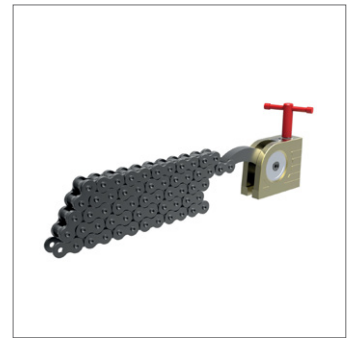
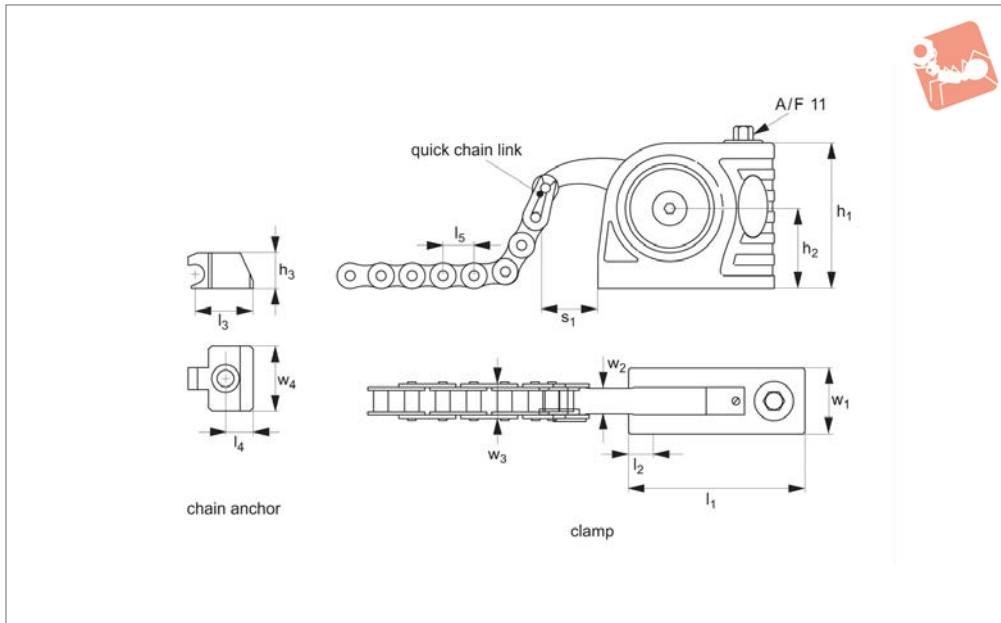




# Chain Clamp Sets - 16kN for large diameter clamping

## Chain Clamping



**12750**

CHAIN CLAMPING

### Material

Clamp: as part no. 10650.  
Chain: steel, 19,05mm pitch - 1 metre.  
Chain anchor: steel.  
Quick chain link: steel.

diameter workpieces.

Extra lengths of chain can be ordered and linked together.  
Clamp or unclamp with a simple turn of the red key. The chain can then easily be removed clear from the workpiece.

### Tips

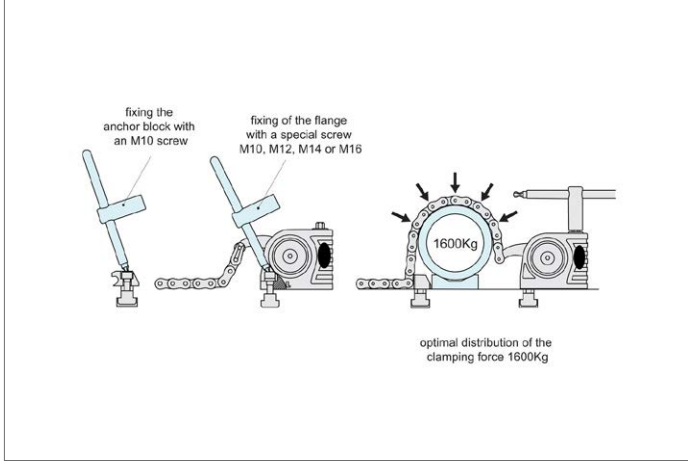
Chains with rubber protective pads can also be provided on request (min. radius 200mm).

