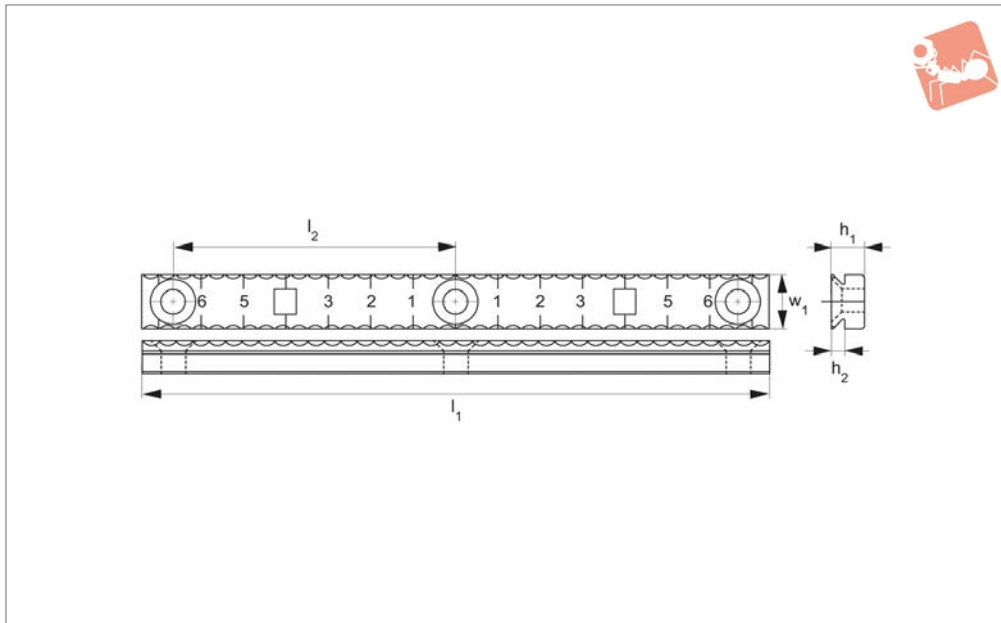




Talongrip Serrated Grip long

Low Profile Side Clamping



12030

LOW PROFILE SIDE CLAMPING

Material

Steel (S7), heat-treated, black oxide.

Technical Notes

Installation instructions:

1. Set grip in Talongrip jaw, install with screws provided. For fixture, machine slot 0,025mm-0,075mm larger than dimension w_1 , drill and tap.
2. Torque screws to 6,1 Nm. for standard

cap screw and 3,3 Nm. for low head cap screw.

3. Tighten vice until penetration is felt. As a general rule, an additional 1/4-3/4 turn of vice handle is needed to secure the workpiece dependent on material type and vice model. Recommended penetration is 0,15mm-0,40mm.

Tips

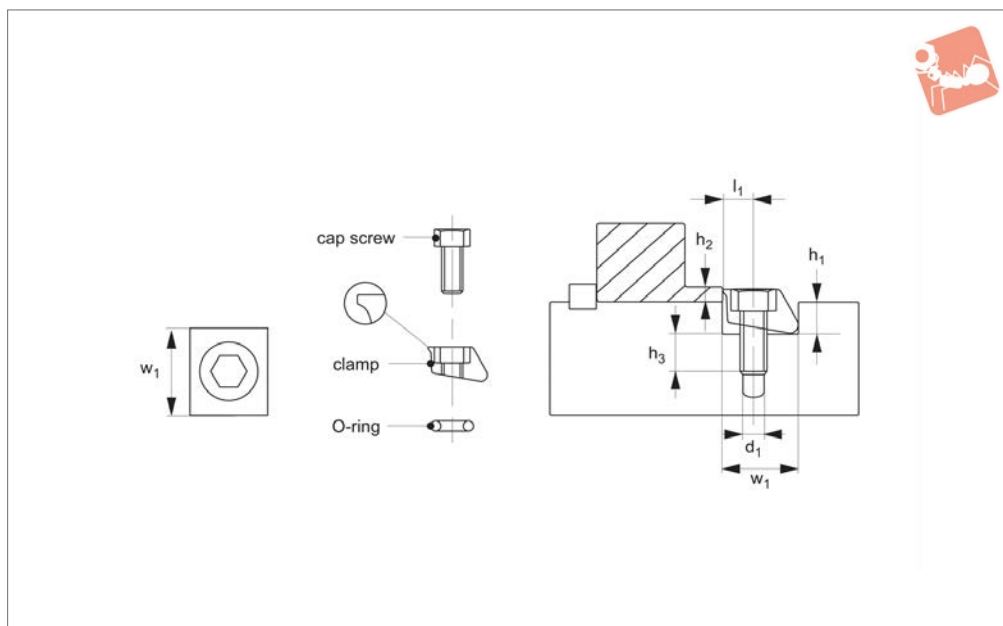
M 5x12 screws provided, as well as 10-32x1/2". Either can be used in M 5 threaded holes as long as they do not exceed 25mm in length.

