

# Clamping & Support V's

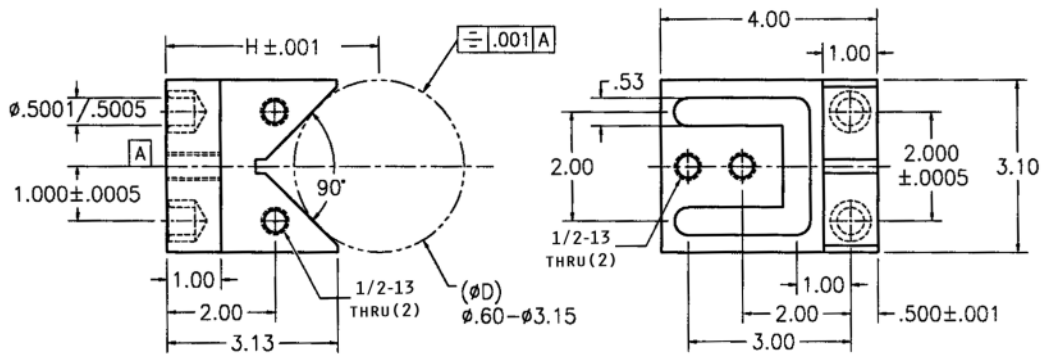
## Clamping "V" with Threads

- Black oxide finish
- Hardened and ground angle surface
- Precision and adjustable location
- Threaded face holes for locator or stop components
- To determine the height (H) the following formula may be used:

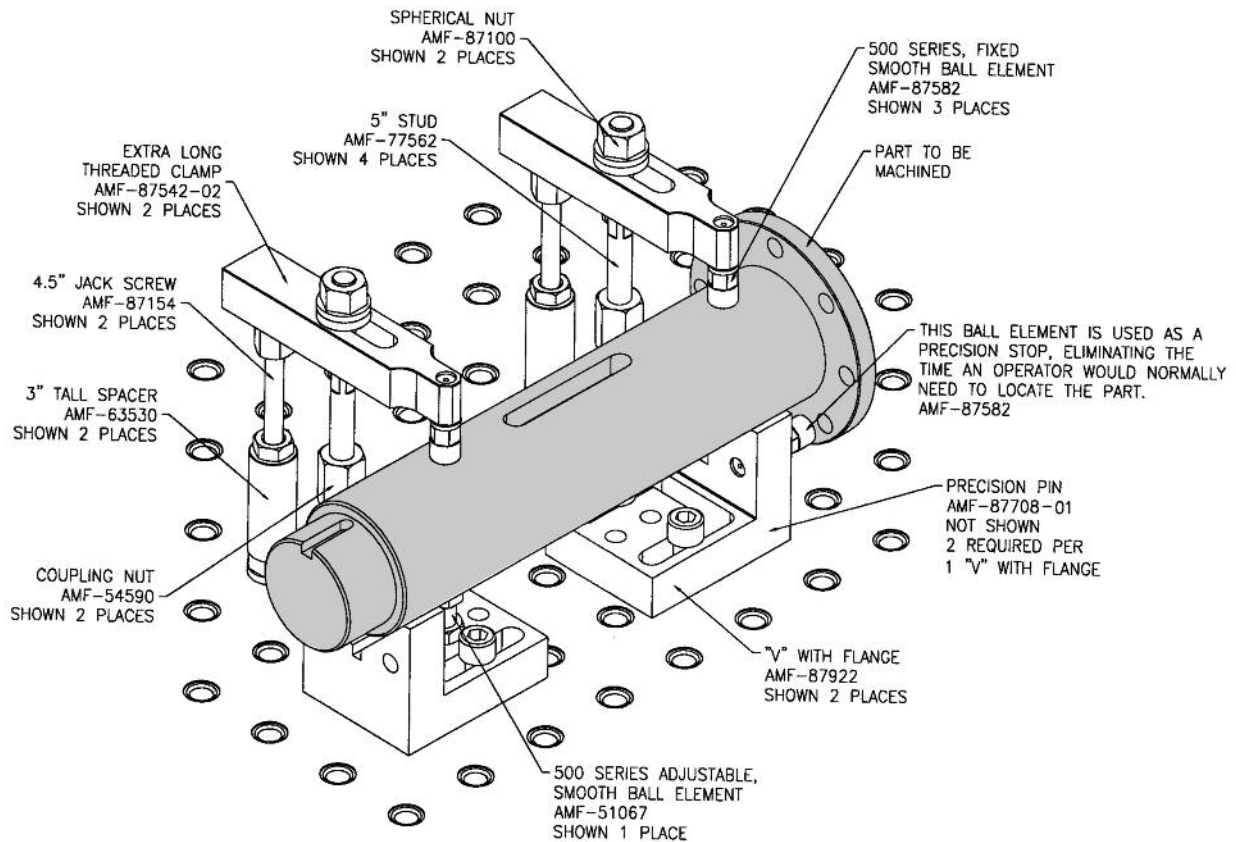
$$H = 1.7099 + \frac{D}{\sqrt{2}}$$



AMF-87922  
(Shown above)



## "V" with Flange Application



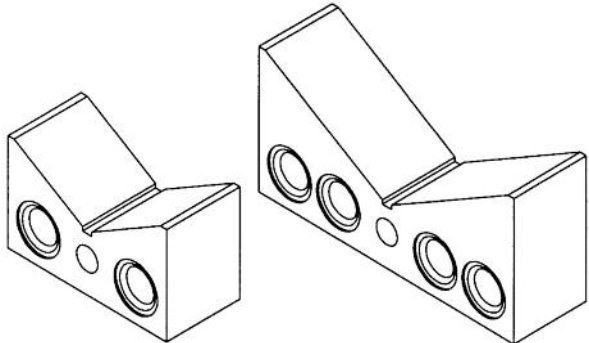
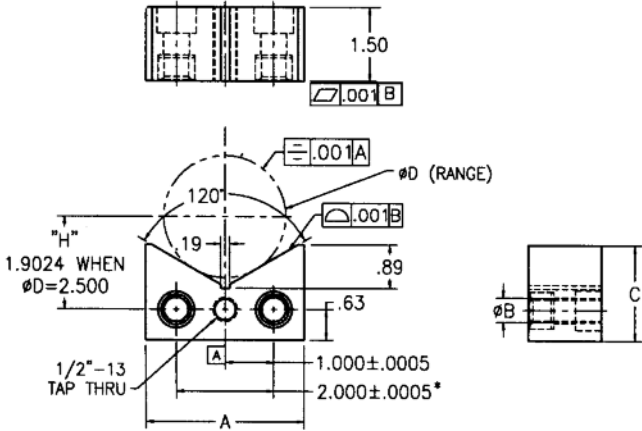


# Clamping & Support V's

## Precision "V" Stop

- Black oxide finish
- Hardened and ground
- Locates on grid with precision bushings in vertical or horizontal position
- When using with standard S.A.F.E. grid system, precision dowel screws AMF-87544 (1/2" system) and AMF-87887 (5/8" system) are used (sold separately)
- Threaded face hole for locator or clamping components
- To determine the height (H) this formula may be used:

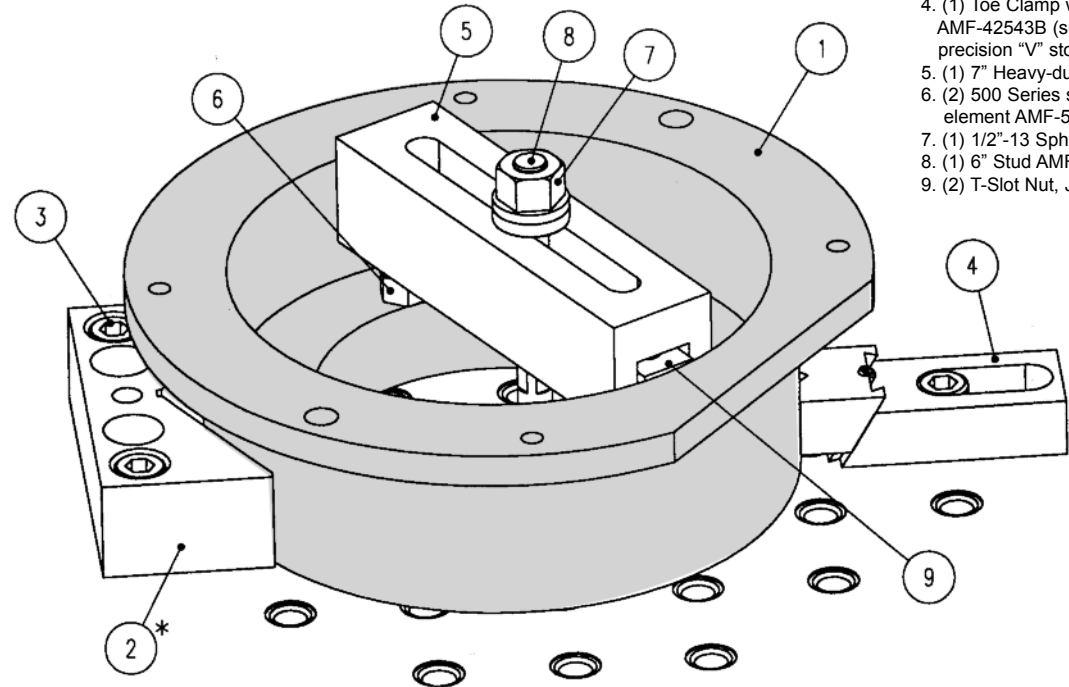
$$H = 1.1547 P/2 - .5174 A/2 + C - .5578$$



Dimensions (in)				Mating Precision Dowel Screw Part# AMF-	Part Number AMF-
A	(System) Dia. B	C	Range Dia. D		
3.25	.5001/.5005	1.95	0.50/5.00	87991	<a href="#">59671</a>
3.25	.6251/.6255	1.95	0.50/5.00	87885	<a href="#">59671-01</a>
5.25*	.5001/.5005	2.53	0.50/9.50	87991	<a href="#">59672</a>
5.25*	.6251/.6255	2.53	0.50/9.50	87885	<a href="#">59672-01</a>

\*5.25" wide "V" stops have a second set of precision bushings on a 4.000 ± .0005 spread as shown in the application example above. "H" tolerance is ± .001

### "V" Stop Application



#### Bill of Materials

- (1) Machined part
- (1) Precision "V" Stop AMF-59672
- (2) Precision Dowel Screw AMF-87544
- (1) Toe Clamp with Brass Gripper AMF-42543B (snug to hold part against precision "V" stop)
- (1) 7" Heavy-duty clamping bar AMF-31570
- (2) 500 Series smooth adjustable ball element AMF-51067
- (1) 1/2"-13 Spherical nut AMF-87100
- (1) 6" Stud AMF-77563
- (2) T-Slot Nut, Jergens Part# 43305

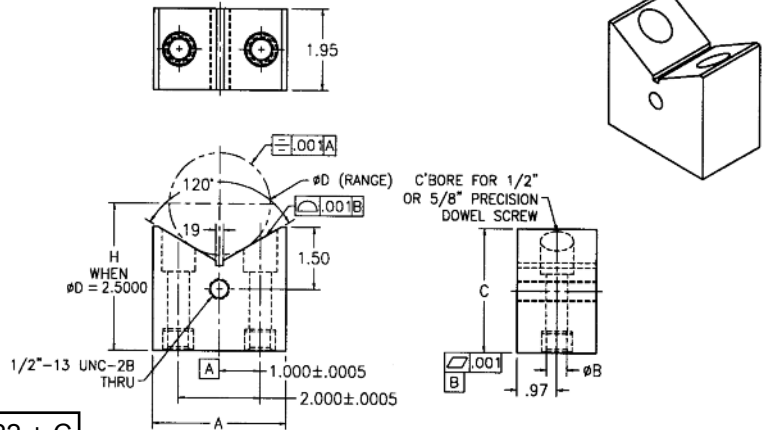
Subject to technical modifications. Custom Sizes available upon request.