### Technical Notes

Provides strong and even clamping of large

| Order No.   | Description                        | $h_1$ | $h_2$ | $h_3$ | $l_1$ | $l_2$ |
|-------------|------------------------------------|-------|-------|-------|-------|-------|
| 12750.W0040 | Set: Clamp, 1m Chain, Chain Anchor | 89    | 49    | -     | 108   | 12.5  |
| 12750.W0900 | Chain - 1m                         | -     | -     | -     | -     | -     |
| 12750.W0905 | Quick Chain Link                   | -     | -     | -     | -     | -     |
| 12750.W0910 | Chain Anchor                       | -     | -     | 22    | -     | -     |

| Order No.   | $l_3$ | $l_4$ | $l_5$ | $w_1$ | $w_2$ | $w_3$ | $w_4$ | A/F | Clamp reach $s_1$ | Clamping force kN max. |
|-------------|-------|-------|-------|-------|-------|-------|-------|-----|-------------------|------------------------|
| 12750.W0040 | -     | -     | -     | 40    | 16    | -     | -     | 11  | 33                | 16                     |
| 12750.W0900 | -     | -     | 19.05 | -     | -     | 19.5  | -     | -   | -                 | -                      |
| 12750.W0905 | -     | -     | 19.05 | -     | -     | -     | -     | -   | -                 | -                      |
| 12750.W0910 | 26    | 17    | -     | -     | -     | -     | 40    | -   | -                 | -                      |

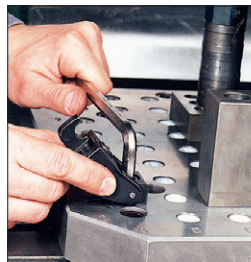




Our comprehensive range of clamping elements includes a compact and powerful workpiece clamping element, the chain clamping set no. 12700. This set was specifically designed for clamping large workpieces with round or arched surfaces.

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.



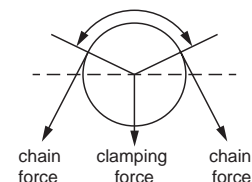
2. Turn the knurled nut on the take-up unit until the pull rod is fully extended. Select the number of chain segments required for the workpiece and attach to the pull rod.



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.

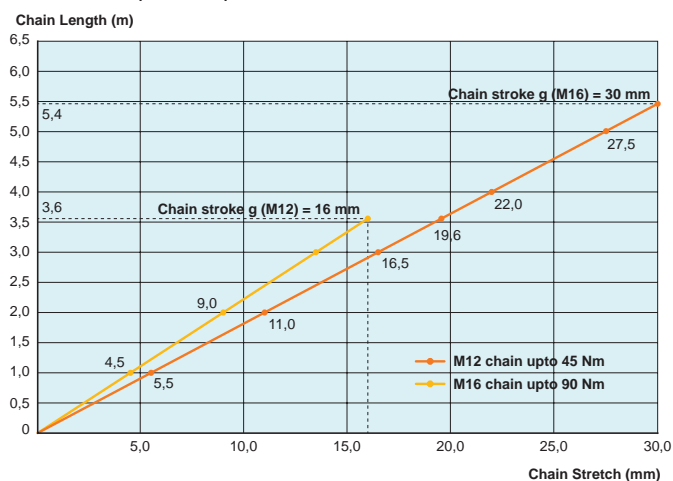


## Important Factors in Selection of Chain Clamp

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



### Chain Length and Stretch

Torque value of 50 Nm is used for M12 set.

Torque value of 90 Nm is used for M16 set.



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%                 |

### Table of Clamping Force to Contact Angle $\alpha$

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