Step 1
Disassembly Instructions for 100-4X or 100-6X Clamp

1. Remove cap (#25) and spring (#24).
2. Remove 4 main body screws (#26).
3. Pull sliding jaw assembly out of clamp.
4. Remove acme rod screw (#12).
5. Slide half nut support (#15) off acme rod (#8).
6. Remove knob spring pin (#2) and knob (#1) from acme rod (#8).
7. Remove acme rod (#8).
8. Remove cam lever screw (#20), cam lever (#21), cam lever spring (#22) and half nut cam (#17).
9. Replace spring cap (#25).
10. Remove slider plate (#16) from inside of sliding jaw tube.

Part No. Description

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<th>Description</th>
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<tr>
<td>1265</td>
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<tr>
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<td>Acme Rod</td>
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<td>1279X-4</td>
<td>Main Body Screw</td>
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Step 2
Reassembly Instructions — Conversion to 100-7X Clamp

1. Grease acme rod (#13).
2. Thread on half nut support 1 inch (#9).
3. Apply thread lock compound on rod screw (#16) and washer (#15) and install on end of acme rod (#13).
4. Place washer (#23), spring (#28), and washer (#23) on handle end of acme rod (#13).
5. Slide acme rod with washers and spring into sliding jaw. Compress spring so end of rod sticks through blue jaw.
6. Place nylon washer (#30) on acme rod end.
7. Place clamp handle (#31) on acme rod over nylon washer (#30).
8. Compress spring (#28) and secure handle with handle screw (#20) and screw cap (#21). Tighten with two 4mm hexes.
9. Install screw (#29) and washer (#26) through rear hole of clamp bracket (#2). Place washer (#26) and nylon nut (#25) on screw (#29).
10. Rotate half nut support (#9) thin side up (as pictured).
11. Slide movable jaw (#11) through fixed jaw (#10) into clamp body (#8). Half nut support (#9) will stop at screw (#29) already installed.
12. Install second screw (#29) and washer (#26) in front hole of clamp bracket (#2). Place washer (#26) and nylon nut (#25) on screw (#29) and tighten both screws (#29).
13. Tighten nut (#25), washer (#26), screw (#29) in clamp bracket (#2) (10mm).

Part No. Description
1278 Clamp Bracket
1241X-7 Clamp Body
1273X Half Nut Support
1256 Fixed Jaw
1261 Movable Jaw
1275X Main Body Cap
1276 Acme Rod
1556-4 Washer
1267 Acme Rod Screw
1964 Handle Screw
1965 Handle Screw Cap
1004-1 Handle Washer
1883-4 Nylon Lock Nut
1926-4 Washer
1271X Compression Spring
1272X-2 Screw
1809X Nylon Washer
1966-7X Clamp Handle