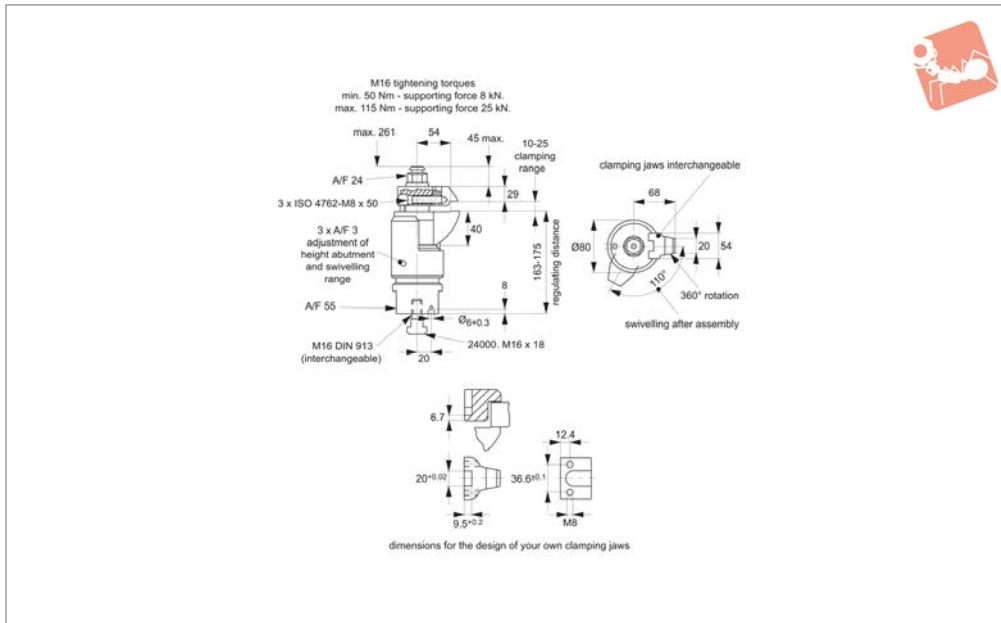




# Floating Clamps M16 combined clamping and locking

# Adjustable Vertical Clamps



## 12664.1

ADJUSTABLE VERTICAL CLAMPS

### Material

Body: steel case-hardened, nitrided 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 extremely pliable work pieces, whilst minimising deformation of component. It also serves to reduce vibration during machining.

### Tips

Alternative clamping jaws available, see part 12664.W0060 to W0066.

### Floating clamp benefits:

Floating clamp 12664.1 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 onto machine bed with A/F 46 spanner. Clamp has 16mm 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 in to component as far as possible. Clamp will contact bottom of component with only low spring pressure.
3. Tighten floating clamp with A/F 24mm hex nut - torque 50Nm, 115Nm max. **In the clamping process the workpiece is clamped and simultaneously supported.**
4. To release, reverse steps 3 to 1.

Order No.	Type	Weight
12664.W0016	Steel	g 6250