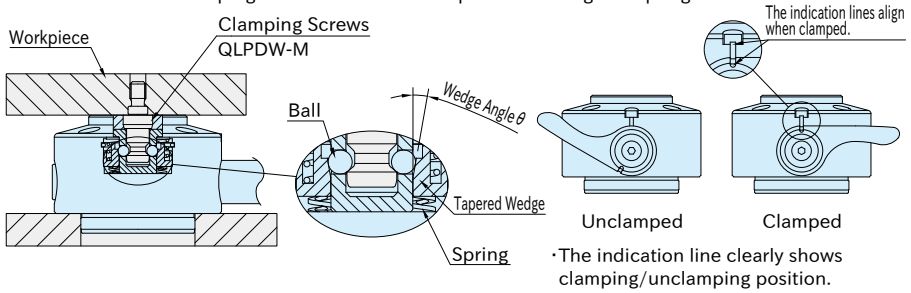


Feature

- By turning the handle, the balls are pushed out by the tapered surface and pull down the clamping pin.
- Provides constant clamping force with mechanical positive locking and spring force.

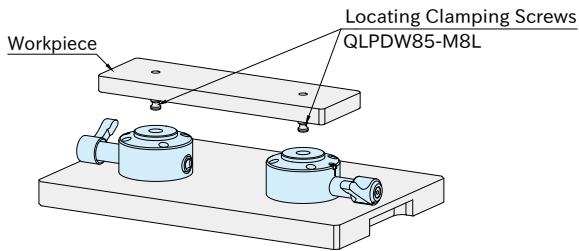


How To Use

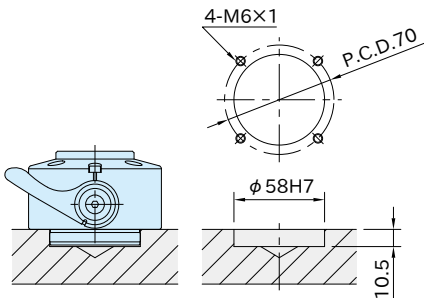
Application Example

If positioning is required, use locating clamping screws.

*) When clamping at three or more points, use locating clamping screws at two points and standard clamping screws at all other points.

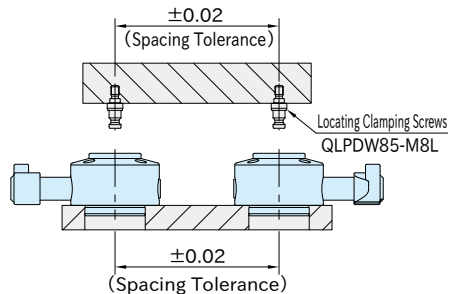


Mounting Hole Dimension



How to Locate Workpiece

Repeatability ± 0.02

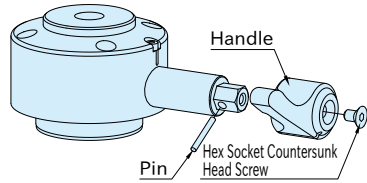


How to Remove Handle

To use two units connected together or to use an extension unit, the handle needs to be removed. Follow the steps below.

1. Remove the hex socket countersunk head screw, and then remove the handle.
2. Remove the pin.

For installation, follow back these steps.



Clamp Connection and Linkage

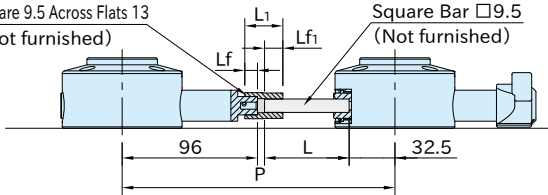
The Stablelock Pull Clamps must be connected in unclamping position.

The distance of the mounting holes "P" must be determined by the customer.

The length of the square bar "L" must be determined according to the socket used.

