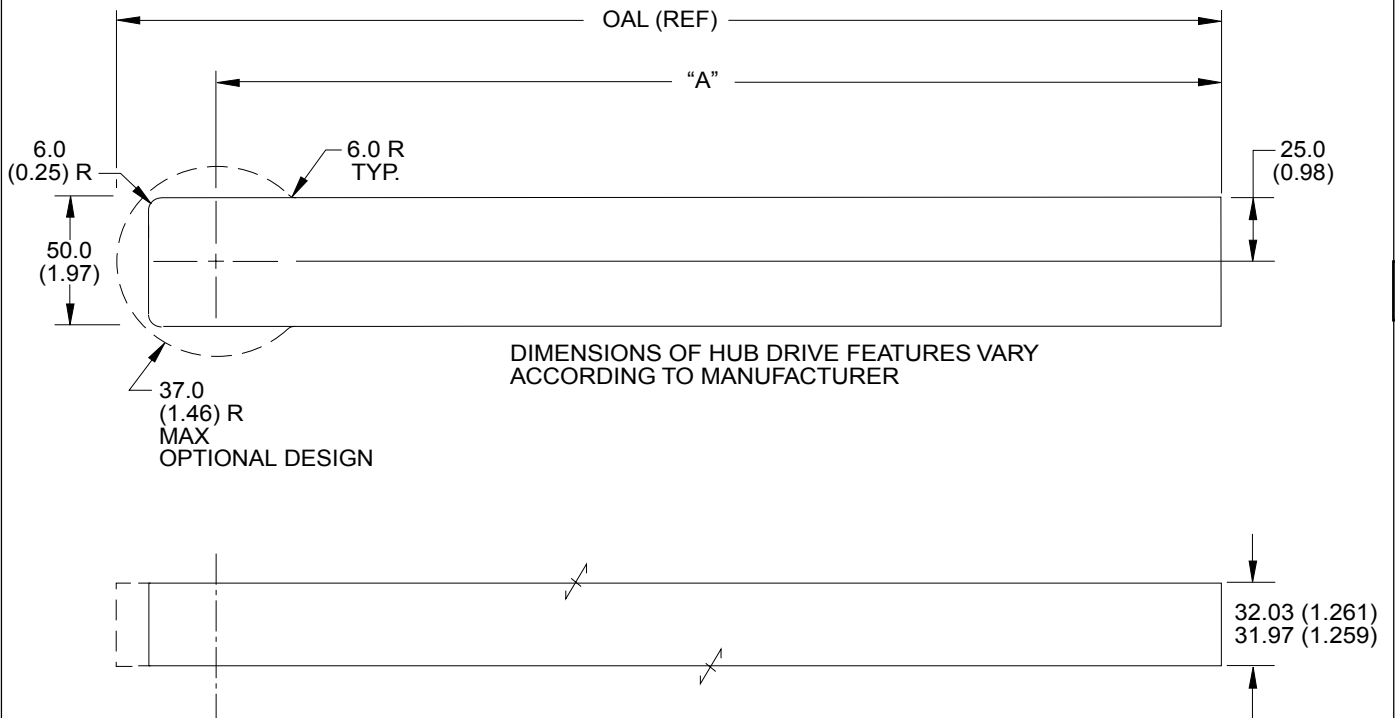
GLOBAL STANDARD COMPONENTS



Assembly

11/10/10

D



A

STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

EXCEPT AS NOTED METRIC TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$

MATERIAL: SAE 4140 or SAE 1045

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.  
DIMENSIONS IN PARENTHESES ARE INCH EQUIVALENT.

C

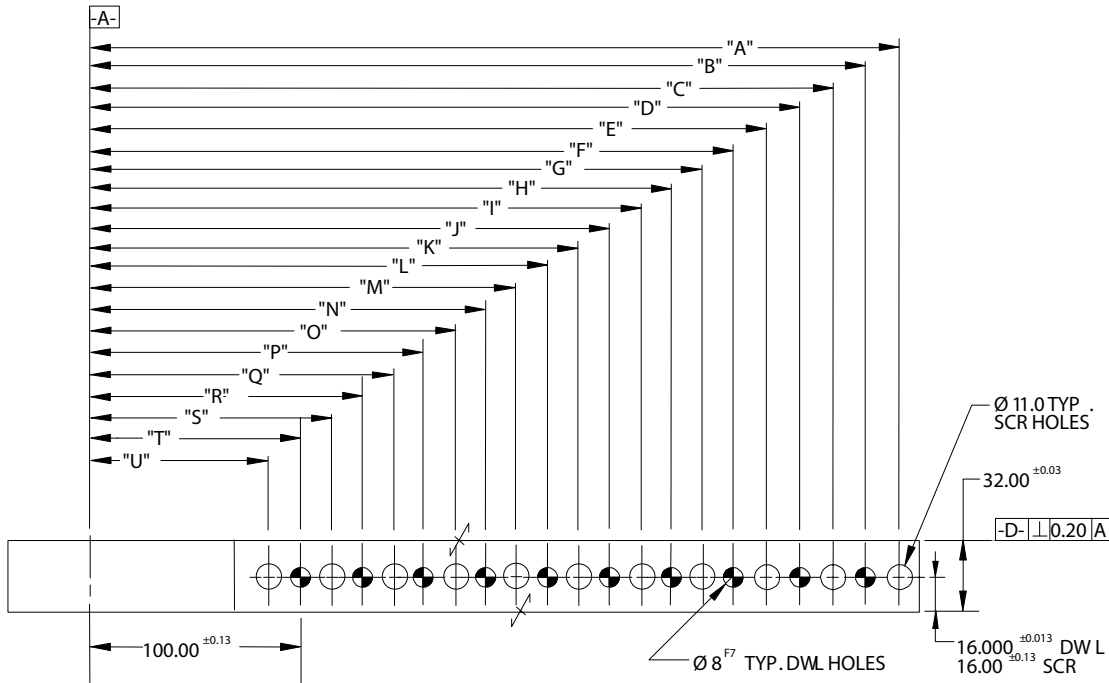
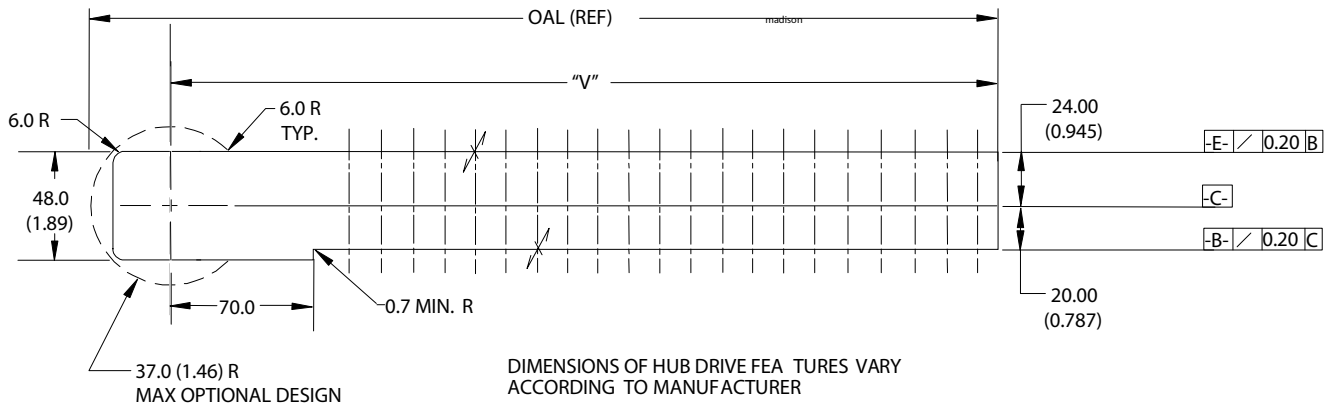
NAAMS CODE	DIM. "A"	MAX OAL (REF)	WEIGHT kg (lb)
ACA100M	155.0 (6.10)	192.0 (7.56)	2.1 (4.6)
ACA101M	185.0 (7.28)	222.0 (8.74)	2.5 (5.5)
ACA102M	215.0 (8.46)	252.0 (9.92)	2.9 (6.4)
ACA103M	245.0 (9.65)	282.0 (11.10)	3.2 (7.1)
ACA104M	275.0 (10.83)	312.0 (12.28)	3.6 (7.9)
ACA105M	305.0 (12.00)	342.0 (13.46)	4.0 (8.8)
ACA106M	335.0 (13.19)	372.0 (14.65)	4.4 (9.7)
ACA107M	365.0 (14.37)	402.0 (15.83)	4.7 (10.4)
ACA108M	395.0 (15.55)	432.0 (17.01)	5.1 (11.2)

B



# POWER CLAMP ARMS 80/90 SERIES (STRAIGHT - MACHINED) (FULL METRIC)

E  
B  
C  
D  
A



STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

PAINT AS PRESCRIBED ON PAGE G-1.2

CLEARANCE HOLES G, I, K, M, O, Q, S AND U ARE OPTIONAL UNTIL FEBRUARY 1, 2006 AND MANDATORY THEREAFTER.

