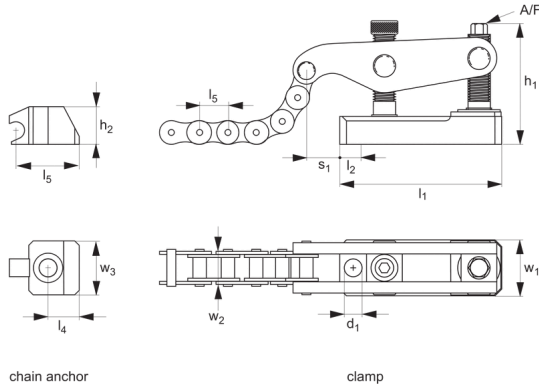




Chain Clamp Sets - 50kN for large diameter clamping

Chain Clamping



12752

CHAIN CLAMPING

Material

Clamp - as part no. 10678.
Chain - steel, 25,4 pitch. 3m long.
Chain anchor - steel.

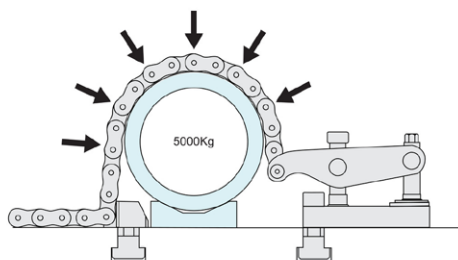
Provides strong and even clamping of large diameter workpieces.
Clamp or unclamp with a simple turn of hexagon socket. Chain can be easily removed clear from the workpiece.
Please use socket head cap screw of

strength class 12,9 for mounting. Please order T-nuts to suit your application separately, if required see part 24000.

Technical Notes

Heavy clamping forces of up to 50kN.

Order No.	Description				d_1	h_1	h_2	l_1	l_2
12752.W0001	Set: Clamp, Chain (3m), Chain Anchor				17	111	35	108	12
Order No.	l_3	l_4	l_5	w_1	w_2	w_3	A/F	Clamp reach s_1	Clamping force kN max.
12752.W0001	57	28	25.4	50	25.4	50	13	30	50



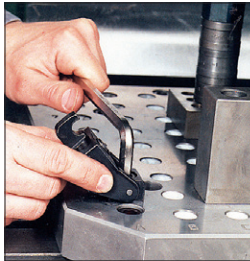
at optimal distribution, clamping force = 5000Kg



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.



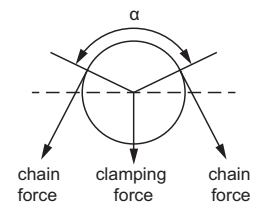
2. Turn the knurled nut on the take-up unit until the pull rod is fully extended. Select the number of chain segments required for the workpiece and attach to the pull rod.



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

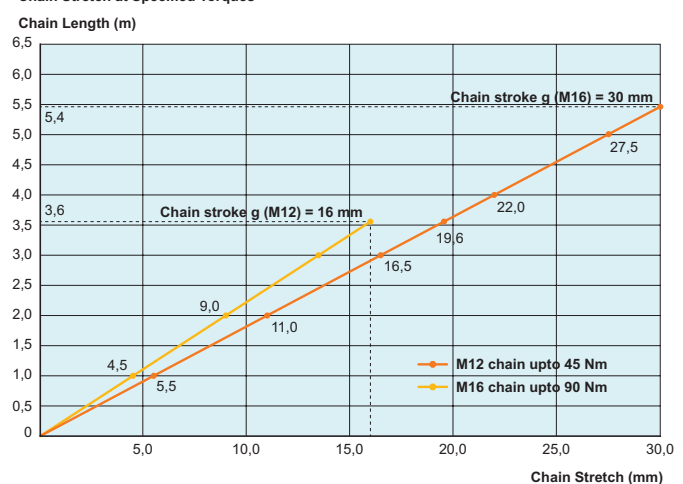
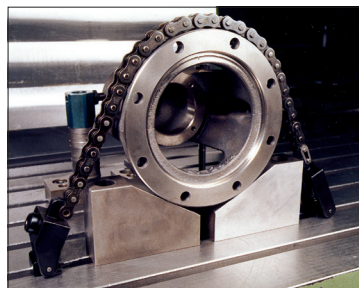


Table of Clamping Force to Contact Angle α



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.