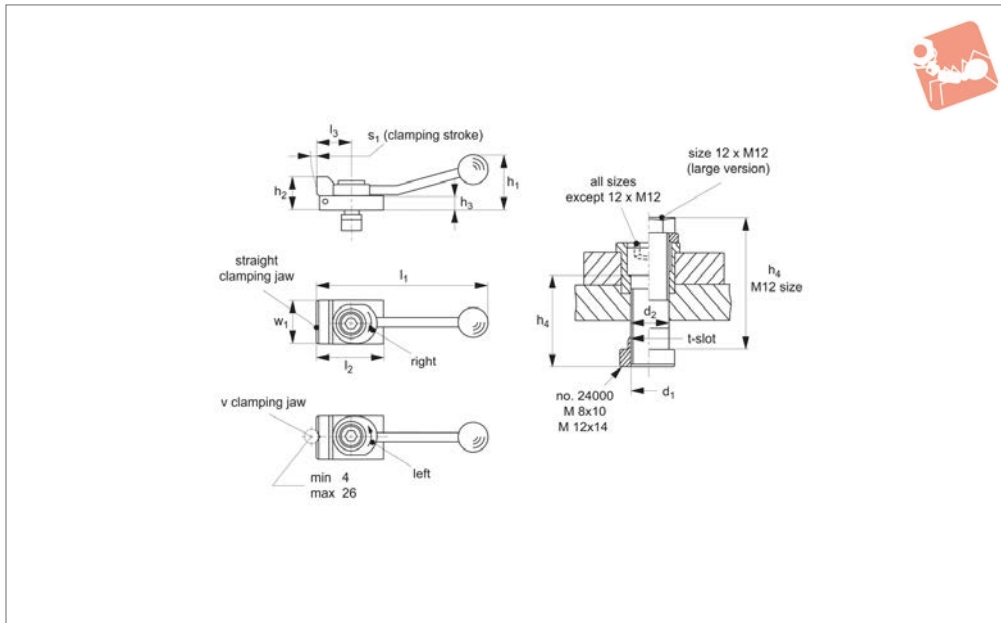




Downhold Clamps with cranked clamping lever

Low Profile Side Clamping



12400

LOW PROFILE SIDE CLAMPING

Material

Steel, case-hardened, blackened.

Technical Notes

For quick clamping from the side. The clamps give forwards and downwards clamping forces.

Tips

Can bridge T-slots when used with holding plate no. 12410. The clamps low profile enables full-face machining. Often used in conjunction with cylindrical stops and bedding supports.

Supplied with standard T-nut. Clamps can be used in other T-slot sizes by selecting T-nuts no. 24000 as required, e.g. M 8x12, M 8x14, M12x16, M12x18.

Order No.	For T-slot	Type	h_1	h_2	h_3	h_4	l_1	l_2	l_3	d_1	d_2	Stroke s_1	w_1	Clamping force horizontal kN max.	Weight g
12400.W0101	10	Straight Jaw, Clamps Right	20	30	8	40	132	50	32	M 8	8,4	3	32	3,5	262
12400.W0321	12	Straight Jaw, Clamps Right	38	60	16	62	190	72	40	M12	12,5	4	48	7,0	870
12400.W0341	14	Straight Jaw, Clamps Right	38	40	16	62	190	72	40	M12	12,5	4	48	7,0	845
12400.W0105	10	Straight Jaw, Clamps Left	20	30	8	40	132	50	32	M 8	8,4	3	32	3,5	262
12400.W0325	12	Straight Jaw, Clamps Left	38	60	16	62	190	72	40	M12	12,5	4	48	7,0	868
12400.W0345	14	Straight Jaw, Clamps Left	38	40	16	62	190	72	40	M12	12,5	4	48	7,0	847
12400.W0102	10	V-Jaw, Clamps Right	20	30	8	40	132	50	32	M 8	8,4	3	32	3,5	263
12400.W0322	12	V-Jaw, Clamps Right	38	60	16	62	190	72	40	M12	12,5	4	48	7,0	893
12400.W0342	14	V-Jaw, Clamps Right	38	40	16	62	190	72	40	M12	12,5	4	48	7,0	838
12400.W0106	10	V-Jaw, Clamps Left	20	30	8	40	132	50	32	M 8	8,4	3	32	3,5	264
12400.W0326	12	V-Jaw, Clamps Left	38	60	16	62	190	72	40	M12	12,5	4	48	7,0	900
12400.W0346	14	V-Jaw, Clamps Left	38	40	16	62	190	72	40	M12	12,5	4	48	7,0	841

