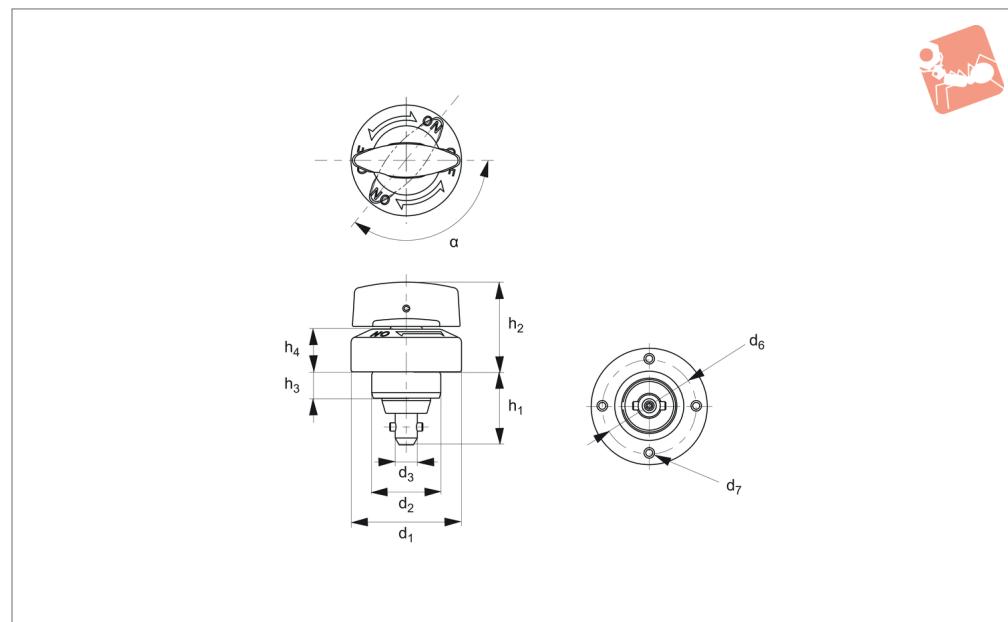


# One-Touch Flex Locator Clamps

knob

Pull Back  
Inserts



**12085.2**

PULL BACK INSERTS

## Material

Body/shank: steel (AISI 4140, 42CrMo4), black oxide finish.

Tapered pin: steel (AISI 4140, 42CrMo4), nitrocarburised.

Knob: stainless steel (AISI 304, 1.4308).

Pin: stainless steel (AISI 303, 1.4305).

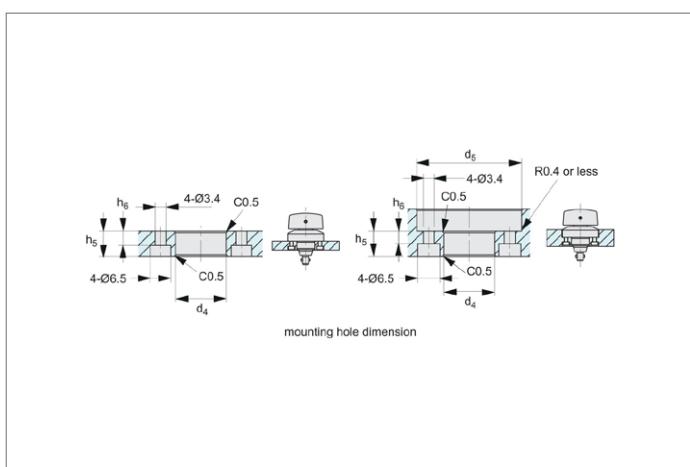
## Technical Notes

The lifting force is the power of the inner spring of the body to push up the moveable tapered pin.

## Tips

Flex locator bushing: for .W0206, see part no. 12085.W0506. For .W0208, see part no. 12085.W0508.