# Clamping & Support V's

## Precision "V" Rest

- Black oxide finish
- Hardened and ground
- Locates on grid with precision bushings in vertical or horizontal position
- Precision dowel screws are used with precision "V" rest (see chart for mating screw, sold separately)
- Threaded face hole for locator or clamping components
- "V" rests of C heights 3.00 and 3.58 will work together as well as the heights of 5.00 and 5.58 (see application below)
- To determine the height (H), this formula may be used:

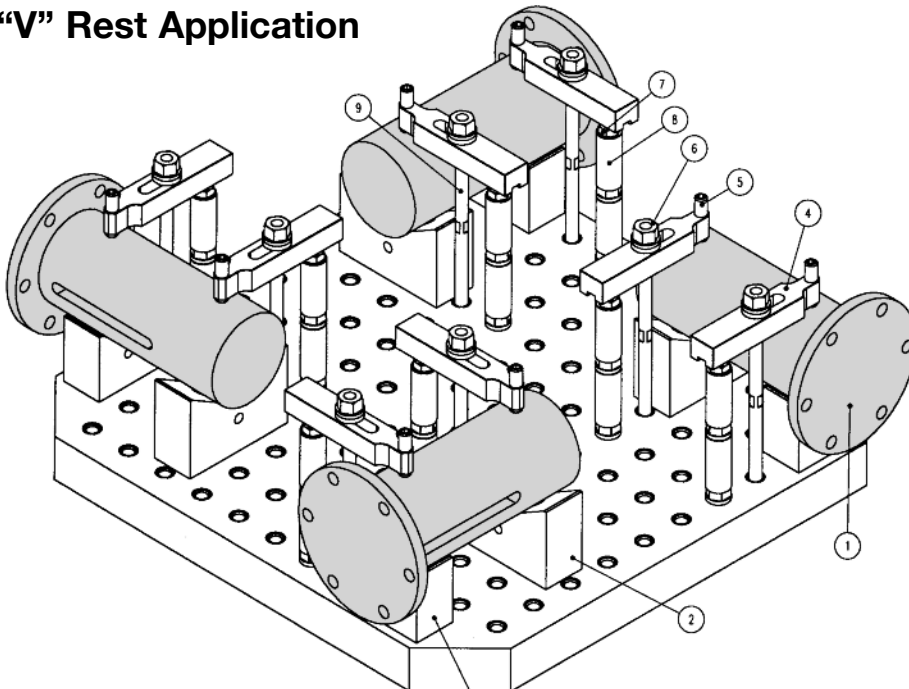
$$H = (1.1547 \times D/2) - (.5774 \times A/2) + .0722 + C$$



Dimensions (in)					Mating Precision Dowel Screw Part# AMF-	Part Number AMF-
A	(System) Dia. B	C	H ±.001	Range Dia. D		
3.25	.5001/.5005	3.00	3.5774	0.50/5.00	87983	<a href="#">59673</a>
3.25	.6251/.6255	3.00	3.5774	0.50/5.00	87882	<a href="#">59673-01</a>
5.25	.5001/.5005	5.00	5.5774	0.50/5.00	87983	<a href="#">59674</a>
5.25	.6251/.6255	5.00	5.5774	0.50/5.00	87882	<a href="#">59674-01</a>
5.25*	.5001/.5005	3.58	3.5774	0.50/9.50	87983	<a href="#">59675</a>
5.25*	.6251/.6255	3.58	3.5774	0.50/9.50	87882	<a href="#">59675-01</a>
5.25*	.5001/.5005	5.58	5.5774	0.50/9.50	87983	<a href="#">59676</a>
5.25*	.6251/.6255	5.58	5.5774	0.50/9.50	87882	<a href="#">59676-01</a>

\*5.25" wide "V" stops have a second set of precision bushings on a 4.000 ± .0005 spread.