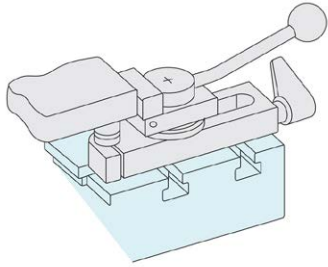
Low Profile Side Clamping

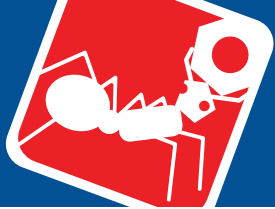


Downhold Clamps with cranked clamping lever



LOW PROFILE SIDE CLAMPING

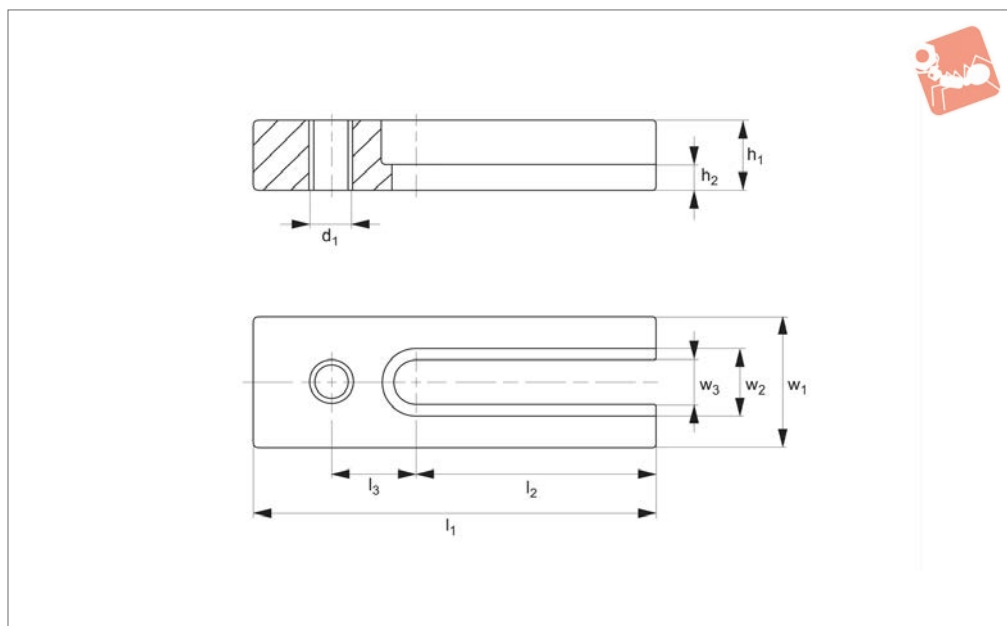




Holding Plates

for downhold clamps nos. 12400 & 12420

Low Profile Side Clamping



12410

LOW PROFILE SIDE CLAMPING

Material

Steel, heat treated, blackened.

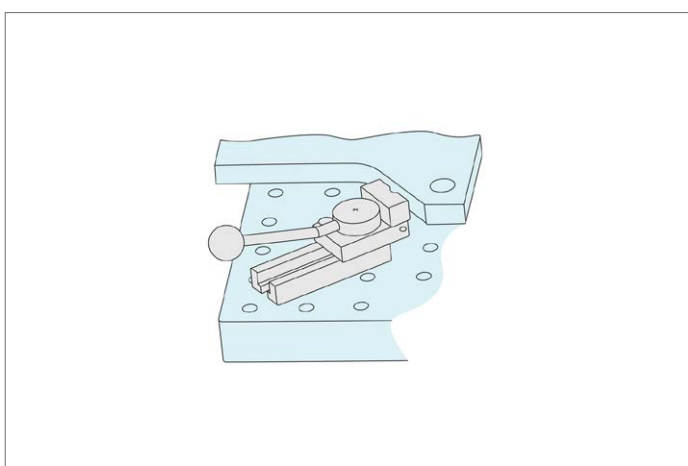
Technical Notes

For use with clamps nos. 12400 and 12420.