Order No.	Size	Clamping force N	d <sub>1</sub>	d <sub>2</sub>	d <sub>3</sub>	d <sub>4</sub>	d <sub>5</sub>	d <sub>6</sub>	d <sub>7</sub>	h <sub>1</sub>	h <sub>2</sub>	h <sub>3</sub>	h <sub>4</sub>	h <sub>5</sub>	h <sub>6</sub>	Lifting force N	α	Weight g
<b>12085.W0206</b>	6	350	32	16	5.5	16	33	25.5	M 3x0,5	22	27	7.5	12.0	8	4	30	120°	96
<b>12085.W0208</b>	8	600	40	25	8.0	25	41	34.0	-	26	32	9.5	15.5	10	6	100	130°	211



12085

Clamping &amp; Height Setting



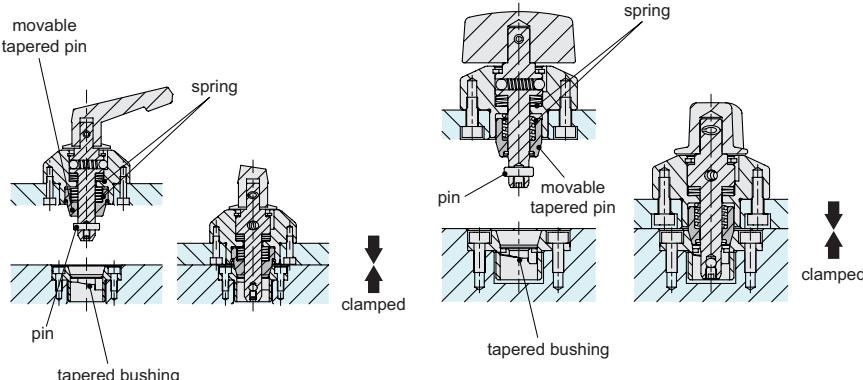
# One Touch Flex Locator Clampers

how to use



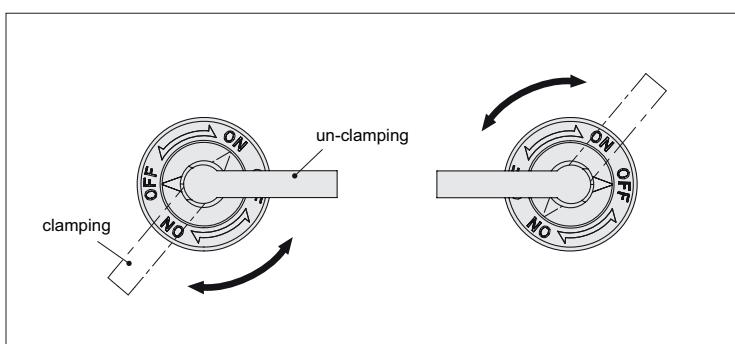
## Feature

PULL BACK INSERTS



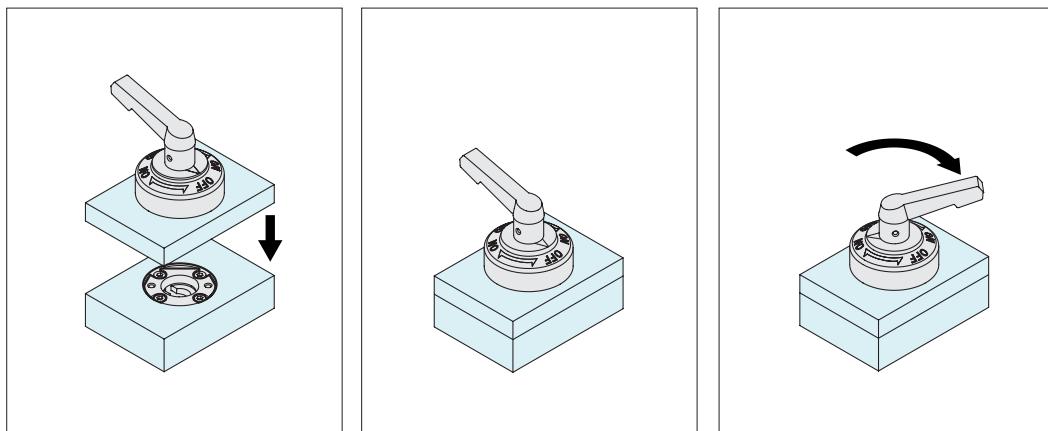
- The plates are located by fitting the tapered pin and the tapered bushing.
- The pin contacts the cam surface inside the bushing, and it compresses the inner spring, then the plates are clamped.

Note: 12085.W0108 does not have locating function.



Two clamping and unclamping positions of handle can be chosen for 12085.W0008/W0108

## How to Operate



1. Ensure the handle is positioned at 'OFF' mark.

\*Follow back these steps for unclamping

\*Same operation for knob style.