## "V" Rest Application



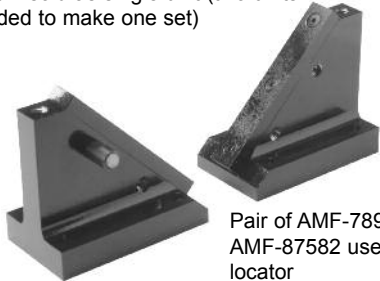
### Bill of Materials

- (4) Machined part
- (1) "V" Rest 5.25" x 3.58" AMF-59675 with (8) Precision Dowel Screws AMF-87985
- (1) "V" Rest 3.25" x 3.00" AMF-59673 with (8) Precision Dowel Screws AMF-87985
- (8) Extra long threaded clamp AMF-87542-02
- (8) 400 Series smooth ball element set screw AMF-87495
- (8) 1/2"-13 Spherical nut AMF-87100
- (8) 1/2"-13 Jack screw AMF-87338
- (16) Spacer 1.00 x 3.00 AMF-63530
- (8) 10" 1/2"-13 stud AMF-77567

# Clamping & Support V's

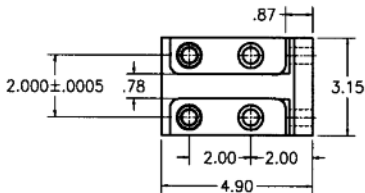
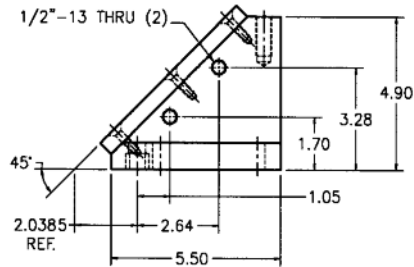
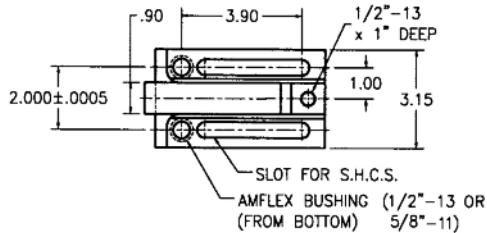
## Split "V"

- Black oxide finish
- Precision and adjustable location
- Threaded holes in face and top for locators, stops and clamps
- Diameters in excess of 120" can be secured when used with consoles
- Split V sold as single unit (two units needed to make one set)



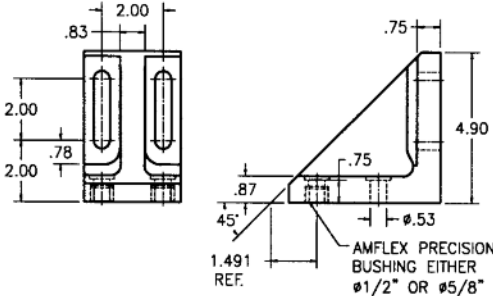
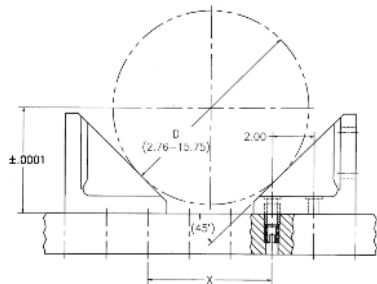
Pair of AMF-78950 with AMF-87582 used as locator

AMF-78950 (1/2"-13)  
AMF-78951 (5/8"-11)



On the grid bases, "V" blocks in two-part version can either be positioned precisely or shifted through the elongated holes. These "V" blocks can be used for cylindrical workpieces with diameters between 2.76 and 15.75 in.

AMF-54439 (1/2" System)  
AMF-54440 (5/8" System)

