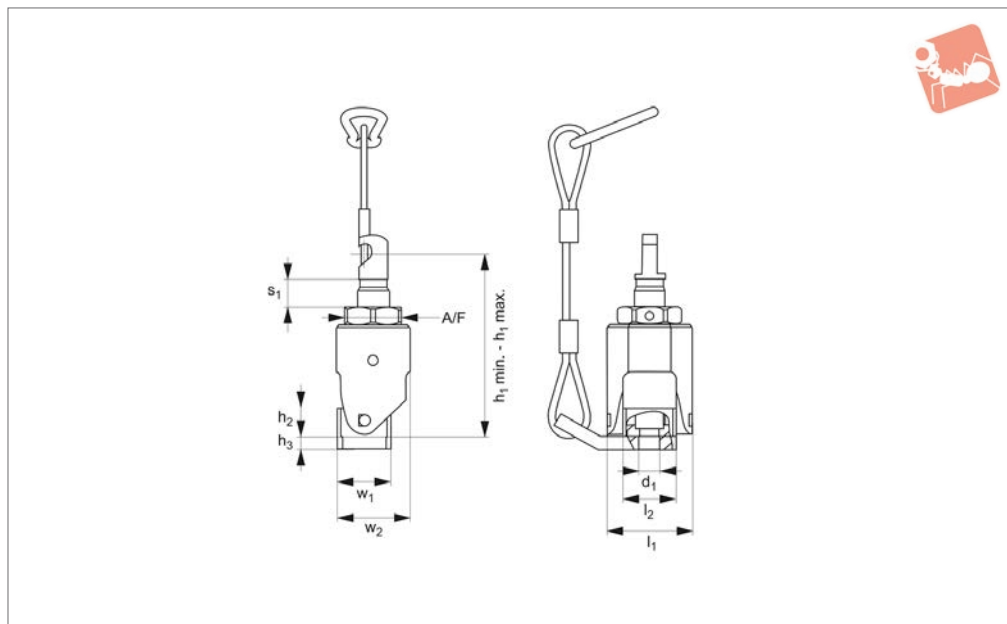




Tension Hook for chain clamping set 12700

Chain Clamping



12702

CHAIN CLAMPING

Material

Hardened and tempered alloy steel.

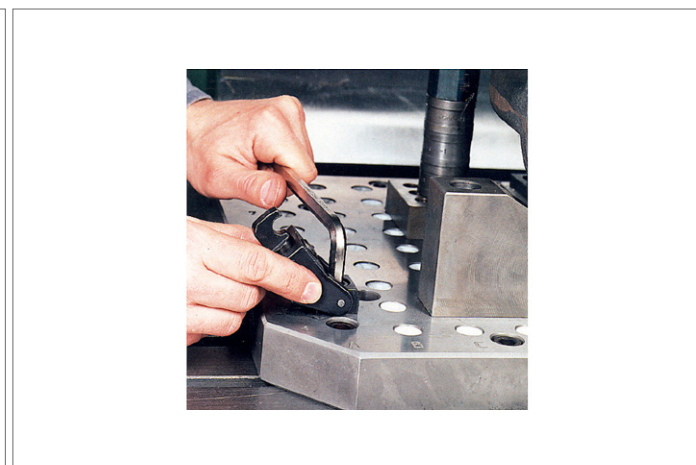
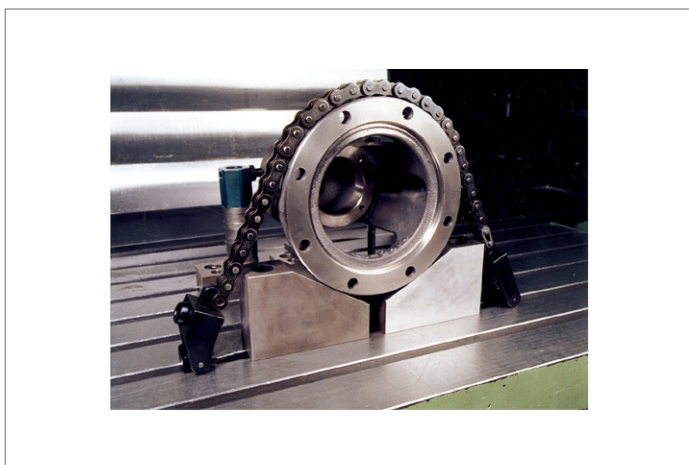
Technical Notes

For use with chain clamp set 12700.

