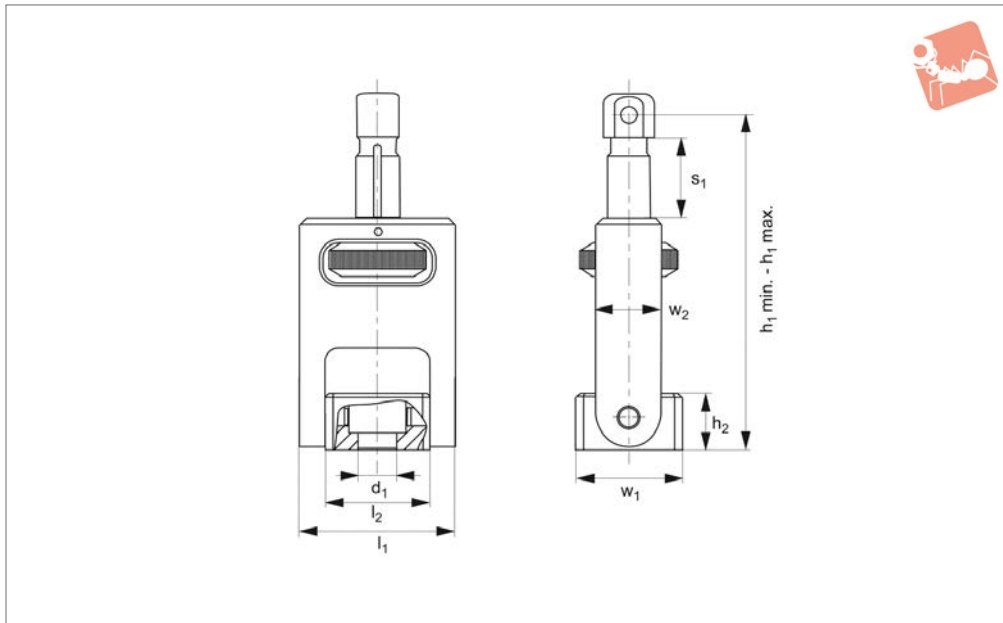




# Counter Catch Hook for chain clamping set 12700

## Chain Clamping



**12703**

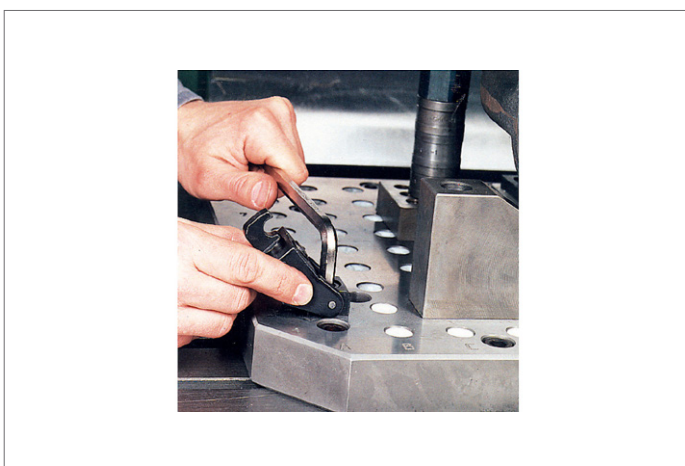
CHAIN CLAMPING

**Material**  
Alloy steel.

Counter catch hook is for the pre-tightening of chain prior to final clamping.

**Technical Notes**  
For use with chain clamp set 12700.

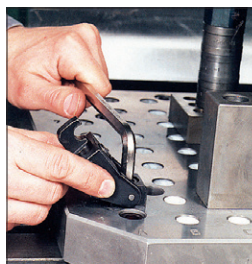
Order No.	Size	For T-slot	d <sub>1</sub>	h <sub>1</sub> min.	h <sub>1</sub> max.	h <sub>2</sub>	l <sub>1</sub>	l <sub>2</sub>	w <sub>1</sub>	w <sub>2</sub>	Stroke s <sub>1</sub>	Clamping force kN max.	Weight g
<b>12703.W0012</b>	12	14, 16 or 18	M12	83	108.0	18	50	34	34	21	25.0	15	553
<b>12703.W0016</b>	16	18, 20, 22 or 24	M16	110	146.0	25	64	44	37	29	36.0	40	1235
<b>12703.W0020</b>	20	22 to 28	M20	162	205.5	41	91	64	58	48	43.5	75	4088
<b>12703.W0024</b>	24	28 to 36	M24	166	209.0	41	91	64	58	48	43.0	120	4145





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.



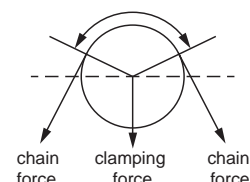
2. Turn the knurled nut on the take-up unit until the pull rod is fully extended. Select the number of chain segments required for the workpiece and attach to the pull rod.



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

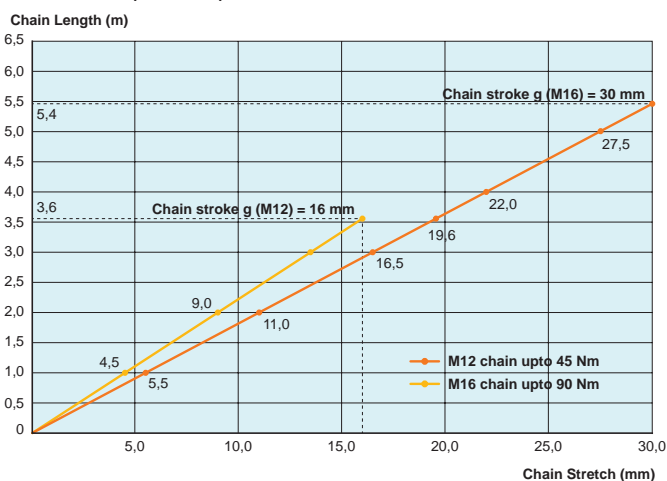
Torque value of 50 Nm is used for M12 set.

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 $\alpha$



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 ( $\alpha$ ) reduces. Please use the table above as a guide.