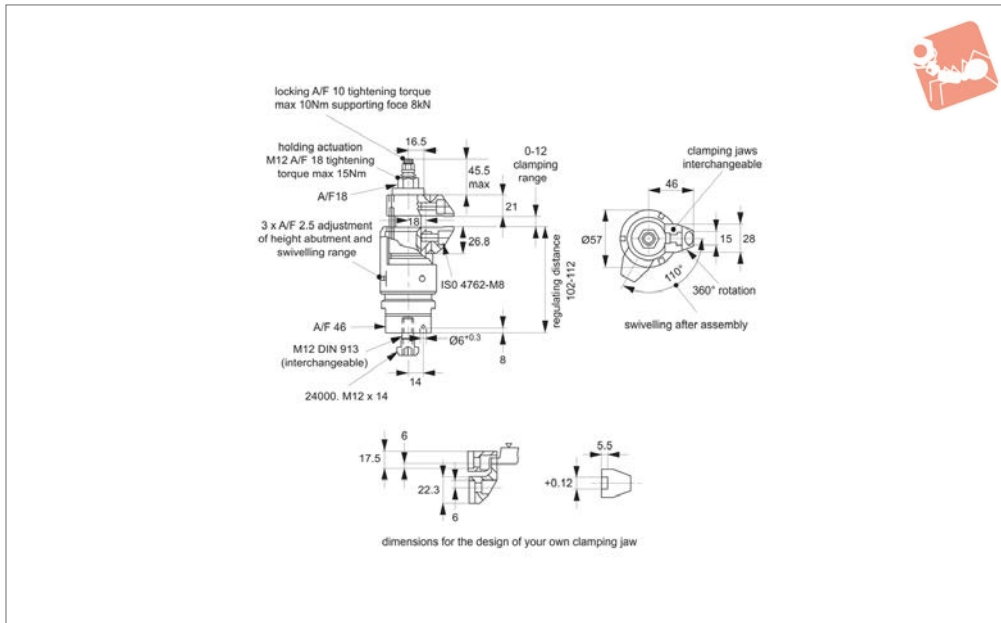




# Floating Clamps M12

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