

# QLRCF

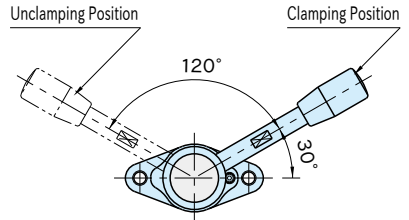
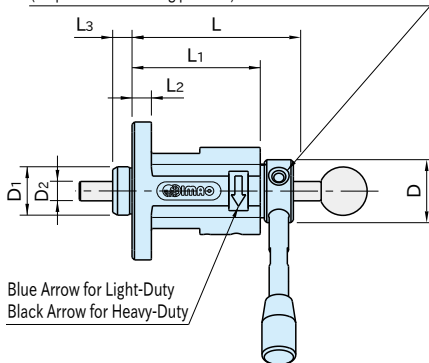
# THRUST CLAMPS (Vertical)



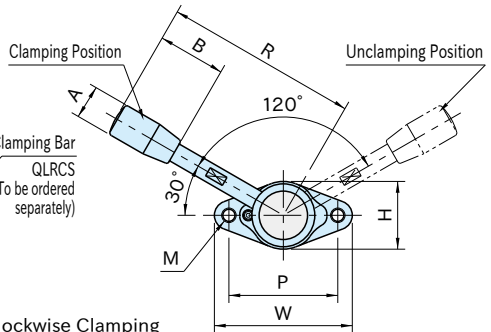
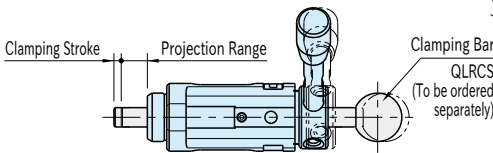
**Light-Duty**  
(Marked with Blue Arrow)      **Heavy-Duty**  
(Marked with Black Arrow)  
Note: Clamping bar is not included.

Body/Lever Arm	Cam	Handle
S45C steel Black oxide finish	SCM415 steel Carburized-hardened Black oxide finish	Phenolic plastic Black matte

M1-4 Lever-Arm Mounting Holes (angle between 2 holes : 90°)  
(4 options of mounting position)



Clockwise Clamping



Counterclockwise Clamping

Type	Clamping Stroke	D <sub>2</sub>	W	H	L <sub>2</sub>	M	P	L	L <sub>1</sub>	L <sub>3</sub>	D	D <sub>1</sub> (-0.04/-0.08)	R	B	A	M <sub>1</sub>
<b>QLRCF-08</b>	1.5	8	57	28	8	M 6×1 (Prepared Hole 5.2)	45	68.5	53	8	26	20	80	28	14	M5×0.8
<b>QLRCF-12</b>	2.3	12	85	40	12	M10×1.5 (Prepared Hole 8.5)	65	90.7	72	12	36	30	132	50	21	M6×1

## QLRCF-L (Light-Duty)

Part Number	Clamping Direction	Allowable Operating Load (N)	Clamping Force (kN)	Weight (g)	Clamping-Bar Projection Range
QLRCF-08R-L	CW	40	0.2	330	QLRCS-08100 0~22
QLRCF-08L-L	CCW				QLRCS-08125 0~47
					QLRCS-08150 0~72
QLRCF-12R-L	CW	100	0.7	930	QLRCS-12125 0~20
QLRCF-12L-L	CCW				QLRCS-12150 0~45
					QLRCS-12200 0~95

## QLRCF (Heavy-Duty)

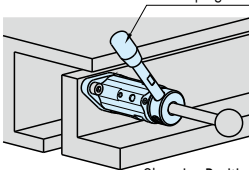
Part Number	Clamping Direction	Allowable Operating Load (N)	Clamping Force (kN)	Weight (g)	Clamping-Bar Projection Range
QLRCF-08R	CW	80	0.5	330	QLRCS-08100 0~22
QLRCF-08L	CCW				QLRCS-08125 0~47
					QLRCS-08150 0~72
QLRCF-12R	CW	150	1.4	950	QLRCS-12125 0~20
QLRCF-12L	CCW				QLRCS-12150 0~45
					QLRCS-12200 0~95

### Feature

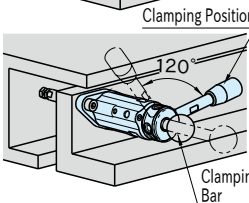
- Can be used in both vertical and horizontal clamping applications.
- The horizontal style is also available. (see page for [QLRC](#))
- Spring-loaded clamp that provides constant clamping force.
- Long clamping-bar projection range allows clamping a recessed part. (When using your own clamping bar, ensure that the diameter is finished to a h9 or better tolerance)

### How To Use

- Operation of CW Type (Invert the operation for CCW type.)  
Unclamping Position

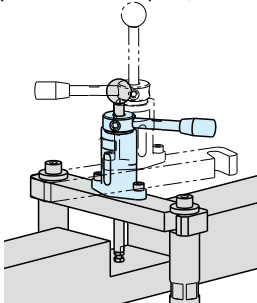


1. Unclamped  
Load or unload a part.



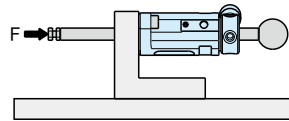
2. Clamping Setup  
Project the clamping bar until it contacts the part.
3. Clamping  
Turn the lever handle (120°) to the clamping position.

- Application Example (Vertical Clamping)



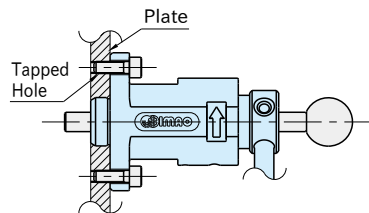
### Note

When a reaction force (F) becomes greater than a clamping force, the clamping bar slides back to get a part unclamped.

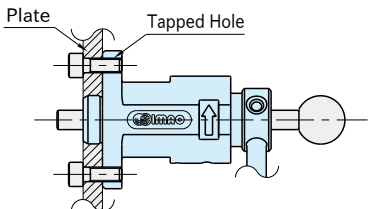


Type	Clamp Releasing Force
QLRCF-08-L	$F > 0.2\text{kN}$
QLRCF-12-L	$F > 0.7\text{kN}$
QLRCF-08	$F > 0.5\text{kN}$
QLRCF-12	$F > 1.4\text{kN}$

- How to Mount



- Face Mounting  
(Use cap screws with one-size smaller threads than mounting-hole threads.)



- Back Mounting  
(Use cap screws with threads of the same size as mounting-hole threads.)