The 10-32 screws sit better in the gripper rail and are less likely to bind during removal.

Order No.	Qty/pack	h_1	l_1	l_2	w_1	Fits Wixroyd jaw set	Gripping height h_2	Weight g
12030.W0052	2	9.3	50.0	38.1	19.1	12035 & 12464	1,3-4,1	113
12030.W0054	2	7.8	98.8	41.3	12.7	12035	1,3-3,2	181
12030.W0056	2	7.8	148.1	66.7	12.7	12035	1,3-3,2	259



12031.1



Material

Tool: steel (Hrc 43-45) or brass.
Screw: steel and oil resistant nitrile rubber.
O-ring: plastic.

Technical Notes

Provides positive down force and a very low grip height. High vertical and horizontal clamping forces. The O-ring lifts the clamp when unclamping.
Hardness: approx. Hrc 45.
Temperature range -30°C to +80°C.
Clamps sold by pack quantity.

Tips

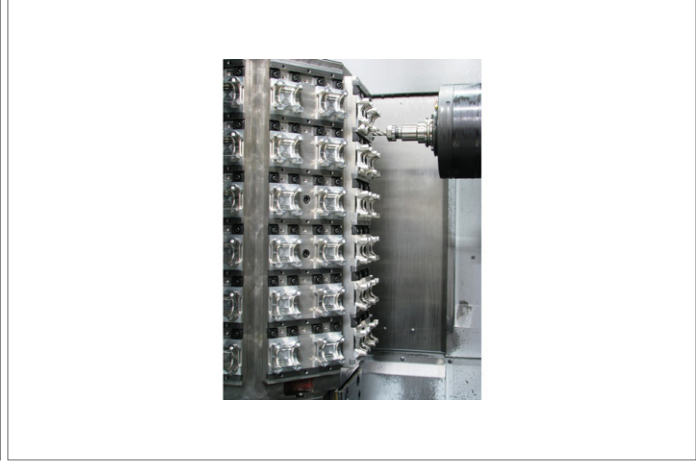
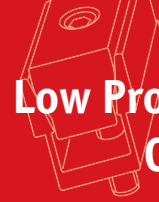
The tool steel blunt edge is less likely to mark workpieces, whilst the knife edge version bites into the material for more aggressive machining requirements. Often used with 12034 Talongrip or 12036 Versagrip. Location rails are ideal for use with pitbull clamps.

Important Notes

1. Machine a slot for the Pitbull clamp in the fixture according to dimensions „w₁“ and „h₁“.

2. Drill and tap a fixing hole to match screw size- refer to dimension „l₁“ for distance of hole from the component.
 3. Assemble clamp as shown in the diagram above.
 4. Position the clamp, and loosely screw to fixture.
 5. Load the component and tighten screw cap.
- Dimension „h₂“ is the minimum recommended clamping height.