TABULATED INFORMATION ON FOLLOWING PAGE

# POWER CLAMP ARMS 80/90 SERIES

(STRAIGHT - MACHINED) (FULL METRIC)

GLOBAL STANDARD COMPONENTS



Assembly

11/10/10

H

MAXIMUM ALLOWABLE ROUGHNESS SHALL BE:  
 1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS  
 2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS  
 3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS

EXCEPT AS NOTED TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$
- 2 PLACE  $\pm 0.03$  GENERAL  
 $\pm 0.03$  BETWEEN DOWELS  
 $\pm 0.13$  TO SCREW HOLES

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

MATERIAL: SAE 4140 or SAE 1045

G

NAAMS CODE	DIM "V" +1.5/-0.0	MAX OAL (REF)	Weight kg*	Dim. "A"	Dim. "B"	Dim. "C"	Dim. "D"	Dim. "E"	Dim. "F"	Dim. "G"	Dim. "H"	Dim. "I"	Dim. "J"	Dim. "K"	Dim. "L"	Dim. "M"
ACA110M	155.00	192.00	1.9	145.00	130.00	115.00	100.00	85.00								
ACA111M	185.00	222.00	2.2	175.00	160.00	145.00	130.00	115.00	100.00	85.00						
ACA112M	215.00	252.00	2.4	205.00	190.00	175.00	160.00	145.00	130.00	115.00	100.00	85.00				
ACA113M	245.00	282.00	2.7	235.00	220.00	205.00	190.00	175.00	160.00	145.00	130.00	115.00	100.00	85.00		
ACA114M	275.00	312.00	3.0	265.00	250.00	235.00	220.00	205.00	190.00	175.00	160.00	145.00	130.00	115.00	100.00	85.00
ACA115M	305.00	342.00	3.2	295.00	280.00	265.00	250.00	235.00	220.00	205.00	190.00	175.00	160.00	145.00	130.00	115.00
ACA116M	335.00	372.00	3.6	325.00	310.00	295.00	280.00	265.00	250.00	235.00	220.00	205.00	190.00	175.00	160.00	145.00
ACA117M	365.00	402.00	3.9	355.00	340.00	325.00	310.00	295.00	280.00	265.00	250.00	235.00	220.00	205.00	190.00	175.00
ACA118M	395.00	432.00	4.1	385.00	370.00	355.00	340.00	325.00	310.00	295.00	280.00	265.00	250.00	235.00	220.00	205.00

C

A

D

E

F

B

DOWEL

NAAMS CODE	Dim. "N"	Dim. "O"	Dim. "P"	Dim. "Q"	Dim. "R"	Dim. "S"	Dim. "T"	Dim. "U"
ACA115M	100.00	85.00						
ACA116M	130.00	115.00	100.00	85.00				
ACA117M	160.00	145.00	130.00	115.00	100.00	85.00		
ACA118M	190.00	175.00	160.00	145.00	130.00	115.00	100.00	85.00

DOWEL

\* Weight of arm as shown. Actual weight may vary due to variations in mounting details.

SEE DRAWING ON PREVIOUS PAGE

# POWER CLAMP ARMS BLANKS 60 SERIES

(STRAIGHT) (INCH AND METRIC DESIGNS)

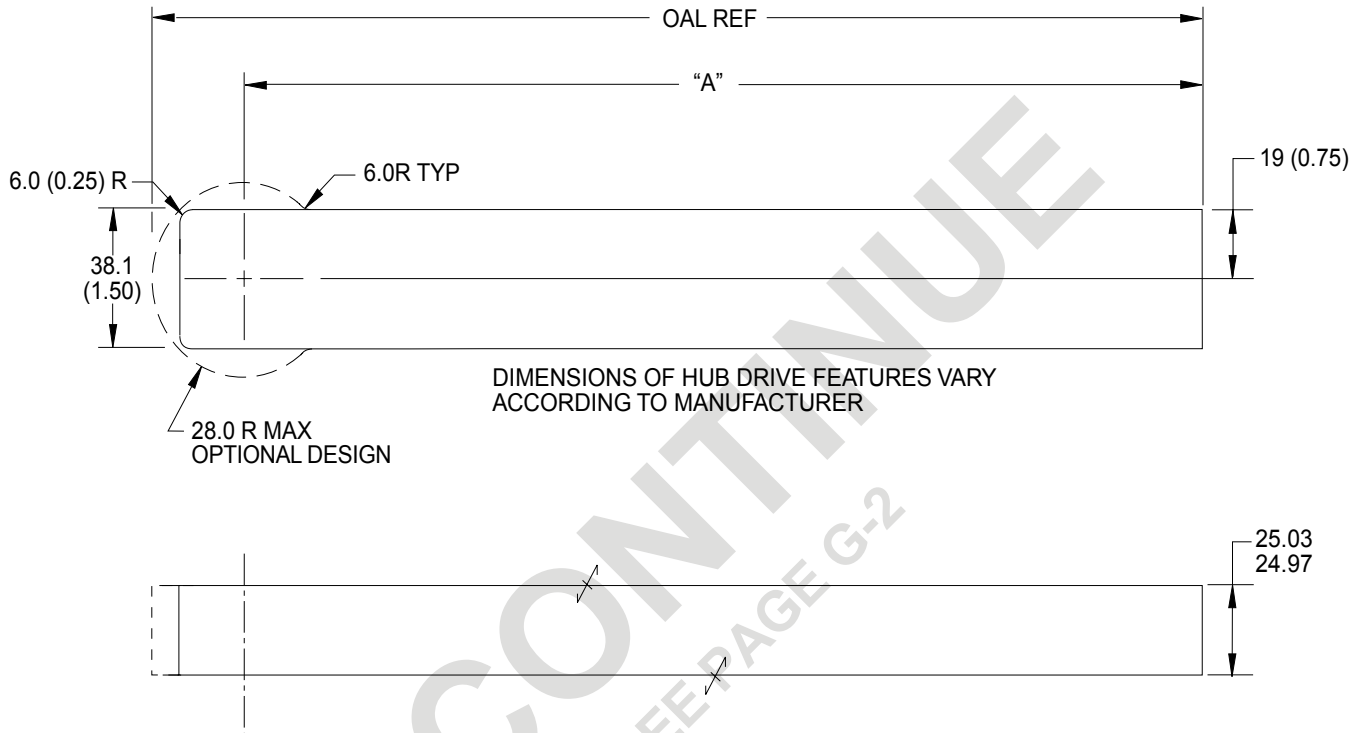
GLOBAL STANDARD COMPONENTS



Assembly

11/10/10

E  
A



B

STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM  
MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

EXCEPT AS NOTED METRIC TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$

MATERIAL: SAE 4140 or SAE 1045

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.  
DIMENSIONS IN PARENTHESES ARE INCH EQUIVALENT.

D

NAAMS CODE	DIM. "A"	MAX OAL (REF)	WEIGHT kg (lb)
ACA001	135.0 (5.31)	163.0 (6.42)	1.2 (2.6)
ACA002	165.0 (6.50)	193.0 (7.60)	1.4 (3.1)
ACA003	195.0 (7.68)	223.0 (8.78)	1.6 (3.5)
ACA004	225.0 (8.86)	253.0 (9.96)	1.9 (4.2)
ACA005	255.0 (10.04)	283.0 (11.14)	2.1 (4.6)
ACA006	285.0 (11.22)	313.0 (12.32)	2.3 (5.1)

