QLSWC SWING CLAMPS

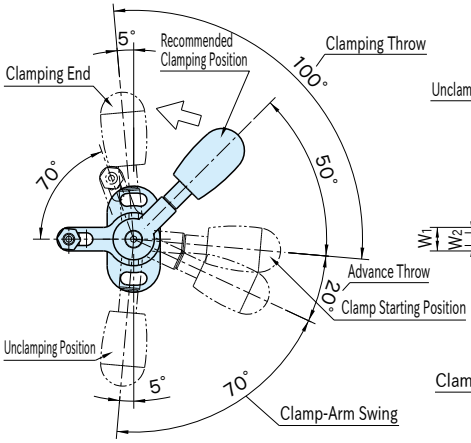
(Black Oxide Finish)

(Electroless Nickel Plated)

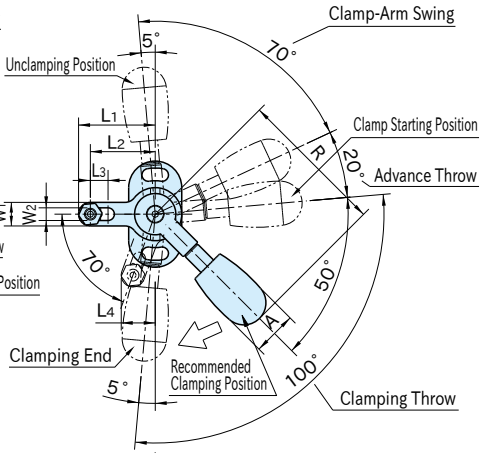
On Request

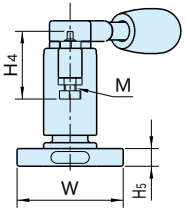
Type	Body/Handle/Clamping Spindle	Arm	Cam Shaft	Knob
QLSWC	S45C steel Quenched and tempered Black oxide finish	SCM440 steel Quenched and tempered Black oxide finish	SCM415 steel Quenched and tempered Black oxide finish	Phenolic plastic Black
QLSWC-NP	S45C steel Quenched and tempered Electroless nickel plated	SCM440 steel Quenched and tempered Electroless nickel plated	SCM415 steel Quenched and tempered Electroless nickel plated	

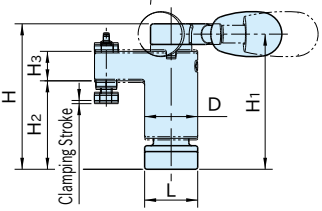
Counterclockwise Clamping

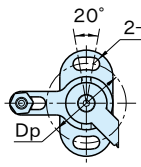


Clockwise Clamping



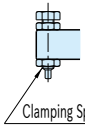




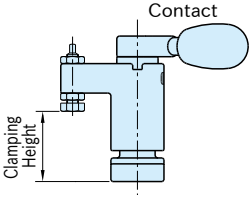


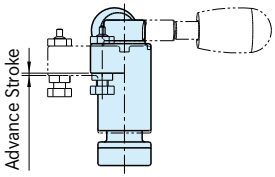
Mounting Holes

Rough Surface Contact



Finished Surface Contact





Part Number	Clamping Direction	Clamping Height *) Finished Surface Contact Min.	Finished Surface Contact Max.	Rough Surface Contact Min.	Rough Surface Contact Max.	Clamping Stroke	Advance Stroke	L_2	L_3	L_1	L_4	W	L	H_5	B
QLSWC100R	CW	22.8 (22.3~23.3)	24.8 (24.3~25.3)	22.4 (21.9~22.9)	24.4 (23.9~24.9)	1	0.8	22	6	26	11.5	36	18	6	4.3
QLSWC100L	CCW														
QLSWC150R	CW	31.3 (30.6~32)	33.3 (32.6~34)	32.2 (31.5~32.9)	34.2 (33.5~34.9)	1.4	1.1	30	8	35	15.3	45	23	8	5.3
QLSWC150L	CCW														
QLSWC200R	CW	32.5 (31.7~33.2)	39 (38.2~39.7)	33.5 (32.7~34.2)	40 (39.2~40.7)	1.5	1.4	37		45	20.7	65	30	12	8.4
QLSWC200L	CCW														
QLSWC300R	CW	36.5 (35.5~37.4)	46 (45~46.9)	39 (38~39.9)	48.5 (47.5~49.4)	1.9	1.7	45		55	25.4	85	40	15	10.5
QLSWC300L	CCW														

Part Number	Dp	H	D	W_1	W_2	H_3	H_2	M	H_4	R	A	H_1	Allowable Operating Load (N) **)	Clamping Force (kN)	Clamping Mechanism
QLSWC100R	27	49	18	8	4.3	10	30	M 4X0.7	22.8	50	15	45.8	100	1.1	Spiral Cam Cam Angle: 5°
QLSWC100L															
QLSWC150R	34	66	23	10	5.3	14	40	M 5X0.8	28.5	63	20	61.3	150	1.8	
QLSWC150L															
QLSWC200R	48	82	30	16	8.4	18	50	M 8X1.25	45.5	80	26	76.5	200	2.2	Spiral Cam Cam Angle: 4°
QLSWC200L															
QLSWC300R	64	100	40	20	10.4	22	60	M10X1.5	57	100	33	93	300	3.5	
QLSWC300L															

QLSWC (Black oxide finish)

Part Number	Weight (g)
QLSWC100R	112
QLSWC100L	
QLSWC150R	250
QLSWC150L	
QLSWC200R	570
QLSWC200L	
QLSWC300R	1200
QLSWC300L	

QLSWC-NP (Electroless nickel) On Request

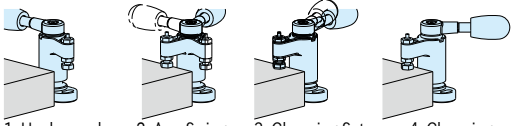
Part Number	Weight (g)
QLSWC100R-NP	112
QLSWC100L-NP	
QLSWC150R-NP	250
QLSWC150L-NP	
QLSWC200R-NP	570
QLSWC200L-NP	
QLSWC300R-NP	1200
QLSWC300L-NP	

*) Clamping height can be adjusted. The parenthesised values denote clamping height range.

**) Allowable load to operate the handle.

How To Use

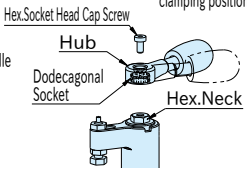
■Operation of CW Type (Invert the operation for CCW type.)



1. Unclamped Load or unload a part.
2. Arm Swing — Turn the handle to set the clamp arm in position.
3. Clamping Setup — Continue turning the handle to set the spindle close to the part.
4. Clamping — Turn the handle to the recommended clamping position.

■How to Change Handle Position

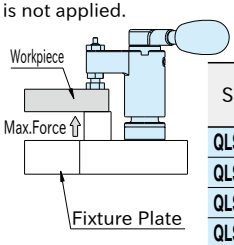
The dodecagonal socket in the hub of the handle allows changing the handle position by 30˚.



Technical Information

■Allowable Loads in Machining of Workpiece Bottom

Ensure that any force more than stated below is not applied.



Series	Allowable Force To Workpiece Bottom (Per Clamp)
QLSWC100	max.2.3kN
QLSWC150	max.3.6kN
QLSWC200	max.3.7kN
QLSWC300	max.5.6kN

Performance Curve