

12010

LOW PROFILE SIDE CLAMPING

Material

Stainless steel (17-4 PH, AISI 630).
Smooth faced jaws (34 HRC), serrated jaws (44 HRC).

Technical Notes

Very low profile, compact design, strong clamping. With smooth or serrated faces. The clamp jaw slides on an angle for positive downhold force - the down force is approx. 25% of the holding force.

The support surface of the clamp is wire-cut to ensure accurate positioning.

Tips

The support surface of the clamp can be installed flush with the fixture plate or raised to allow through drilling. Often used in conjunction with our Talongrips, part no. 12034.

Important Notes

1. Bore installation hole d_1 , with a centre-line at distance l_1 (tol. M8) from edge of workpiece.
2. Drill and tap „ d_2 “ to mount the clamp in the pocket.
3. Machine counterbore „ h_4 “ if recessing the clamp into the fixture.
4. Provide a back stop to locate the part.

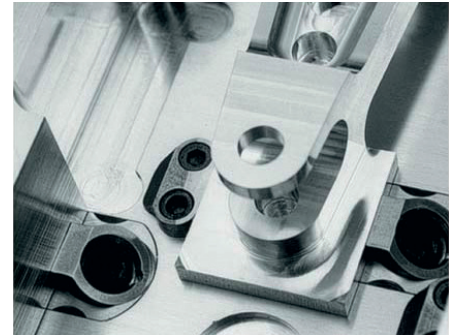
Order No.	Jaw type	d_1	d_2	Drive screw d_3	h_1	h_2	h_3 min.	h_3 opt.	h_3 max.	h_4	h_5 +0.1 -0.1	l_1 +0.1 -0.1	l_2	r_1 +0.1 -0.0	Weight g
12010.W0014	Smooth	20	M 5	M 6x12	19.0	4.5	3.3	5.0	6.8	4.5	20	4.9	5.0	25	54
12010.W0018	Serrated	20	M 5	M 6x12	19.0	4.5	3.3	5.0	6.8	4.5	20	4.9	5.0	25	54
12010.W0020	Smooth	25	M 6	M 8x16	24.0	5.0	4.5	6.5	8.3	5.0	25	5.6	6.0	30	100
12010.W0022	Serrated	25	M 6	M 8x16	24.0	5.0	4.5	6.5	8.3	5.0	25	5.6	6.0	30	100
12010.W0024	Smooth	30	M 8	M10x18	29.0	7.0	4.5	7.5	10.8	7.0	30	7.1	7.5	38	159
12010.W0028	Serrated	30	M 8	M10x18	29.0	7.0	4.5	7.5	10.8	7.0	30	7.1	7.5	38	159

Order No.	r_2 +0.1 -0.0	R_3	Stroke s_1	w_1	w_2	w_3	Torque to Nm max.	Key size A/F	Holding force kN
12010.W0014	20	6.0	2.0	24.9	19.9	13.5	10	5	8.8
12010.W0018	20	6.0	2.0	24.9	19.9	13.5	10	5	8.8
12010.W0020	25	6.5	2.2	29.9	24.9	15.0	24	6	11.5
12010.W0022	25	6.5	2.2	29.9	24.9	15.0	24	6	11.5
12010.W0024	30	8.0	3.8	37.9	29.9	20.0	42	8	14.2
12010.W0028	30	8.0	3.8	37.9	29.9	20.0	42	8	14.2



Height of jaw "h3" in relation to centreline of bore from edge of workpiece:

jaw height h_3	clamp dia $d_1 =$ 20mm distance from centreline	clamp dia $d_1 =$ 25mm distance from centreline	clamp dia $d_1 =$ 30mm distance from centreline
	l_1	l_1	l_1
3,25	5,91		
3,50	5,77		
3,75	5,62		
4,00	5,48		
4,25	5,33		
4,50	5,19	6,81	8,78
4,75	5,05	6,66	8,63
5,00	4,90	6,52	8,49
5,25	4,76	6,37	8,35
5,50	5,61	6,23	8,20
5,75	4,47	6,08	8,06
6,00	4,32	5,94	7,91
6,25	4,18	5,80	7,77
6,50	4,03	5,65	7,62
6,75	3,89	5,51	7,48
7,00		5,36	7,34
7,25		5,22	7,19
7,50		5,07	7,05
7,75		4,93	6,90
8,00		4,78	6,76
8,25		4,64	6,61
8,50			6,47
8,75			6,33
9,00			6,18
9,25			6,04
9,50			5,89
9,75			5,75
10,00			5,60
10,25			5,46
10,50			5,31
10,75			5,17



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