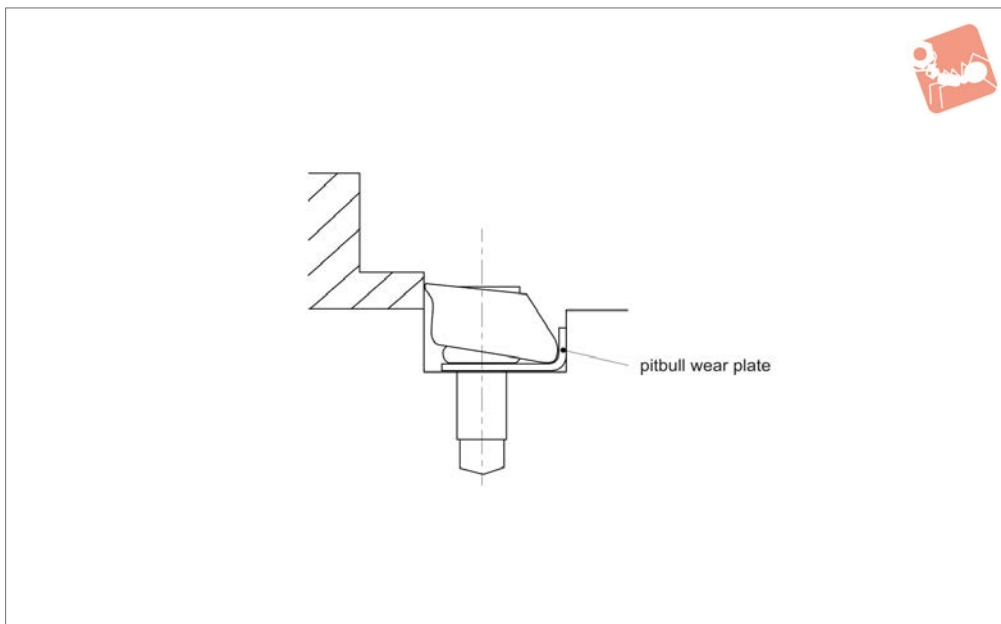
Order No.	Material	Type	Qty/pack	d ₁	h ₁	h ₂	h ₃	l ₁	Stroke s ₁	w ₁	Torque to Nm max.	Holding force kN	Weight g
12031.W0015	Brass	Blunt Edge	8	M 2,5	3.6	1.9	5.6	3.8	0.2	9.5	0.6	0.9	45
12031.W0040	Brass	Blunt Edge	8	M 4	4.8	2.6	8.6	5.1	0.4	12.7	2.8	1.8	64
12031.W0065	Brass	Blunt Edge	6	M 6	7.1	3.8	11.2	7.6	0.6	19.0	5.6	4.2	163
12031.W0005	Tool Steel	Knife Edge	8	M 2,5	3.6	1.9	6.6	3.8	0.2	9.5	1.8	2.8	32
12031.W0010	Tool Steel	Blunt Edge	8	M 2,5	3.6	1.9	6.6	3.8	0.2	9.5	1.8	2.8	45
12031.W0020	Tool Steel	Knife Edge	8	M 4	4.8	2.6	9.9	5.1	0.4	12.7	5.6	6.6	64
12031.W0030	Tool Steel	Blunt Edge	8	M 4	4.8	2.6	9.9	5.1	0.4	12.7	5.6	6.6	64
12031.W0050	Tool Steel	Knife Edge	6	M 6	7.1	3.8	14.5	7.6	0.6	19.0	22.5	16.0	136
12031.W0060	Tool Steel	Blunt Edge	6	M 6	7.1	3.8	14.5	7.6	0.6	19.0	22.5	16.0	132
12031.W0070	Tool Steel	Knife Edge	4	M10	11.4	6.4	18.0	10.2	1.3	25.4	40.6	26.0	256
12031.W0075	Tool Steel	Blunt Edge	4	M10	11.4	6.4	18.0	10.2	1.3	25.4	40.6	26.0	277
12031.W0080	Tool Steel	Knife Edge	2	M12	16.3	9.5	19.6	15.2	1.9	38.1	145.0	50.0	408
12031.W0085	Tool Steel	Blunt Edge	2	M12	16.3	9.5	19.6	15.2	1.9	38.1	145.0	50.0	408



LOW PROFILE SIDE CLAMPING



12031.2



Technical Notes

Provides a hard barrier between pitbull clamp and fixture, preventing distortion of back wall when using aluminium or mild

