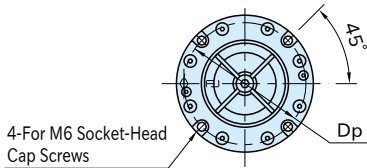


AMCH-W

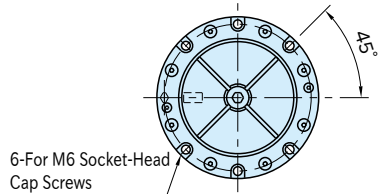
PNEUMATIC OD HOLDING CLAMPS



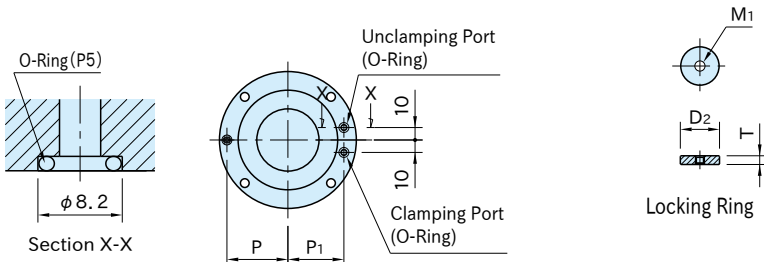
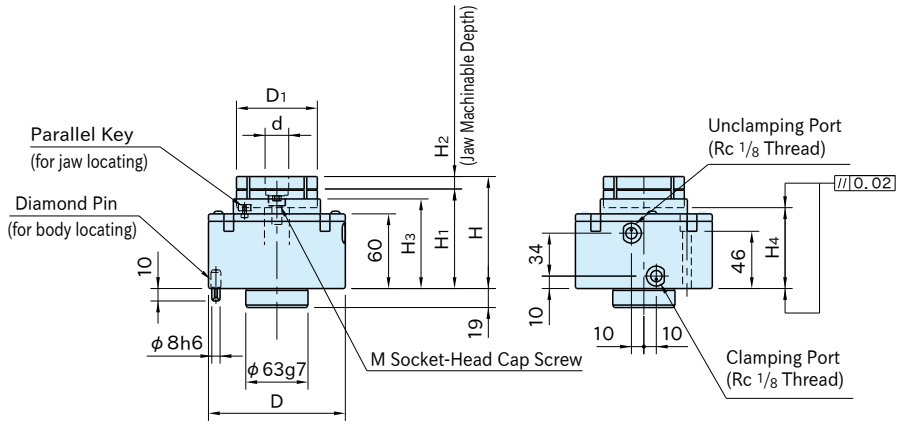
Body	Jaw
S45C steel Electroless nickel plated	A7075 aluminum Anodized Blue



AMCH080-5W



AMCH100-5W



Part Number	D ₁	d	H	H ₂	D	H ₁	H ₃	H ₄ (±0.02)	Dp	P (±0.02)	P ₁	M	M ₁
AMCH080-5W	65	19	90	10	110	80	72	65	98	49	45	M 8×1.25-15L	M4×0.7
AMCH100-5W	90	23	100	15	130	85	74	66	118	59	55	M10×1.5 -20L	M5×0.8

Part Number	D ₂	T	Furnished O-Ring	Operating Air Pressure(MPa *)	Clamping Force (kN **)	Weight (kg)
AMCH080-5W	18	4	P5	0.5	4	4.2
AMCH100-5W	22	6			6	6

*) Operating air pressure range: 0.45 - 0.55 MPa.

**) The clamping forces above are at 0.5 MPa.

Supplied With

- 1 of locking ring
- 2 of O-Ring
- 1 of diamond pin

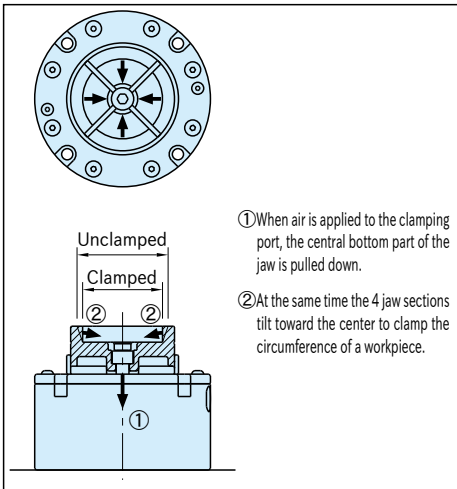
Technical Information

- Workpiece locating repeatability : ±0.03
- Jaw locating repeatability : ±0.02

Note

- Do not actuate clamping without a workpiece inserted to avoid damage and deformation.
- Do not machine the jaw beyond the machinable area.
- Changeable Jaws [CPI21](#) are available.
- Use clean air by removing moisture and debris with an air dryer and air filter.
- Impurities in the compressed air can cause malfunction.

Feature



- The diaphragm clamping mechanism allows securely clamping a workpiece with 4 jaw sections.
- Different irregularly-shaped workpieces can be clamped.
- The allowable compression diameter is 0.6 mm, making it ideal for lost wax, die cast, extruded, drawn, and premachined workpieces.

① When air is applied to the clamping port, the central bottom part of the jaw is pulled down.

