

# PSL Assemblies Limited

## Operating Procedure For The Standard C-Clamp Range

By virtue of their design, this range of clamps can only be used in multiple sets, and each assembled for the same load for any clamping arrangement that they may be used. Different load arrangements may not be used together! It is also imperative that the disc spring washers are lubricated with a suitable load bearing grease prior to assembly and that they are so arranged as specified for any given load requirement. The loading of any limb assembly must be followed as shown below, making reference to the table and/or the appropriate G.A. for the particular load application:

1. With the C-Clamp correctly assembled, fit to limb with a suitably long screw or bolt with a thread as specified in the table. Tighten with fingers only - **NO LEVERAGE TOOLS** - until the screws/bolts of all the C-Clamps are as tight as is feasible. If the bolt head cannot be reached, the use of a socket may be used. Ensure that the heatsink to semiconductor surfaces are fully seated and parallel.
2. Using a suitable wrench, tighten the clamp assemblies progressively in sequence with one quarter of a turn each until the maximum turns shown in the table is attained. It is important that the clamps are loaded in small stages together so as to be able to load the semiconductor evenly. Semiconductor to heatsink contact will be severely impaired if this operation is not performed with enough due care and attention.

Part Number	G.A. Drawing Number	Load per C-Clamp	Number of Turns	Thread Size
C-CLAMP/B/2	B0003/G10	2 kN	1	M6
C-CLAMP/B/3	B0003/GA7	3 kN	$\frac{3}{4}$	M6
C-CLAMP/B/4	B0003/GA8	4 kN	$\frac{1}{2}$	M6
C-CLAMP/B/5	B0003/GA9	5 kN	$\frac{1}{2}$	M6
C-CLAMP/A/3.25	B0003/GA4	3.25 kN	2	M8
C-CLAMP/A/6.5	B0003/GA3	6.5 kN	1 $\frac{1}{4}$	M8
C-CLAMP/A/10	B0003/GA2	10 kN	1	M8
C-CLAMP/A/13.5	B0003/GA6	13.5 kN	$\frac{5}{8}$	M8
C-CLAMP/A/17.5	B0003/G11	17.5 kN	$\frac{5}{8}$	M8
C-CLAMP/A/20	B0003/G17	20Kn	$\frac{3}{4}$	M8
C-CLAMP/A/25	B0003/GA5	25 kN	$\frac{1}{3}$	M8

If required, a copy of the relevant General Assembly from the above table will be supplied upon request.