C

# POWER CLAMP ARMS 60 SERIES (STRAIGHT - MACHINED)

I  
B

H  
A

D

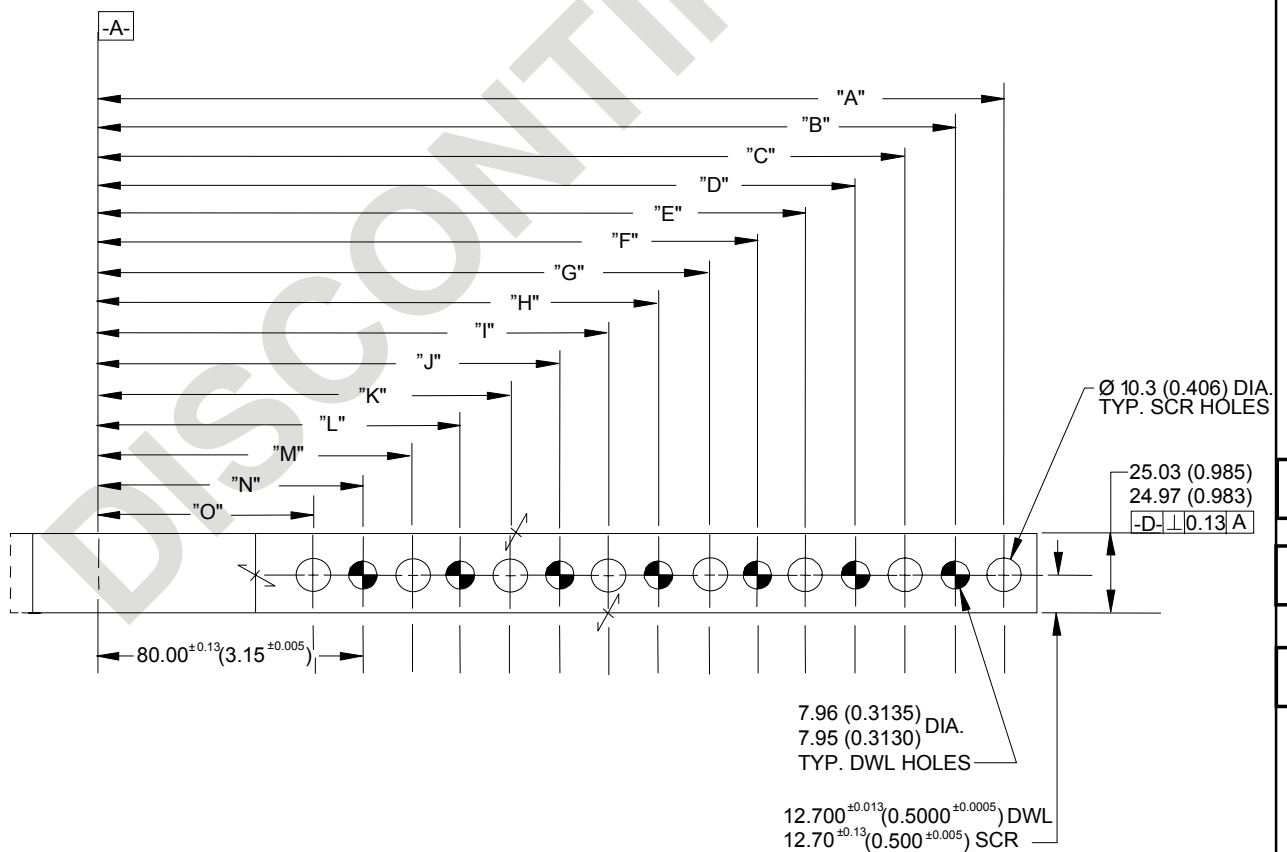
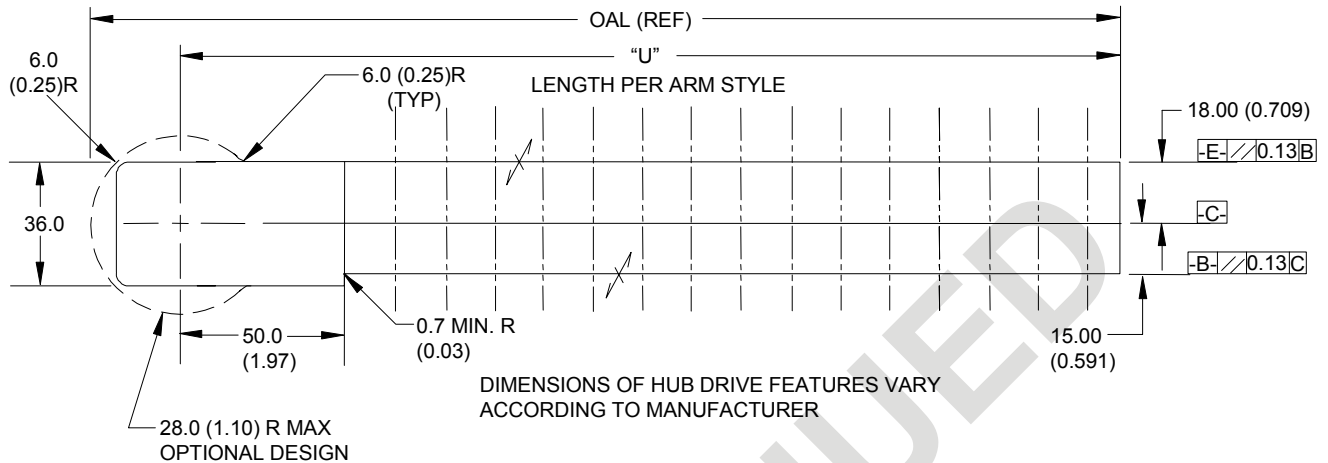
F

E

D

G

C



STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

PAINT AS PRESCRIBED ON PAGE G-1.2

CLEARANCE HOLES G, I, K, M AND O ARE OPTIONAL UNTIL FEBRUARY 1, 2006 AND MANDATORY THEREAFTER.

TABULATED INFORMATION ON FOLLOWING PAGE

# POWER CLAMP ARMS 60 SERIES (STRAIGHT - MACHINED)

E

EXCEPT AS NOTED METRIC TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$
- 2 PLACE  $\pm 0.03$  GENERAL
  - $\pm 0.03$  BETWEEN DOWELS
  - $\pm 0.13$  TO SCREW HOLES

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.  
DIMENSIONS IN PARENTHESES ARE INCH EQUIVALENT.

MATERIAL: 4140 OR EQUIVALENT

NAAMS CODE	DIM "U" +1.5/-0.0	MAX OAL (REF)	Weight kg*	Dim. "A"	Dim. "B"	Dim. "C"	Dim. "D"	Dim. "E"	Dim. "F"	Dim. "G"	Dim. "H"	Dim. "I"	Dim. "J"	Dim. "K"	Dim. "L"	Dim. "M"
ACA007	135.0 (5.31)	163.0 (6.42)	1.0 (2.2)	125.00 (4.921)	110.00 (4.331)	95.00 (3.740)	80.00 (3.150)	65.00 (2.559)								
ACA008	165.0 (6.50)	193.0 (7.60)	1.2 (2.6)	155.00 (6.102)	140.00 (5.512)	125.00 (4.921)	110.00 (4.331)	95.00 (3.740)	80.00 (3.150)	65.00 (2.559)						
ACA009	195.0 (7.68)	223.0 (8.78)	1.3 (2.9)	185.00 (7.283)	170.00 (6.693)	155.00 (6.102)	140.00 (5.512)	125.00 (4.921)	110.00 (4.331)	95.00 (3.740)	80.00 (3.150)	65.00 (2.559)				
ACA010	225.0 (8.86)	253.0 (9.96)	1.4 (3.1)	215.00 (8.464)	200.00 (7.874)	185.00 (7.283)	170.00 (6.693)	155.00 (6.102)	140.00 (5.512)	125.00 (4.921)	110.00 (4.331)	95.00 (3.740)	80.00 (3.150)	65.00 (2.559)		
ACA011	255.0 (10.04)	283.0 (11.14)	1.6 (3.5)	245.00 (9.646)	230.00 (9.055)	215.00 (8.464)	200.00 (7.874)	185.00 (7.283)	170.00 (6.693)	155.00 (6.102)	140.00 (5.512)	125.00 (4.921)	110.00 (4.331)	95.00 (3.740)	80.00 (3.150)	65.00 (2.559)
ACA012	285.0 (11.22)	313.0 (12.32)	1.8 (4.0)	275.00 (10.827)	260.00 (10.236)	245.00 (9.646)	230.00 (9.055)	215.00 (8.464)	200.00 (7.874)	185.00 (7.283)	170.00 (6.693)	155.00 (6.102)	140.00 (5.512)	125.00 (4.921)	110.00 (4.331)	95.00 (3.740)

A

B

C

DOWEL

D

NAAMS CODE	Dim. "N"	Dim. "O"
ACA012	80.00 (3.150)	65.00 (2.559)

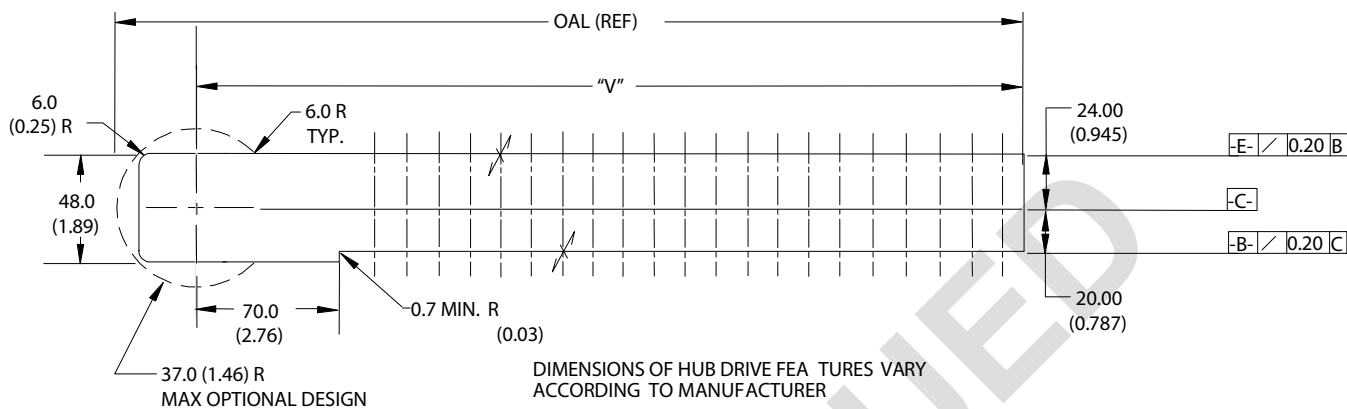
DOWEL

\* Weight of arm as shown. Actual weight may vary due to variations in mounting details.

