

# 4-way Pressure Clamp System

PLU# 666 and 670

Version 2.0

## Safety First



Disconnect machine from power source before making any adjustments.



Always wear proper ear protection when working with machinery.



Use caution when handling sharp objects (saw blades, router bits, drill bits and so on). Use protective gloves whenever possible.



Always wear proper eye protection when working with machinery and tools.

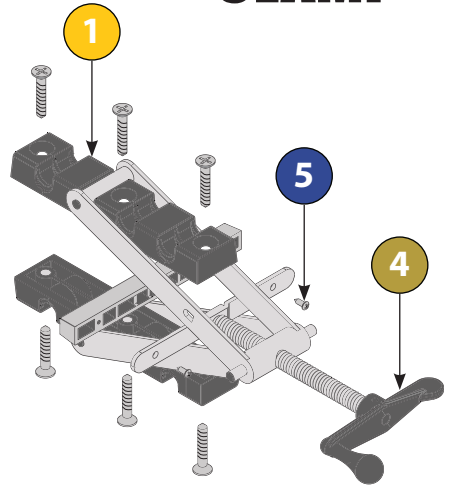
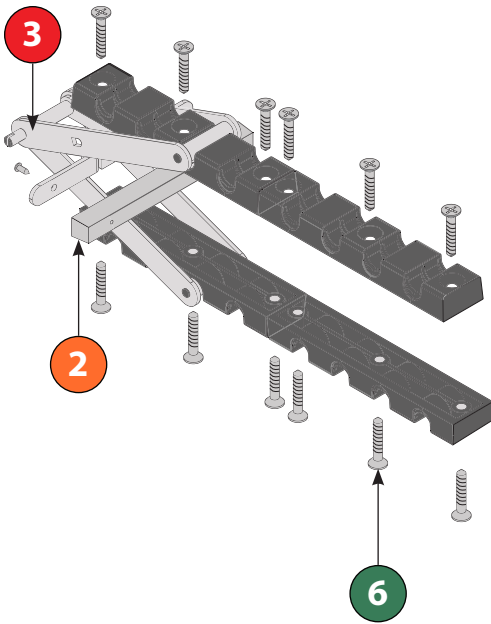


Always wear proper respiratory protection when working near airborne dust particles.

*Please read and fully understand any and all safety materials that came with your power tools or machinery before operation. Always follow all safety guidelines set in place by the power tool or machine manufacturer.*



# 4 WAY PRESSURE CLAMP



## 4 WAY PRESSURE CLAMP SINGLE PARTS LIST (670)

No.	Part	QTY
1	6 $\frac{3}{4}$ " Notched Bar	6
2	Plastic Jaw Pads	2
3	Clamp Assembly	1
4	Handled Clamp Assembly	1
5	3/8" Pan Head Screw	4
6	1 $\frac{1}{4}$ " Wood Screw	18

## 4 WAY PRESSURE CLAMP 2 PACK PARTS LIST (666)

No.	Part	QTY
1	6 $\frac{3}{4}$ " Notched Bar	12
2	Plastic Jaw Pads	4
3	Clamp Assembly	2
4	Handled Clamp Assembly	2
5	3/8" Pan Head Screw	8
6	1 $\frac{1}{4}$ " Wood Screw	36

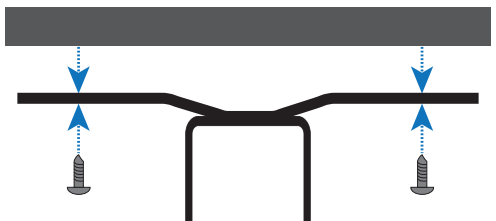
### PINCHING HAZARD



Each clamp assembly has multiple pinch points that can cause serious injury. Always use caution when handling the Clamps. Failure to do so may result in serious bodily harm.

1

As shown in the drawing to the right, secure the Plastic Jaw Pads (2) to the steel plates on both clamp assemblies using the 3/8" Pan Head Screws (5).