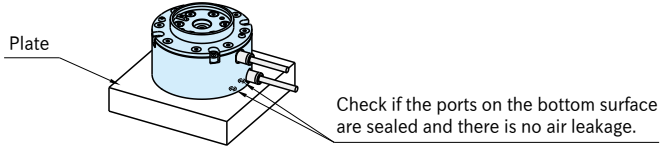
② At the same time the 4 jaw sections tilt toward the center to clamp the circumference of a workpiece.

How To Use

Body Installing

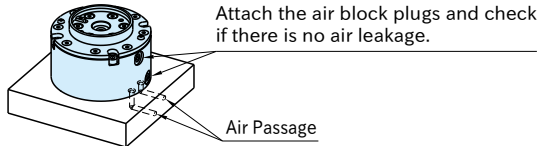
With Side Ports

- Attach the furnished o-rings to the bottom ports.
- Plate surface must be flat ($\sqrt{6.3}$) to get the bottom ports sealed up.
- Check if there is no air leakage from the area of the bottom ports.

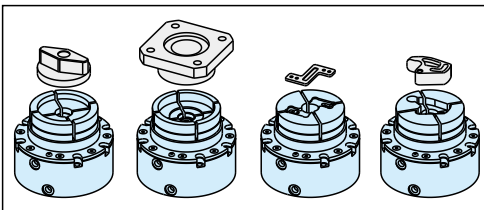
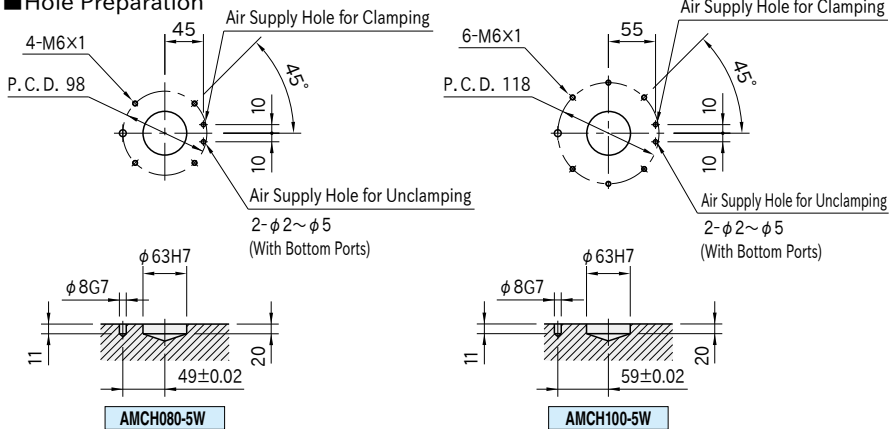


With Bottom Ports

- Attach the furnished o-rings to the bottom ports.
- Plate surface must be flat ($\sqrt{6.3}$) to get the bottom ports sealed up.
- Refer to the figure below for the hole positions for ports.
- Ensure that the furnished air block plugs are attached to the side ports.



Hole Preparation

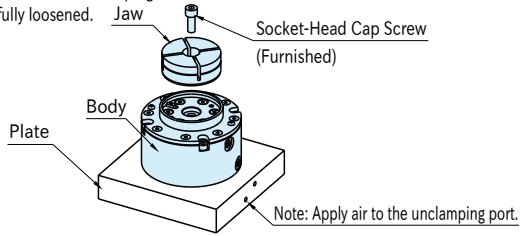


- Machinable jaws allow clamping workpieces of various shapes.
- Ideal way to hold workpieces for machining on small-size machining centers, tapping centers, small-size 5-axis machines, CNC rotary tables, etc.

Changeable Jaws [CP121](#) are available.

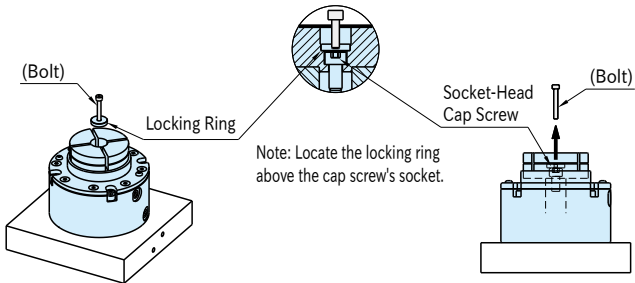
■ Jaw Setting

At jaw installation, ensure that air is applied to the unclamping port and the socket-head cap screw is fully loosened.

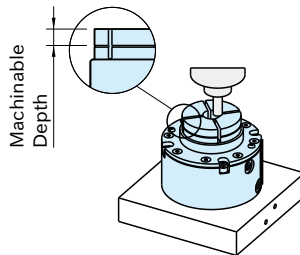


■ Jaw Machining

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.)

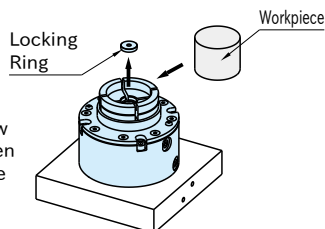


3. Machine the jaw to custom fit a workpiece.



■ Workpiece Setting

1. After machining apply air to the unclamping port to take out 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.