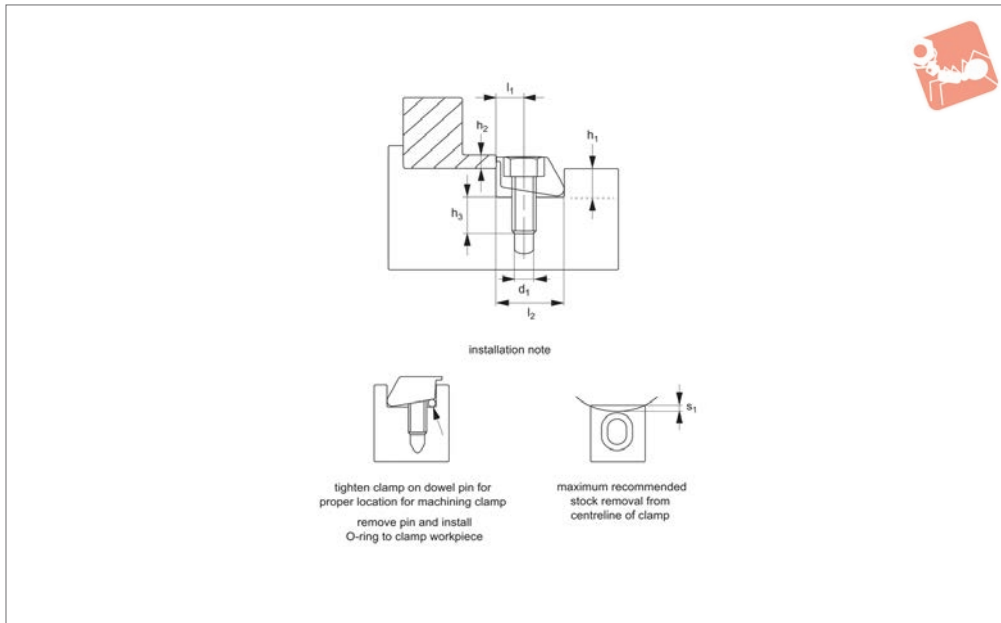
steel fixtures.

Tips

To keep fixtures light, maintain full clamp

travel and holding forces at max. pressure. Refurbish old fixtures or add to existing aluminium fixtures to maximise machining capabilities.

Order No.	Screw	Part number	Qty/pack
12031.W0615	M 2,5	12031.W0005, 12031.W0010, 12031.W0015	8
12031.W0640	M 4	12031.W0020, 12031.W0030, 12031.W0040	8
12031.W0665	M 6	12031.W0050, 12031.W0060, 12031.W0065	6
12031.W0670	M10	12031.W0070, 12031.W0075, 12032.W0570	4
12031.W0680	M12	12031.W0080, 12031.W0085, 12032.W0580	2



12032

LOW PROFILE SIDE CLAMPING

Material

Tool: steel, heat treated to HRC 43, machinable.

Screw: steel and oil resistant nitrile rubber.

O-ring: plastic.

Technical Notes

A machinable version of the standard pitbull clamps.

Provides positive down force and a very low grip height.

High vertical and horizontal clamping forces.

Hardness: approx. 45HRC

Tips

There is additional material of the clamp

face to allow machining of a radius. Often used with part no. 12034 Talongrip or part no. 12036 Versagrip.

