

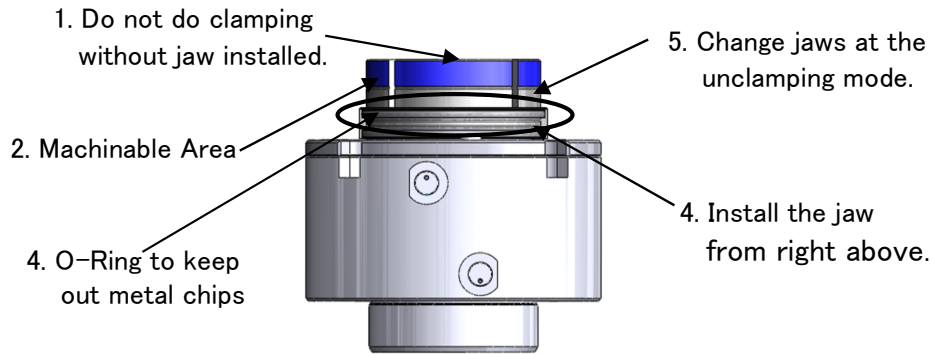
# PNEUMATIC OD HOLDING CLAMPS

## 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.



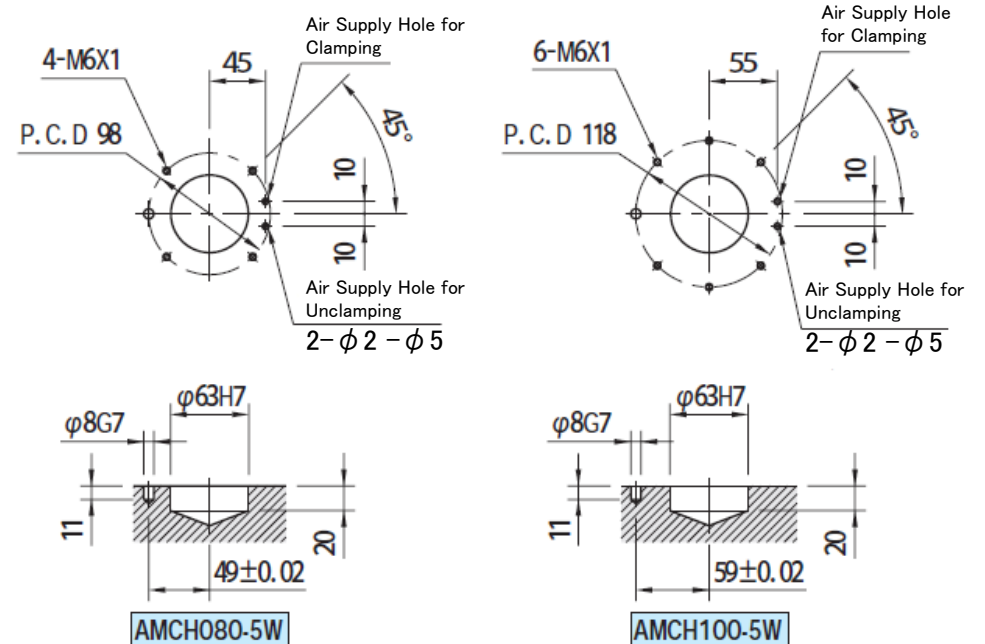
- Use clean air by removing dust with filter or draining with dryer.
- Impure compressed air may cause malfunction of the products.
- Using lubricator is recommended.

### 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	Rc1/8	CO 00002(P5)	4	4.2
AMCH100-5W	100	(0.45~0.55)	Rc1/8	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	M6 × 55L	BJ722-08001	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

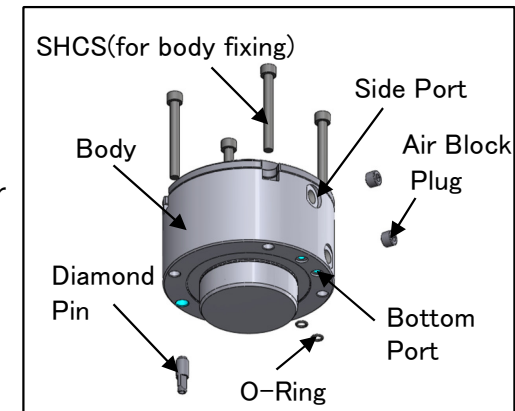
#### •To Use with Side Port

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.



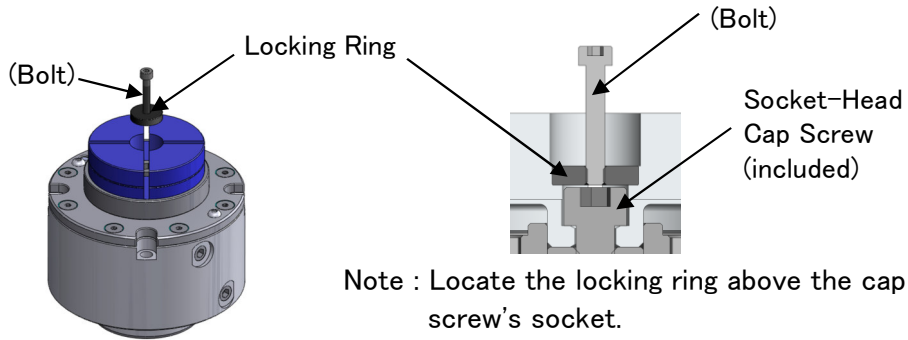
(2) Fit the included O-ring to the bottom port.