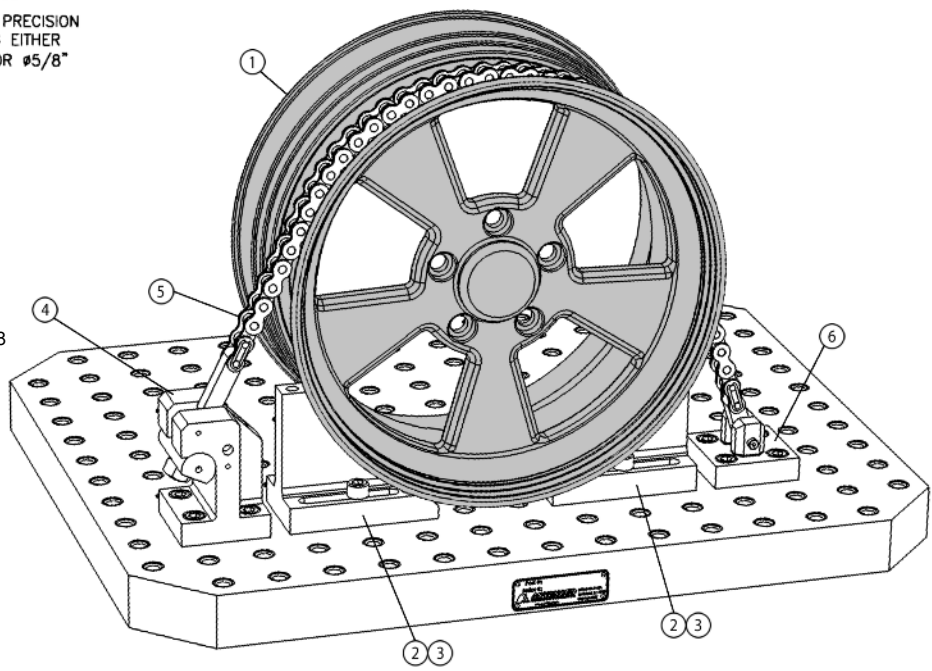


$$H = \frac{D}{\sqrt{2}} + 1.4908 - \frac{X}{2} \geq \frac{D}{2}$$

## Split "V" Application

### Bill of Materials

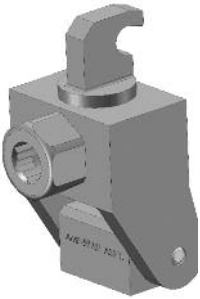
- (1) Machined part
- (2) Split "V" AMF-78950
- (4) Amflex Threaded Dowel Pin AMF-87992
- (1) Amflex Chain Clamp Adjustable Assembly AMF-59723
- (1) #60 Chain (length to suit) AMF-59668
- (1) Amflex Chain Clamp Fixed Assembly AMF-59724



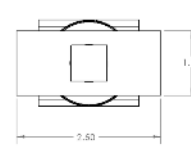
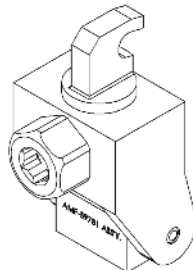
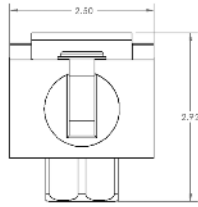
Subject to technical modifications.  
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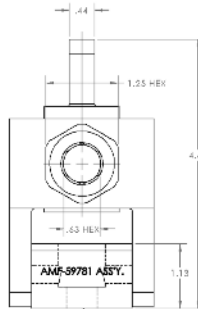
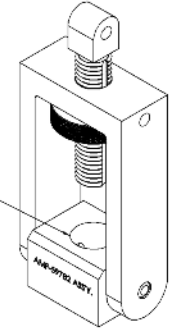
## Chain Clamp and Accessories



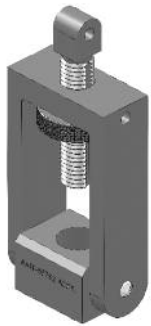
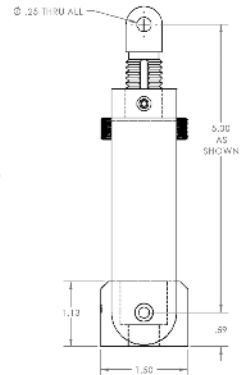
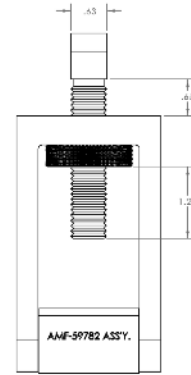
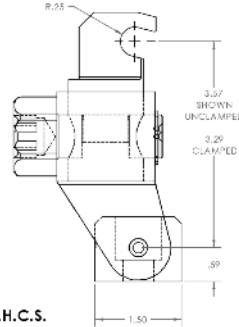
Adjustable Hook Chain  
Clamp Ass'y  
AMF-59781 1/2"-13  
AMF-59783 5/8"-11