Tips

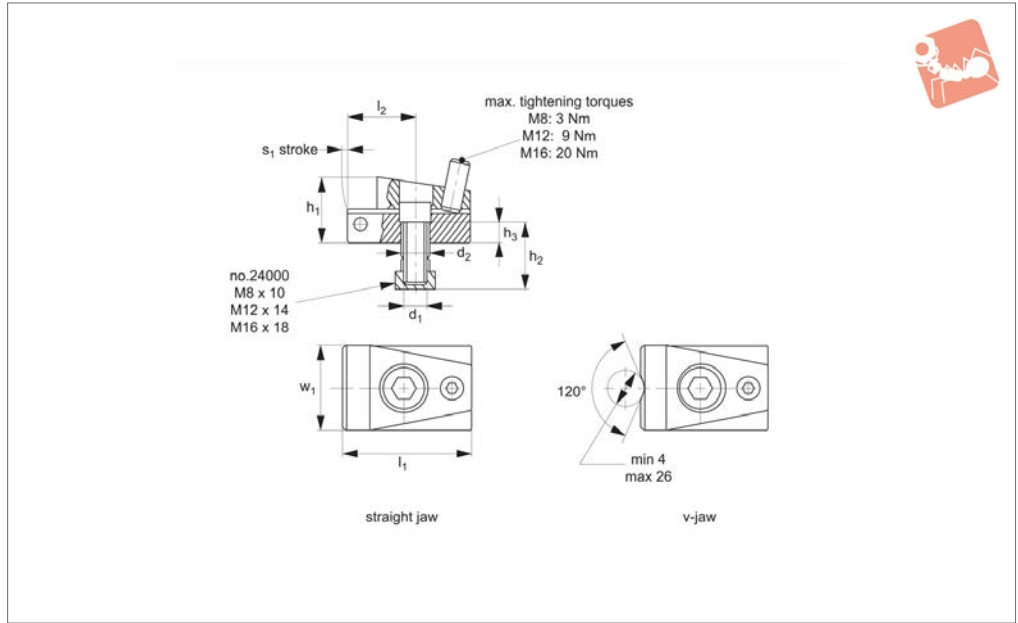
Allows downhold clamps to be placed in any desired position, across T-slots etc.

Order No.	h_1 -0.4	h_2	l_1	l_2	l_3	d_1	w_1	w_2	w_3	Weight g
12410.W0730	15	6.5	100	63	20	M 8	30	15	9	246
12410.W0740	20	7.5	120	72	25	M12	40	20	13	515
12410.W0760	30	13.0	140	80	30	M16	60	26	17	1456
12410.W0770	40	18.0	200	110	50	M20	80	32	21	3900
12410.W0780	50	24.0	220	130	55	M24	90	38	25	5850





12420



Material

Steel, ground, case-hardened and blackened.

Technical Notes

Actuate by self-aligning screw on top, rear of the clamp. Extremely high clamping

forces, as the clamp pivots forwards and downwards to securely hold the workpiece. **T-nuts no. 24000 allow the clamps to be used in a variety of T slot sizes.**