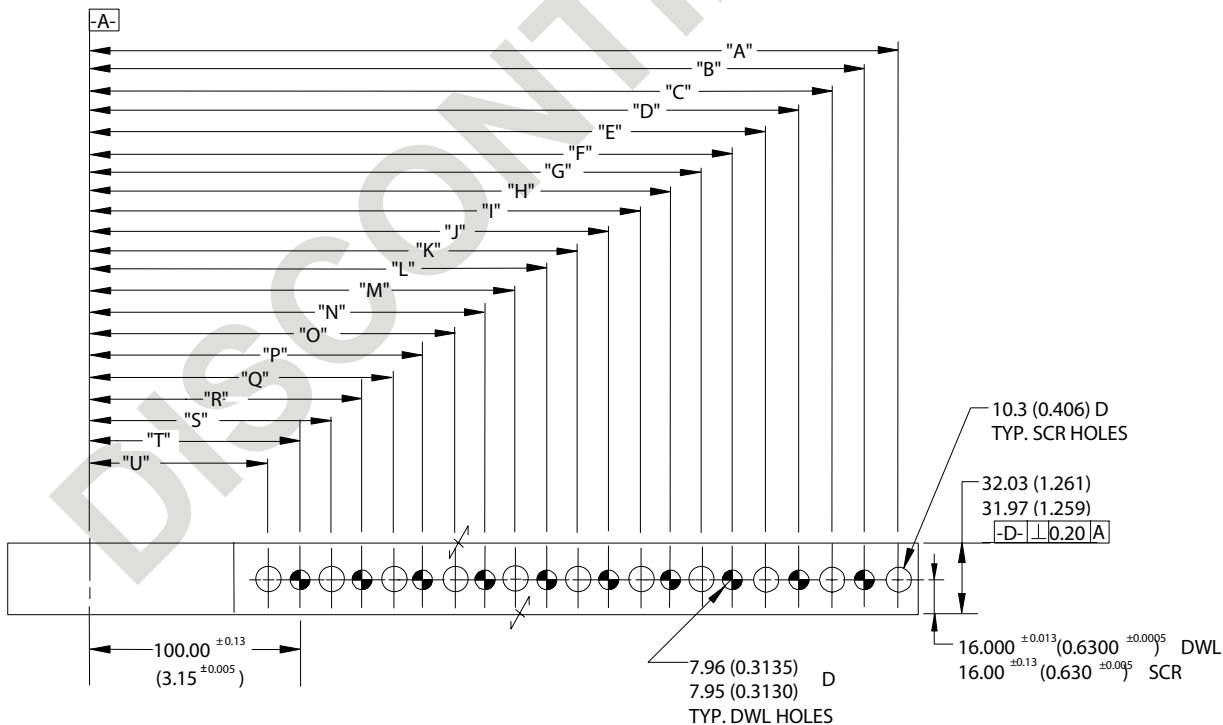
SEE DRAWING ON PREVIOUS PAGE

# POWER CLAMP ARMS 80/90 SERIES (STRAIGHT - MACHINED)

E



B



C

STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

PAINT AS PRESCRIBED ON PAGE G-1.2

CLEARANCE HOLES G, I, K, M, O, Q, S AND U ARE OPTIONAL UNTIL FEBRUARY 1, 2006 AND MANDATORY THEREAFTER.

TABULATED INFORMATION ON FOLLOWING PAGE

D

A

# POWER CLAMP ARMS 80/90 SERIES (STRAIGHT - MACHINED)

G

MAXIMUM ALLOWABLE ROUGHNESS SHALL BE:  
1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS  
2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS  
3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS

EXCEPT AS NOTED TOLERANCES SHALL BE:  
1 PLACE MACHINING  $\pm 0.3$   
1 PLACE FABRICATION  $\pm 1.5$   
2 PLACE  $\pm 0.03$  GENERAL  
 $\pm 0.03$  BETWEEN DOWELS  
 $\pm 0.13$  TO SCREW HOLES

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

MATERIAL: 4140 OR EQUIVALENT

NAAMS CODE	DIM "V" +1.5/-0.0	MAX OAL (REF)	Weight kg*	Dim. "A"	Dim. "B"	Dim. "C"	Dim. "D"	Dim. "E"	Dim. "F"	Dim. "G"	Dim. "H"	Dim. "I"	Dim. "J"	Dim. "K"	Dim. "L"	Dim. "M"
ACA110	155.0 (6.10)	192.0 (7.56)	1.9 (4.2)	145.0 (5.709)	130.00 (5.118)	115.00 (4.528)	100.00 (3.937)	85.00 (3.346)								
ACA111	185.0 (7.28)	222.0 (8.84)	2.2 (4.8)	175.00 (6.890)	160.00 (6.299)	145.00 (5.709)	130.00 (5.118)	115.00 (4.528)	100.00 (3.937)	85.00 (3.346)						
ACA112	215.0 (8.46)	252.0 (9.92)	2.4 (5.4)	205.00 (8.071)	190.00 (7.480)	175.00 (6.890)	160.00 (6.299)	145.00 (5.709)	130.00 (5.118)	115.00 (4.528)	100.00 (3.937)	85.00 (3.346)				
ACA113	245.0 (9.65)	282.0 (11.10)	2.7 (6.0)	235.00 (9.252)	220.00 (8.661)	205.00 (8.071)	190.00 (7.480)	175.00 (6.890)	160.00 (6.299)	145.00 (5.709)	130.00 (5.118)	115.00 (4.528)	100.00 (3.937)	85.00 (3.346)		
ACA114	275.0 (10.83)	312.0 (12.28)	3.0 (6.5)	265.00 (10.433)	250.00 (9.843)	235.00 (9.252)	220.00 (8.661)	205.00 (8.071)	190.00 (7.480)	175.00 (6.890)	160.00 (6.299)	145.00 (5.709)	130.00 (5.118)	115.00 (4.528)	100.00 (3.937)	85.00 (3.346)
ACA115	305.0 (12.00)	342.0 (13.46)	3.2 (7.1)	295.00 (11.614)	280.00 (11.024)	265.00 (10.433)	250.00 (9.843)	235.00 (9.252)	220.00 (8.661)	205.00 (8.071)	190.00 (7.480)	175.00 (6.890)	160.00 (6.299)	145.00 (5.709)	130.00 (5.118)	115.00 (4.528)
ACA116	335.0 (13.19)	372.0 (14.65)	3.6 (7.9)	325.00 (12.795)	310.00 (12.205)	295.00 (11.614)	280.00 (11.024)	265.00 (10.433)	250.00 (9.843)	235.00 (9.252)	220.00 (8.661)	205.00 (8.071)	190.00 (7.480)	175.00 (6.890)	160.00 (6.299)	145.00 (5.709)
ACA117	365.0 (14.37)	402.0 (15.83)	3.9 (8.5)	355.00 (13.976)	340.00 (13.386)	325.00 (12.795)	310.00 (12.205)	295.00 (11.614)	280.00 (11.024)	265.00 (10.433)	250.00 (9.843)	235.00 (9.252)	220.00 (8.661)	205.00 (8.071)	190.00 (7.480)	175.00 (6.890)
ACA118	395.0 (15.55)	432.0 (17.01)	4.1 (9.1)	385.00 (15.157)	370.00 (14.567)	355.00 (13.976)	340.00 (13.386)	325.00 (12.795)	310.00 (12.205)	295.00 (11.614)	280.00 (11.024)	265.00 (10.433)	250.00 (9.843)	235.00 (9.252)	220.00 (8.661)	205.00 (8.071)

A

B

D

E

F

C

DOWEL

NAAMS CODE	Dim. "N"	Dim. "O"	Dim. "P"	Dim. "Q"	Dim. "R"	Dim. "S"	Dim. "T"	Dim. "U"
ACA115	100.00 (3.937)	85.00 (3.346)						
ACA116	130.00 (5.118)	115.00 (4.528)	100.00 (3.937)	85.00 (3.346)				
ACA117	160.00 (6.299)	145.00 (5.709)	130.00 (5.118)	115.00 (4.528)	100.00 (3.937)	85.00 (3.346)		
ACA118	190.00 (7.480)	175.00 (6.890)	160.00 (6.299)	145.00 (5.709)	130.00 (5.118)	115.00 (4.528)	100.00 (3.937)	85.00 (3.346)

DOWEL

\* Weight of arm as shown. Actual weight may vary due to variations in mounting details.

SEE DRAWING ON PREVIOUS PAGE

# POWER CLAMP ARMS BLANKS

## 50 SERIES

(STRAIGHT) (FULL METRIC)