2

2" x 4" Half

2" x 4" Half

Cut a section of 2"x4" lumber to your desired length. Generally 24", 36" or 48" are the standard sizes. Joint both edges of the 2" x 4", then rip it in half. This creates the two clamp surfaces we will use with the 4 way pressure clamp. Once cut, we recommended that you sand and finish the halves before attaching to the clamp assemblies. This will help prevent wood glue from adhering to the wood bars.

3



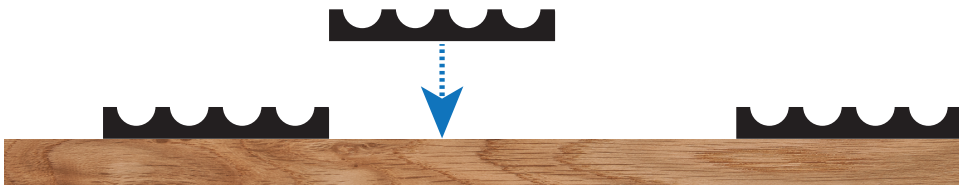
On one of the 2" x 4" ripped halves, use the 1¼" Wood Screws (6) to secure one of the 6¾" notched bars (1) flush to one end as shown above.

4



On the other end of the ripped half, measure in 2" from the end and secure one of the notched bars (1) at that mark.

5



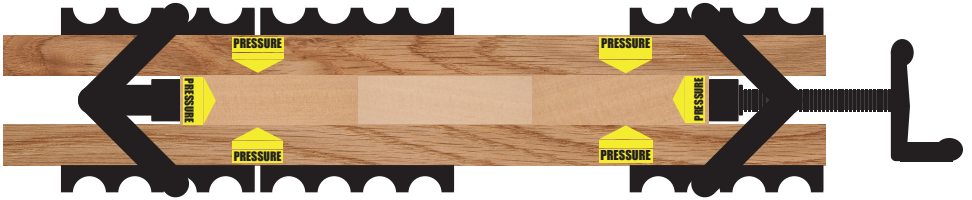
Add a third notched bar. This bar may be butted up against the offset notched bar or moved inward for narrower stock.

6

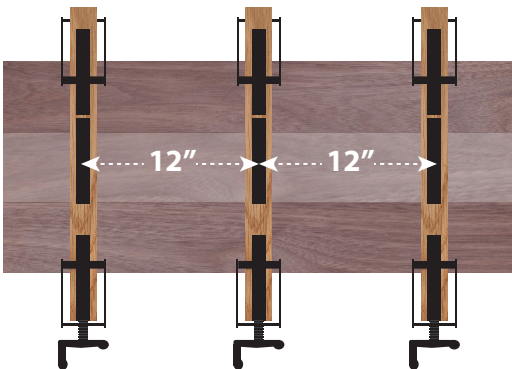


Once the wood bars are complete, they should resemble the image above and are now ready for the clamp assemblies to be attached.

7



- Position lumber to be glued flat between the 2 x 4 halves.
- Place the handled clamping assembly into position on the pads that are on the flush end of the halves. When properly placed, the plastic jaw pad is positioned between the 2 x 4's so that contact can be made with the wood being glued. The rounded bars on each side of the clamping mechanism should be positioned in a notch of the notched bar.
- Using the same process, place the non-handled clamping assembly into position on the other end. Take up as much of the slack as possible, positioning the non-handled pad as close to the wood being glued as you can.
- Rotate the handle of the clamping assembly. This will begin to bring tension to the clamp. As you tighten the handle you will see the 2 x 4 clamping surfaces begin to "draw" on to the flat surface of the wood, while the plastic jaw pads apply side or end pressure. This action ensures the boards are held flat while end pressure is applied at the same time.



### *Plan Your Projects...*

*When deciding what size panel you want to glue up, make sure you have enough 4 way pressure clamps to do the job. We recommend that you set your 4 way pressure clamps at 12" intervals. This helps keep even pressure throughout the panel. The 4 way pressure clamp can also be used in conjunction with pipe or bar clamps to help provide even clamping pressure that pipe or bar clamps typically can not on there own.*