



# ATTENTION!



**PLK DESIGN 2 (6) replaces PLK DESIGN 1 (5) and most PLK DESIGN 1 (5) C-numbers**  
**Where applicable, PLK DESIGN 1 (5) and C-numbers have been automatically converted**

**NEW!**

## PLK DESIGN 2 (6)

PIN Ø = PIN Ø SPECIFIED = +0.00 / -0.02 mm  
 (+0.0000 / -0.0008 in)

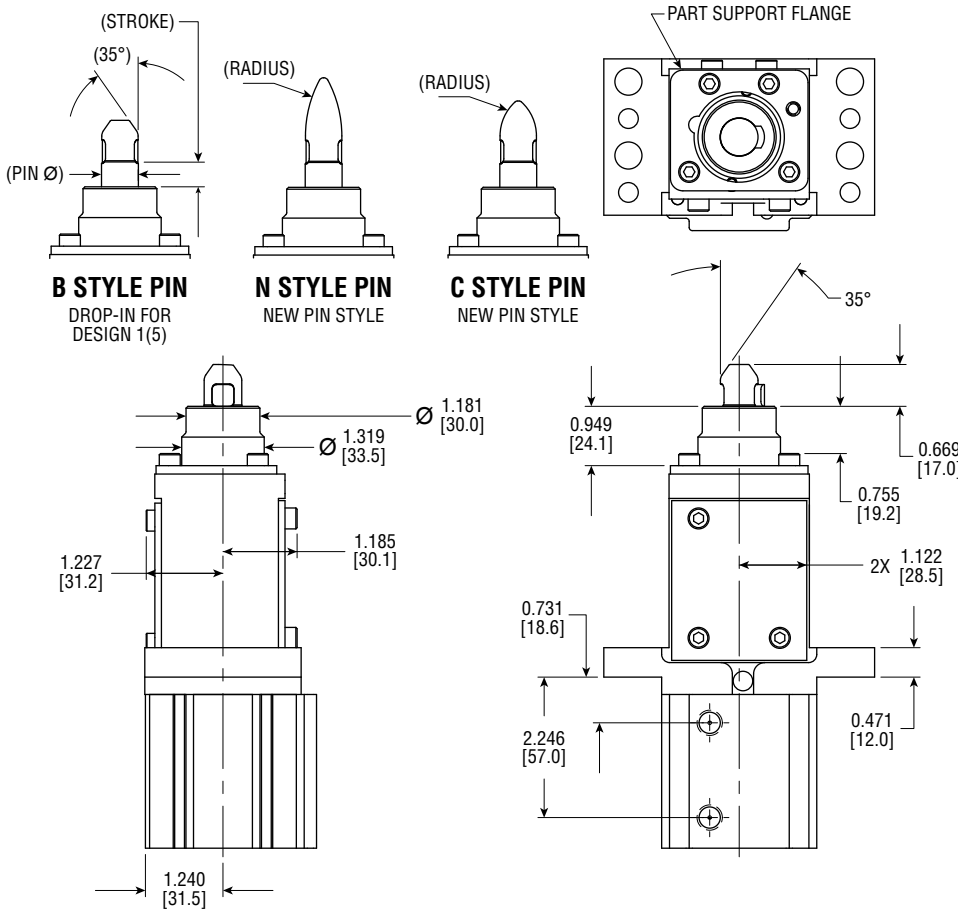
PIN Ø AVAILABLE FROM 12.00 mm TO 30.00 mm

ALL DIMENSIONS ARE REFERENCE ONLY UNLESS SPECIFICALLY TOLERANCED.

- 2 strokes (505 & 510)
- Imperial (2) & Metric (6) Ports
- 1800 pin diameters 12.00 thru 30.00 (+.00/- .02 mm Tolerance)
- 3 Pin Styles (B, C & N)
- Std. Flange Mount Height (110 mm to 140 mm - .5 mm increments)
- 4 Std. Finger Directions (Easily changed in the field)
- Standard Single Finger and Dual Finger (15 mm dia and above)
- Port Position 1 thru 4 (available with all positional sensing options)
- Port Fittings (-LAA & LBB)
- Cylinder Options (-R01 & R02)
- Cylinder Switch options (SW00, 41, 42, 51 & 52)
- Additional Rear Mounting options standard (-B01 thru -B06)
- Lock Setting (-MT00 thru -MT40) (See page 2 for new lock adjustment procedures)

### Additional Benefits

- Completely enclosed design
- NAAMS mounting
- Interchangeable pin sizes, styles and heights
- Positional Sensing available
- Self Locking threads throughout



Please refer to catalog for dimensions not shown.

