12085.2

Material
Body/shank: steel (AISI 4140, 42CrMo4), black oxide finish.
Tapered pin: steel (AISI 4140, 42CrMo4), nitrocarburised.
Knob: stainless steel (AISI 304, 1.4308).

Pin: stainless steel (AISI 303, 1.4305).

Technical Notes
The lifting force is the power of the inner spring of the body to push up the moveable tapered pin.
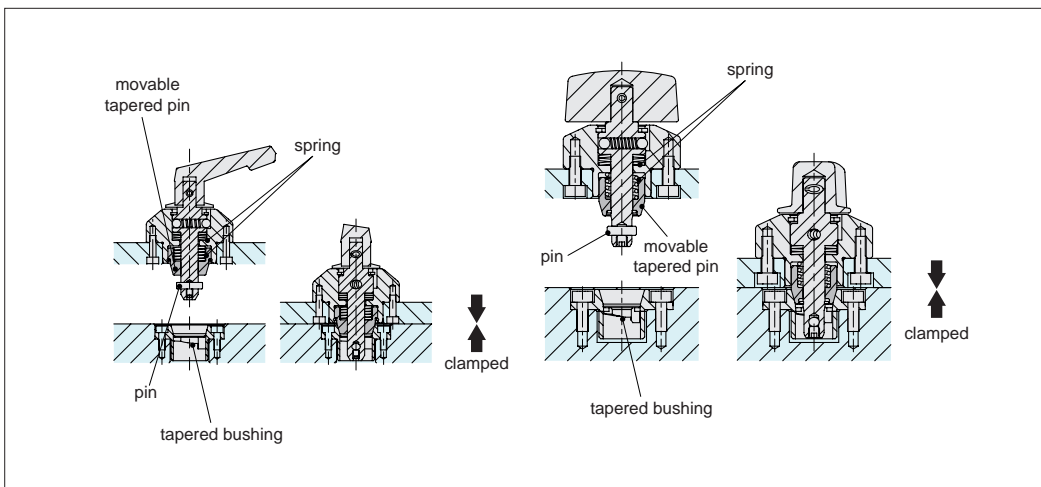
Tips
Flex locator bushing: for .W0206, see part no. 12085.W0506. For .W0208, see part no. 12085.W0508.

Order No.	Size	Clamping force N	d₁	d₂	d₃	d₄	d₅	d₆	d₇	h₁	h₂	h₃	h₄	h₅	h₆	Lifting force N	α	Weight g
12085.W0206	6	350	32	16	5.5	16	33	25.5	M 3x0,5	22	27	7.5	12.0	8	4	30	120°	96
12085.W0208	8	600	40	25	8.0	25	41	34.0	-	26	32	9.5	15.5	10	6	100	130°	211

mounting hole dimension

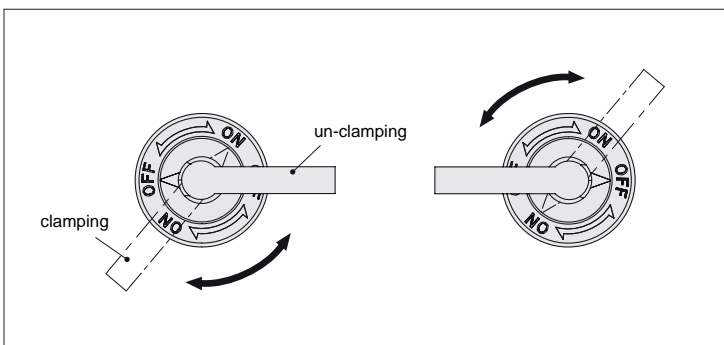**Wixroyd**
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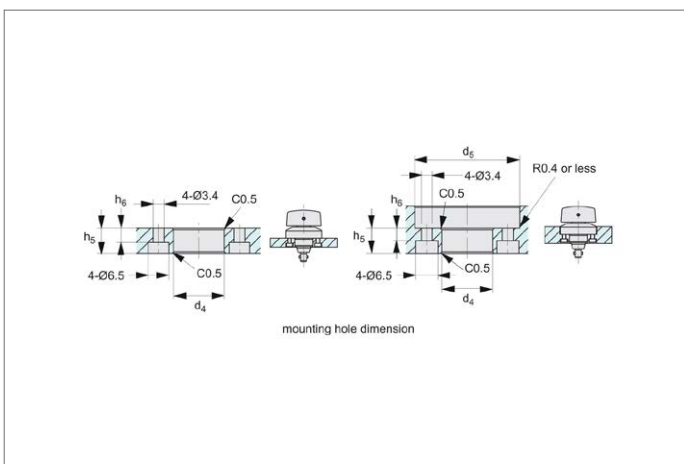
Feature

- The plates are located by fitting the tapered pin and the tapered bushing.
- The pin contacts the cam surface inside the bushing, and it compresses the inner spring, then the plates are clamped.

Note: 12085.W0108 does not have locating function.