Tension hook provides final clamping and tightening of component when chain clamp 12700 is used. Counter catch hook is for the initial pre-tightening of chain

prior to final clamping.
Comes complete with safety lanyard.

Order No.	Size	For T-slot	d ₁	h ₁ min.	h ₁ max.	h ₂	h ₃	l ₁	l ₂	Torque to Nm max.	w ₁	w ₂	A/F	Clamp stroke s ₁	Clamping force kN max.	Weight g
12702.W0012	12	14, 16 of 18	M12	100	118	18	8	54	34	45	34	47	36	18	15	853
12702.W0016	16	18, 20, 22 or 24	M16	122	153	25	10	70	44	90	37	62	46	31	40	1902
12702.W0020	20	22 to 28	M20	195	250	41	10	98	64	190	58	86	65	55	75	6037
12702.W0024	24	28 to 36	M24	199	260	41	10	98	64	300	58	86	65	61	120	6040

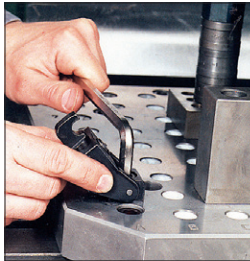




Our comprehensive range of clamping elements includes a compact and powerful workpiece clamping element, the chain clamping set no. 12700. This set was specifically designed for clamping large workpieces with round or arched surfaces.

Due to an increase in the bearing surface of the chain, the clamping force is distributed across the workpiece thereby reducing deformation.

Setting Up



1. Attach the hook unit and the take-up unit as close to the workpiece as possible.



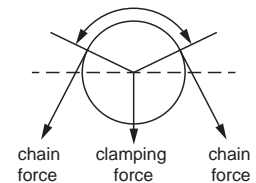
2. Turn the knurled nut on the take-up unit until the pull rod is fully extended. Select the number of chain segments required for the workpiece and attach to the pull rod.



3. Fine adjustment of the chain lengths is made by tightening the knurled nut until the chain slightly touches the workpiece.



4. To clamp the workpiece connect the free end of the chain onto the hook unit. Using a hex key tighten the eccentric shaft, and ensure the lever is rotated to its fully locked position (180°). The workpiece is now clamped.



Important Factors in Selection of Chain Clamp

Chain Length and Stretch

Torque value of 50 Nm is used for M12 set.

Torque value of 90 Nm is used for M16 set.

The clamping force achievable through the Wixroyd chain clamp set is dependent upon three factors:

- Workpiece diameter (see graph).
- Chain length and stretch (see graph).
- Contact angle of chain and workpiece (see table below right).

Chain Stretch at Specified Torques

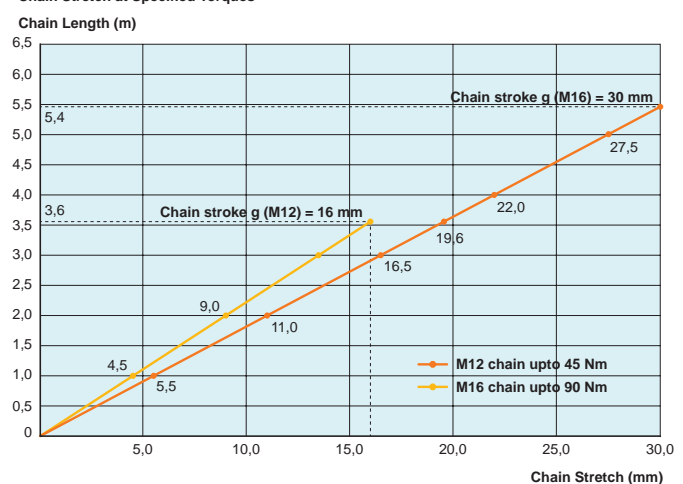


Table of Clamping Force to Contact Angle α



Clamping with the chain clamp set.

	Torque	$\alpha = 105^\circ$	$\alpha = 120^\circ$	$\alpha = 135^\circ$	$\alpha = 150^\circ$	$\alpha = 180^\circ$
M12	50Nm	80%	87%	92%	97%	100%
M16	90Nm	80%	87%	92%	97%	100%

Important Note: Achievable clamping force decreases as the contact angle of chain and workpiece (α) reduces. Please use the table above as a guide.