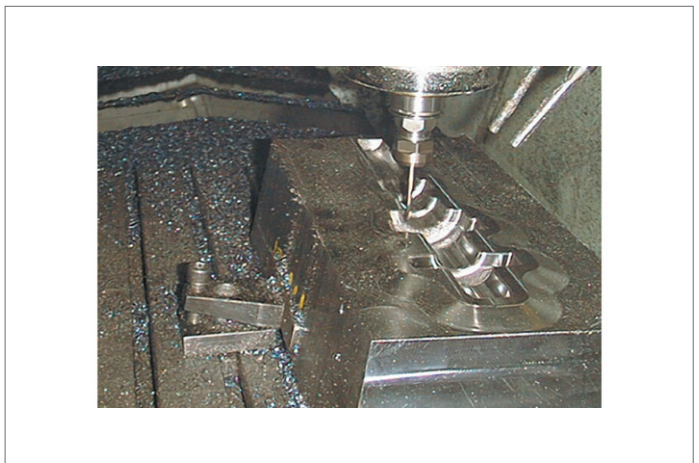
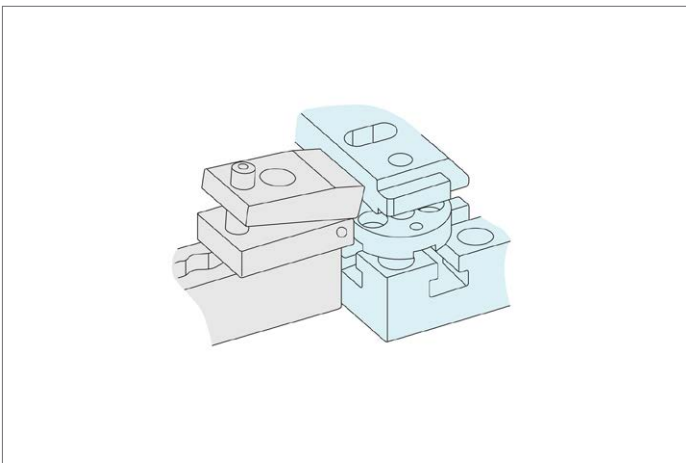
Tips

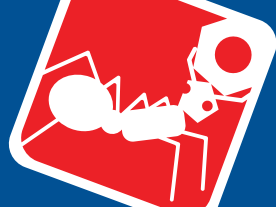
Do not over torque clamping screw as

this can result in the stripping of the thread. For recommended torques - please see table.

May be used with holding plate no. 12410.

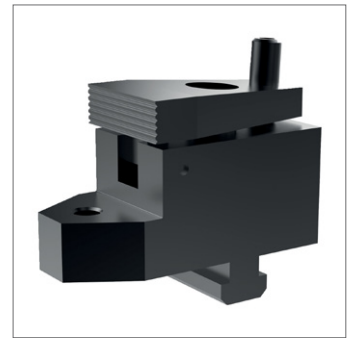
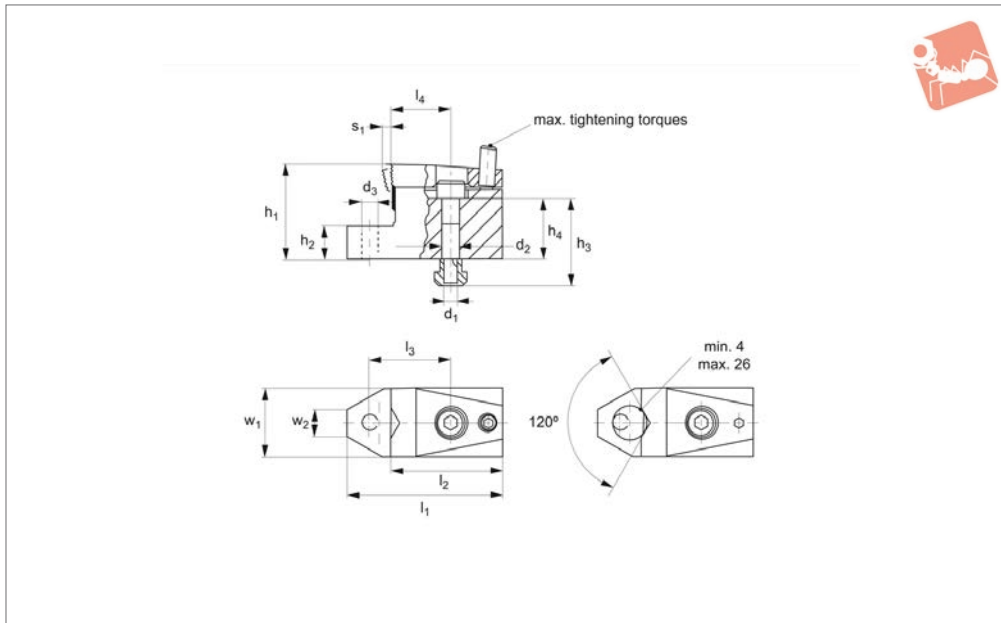
Order No.	For T-slot	Type	h_1	h_2	h_3	l_1	l_2	d_1	d_2	Stroke s_1	w_1	Clamping force horizontal kN max.	Torque to Nm max.	Weight g
12420.W0501	10	Straight Jaw	24	20	8	52	28,0	M 8	8,4	3	32	7,0	3	276
12420.W0521	14	Straight Jaw	37	30	11	72	40,0	M12	12,5	4	48	15,0	9	831
12420.W0541	18	Straight Jaw	47	35	13	86	41,0	M16	16,5	7	68	21,5	20	1749
12420.W0502	10	V-Jaw	24	20	8	52	28,0	M 8	8,4	3	32	7,0	3	266
12420.W0522	14	V-Jaw	37	30	11	72	40,0	M12	12,5	4	48	15,0	9	833
12420.W0542	18	V-Jaw	47	35	13	86	41,0	M16	16,5	7	68	21,5	20	1730





