

# Haas Workholding by Mitee-Bite Products



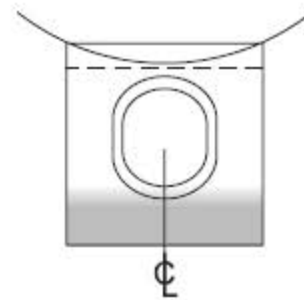
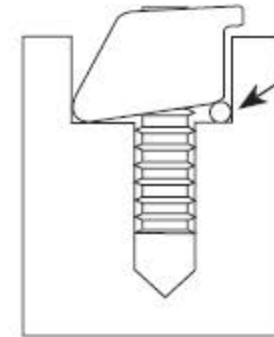
Haas  
F1 Team



## Machinable Pitbull® Instructions

1. Machine a pocket to locate workpiece and pockets for clamps.
2. If machining maximum amount from clamp use standard dimensions for "A" from Technical Specs. If machining less, adjust dimension accordingly.
3. Assemble clamp without O-ring and install in fixture with dowel pin, under front edge of clamp as shown in diagram. Tighten securely and machine clamps for a slip fit with workpiece.
4. Remove dowel pin, add O-ring and install clamp.
5. Clamp is at approximately 43RC, carbide tooling is recommended for machining.

**NOTE:** Clamp can be machined concave or convex. However maximum recommended stock removal should be adhered to at center line of clamp.



Maximum recommended stock removal from centerline of clamp:  
05-0424 = 0.06 in    05-0431 = 1.5 mm