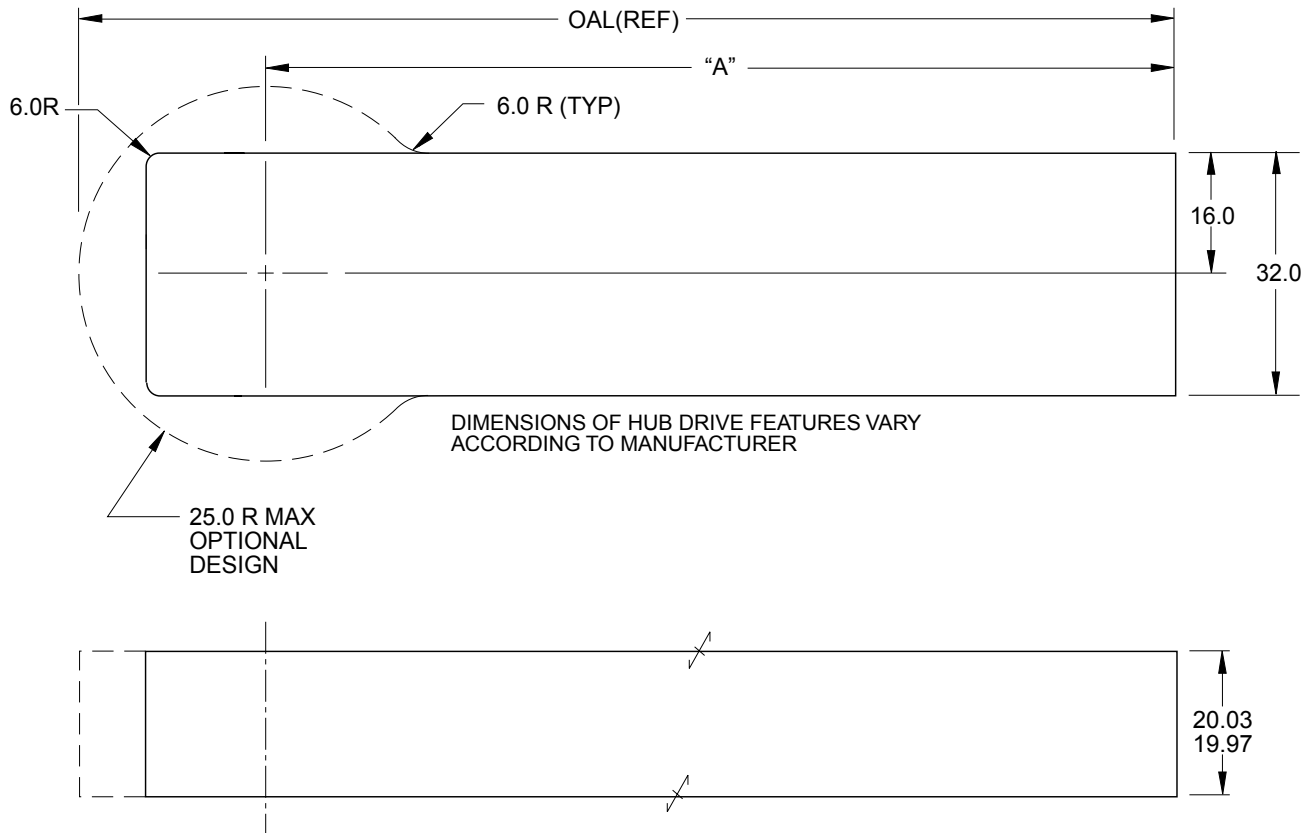
GLOBAL STANDARD COMPONENTS



Assembly

11/10/10

D



A

STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

EXCEPT AS NOTED TOLERANCES SHALL BE:  
1 PLACE FABRICATION  $\pm 1.5$

MATERIAL: SAE 4140 or SAE 1045

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

C

NAAMS CODE	DIM. "A"	MAX OAL (REF)	WEIGHT kg
ACA201M	90.0	115.0	0.5
ACA202M	120.0	145.0	0.7
ACA203M	150.0	175.0	0.8

B



# POWER CLAMP ARMS 50 SERIES

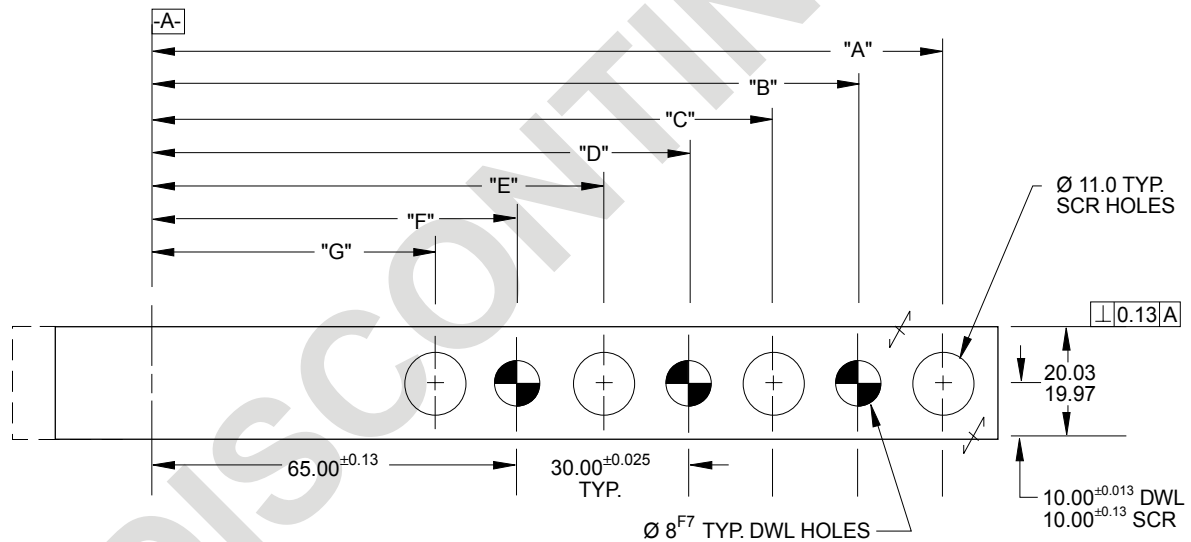
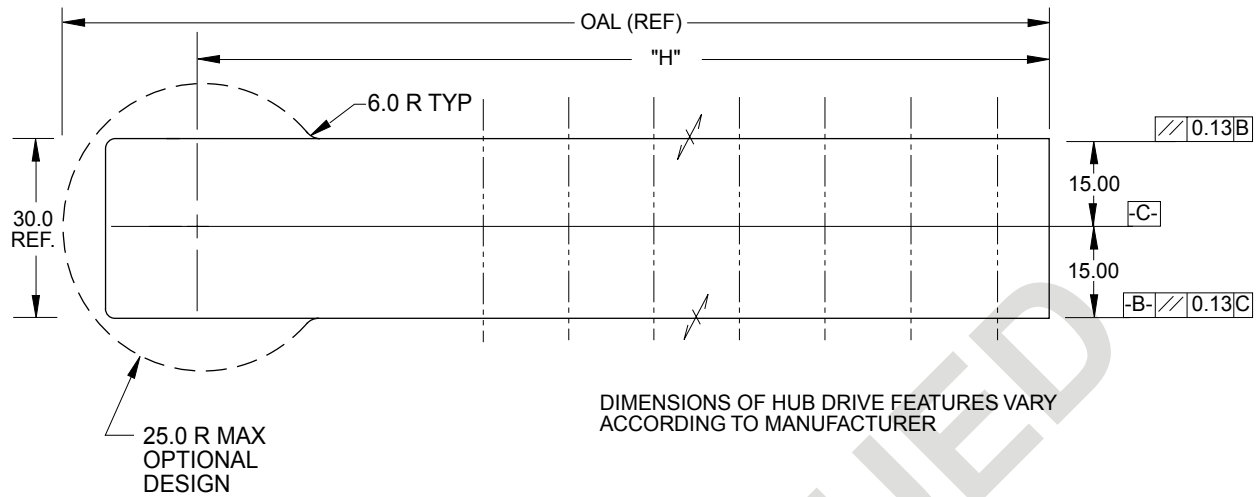
(STRAIGHT) (MACHINED - FULL METRIC)

GLOBAL STANDARD COMPONENTS



Assembly

11/10/10



EXCEPT AS NOTED TOLERANCES SHALL BE:

- 1 PLACE MACHINING ±0.3
- 1 PLACE FABRICATION ±1.5
- 2 PLACE ± 0.03 GENERAL
- ± 0.03 BETWEEN DOWELS
- ± 0.13 TO SCREW HOLES

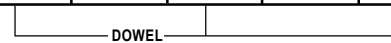
NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

MATERIAL: SAE 4140 or SAE 1045

STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

PAINT AS PRESCRIBED ON PAGE G-1.2

NAAMS CODE	DIM. "A"	DIM. "B"	DIM. "C"	DIM. "D"	DIM. "E"	DIM. "F"	DIM. "G"	DIM. "H" +1.5/-0.0	MAX OAL (REF)	WEIGHT kg
ACA206M	80.00	65.00	50.00					90.0	115.0	0.4
ACA207M	110.00	95.00	80.00	65.00	50.00			120.0	145.0	0.5
ACA208M	140.00	125.00	110.00	95.00	80.00	65.00	50.00	150.0	175.0	0.6



I  
D  
J  
A  
G  
F  
B  
H  
C  
E

# POWER CLAMP ARMS

## 50 SERIES

(STRAIGHT - MACHINED) (FULL METRIC)