Downhold Clamps with support ledge

Low Profile Side Clamping



12422

LOW PROFILE SIDE CLAMPING

Material

Steel, case-hardened, blackened, ground.

Technical Notes

By tightening the ball-ended thrust screw the workpiece is simultaneously pressed towards the stops and fixture plate. This

pivoting action enables high horizontal clamping forces. The integrated support has a thread suitable for rest buttons.

Tips

Do not over torque clamping screw as this can result in the stripping of the

thread. For recommended torques - please see table.

May be used with holding plate no. 12410.

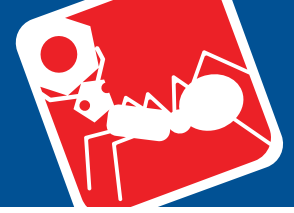
Order No.	For T-slot	Jaw type	h_1	h_2 ± 0.01	h_3 \approx	h_4 \approx	l_1	l_2	Weight g
12422.W0051	10	Straight Jaw	44	15	40	28	52	28	556
12422.W0061	14	Straight Jaw	53	15	45	27	72	40	1342
12422.W0071	18	Straight Jaw	72	20	60	38	86	41	3149
12422.W0052	10	V- Jaw	44	15	40	28	52	28	553
12422.W0062	14	V- Jaw	53	15	45	27	72	40	1324
12422.W0072	18	V- Jaw	72	20	60	38	86	41	3100

Order No.	l_3	l_4	d_1	d_2	d_3	Stroke s_1	w_1	w_2	Clamping force horizontal kN max.	Tightening torque Nm max.
12422.W0051	72.5	38	M 8	8.4	M 8	3	32	12.1	7.0	3
12422.W0061	100.0	55	M12	13.0	M12	4	48	16.0	15.0	9
12422.W0071	126.0	63	M16	17.0	M16	7	68	18.8	21.5	20
12422.W0052	72.5	38	M 8	8.4	M 8	3	32	12.1	7.0	3
12422.W0062	100.0	55	M12	13.0	M12	4	48	16.0	15.0	9
12422.W0072	126.0	63	M16	17.0	M16	7	68	18.8	21.5	20

