



$\varnothing$ .490 AS SHIPPED  
 MANDREL SHOULD NOT BE EXPANDED MORE  
 THAN .010 FROM RELAXED DIAMETER.  
 MANDREL DESIGNED TO BE MACHINED DOWN  
 TO FIT SPECIFIC WORKPIECE HOLE  
 RANGING FROM  $\varnothing$ .28 TO  $\varnothing$ .49

$\varnothing$ 2.230  
 $\varnothing$ 1.172  
 45°  
 4X  
 $\varnothing$ .374  $\nabla$ .230  
 $\varnothing$ .213 THRU  
 EQ SPACED ON  
 $\varnothing$ 1.732 BOLT CIRCLE  
 4X  
 6-32 UNC 2B  $\nabla$ .380  
 EQ SPACED ON  $\varnothing$ 1.626  
 BOLT CIRCLE

.590 .630 .760  
 (3.051)  
 SAE 2 UNCLAMP PORT  
 SAE 2 CLAMP PORT  
 (2.061)  
 2.291  
 1.066  
 $\varnothing$ 2.190 $\pm$ .001  
 .250

4X  $\varnothing$ 1/4-20 UNC 2B  $\nabla$ .630  
 $\varnothing$ .980  
 2X .812  
 CBORE FOR -O11 O-RING  
 INCLUDED WITH ASSEMBLY  
 UNCLAMP MANIFOLD MOUNT PORT  
 CBORE FOR -O11 O-RING  
 INCLUDED WITH ASSEMBLY  
 CLAMP MANIFOLD MOUNT PORT  
 30°  
 60°

<b>CAD CONTROL DRAWING</b>			
		VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
A	4221	RELEASE	ALS
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY
DRW BY: DLG	<b>DRAWING STATUS: Released</b>		8/26/22
DATE: 06/24/2020	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		DATE
		TOLERANCES DO NOT APPLY DIMENSIONS ARE NOMINAL	15520600
		SIZE B	A
		I LC15520600	CLAMP, ID, EXPANSION, 980, #0
		FORM FEG036, Rev. B	8-32 PISTON THREAD