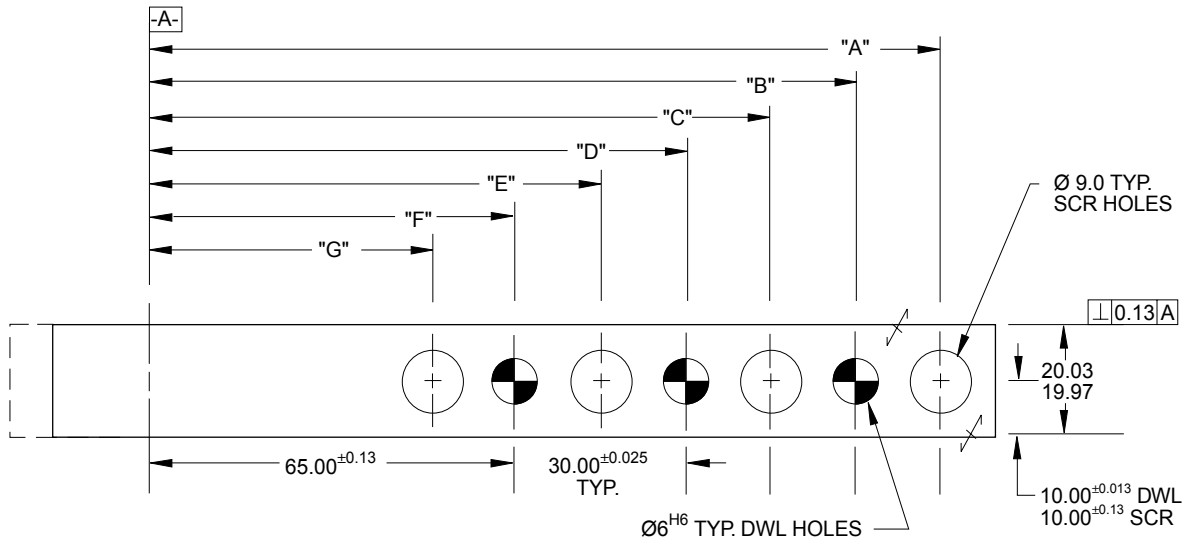
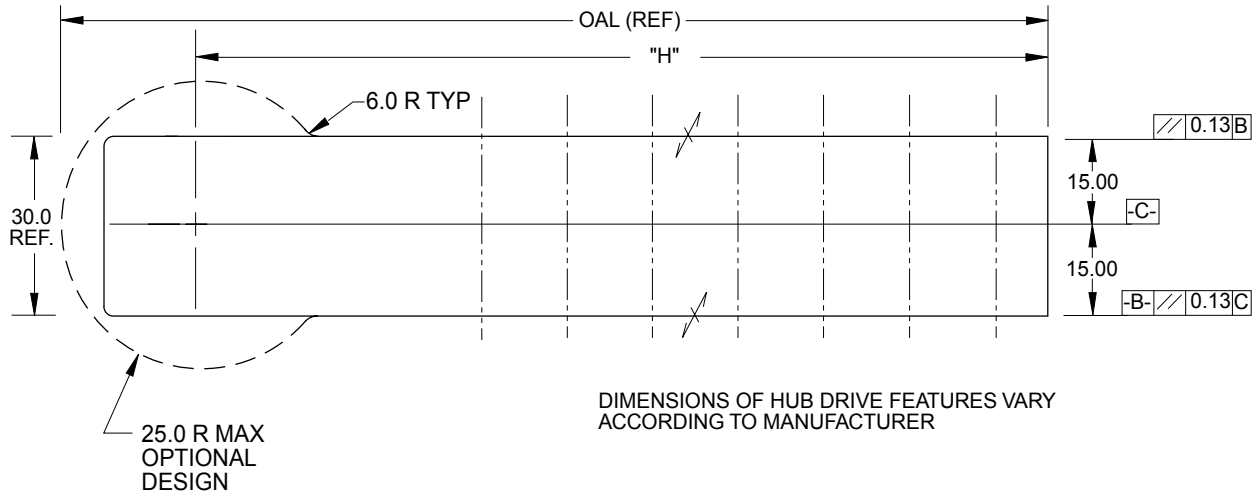
GLOBAL STANDARD COMPONENTS



Assembly

09/05/12

D



EXCEPT AS NOTED TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$
- 2 PLACE  $\pm 0.03$  GENERAL
- $\pm 0.03$  BETWEEN DOWELS
- $\pm 0.13$  TO SCREW HOLES

STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

PAINT AS PRESCRIBED ON PAGE G-1.2

MATERIAL: SAE 4140 or SAE 1045

NAAMS CODE	DIM. "A"	DIM. "B"	DIM. "C"	DIM. "D"	DIM. "E"	DIM. "F"	DIM. "G"	DIM. "H" +1.5/-0.0	MAX OAL (REF)	WEIGHT kg
ACA236M	80.00	65.00	50.00					90.0	115.0	0.4
ACA237M	110.00	95.00	80.00	65.00	50.00			120.0	145.0	0.5
ACA238M	140.00	125.00	110.00	95.00	80.00	65.00	50.00	150.0	175.0	0.6



E  
B  
F

A

C

# POWER CLAMP ARMS 50 SERIES

(STRAIGHT - MACHINED) (FULL METRIC)

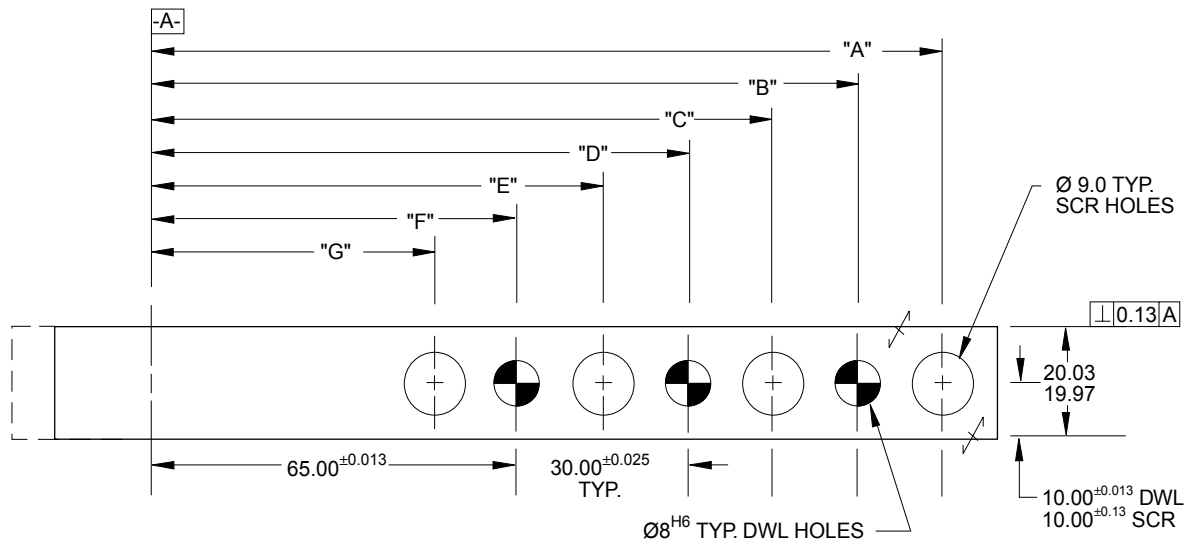
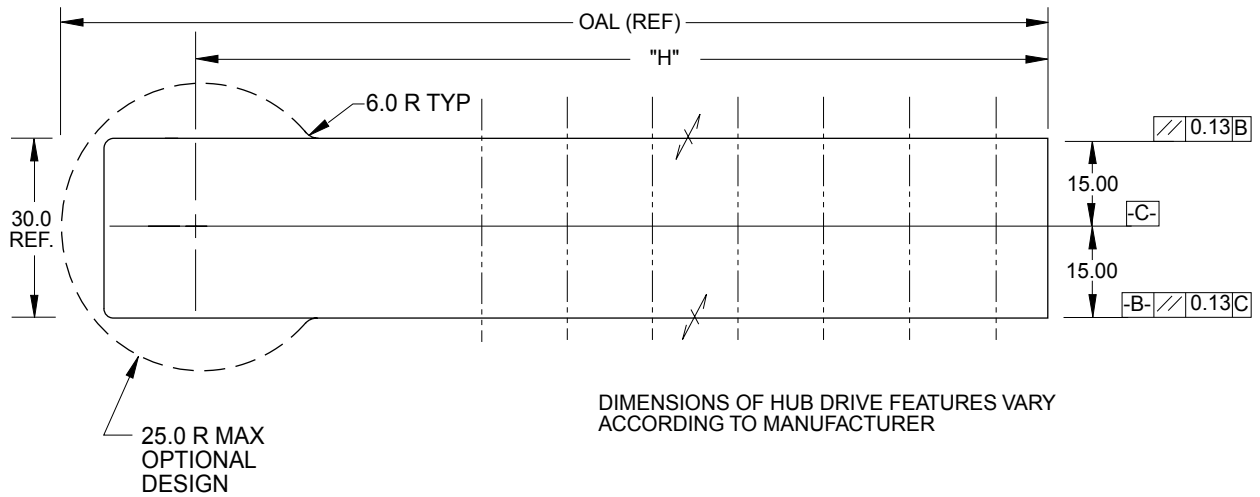
GLOBAL STANDARD COMPONENTS



Assembly

09/05/12

A



EXCEPT AS NOTED TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$
- 2 PLACE  $\pm 0.03$  GENERAL
- $\pm 0.03$  BETWEEN DOWELS
- $\pm 0.13$  TO SCREW HOLES