2. Insert the clamp to the bushing.

3. Turn the handle to 'ON' mark for clamping.



# One Touch Flex Locator Clampers

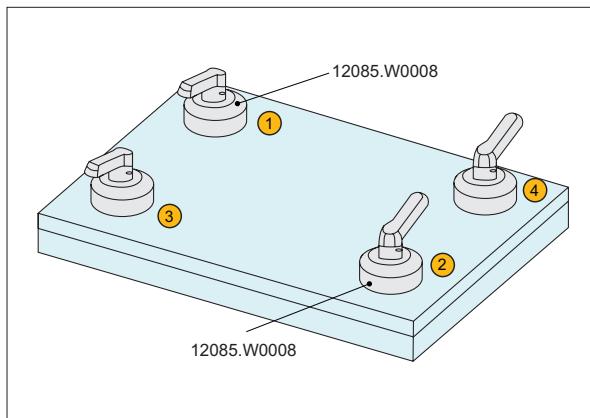
how to use



**12085**

Clamping & Height Setting

PULL BACK INSERTS



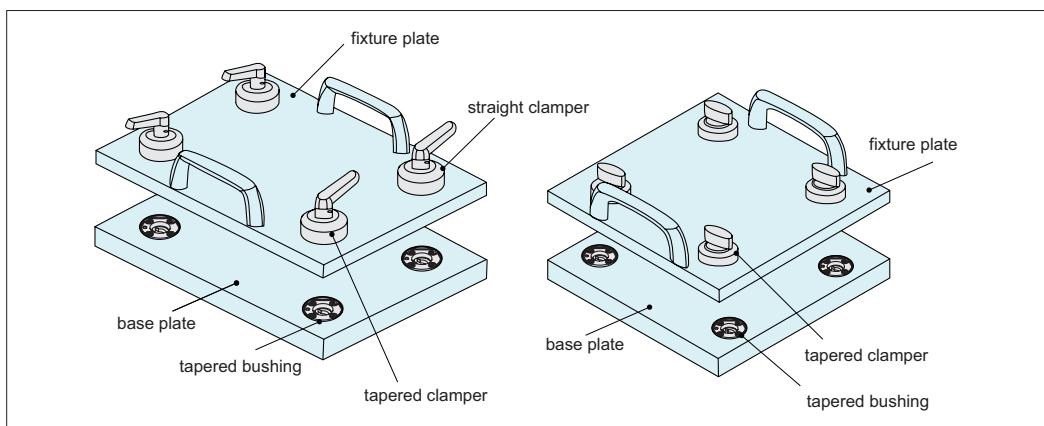
Ensure the handle os positioned at 'OFF' mark and lift down the fixture plate.

Turn the handle and clamp in order of  
**① - ② - ③ - ④**

\*For unclamping, ensure the handle is positioned at 'OFF' mark and disassemble the fixture plate.

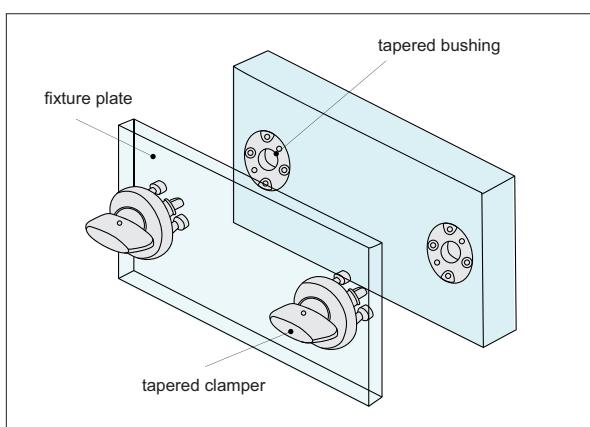
If the handles are not tightened in the correct order, the locating repeatability may exceed 10  $\mu$  m.

## Tightening Order



## How to Use Horizontal Assembly of Fixture Plate

Note: Ensure not to lift the fixture plate up and down with gripping the handle of the clamps.



## Clamp and Bush Combination      Max. Loading Capacity (N)

<b>12085.W0206</b>	Ø6	120
<b>12085.W0008</b>	Ø8	400
<b>12085.W0108</b>	Ø8	400
<b>12085.W0208</b>	Ø8	400

Note: The maximum load is the entire sum of the load of fixture plates, fixtures and workpieces.

The maximum loading capacity shown is the value when two sets of tapered clamp and tapered bushing are used.

## Vertical Assembly of Fixture Plate

Note: Locating repeatability is 10  $\mu$  m.