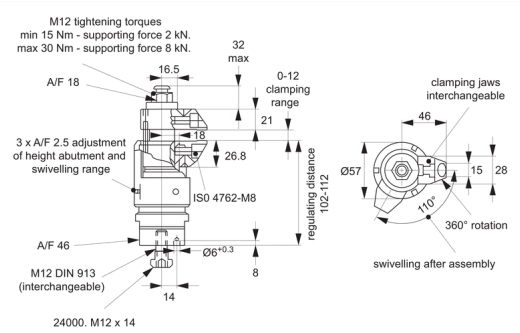

dimensions for the design of your own clamping jaws

12660.1

Material
Body: steel case-hardened, nitrided, blackened and ground.
Clamping jaws: steel case-hardened, nitrided, blackened.
Housing: aluminium, red anodised.

Technical Notes
Used to clamp and support additional clamping points on components, whilst minimising distortion in the clamping of components. It also serves to reduce vibration during machining.

Tips
Alternative clamping jaws available, see part 12660.W0050 to W0058 and 12660.W0148 to W0156.
The benefits of the floating clamp are:
• Avoids vibration during the processing
• Clamps ribs and flanges to reinforce clamped components
• Distortion-free clamping of first op. parts.

Assembly
1. Mount the floating clamp (M 12 connection thread) onto the device with a wrench (A/F 46).
2. Adjust the height limit stop and the rotating area with the red sleeve and clamp with a set screw (3 x A/F 2,5). When setting the height limit, consider tolerance of workpiece.

Operation
1. Push the floating clamp downwards.
2. Pivot the clamping jaws in as far as possible. The floating clamp contacts the bottom of the workpiece with a slight spring load.
3. Tighten the floating clamp with a hexagonal nut (A/F 18) having a min. torque of 15 Nm and a maximum torque of 30 Nm. In the clamping process, the workpiece is clamped and simultaneously supported.
4. Releasing is done in reverse order.

Order No.	Description	Clamping & support force kN max.	Clamping stroke	Weight g
12660.W0012	Clamping & Support	8	0-12	2076

Floating Clamps M12

combined clamping and locking