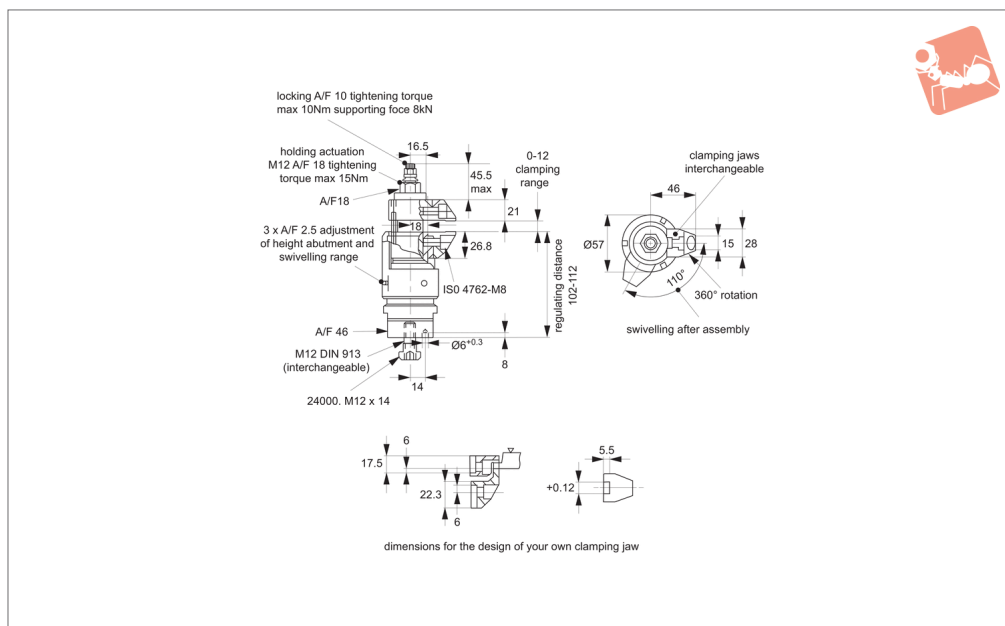


Floating Clamps M12

separate clamping and locking

Adjustable Vertical Clamps



12662.1

ADJUSTABLE VERTICAL CLAMPS

Material

Body: case hardened steel, nitrided and ground.

Clamping jaws: case hardened steel, nitrided.

Housing: aluminium, blue anodised.

Technical Notes

Used to clamp and support additional clamping points on extremely pliable work pieces, whilst minimising deformation of component. It also serves to reduce vibration during machining.

Tips

Alternative clamping jaws available, see part 12660.W0050 to W0058 and 12660.W0148 to W0156.

Floating clamp benefits:

Floating clamp 12662.1 is used to clamp and support over determined points on a component, offering the following benefits:

1. No deformation in the clamping of unstable components.
2. Eliminates vibration during machining.
3. Clamps on the smallest area to improve clamping stability.

Installation of floating clamp on fixture:

1. Fix clamp on to machine bed with A/F 46 spanner. Clamp has 12mm thread, select suitable T-nut for your machine bed.
2. Adjust the clamp's height limit stop and rotating area with the blue setting sleeve, set sleeve position through tightening the 3 grub screws (A/F 2,5mm). When setting the height limit, make generous allowance

for variation in workpiece tolerance.

Clamping process:

1. Push floating clamp downwards.
2. Pivot clamping jaws into component as far as possible. Clamp will contact bottom of component with only light spring pressure.
3. Tighten floating clamp with A/F 18mm hex nut - torque to min. 15Nm, 30Nm max. The jaws are clamping the workpiece, the clamp is still floating.
4. Tighten hexagon collar with A/F 10mm hex to max. 10Nm torque.
5. Clamping process is complete.
6. To release, reverse steps 5 to 1.

Order No.	Type	Weight g
12662.W0014	Steel	1890