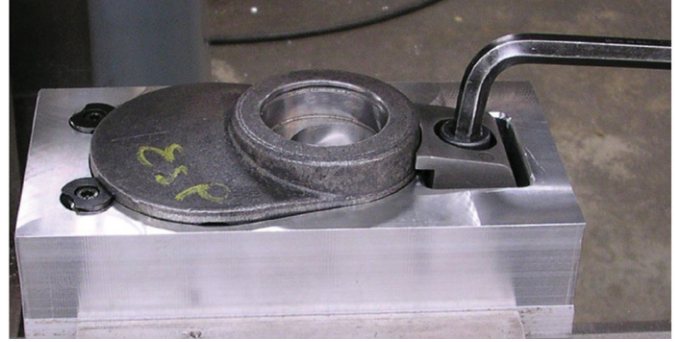
Important Notes

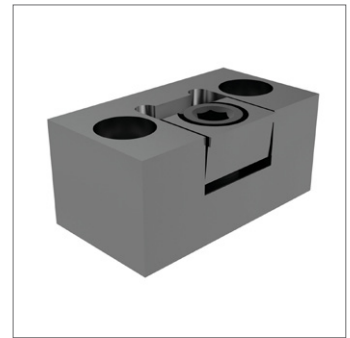
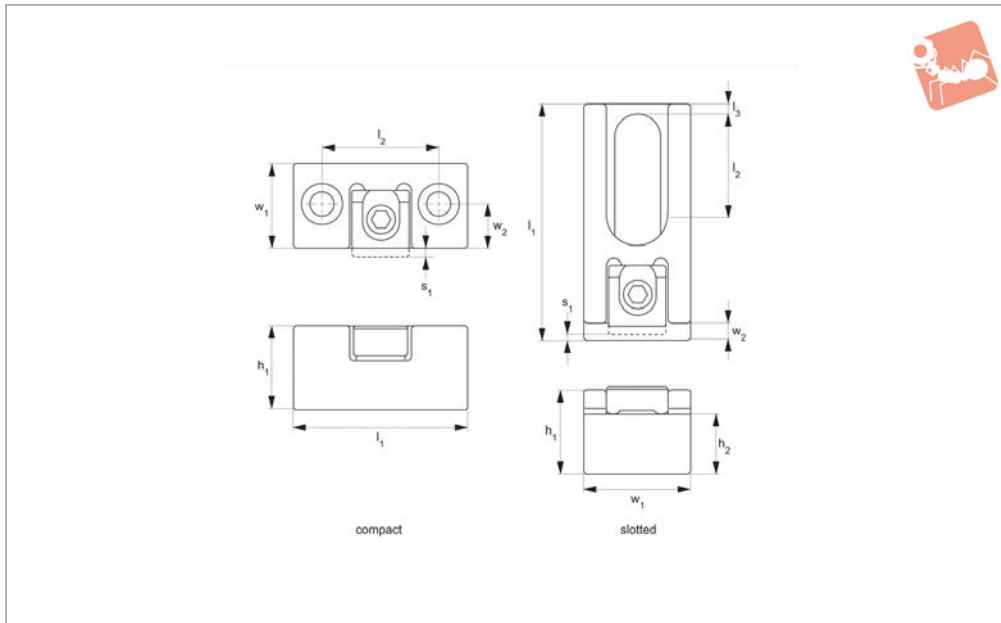
Installation:

1. Machine face of clamp to suit profile of component, taking note of dimension „s₁“ as the max. recommended stock removal. A dowel pin is included in each pack to locate the clamp whilst machining the face. After machining of face, remove pin and install O-ring to clamp workpiece.
2. Machine a slot for the pitbull clamp in the fixture, according to dimensions „l₂“ and „h₂“.
3. Drill and tap a fixing hole to match

4. Assemble clamp as shown in the diagram above.
 5. Position the clamp, and loosely screw to fix.
 6. Load the component and tighten the cap screw.
- Dimension „h₂“ is the minimum recommended clamping height.

Order No.	Qty/pack	d ₁	Stroke max.	h ₁	h ₂	h ₃	l ₁	l ₂	s ₁	Dowel pin dia.	Torque to Nm max.	Holding force kN	Weight g
12032.W0570	4	M10	1.27	11.43	6.4	18.0	10.16	25.4	1.5	3.18	40	26	263
12032.W0580	2	M12	1.90	16.26	9.5	19.6	15.24	38.1	4.5	6.35	145	50	463





12033.1

LOW PROFILE SIDE CLAMPING

Material

Body: steel hardened and ground with pitbull clamps insert (part no. 12031).

Technical Notes

Designed to be used in fixtures, on cubes etc.

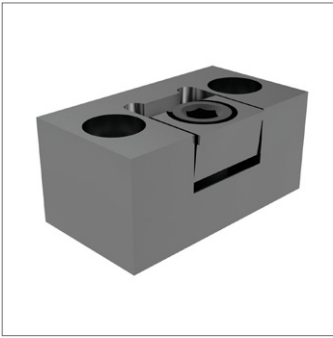
The slotted version has a clamp step to support the workpiece off the machine table for through milling or drilling.

The height of the clamp can be adjusted by varying the depth of the milled slot used to locate the clamp.