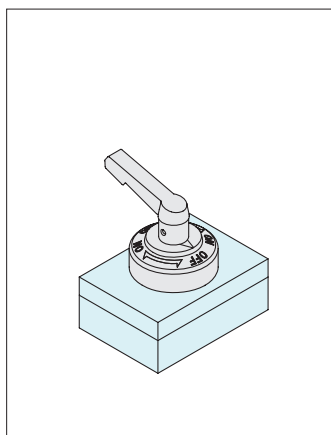Two clamping and unclamping positions of handle can be chosen for 12085.W0008/W0108
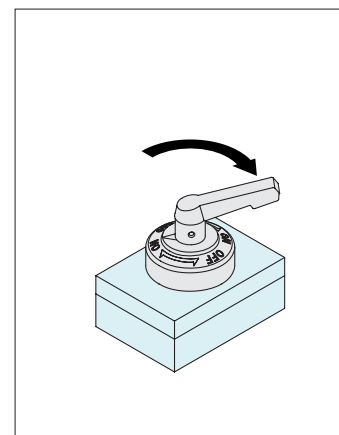
How to Operate
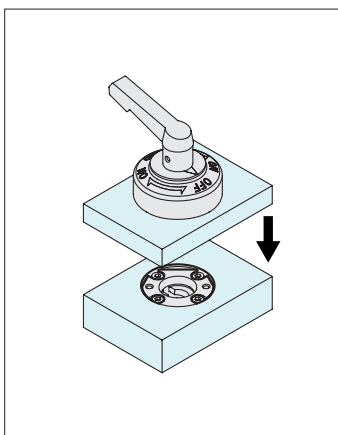
1. Ensure the handle is positioned at 'OFF' mark.

*Follow back these steps for unclamping

*Same operation for knob style.

2. Insert the clamper to the bushing.

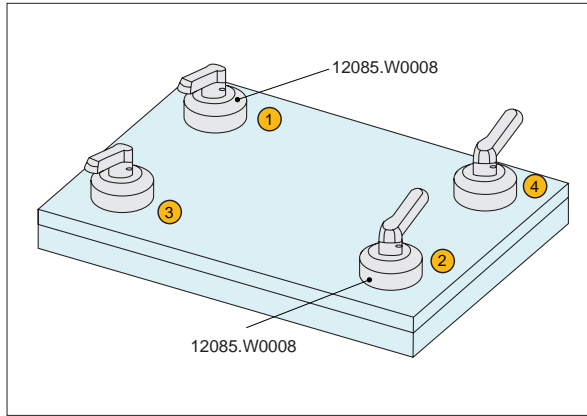**3. Turn the handle to 'ON' mark for clamping.**

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Ensure the handle os positioned at 'OFF' marke and lift down the fixture plate.
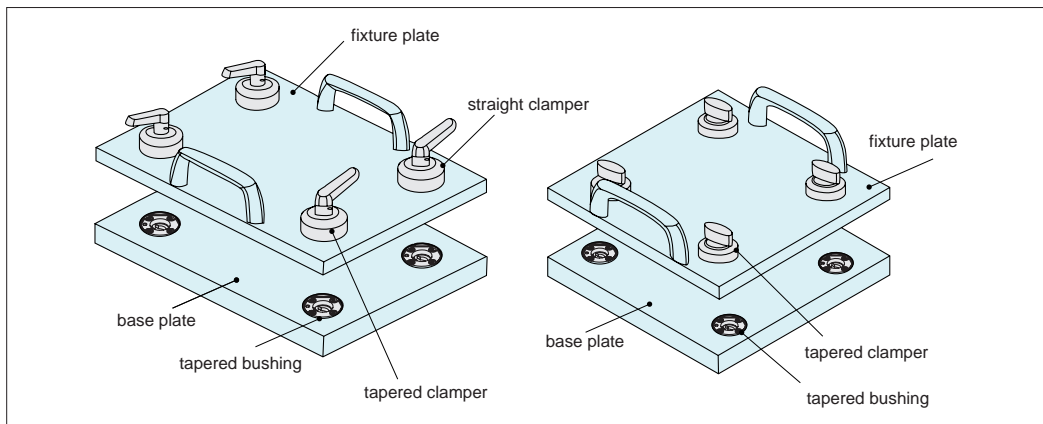
Turn the handle and clamp in order of
① - ② - ③ - ④

*For unclamping, ensure the handle is positioned at 'OFF' mark and disassemble the fixture plate.

If the handles are not tightened in the correct order, the locating repeatability may exceed 10 µ m.
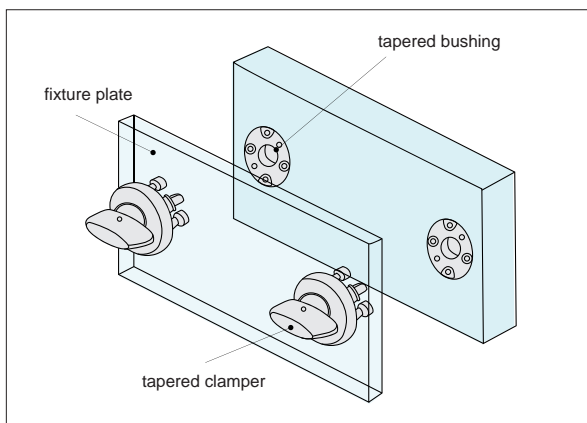
Tightening Order

How to Use

Horizontal Assembly of Fixture Plate

Note: Ensure not to lift the fixture plate up and down with gripping the handle of the clampers.

Clamp and Bush Combination		Max. Loading Capacity (N)
12085.W0206	Ø6	120
12085.W0008	Ø8	400
12085.W0108	Ø8	400
12085.W0208	Ø8	400

Note: The maximum load is the entire sum of the load of fixture plates, fixtures and workpieces.

The maximum loading capacity shown is the value when two sets of tapered clamper and tapered bushing are used.

Vertical Assembly of Fixture Plate

Note: Locating repeatibility is 10 µ m.