

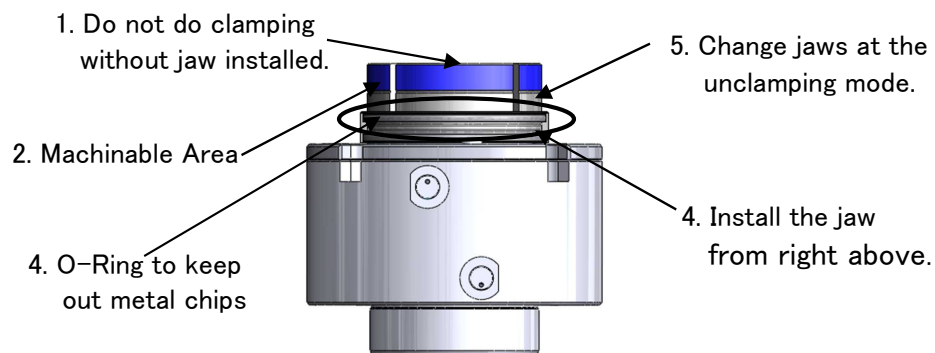
PNEUMATIC OD HOLDING CLAMPS

INSTRUCTIONS

AMCH080-5W
AMCH100-5W

Precautions :

1. Do not actuate clamping without a workpiece inserted, to avoid damage and deformation.
2. Do not machine the jaw beyond the machinable area.
3. Check if the O-Ring is fitted properly before installing the jaw.
4. The O-Ring can make it hard to insert the jaw.
Insert the Jaw completely from right above.
5. Apply air pressure to the unclamping port to change jaws.



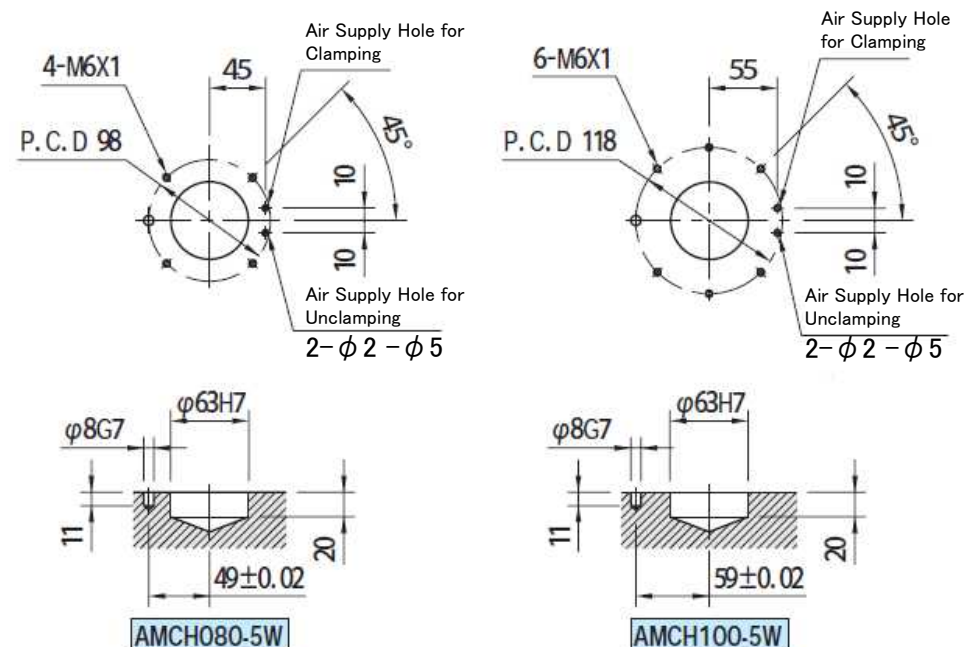
- Use clean air by removing moisture and debris with an air dryer and air filter.
- Impurities in the compressed air can cause malfunction.

