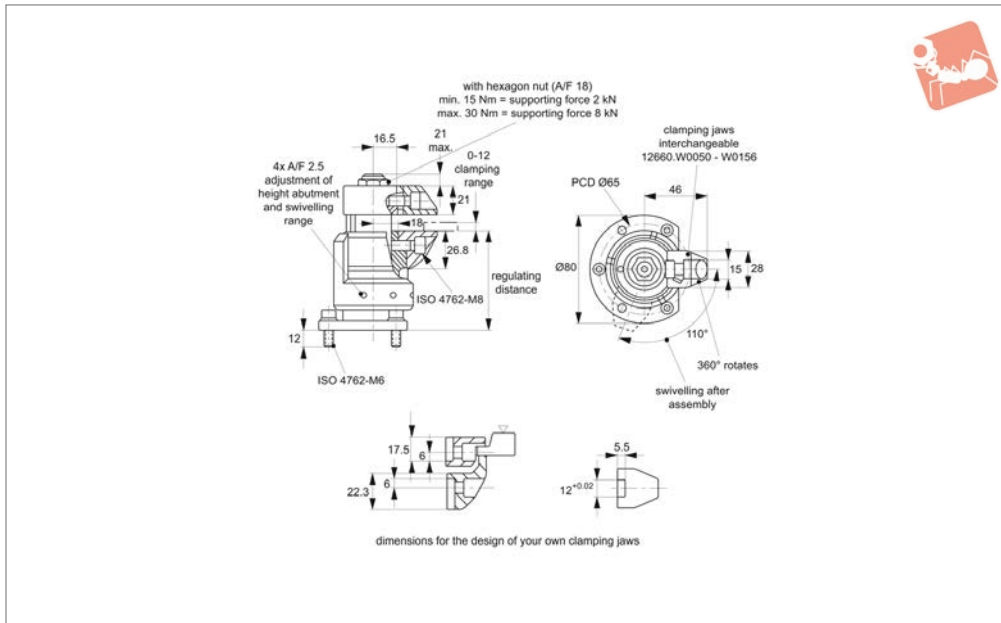




Compact Floating Clamps M12

combined clamping and locking

Adjustable Vertical Clamps



12660.2

ADJUSTABLE VERTICAL CLAMPS

Material

Body: steel case-hardened, nitrided, manganese phosphate treated and ground.
Clamping jaws: steel case-hardened, nitrided, manganese phosphate treated.
Housing: aluminium, red anodised.

Technical Notes

Used to clamp and support additional clamping points on components, whilst minimising distortion in the clamping of components. 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 12660.1 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 connection thread, select suitable T-nut for your machine bed.

2. Adjust the clamp's height limit stop and rotating area with the red 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 a light spring pressure.
3. Tighten floating clamp with A/F 18mm hex nut – torque to min. 15Nm, 30Nm max. In the clamping process workpiece is clamped and simultaneously supported.
4. To release, reverse steps 3 to 1.

Order No.	Description	Clamping & support force kN max.	Clamping stroke	Weight g
12660.W0008	Clamping & Support	8	0-12	1450