Socket

Square 9.5 Across Flats 13
(Not furnished)



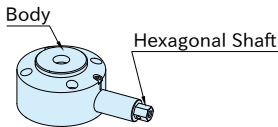
The length of Square Bar

$$L = P - 96 - 32.5 - (L_1 - L_f - L_{f1}) - 1$$

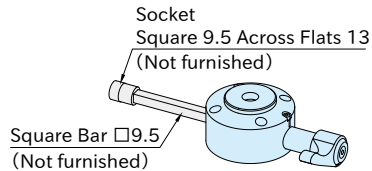
Socket size

Clearance for Square Bar

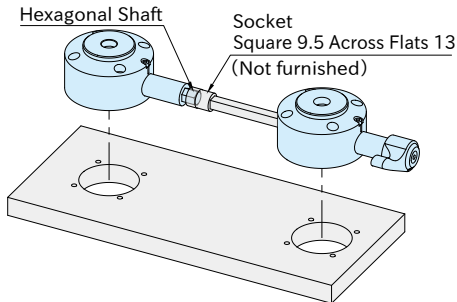
1. Remove the handle from one of the Stablelock Pull Clamps.



2. Attach the square bar and socket to another clamp.

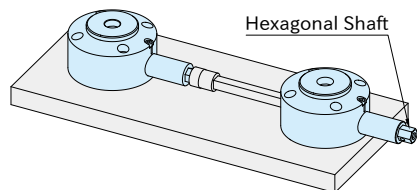
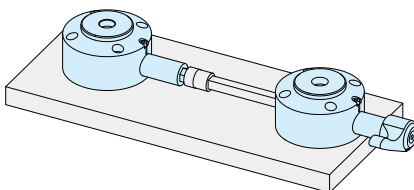


3. Insert the socket into the hexagonal shaft and mount both clamps into the mounting holes and secure. The handle removed in step 1 is not used.



Coupling two clamps doubles the handle operating load.

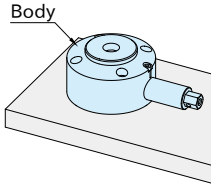
If the lever operation is too hard, the hexagonal shaft can be operated directly with a socket wrench.



■ Extension of Operating Part

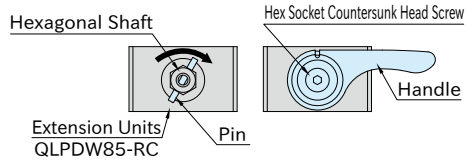
The Stablelock Pull Clamps must be connected in unclamping position.

1. Fix the body with the handle removed.



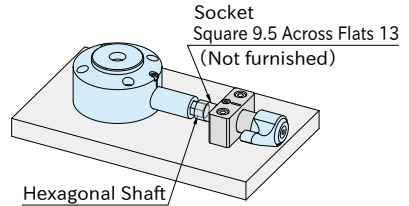
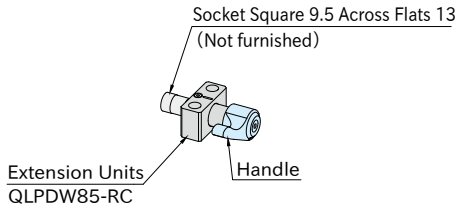
2. Turn the hexagonal shaft on the Extension Units to the right until it stops.

Mount the handle in the direction shown below, and fix it with a hex socket countersunk head screw.

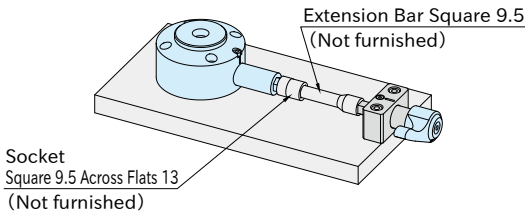


3. Turn the handle to unclamping position, and insert a socket into the Extension Units.

4. Insert the socket into the hexagonal shaft, and fix the Extension units.



Add extension bars to extend further.



Technical Information

■ Allowable Loads in Machining of Workpiece Bottom

Ensure that any force more than max.5kN is not applied to the workpiece bottom.

