

12010

LOW PROFILE SIDE CLAMPING

Material

Stainless steel (17-4 PH, AISI 630).
Smooth faced jaws (34 HRC), serrated jaws (44 HRC).

Technical Notes

Very low profile, compact design, strong clamping. With smooth or serrated faces. The clamp jaw slides on an angle for positive downhold force - the down force is approx. 25% of the holding force.

The support surface of the clamp is wire-cut to ensure accurate positioning.

Tips

The support surface of the clamp can be installed flush with the fixture plate or raised to allow through drilling. Often used in conjunction with our Talongrips, part no. 12034.

Important Notes

1. Bore installation hole d_1 , with a centre-line at distance l_1 (tol. M8) from edge of workpiece.
2. Drill and tap „ d_2 “ to mount the clamp in the pocket.
3. Machine counterbore „ h_4 “ if recessing the clamp into the fixture.
4. Provide a back stop to locate the part.

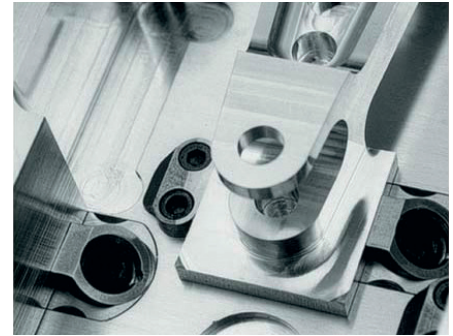
| Order No. | Jaw type | d_1 | d_2 | Drive screw d_3 | h_1 | h_2 | h_3 min. | h_3 opt. | h_3 max. | h_4 | h_5 +0.1 -0.1 | l_1 +0.1 -0.1 | l_2 | r_1 +0.1 -0.0 | Weight g |
|-------------|----------|-------|-------|-------------------|-------|-------|------------|------------|------------|-------|-----------------|-----------------|-------|-----------------|----------|
| 12010.W0014 | Smooth | 20 | M 5 | M 6x12 | 19.0 | 4.5 | 3.3 | 5.0 | 6.8 | 4.5 | 20 | 4.9 | 5.0 | 25 | 54 |
| 12010.W0018 | Serrated | 20 | M 5 | M 6x12 | 19.0 | 4.5 | 3.3 | 5.0 | 6.8 | 4.5 | 20 | 4.9 | 5.0 | 25 | 54 |
| 12010.W0020 | Smooth | 25 | M 6 | M 8x16 | 24.0 | 5.0 | 4.5 | 6.5 | 8.3 | 5.0 | 25 | 5.6 | 6.0 | 30 | 100 |
| 12010.W0022 | Serrated | 25 | M 6 | M 8x16 | 24.0 | 5.0 | 4.5 | 6.5 | 8.3 | 5.0 | 25 | 5.6 | 6.0 | 30 | 100 |
| 12010.W0024 | Smooth | 30 | M 8 | M10x18 | 29.0 | 7.0 | 4.5 | 7.5 | 10.8 | 7.0 | 30 | 7.1 | 7.5 | 38 | 159 |
| 12010.W0028 | Serrated | 30 | M 8 | M10x18 | 29.0 | 7.0 | 4.5 | 7.5 | 10.8 | 7.0 | 30 | 7.1 | 7.5 | 38 | 159 |

| Order No. | r_2 +0.1 -0.0 | R_3 | Stroke s_1 | w_1 | w_2 | w_3 | Torque to Nm max. | Key size A/F | Holding force kN |
|-------------|-----------------|-------|--------------|-------|-------|-------|-------------------|--------------|------------------|
| 12010.W0014 | 20 | 6.0 | 2.0 | 24.9 | 19.9 | 13.5 | 10 | 5 | 8.8 |
| 12010.W0018 | 20 | 6.0 | 2.0 | 24.9 | 19.9 | 13.5 | 10 | 5 | 8.8 |
| 12010.W0020 | 25 | 6.5 | 2.2 | 29.9 | 24.9 | 15.0 | 24 | 6 | 11.5 |
| 12010.W0022 | 25 | 6.5 | 2.2 | 29.9 | 24.9 | 15.0 | 24 | 6 | 11.5 |
| 12010.W0024 | 30 | 8.0 | 3.8 | 37.9 | 29.9 | 20.0 | 42 | 8 | 14.2 |
| 12010.W0028 | 30 | 8.0 | 3.8 | 37.9 | 29.9 | 20.0 | 42 | 8 | 14.2 |



Height of jaw "h3" in relation to centreline of bore from edge of workpiece:

| jaw height h_3 | clamp dia $d_1 =$ 20mm distance from centreline | clamp dia $d_1 =$ 25mm distance from centreline | clamp dia $d_1 =$ 30mm distance from centreline |
|---------------------|---|---|---|
| | l_1 | l_1 | l_1 |
| 3,25 | 5,91 | | |
| 3,50 | 5,77 | | |
| 3,75 | 5,62 | | |
| 4,00 | 5,48 | | |
| 4,25 | 5,33 | | |
| 4,50 | 5,19 | 6,81 | 8,78 |
| 4,75 | 5,05 | 6,66 | 8,63 |
| 5,00 | 4,90 | 6,52 | 8,49 |
| 5,25 | 4,76 | 6,37 | 8,35 |
| 5,50 | 5,61 | 6,23 | 8,20 |
| 5,75 | 4,47 | 6,08 | 8,06 |
| 6,00 | 4,32 | 5,94 | 7,91 |
| 6,25 | 4,18 | 5,80 | 7,77 |
| 6,50 | 4,03 | 5,65 | 7,62 |
| 6,75 | 3,89 | 5,51 | 7,48 |
| 7,00 | | 5,36 | 7,34 |
| 7,25 | | 5,22 | 7,19 |
| 7,50 | | 5,07 | 7,05 |
| 7,75 | | 4,93 | 6,90 |
| 8,00 | | 4,78 | 6,76 |
| 8,25 | | 4,64 | 6,61 |
| 8,50 | | | 6,47 |
| 8,75 | | | 6,33 |
| 9,00 | | | 6,18 |
| 9,25 | | | 6,04 |
| 9,50 | | | 5,89 |
| 9,75 | | | 5,75 |
| 10,00 | | | 5,60 |
| 10,25 | | | 5,46 |
| 10,50 | | | 5,31 |
| 10,75 | | | 5,17 |



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