Specifications :

Part Number	Cylinder I.D. (mm)	Operating Air Pressure(MPa)	Side Port	Bottom Port	Clamping Force (kN)	Weight (kg)
AMCH080-5W	80	0.5 (0.45~0.55)	Rc1/8	CO 00002(P5)	4	4.2
AMCH100-5W	100			NOK	6	6

Part Number	Mounting Screw	Locating Pin	Jaw Mounting Screw	O-Ring for Jaws	Proper Jaws
AMCH080-5W	SHCS M6 × 55L	IMAO BJ722-08001	SHCS M8 × 15L	CO 0544(S65)NOK	CP121-06501
AMCH100-5W			SHCS M10 × 20L	CO 0551(S90)NOK	CP121-09001

Fixture-Plate Machining Instructions



Installation Instructions

1. Body Setting

(1) 2 Options of Port Positions : Side Port and Bottom Port

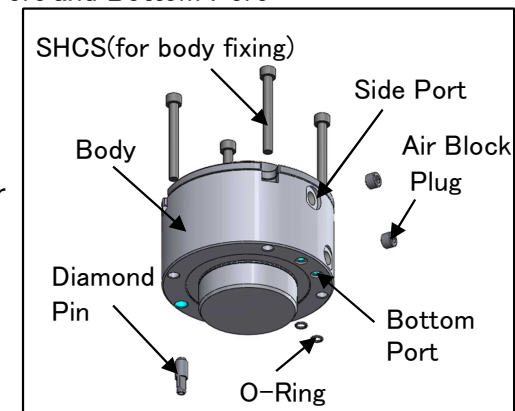
•To Use with Side Port

Remove the air block plug from the side port, and then fit a R1/8 coupler.

•To Use with Bottom Ports

Supply air through the air supply hole for clamping, to the bottom port.

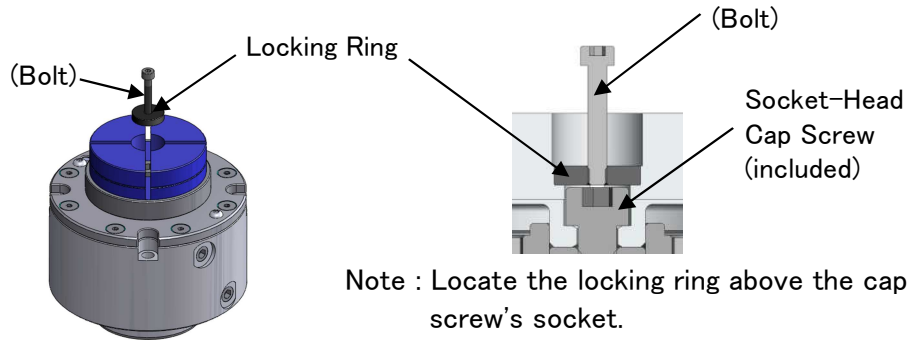
Note :See “Fixture-Plate Machining Instructions” for the size and location of the air supply hole.



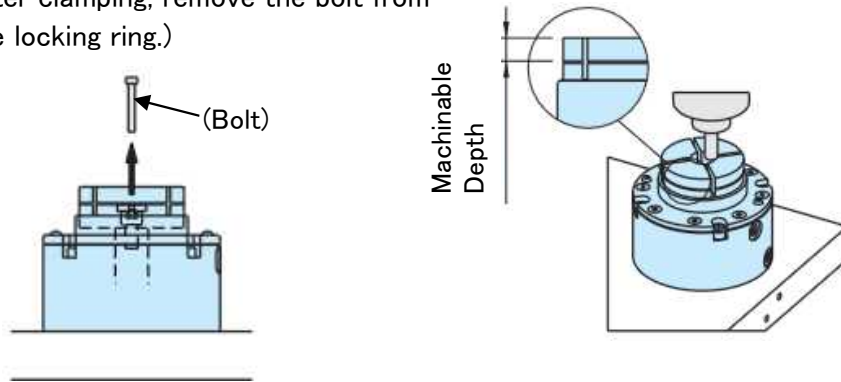
- (2) Fit the included O-ring to the bottom port.
- (3) Insert a diamond pin to the body and secure the body to the fixture plate using hex socket head cap screws.
Note) Plate surface must be flat ($\sqrt{6.3}$) to get the bottom ports sealed up.

2. Jaw Machining

- (1) Set the locking ring in the jaw.
(Using a bolt facilitates setting.)

