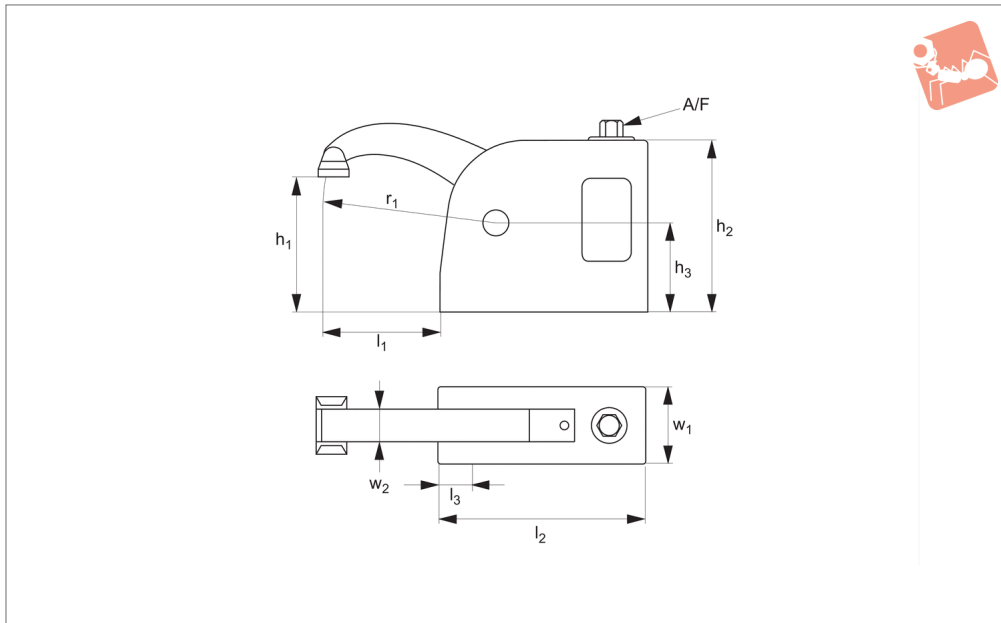




**10658**

ADJUSTABLE VERTICAL CLAMPS

### Material

Aluminium body, steel arm and screw.  
Aluminium clamp thrust product.

### Technical Notes

The only clamp specially designed for

electro-discharge (EDM) machines. The body has a large opening to ensure free flow of fluid.

These clamps are easily disassembled without tools, cleaned, greased and re-

assembled.

### Important Notes

Supplied with clamping key and clamping screw (M8 x 30mm) for mounting to machine bed.

| Order No.          | Arm type | Clamp reach $l_1$ | Clamping force<br>kN<br>max. | Clamping height $h_1$<br>min.   max. | $h_2$ | $h_3$ | $l_2$ | $l_3$ | $r_1$ | $w_1$ | $w_2$ | A/F | Torque to<br>Nm<br>max. |
|--------------------|----------|-------------------|------------------------------|--------------------------------------|-------|-------|-------|-------|-------|-------|-------|-----|-------------------------|
| <b>10658.W0022</b> | Short    | 54                | 6                            | -15 to 58                            | 62.5  | 31    | 73    | 11    | r 76  | 32    | 16    | 8   | 80                      |
| <b>10658.W0023</b> | Long     | 100               | 4                            | -40 to 90                            | 62.5  | 31    | 73    | 11    | r122  | 32    | 16    | 8   | 30                      |





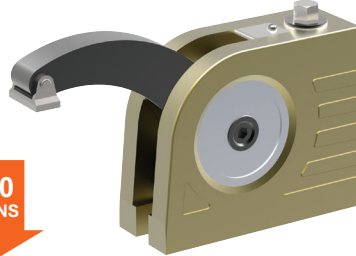
## A Wide Range of Clamps to Match any Requirement