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

MATERIAL: SAE 4140 or SAE 1045

STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

PAINT AS PRESCRIBED ON PAGE G-1.2

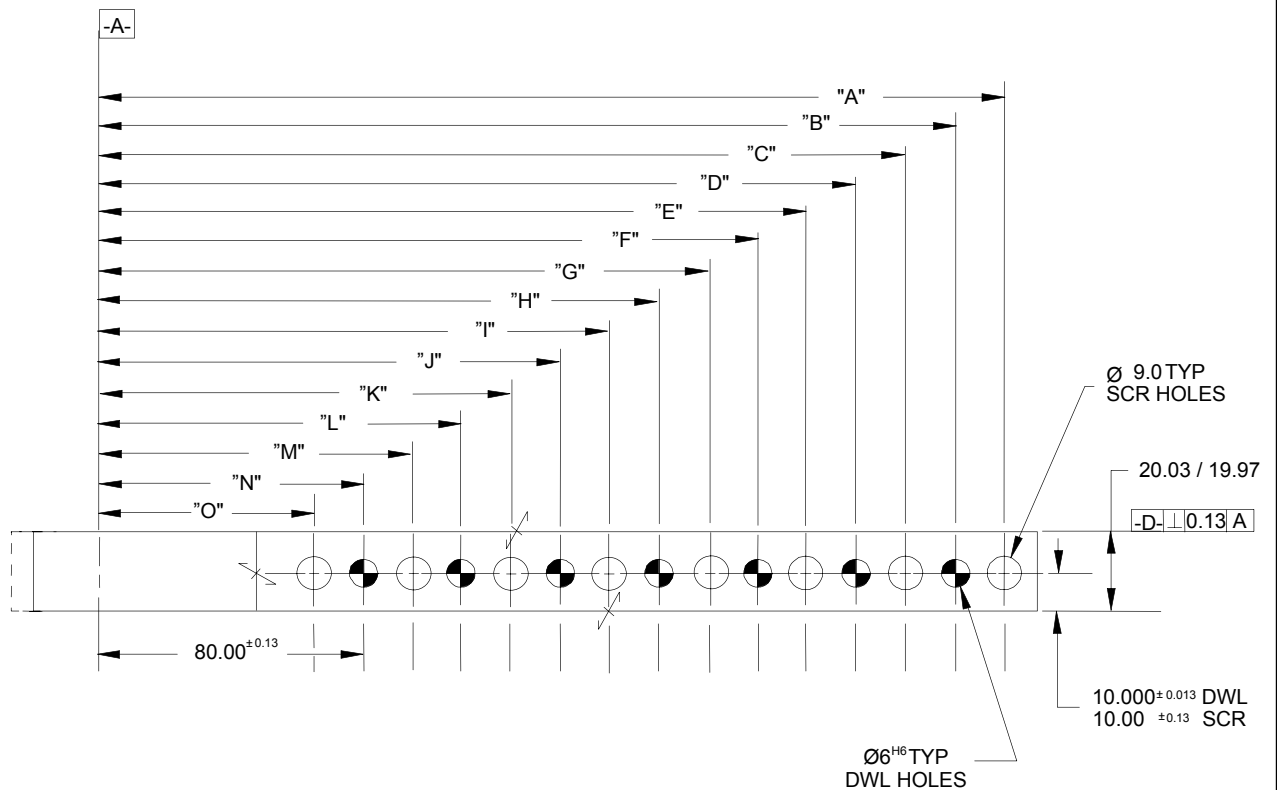
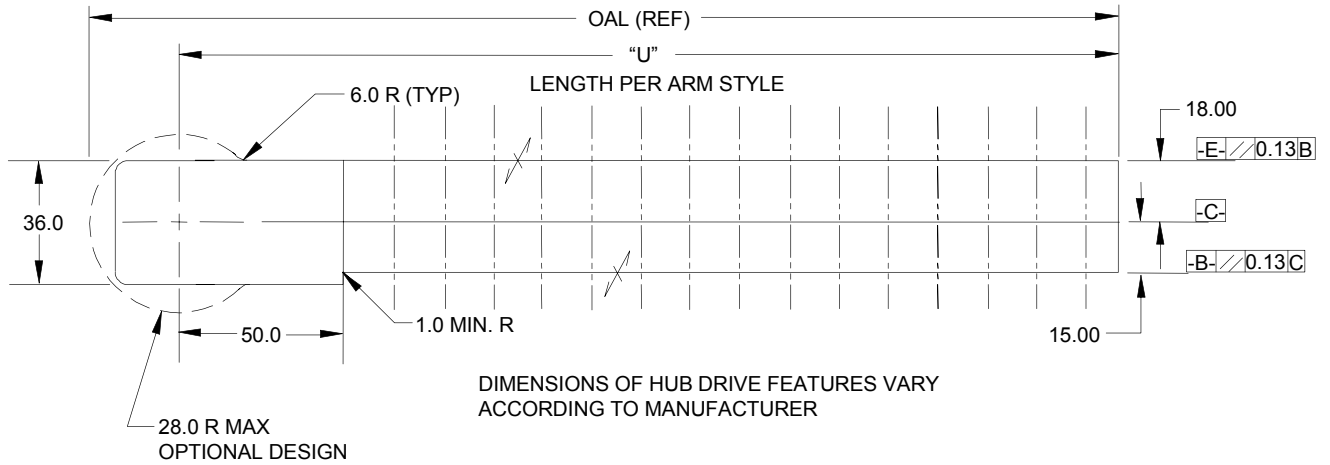
NAAMS CODE	DIM. "A"	DIM. "B"	DIM. "C"	DIM. "D"	DIM. "E"	DIM. "F"	DIM. "G"	DIM. "H" +1.5/-0.0	MAX OAL (REF)	WEIGHT kg
ACA401M	80.00	65.00	50.00					90.0	115.0	0.4
ACA402M	110.00	95.00	80.00	65.00	50.00			120.0	145.0	0.5
ACA403M	140.00	125.00	110.00	95.00	80.00	65.00	50.00	150.0	175.0	0.6



B

# POWER CLAMP ARMS 60 SERIES

(STRAIGHT - MACHINED) (20mm WIDE)



STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM  
MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

PAINT AS PRESCRIBED ON PAGE G-1.2

TABULATED INFORMATION ON FOLLOWING PAGE

# POWER CLAMP ARMS 60 SERIES

(STRAIGHT - MACHINED) (20mm WIDE)

A

EXCEPT AS NOTED TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$
- 2 PLACE  $\pm 0.03$  GENERAL
- $\pm 0.03$  BETWEEN DOWELS
- $\pm 0.13$  TO SCREW HOLES

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

MATERIAL: SAE 4140 or SAE 1045

NAAMS CODE	DIM "U" +1.5/-0.0	MAX OAL (REF)	Weight kg*	Dim. "A"	Dim. "B"	Dim. "C"	Dim. "D"	Dim. "E"	Dim. "F"	Dim. "G"	Dim. "H"	Dim. "I"	Dim. "J"	Dim. "K"	Dim. "L"	Dim. "M"
ACA507M	135.0	163.0	1.0	125.00	110.00	95.00	80.00	65.00								
ACA508M	165.0	193.0	1.2	155.00	140.00	125.00	110.00	95.00	80.00	65.00						
ACA509M	195.0	223.0	1.3	185.00	170.00	155.00	140.00	125.00	110.00	95.00	80.00	65.00				
ACA510M	225.0	253.0	1.4	215.00	200.00	185.00	170.00	155.00	140.00	125.00	110.00	95.00	80.00	65.00		
ACA511M	255.0	283.0	1.6	245.00	230.00	215.00	200.00	185.00	170.00	155.00	140.00	125.00	110.00	95.00	80.00	65.00
ACA512M	285.0	313.0	1.8	275.00	260.00	245.00	230.00	215.00	200.00	185.00	170.00	155.00	140.00	125.00	110.00	95.00



NAAMS CODE	Dim. "N"	Dim. "O"
ACA512M	80.00	65.00

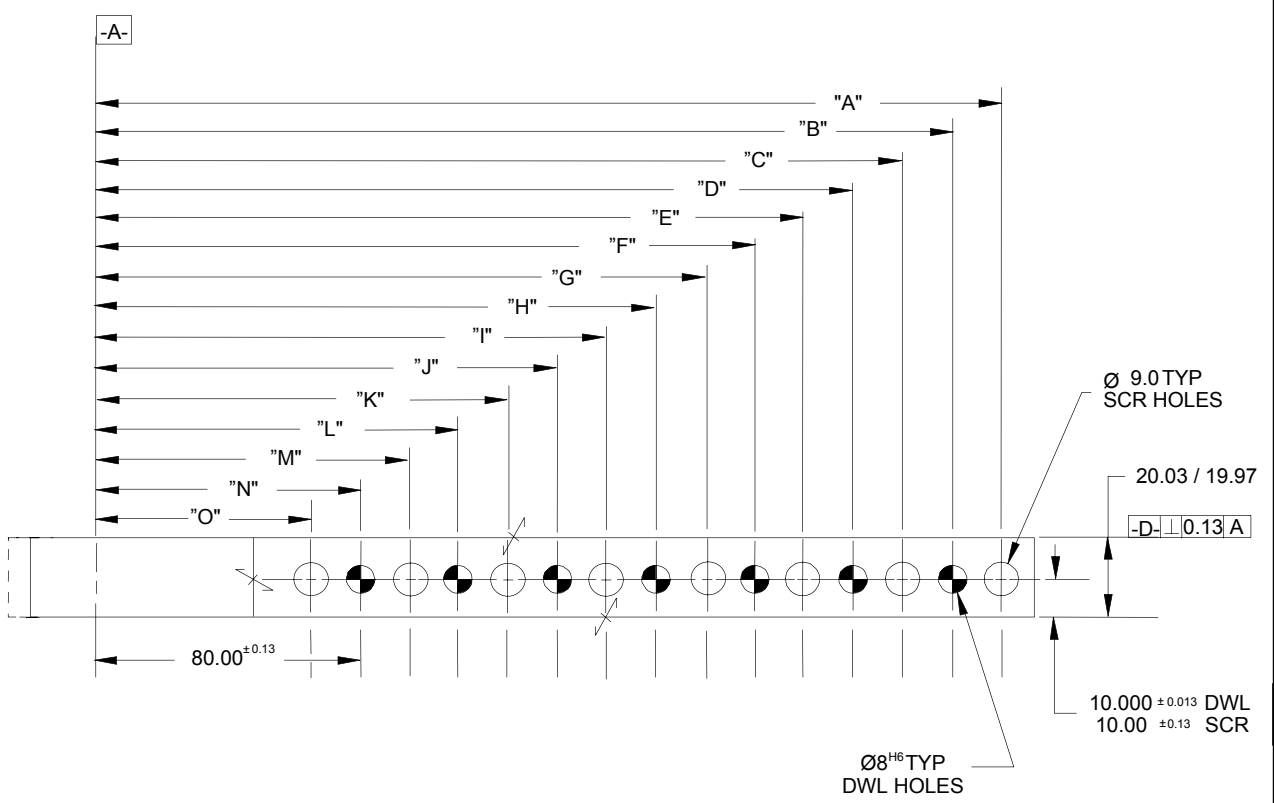
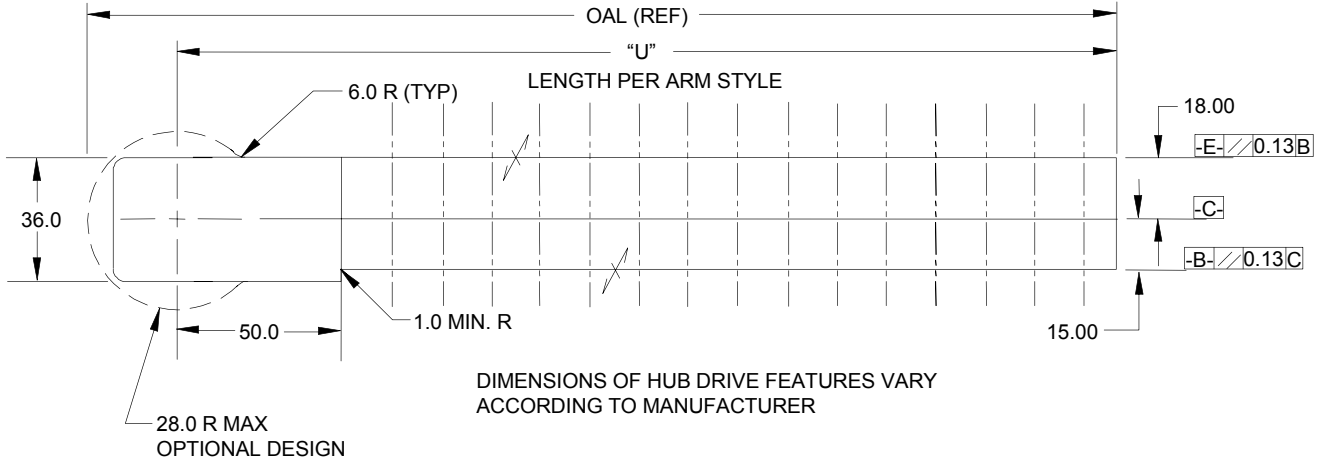