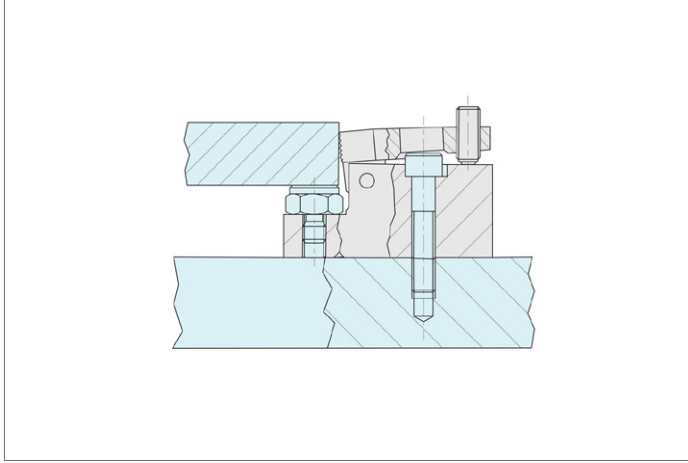
Low Profile Side Clamping

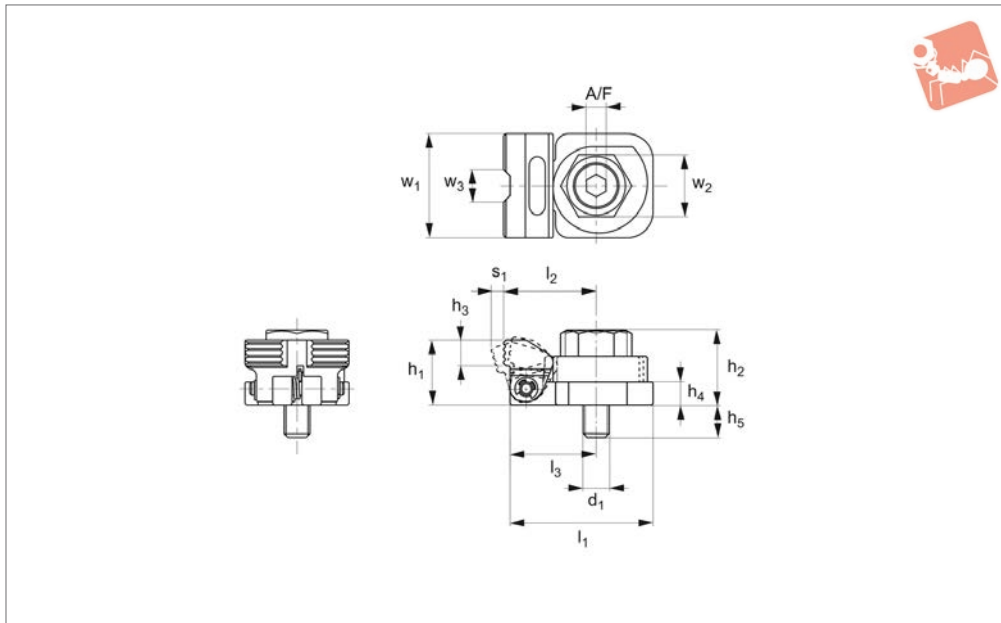
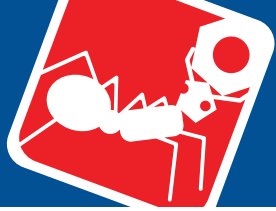


Downhold Clamps with support ledge



LOW PROFILE SIDE CLAMPING





12426

LOW PROFILE SIDE CLAMPING

Material

Body/jaw: steel (42CrMo), tempered and black oxide finish.

Cam: steel (C45), tempered and black

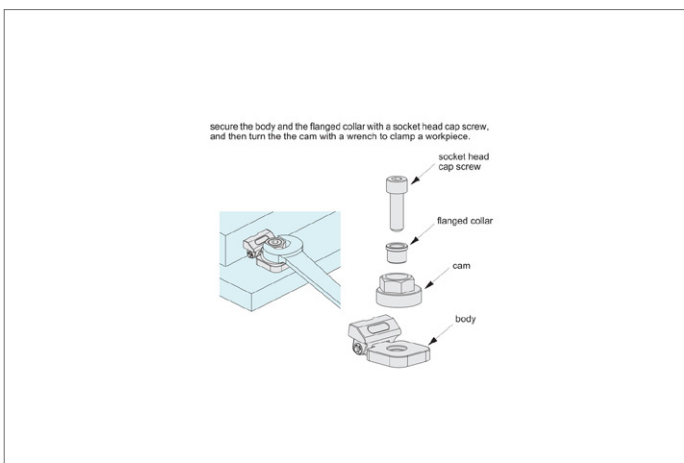
oxide finish.