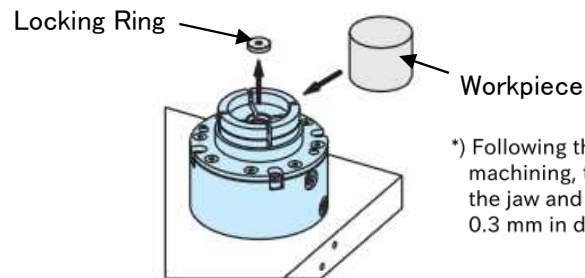


- (2) Apply air to the clamping port to clamp the locking ring.
(After clamping, remove the bolt from the locking ring.)
- (3) Machine the jaw to the contours of a workpiece.



3. Workpiece Setting

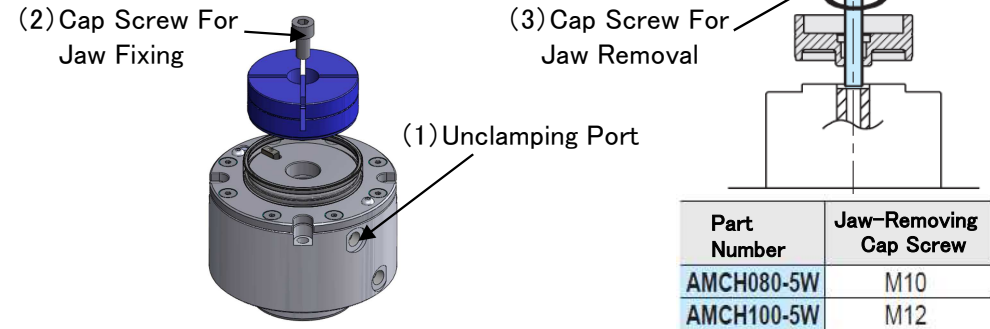
- (1) After machining, apply air to the unclamping port to remove the locking ring.
- (2) Mount a workpiece and then apply air to the clamping port for clamping.



*) Following the above steps for jaw machining, the clearance between the jaw and the workpiece will be 0.3 mm in diameter.

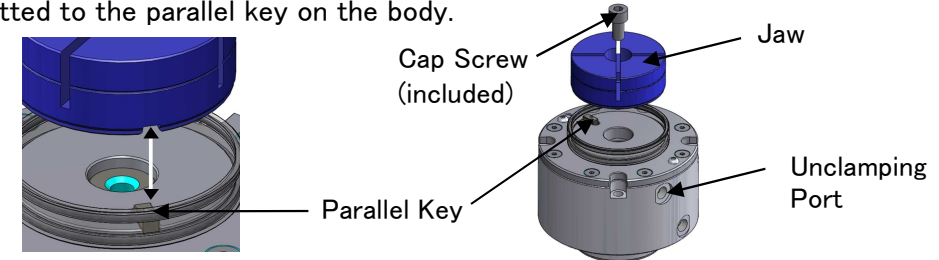
Jaw Removing

- (1) Apply air pressure to the unclamping port.
- (2) Remove the socket-head cap screw for jaw fixing.
- (3) Screw a bolt of thread size shown below into the jaw-removing tapped hole to push it against the body, for easier removal.



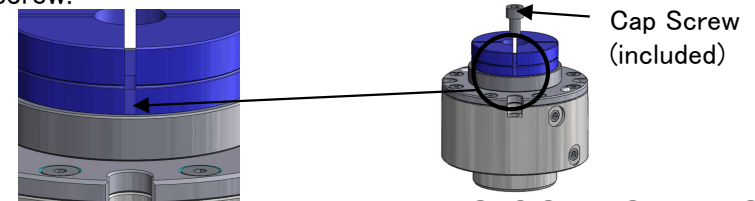
Jaw Setting

- (1) Push the jaw into the body from right above with the keyway in the jaw fitted to the parallel key on the body.



Note : Jaw setting must be done with the unclamping port pressurized.

- (2) Once the jaw is positioned properly, fasten the jaw with the included cap screw.



Note : Ensure the slit bottom is flush with the top of the body cover at all four places, as shown above.

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