(3) Insert a diamond pin to the body and secure the body to the fixture plate using hex socket head cap screws.

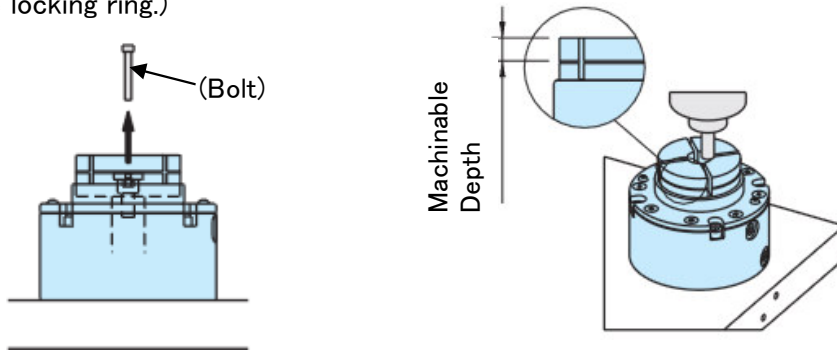
Note) Plate surface must be flat ( $\sqrt{6.3}$ ) to get the bottom ports sealed up.

## 2. Jaw Machining

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

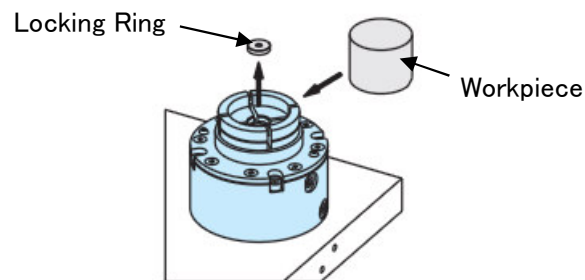


- (2) Apply air to the clamping port to clamp the locking ring.  
 (After clamping, remove the bolt from the locking ring.)
- (3) Machine the jaw to the contours of a workpiece.



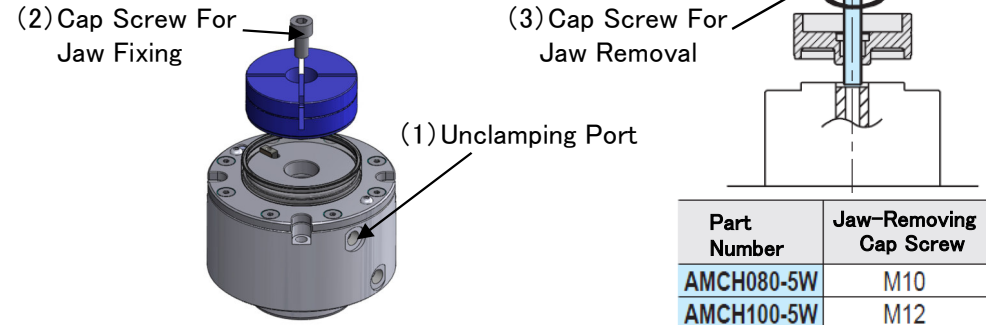
## 3. Workpiece Setting

- (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.



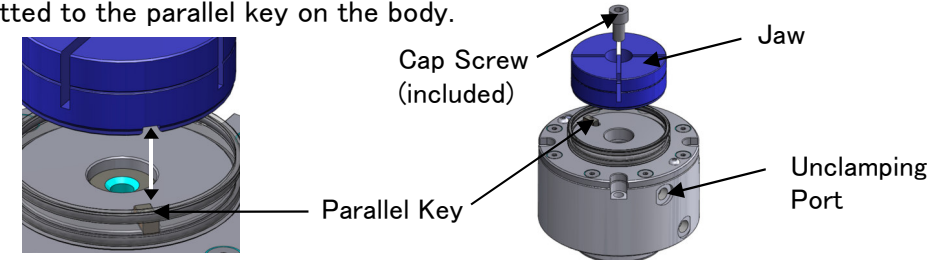
## Jaw Removing

- (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.



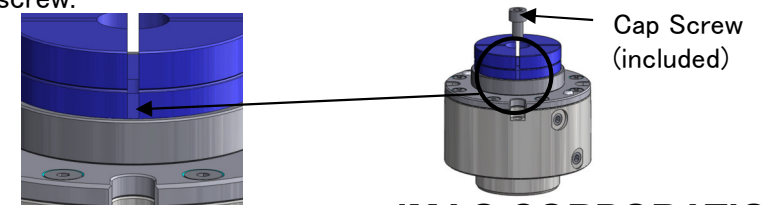
## Jaw Setting

- (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.

**IMAO CORPORATION**  
**【CONTACT US】**

Export Sales Team

<https://www.imao.com/en/contact-us/>