Technical Notes

Secure the body and the flanged collar

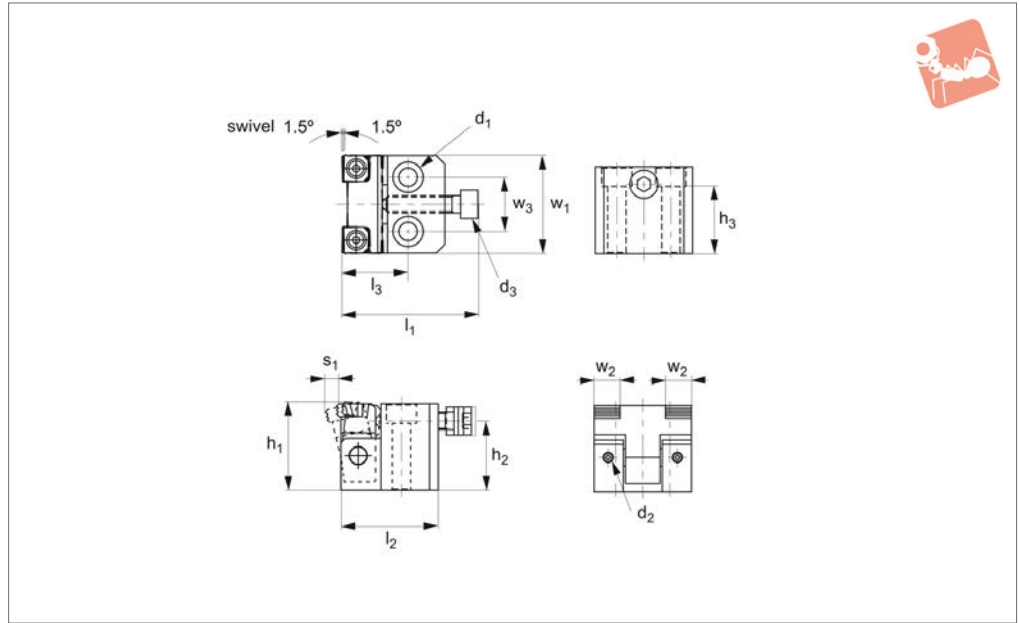
with a socket head cap screw. Turn the cam with a wrench to clamp a workpiece.

Order No.	h_1	h_2	h_3	h_4	h_5	l_1	l_2	l_3	d_1	Stroke s_1	w_1	w_2	w_3	A/F	Clamping force kN max.	Torque to Nm max.	Weight g
12426.W0032	20	23	8	7	15	44	28,5	26,5	M 8x30	4,0	32	19	10	6	3,5	45	160
12426.W0040	25	29	10	9	16	54	35,0	33,0	M10x35	5,0	40	24	12	8	5,5	55	310
12426.W0046	30	35	12	11	17	62	39,5	37,5	M12x40	5,5	46	27	14	10	7,0	70	490





12428



Material

Body: steel (C45), black oxide finish.
 Arm: steel (C45), tempered and black oxide finish.
 Jaw: steel (SKH51), tempered and black oxide finish.

Technical Notes

The jaw swivels to align to an unmachined surface of the workpiece. The jaw is replaceable.
 For mounting, use a cap screw to suit d_1

Tips

For replacement jaws, see part nos. 35520.W0303, 35520.W0306 and 35520.W0310.

Order No.	h_1	h_2	h_3	l_1	l_2	l_3	d_1	d_2	d_3	Stroke s_1	w_1	w_2	w_3	Clamping force kN max.	Torque to Nm max.	Weight g
12428.W0012	40	32	31	62.5	45	30	M 8	M 4x4	M 8x35	5.3	45	12	25	15	25	0.6
12428.W0016	50	40	39	74.0	55	40	M10	M 4x4	M10x40	7.1	55	16	30	27	50	1.0
12428.W0020	60	48	47	91.0	65	45	M12	M 5x5	M12x50	8.0	65	20	35	38	90	1.7