CLAMPING FORCE  
**UPTO  
50000  
NEWTONS**

ADJUSTABLE VERTICAL CLAMPS

**10650** All machining operations

**16000  
NEWTONS**



**10655** Light machining

**6500  
NEWTONS**



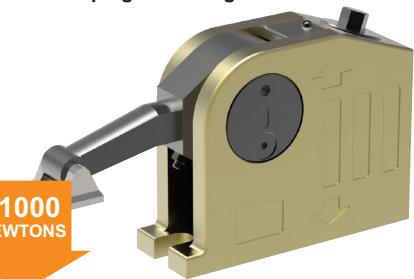
**10658** Electrical discharge machining

**6500  
NEWTONS**



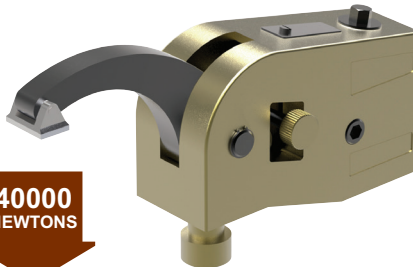
**10660** Clamping and lifting

**11000  
NEWTONS**



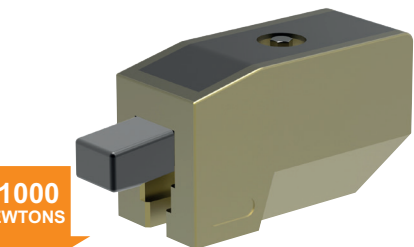
**10661** Heavy machining

**40000  
NEWTONS**



**10670** Repetitive machining

**11000  
NEWTONS**



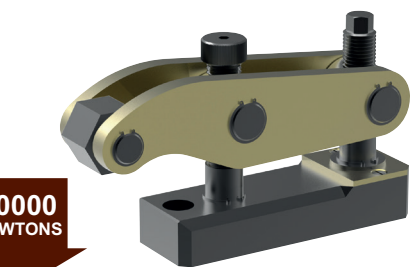
**10675** Heavy machining

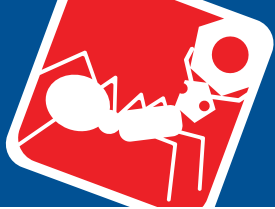
**35000  
NEWTONS**



**10678** Press Tool Clamping

**50000  
NEWTONS**