C'BORE FOR 1/2 S.H.C.S.  
#AMF-59782  
C'BORE FOR 5/8 S.H.C.S.  
#AMF-59784

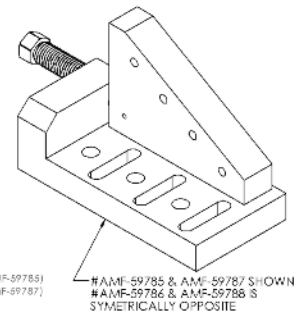
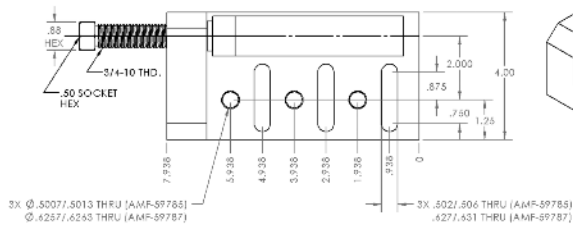


C'BORE FOR 1/2 S.H.C.S.  
#AMF-59781  
C'BORE FOR 5/8 S.H.C.S.  
#AMF-59783

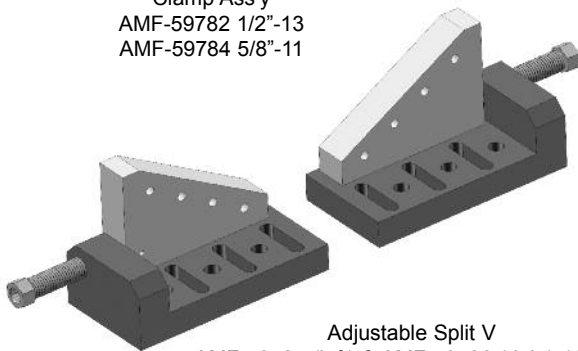


Adjustable Link Pin Chain  
Clamp Ass'y  
AMF-59782 1/2"-13  
AMF-59784 5/8"-11

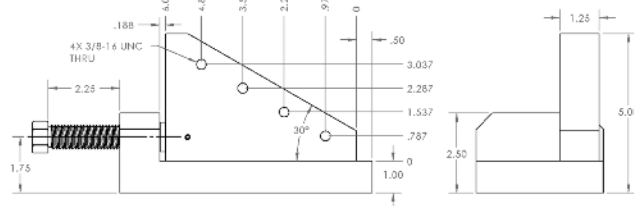
C'BORE FOR 1/2 S.H.C.S.  
#AMF-59781  
C'BORE FOR 5/8 S.H.C.S.  
#AMF-59783



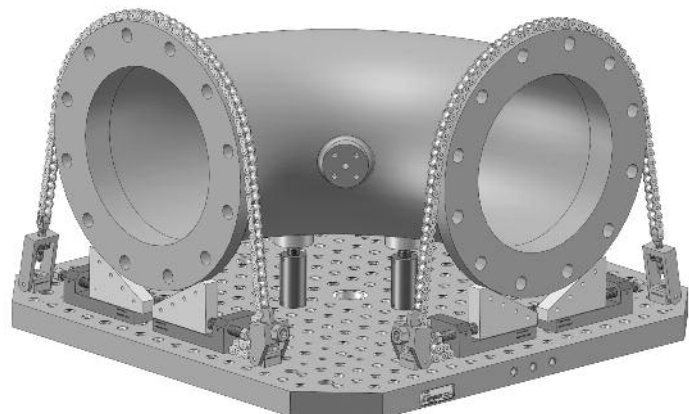
#AMF-59785 & AMF-59787 SHOWN  
#AMF-59786 & AMF-59788 S  
SYMMETRICALLY OPPOSITE



Adjustable Split V  
AMF-59785 (left) & AMF-59786 (right) 1/2"-13  
AMF-59787 (left) & AMF-59788 (right) 5/8"-11



System	Part # AMF -
1/2"-13	<a href="#">59781</a>
1/2"-13	<a href="#">59782</a>
5/8"-11	<a href="#">59783</a>
5/8"-11	<a href="#">59784</a>
1/2"-13	<a href="#">59785</a>
1/2"-13	<a href="#">59786</a>
5/8"-11	<a href="#">59787</a>
5/8"-11	<a href="#">59788</a>









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