**Previous PLK DESIGN 1 (5) and associated C-numbers are only available as Unique Solutions®.**



For additional technical assistance, call or visit our website:

**phd, Inc.** P.O. Box 9070, Fort Wayne, IN 46899  
**1-800-624-8511**  
[www.phdinc.com](http://www.phdinc.com)

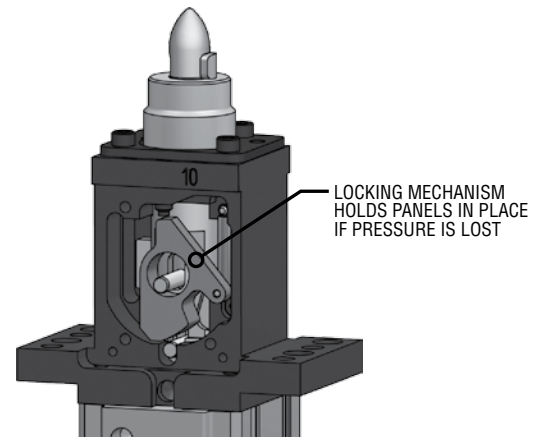
## MTxx MATERIAL THICKNESS ADJUSTMENT

Provides the clamp with the adjustable lock already set for the maximum material thickness for the application. Specify the thickest material.

**Example:** 1.6 mm material = MT16

Specify MT16 and the clamp will arrive preset to lock at that material thickness. The sequenced design prevents the finger from retracting until the pin is fully extended. The part can move the amount of clearance between the lock bracket and adjustment screw, but the extended finger keeps the part trapped securely on the pin.

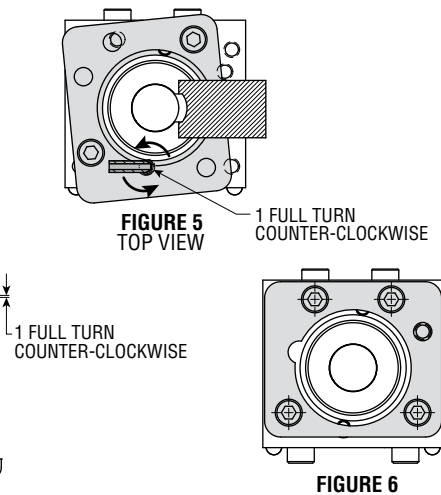
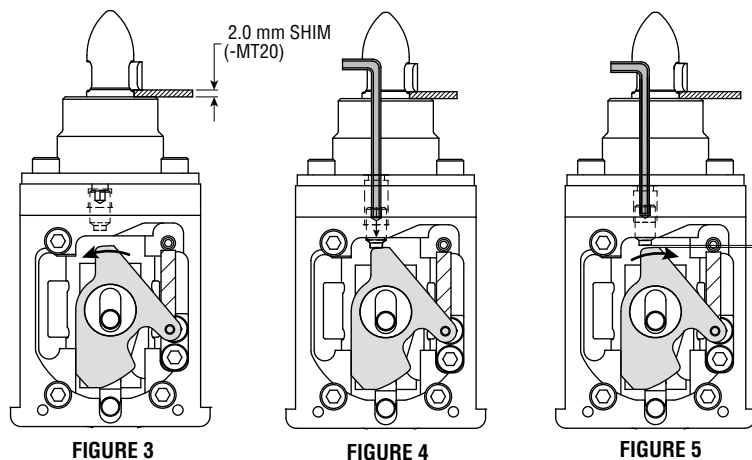
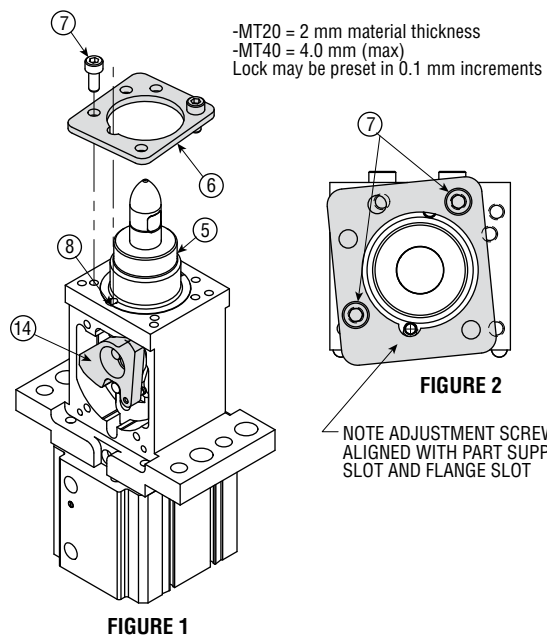
Unless otherwise specified, the factory lock default setting is MT20 = 2.0 mm material.



## LOCK SETTING PROCEDURE

### Adjustment procedures for PLK lock with material specified:

- 1) Start in the unclamped position, with the pin up, and the finger(s) retracted into the pin.
- 2) Install the part support (item 5) with the adjustment slot over the adjustment screw (item 8). Install the flange plate over the part support aligning the adjustment screw and two holes as shown. Hand tighten two times (item 7). (See Figures 1 and 2.)
- 3) Install the shims to match the panel thickness requested. Close the clamp on the shims with air pressure (87 psi).
- 4) Make sure the lock bracket (item 14) rotates counterclockwise into position under the adjustment screw (see Figure 3). Turn the adjustment screw clockwise until it contacts the top of the lock bracket (see Figure 4).
- 5) After touching, back the adjustment screw off one full turn to assure clearance so the lock bracket is free to rotate clockwise when the clamp opens (see Figure 5).
- 6) Unclamp the unit, remove the shim and two fasteners (item 7).
- 7) Rotate the flange plate (item 6) on the part support and align the four mounting holes as shown. (Figure 6)
- 8) Add the four screws (item 7) and tighten to 44 in-lbs.



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