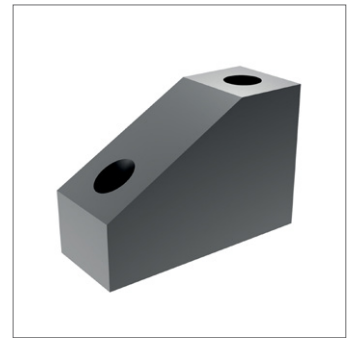
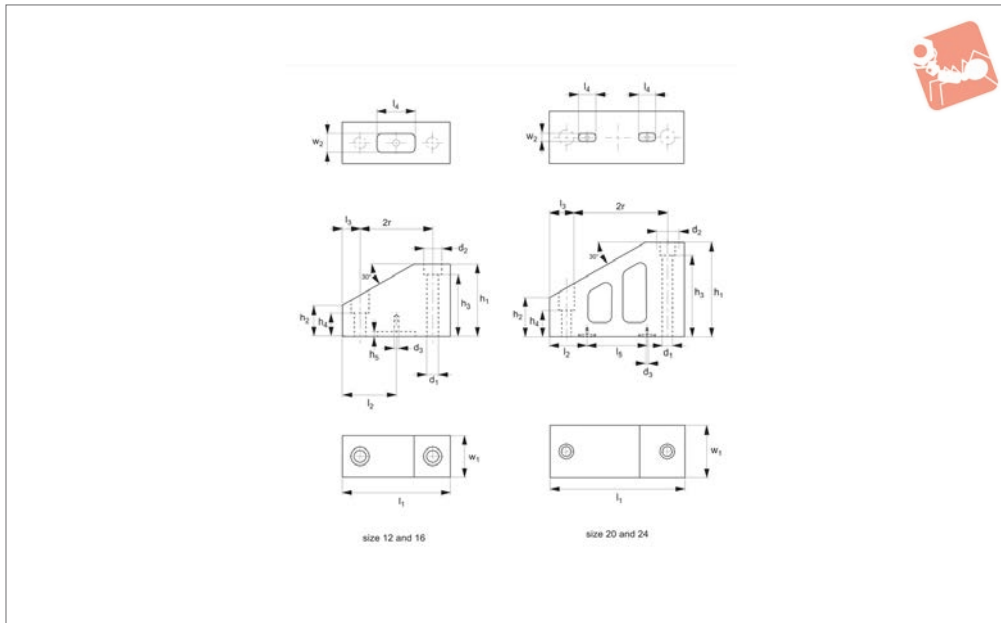




Angle Block - 120° for chain clamping

Chain Clamping



12706

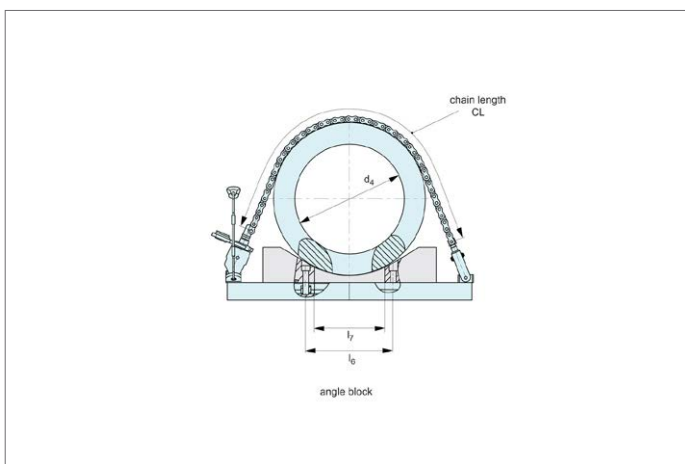
CHAIN CLAMPING

Technical Notes

Ideal for use when clamping components with chain clamp set 12700. 2 off prisms

provide ideal support for components with large circumferences. **Sold individually.**

Order No.	Size	2r	d ₁	d ₂	d ₃	h ₁	h ₂	h ₃	h ₄	h ₅	l ₁	l ₂	l ₃	l ₄	l ₅	w ₁	w ₂	Weight g
12706.W0012	12	80	13.5	20	M 6	80	35	67	27	5.5	118	59	19	42	-	47	20	3230
12706.W0016	16	100	17.5	26	M 6	100	44	33	33	5.5	148	74	24	44	-	47	20	3960
12706.W0020	20	270	22.0	33	M 6	250	102	161	91	5.5	360	100	45	44	160	78	20	32455
12706.W0024	24	270	22.0	40	M 6	250	102	161	91	5.5	360	100	45	44	160	78	20	31760

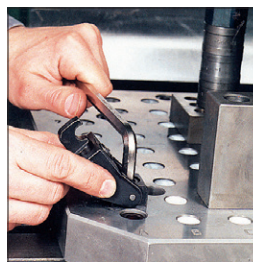




Our comprehensive range of clamping elements includes a compact and powerful workpiece clamping element, the chain clamping set no. 12700. This set was specifically designed for clamping large workpieces with round or arched surfaces.

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.



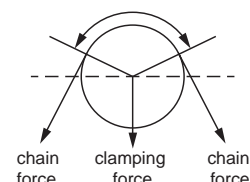
2. Turn the knurled nut on the take-up unit until the pull rod is fully extended. Select the number of chain segments required for the workpiece and attach to the pull rod.



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

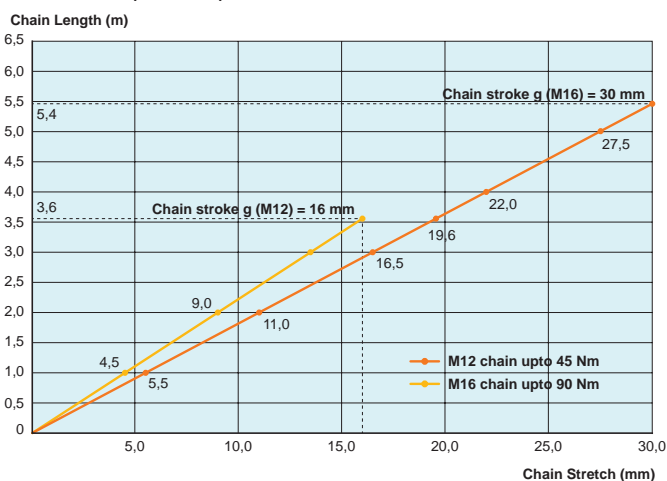
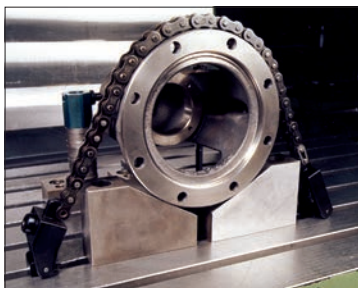


Table of Clamping Force to Contact Angle α



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.