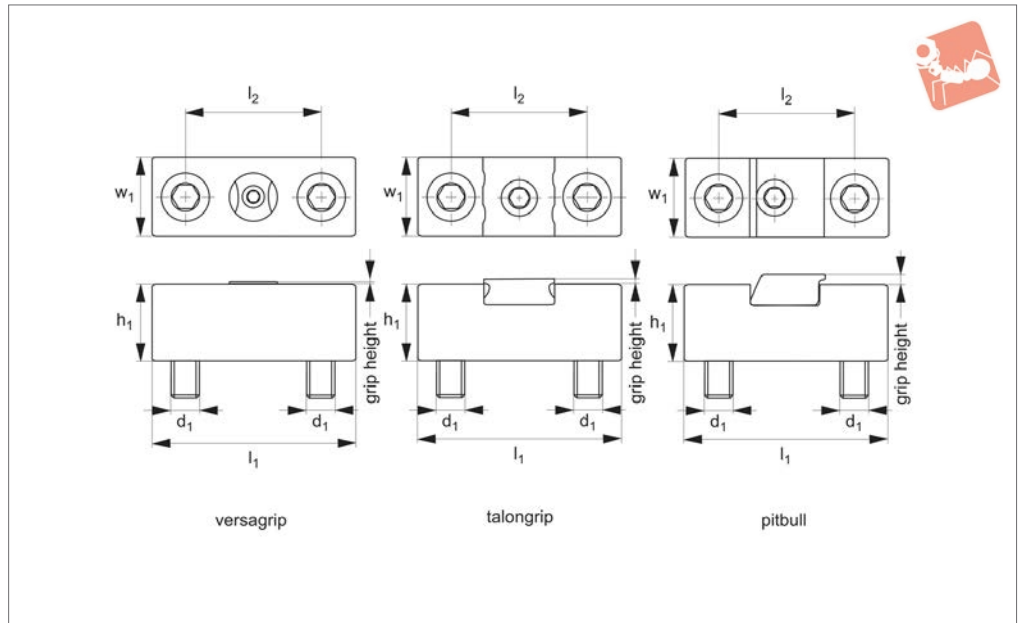
Tips

The compact version is ideal for clamping workpieces in series using the back surface of clamp to locate the next workpiece. Back of clamp is ground square to the bottom for precise part location.

Order No.	Body type	Clamp type	h_1	h_2 +0.000 -0.013	l_1	l_2	l_3	Stroke s_1	w_1	w_2	Torque to Nm max.	Clamping force kN max.	Mounting screw	Replacement clamps 12031	Weight g
12033.W0020	Compact	Knife	25,1		57,1	38,1		0,6	31,2	15,7	22,5	16	M 8	.W0050	
12033.W0025	Compact	Blunt	25,1		57,1	38,1		0,6	31,2	15,7	22,5	16	M 8	.W0060	
12033.W0030	Compact	Knife	31,5		68,6	47,0		1,3	37,6	18,8	40,6	26	M10	.W0070	
12033.W0035	Compact	Blunt	31,5		68,6	47,0		1,3	37,6	18,8	40,6	26	M10	.W0075	
12033.W0040	Slotted	Knife	25,1	18,5	103,6	43,2	12,7	0,6	31,7	9,1	22,5	16	M12	.W0050	12,7
12033.W0045	Slotted	Blunt	25,1	18,5	103,6	43,2	12,7	0,6	31,7	9,1	22,5	16	M12	.W0060	12,7
12033.W0050	Slotted	Knife	40,9	35,0	107,0	37,6	10,9	1,3	38,1	9,1	40,6	26	M16	.W0075	10,9
12033.W0055	Slotted	Blunt	40,9	35,0	107,0	37,6	10,9	1,3	38,1	9,1	40,6	26	M16	.W0075	10,9



12033.2



Material

Hardened and ground steel bodies with pitbull clamps insert (part no. 12031).

Technical Notes

Designed to be used in fixtures, on cubes etc.

The slotted version has a clamp step to

support the workpiece off the machine table for through milling or drilling. The height of the clamp can be adjusted by varying the depth of the milled slot used to locate the clamp.

Tips

The compact version is ideal for clamping

workpieces in series, using the back surface of the clamp to locate the next workpiece.

Back of clamp is ground square to the bottom for precise part location.

Order No.	Clamp type	d ₁	h ₁	l ₁	l ₂	w ₁	Grip height	Replacement clamps
12033.W0150	Versagrip	M12	35	76.2	50	25.4	1,5 to 3,0	12036.W0175
12033.W0155	Talongrip	M12	35	76.2	50	25.4	1,5 to 3,0	12034.W0050
12033.W0160	Pitbull - Knife	M12	35	76.2	50	25.4	6.4	12031.W0060
12033.W0165	Pitbull - Blunt	M12	35	76.2	50	25.4	6.4	12031.W0070
12033.W0170	Pitbull - Mach.	M12	35	76.2	50	25.4	6.4	12032.W0570