\* Weight of arm as shown. Actual weight may vary due to variations in mounting details.

SEE DRAWING ON PREVIOUS PAGE

# POWER CLAMP ARMS 60 SERIES (STRAIGHT - MACHINED) (20mm WIDE)

A



C

B

STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM  
MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.  
PAINT AS PRESCRIBED ON PAGE G-1.2

TABULATED INFORMATION ON FOLLOWING PAGE

# POWER CLAMP ARMS 60 SERIES

(STRAIGHT - MACHINED) (20mm WIDE)

A

EXCEPT AS NOTED TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$
- 2 PLACE  $\pm 0.03$  GENERAL
- $\pm 0.03$  BETWEEN DOWELS
- $\pm 0.13$  TO SCREW HOLES

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

MATERIAL: SAE 4140 or SAE 1045

NAAMS CODE	DIM "U" +1.5/-0.0	MAX OAL (REF)	Weight kg*	Dim. "A"	Dim. "B"	Dim. "C"	Dim. "D"	Dim. "E"	Dim. "F"	Dim. "G"	Dim. "H"	Dim. "I"	Dim. "J"	Dim. "K"	Dim. "L"	Dim. "M"
ACA513M	135.0	163.0	1.0	125.00	110.00	95.00	80.00	65.00								
ACA514M	165.0	193.0	1.2	155.00	140.00	125.00	110.00	95.00	80.00	65.00						
ACA515M	195.0	223.0	1.3	185.00	170.00	155.00	140.00	125.00	110.00	95.00	80.00	65.00				
ACA516M	225.0	253.0	1.4	215.00	200.00	185.00	170.00	155.00	140.00	125.00	110.00	95.00	80.00	65.00		
ACA517M	255.0	283.0	1.6	245.00	230.00	215.00	200.00	185.00	170.00	155.00	140.00	125.00	110.00	95.00	80.00	65.00
ACA518M	285.0	313.0	1.8	275.00	260.00	245.00	230.00	215.00	200.00	185.00	170.00	155.00	140.00	125.00	110.00	95.00



NAAMS CODE	Dim. "N"	Dim. "O"
ACA518M	80.00	65.00



\* Weight of arm as shown. Actual weight may vary due to variations in mounting details.

SEE DRAWING ON PREVIOUS PAGE

# POWER CLAMP ARMS

## 50 SERIES

### FOR GRIPPER CLAMPING COMPONENTS

#### (STRAIGHT - MACHINED) (FULL METRIC)

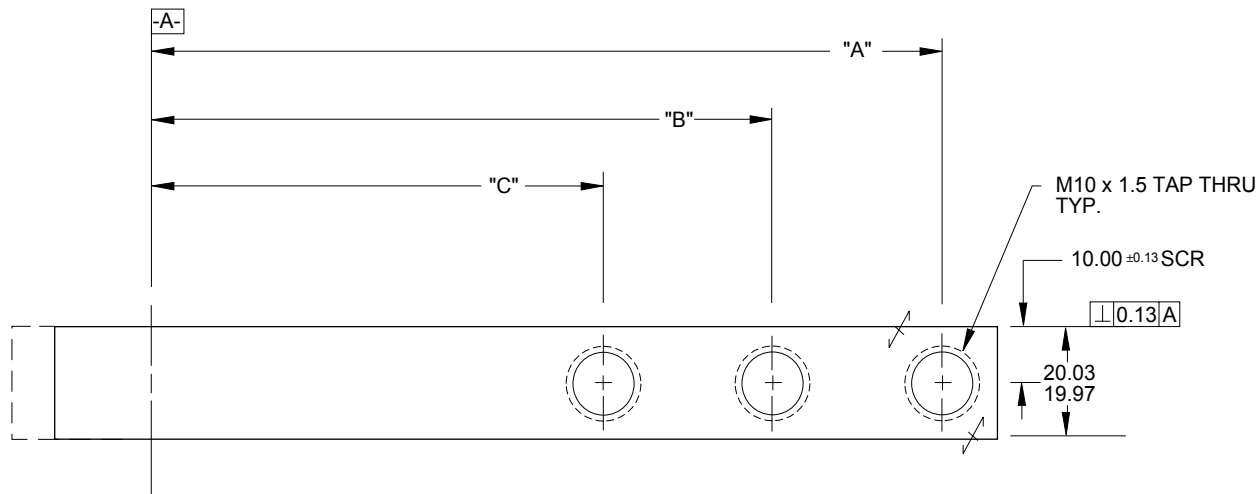
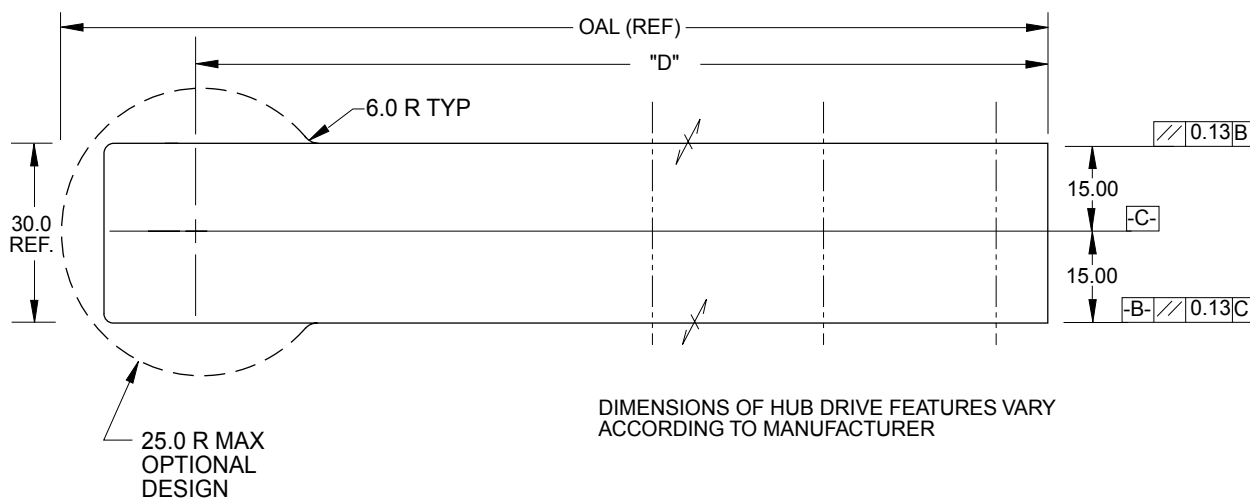
GLOBAL STANDARD COMPONENTS



Assembly

04/30/15

A



A

EXCEPT AS NOTED TOLERANCES SHALL BE:

- 1 PLACE MACHINING  $\pm 0.3$
- 1 PLACE FABRICATION  $\pm 1.5$
- 2 PLACE  $\pm 0.03$  GENERAL
- $\pm 0.03$  BETWEEN DOWELS
- $\pm 0.13$  TO SCREW HOLES

STAMP OR ETCH THE NAAMS CODE NUMBER AND THE CLAMP ARM MANUFACTURER'S NUMBER, IF DIFFERENT, ON THE SIDE OF THE ARM.

NOTES: ALL DIMENSIONS METRIC UNLESS OTHERWISE NOTED.

PAINT AS PRESCRIBED ON PAGE G-1.4

MATERIAL: SAE 4140 or SAE 1045

NAAMS CODE	DIM. "A"	DIM. "B"	DIM. "C"	DIM. "D" +1.5/-0.0	MAX OAL (REF)	WEIGHT kg
ACA201G	80.00			90.0	115.0	0.4
ACA202G	110.00	80.00		120.0	145.0	0.5
ACA203G	140.00	110.00	80.00	150.0	175.0	0.6