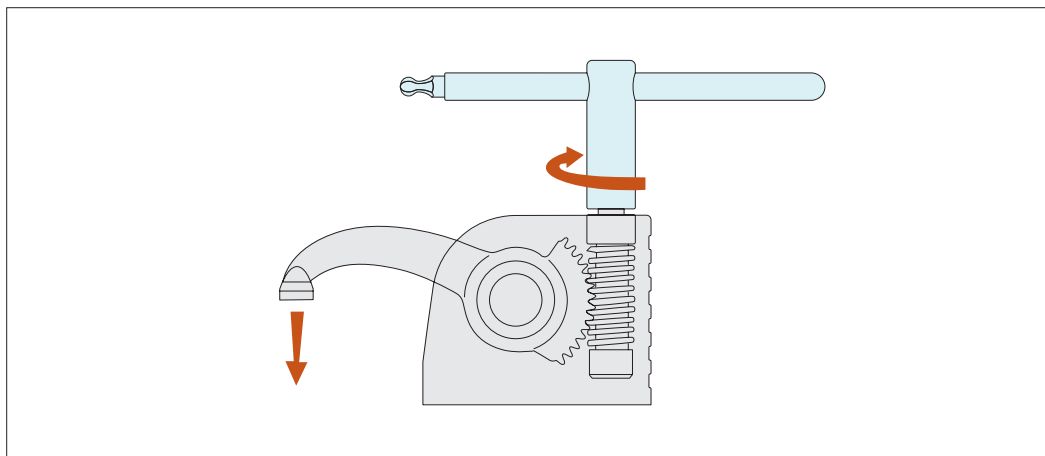


# Monobloc Clamps

stackable vertical clamping

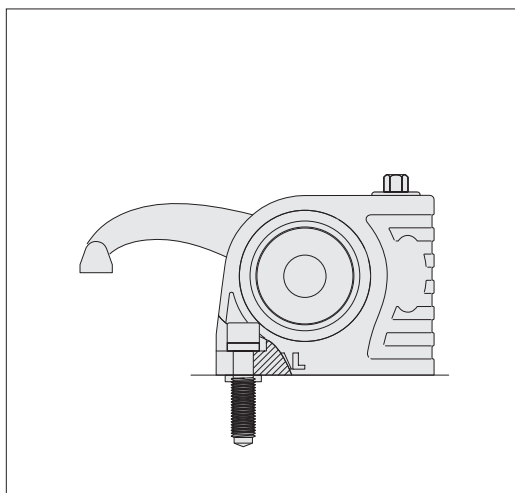
## Clamping & Height Setting

ADJUSTABLE VERTICAL CLAMPS

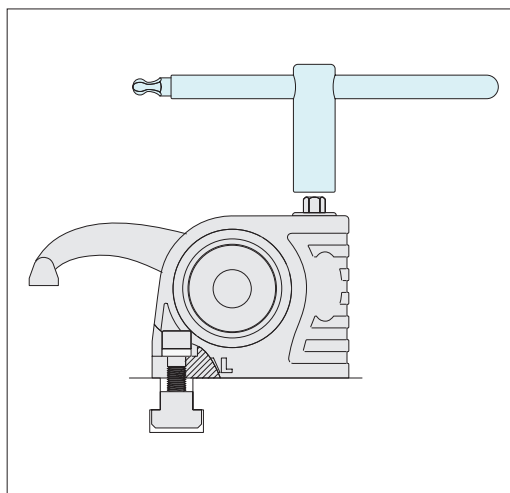


Slide the T-nut into the T-slot position and tighten the clamp onto the T-slot base, with the aid of the clamp key (shown in the image in blue).

Clamp the workpiece by twisting the key. Start machining.

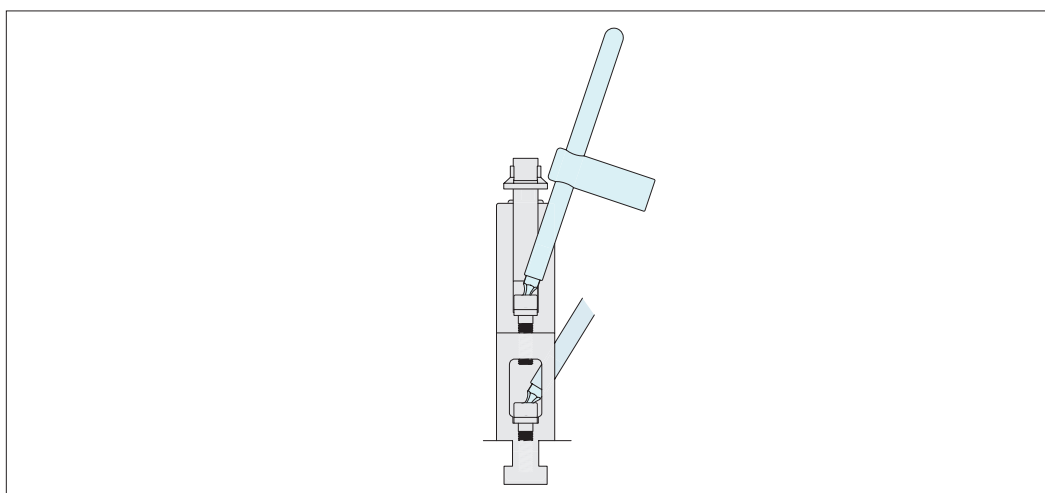


Fix to threaded bases with a special screw M10, M12, M14, M16.



Fix to T-slots with suitable T-nuts.

When unclamped the arm and the clamp remain in position



The clamps are easily stackable to achieve required clamping height.