

QLSWH

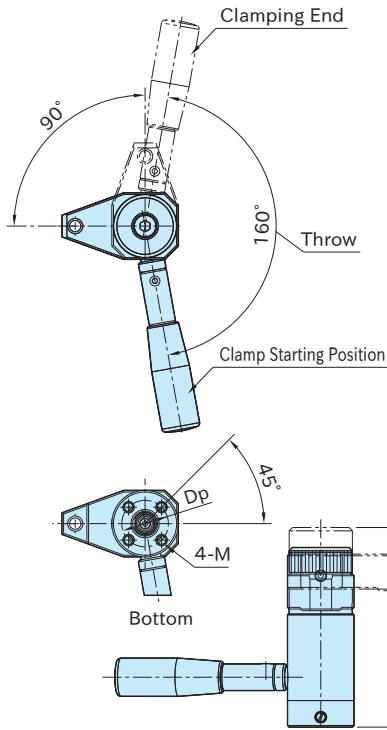
SWING CLAMPS (Heavy)



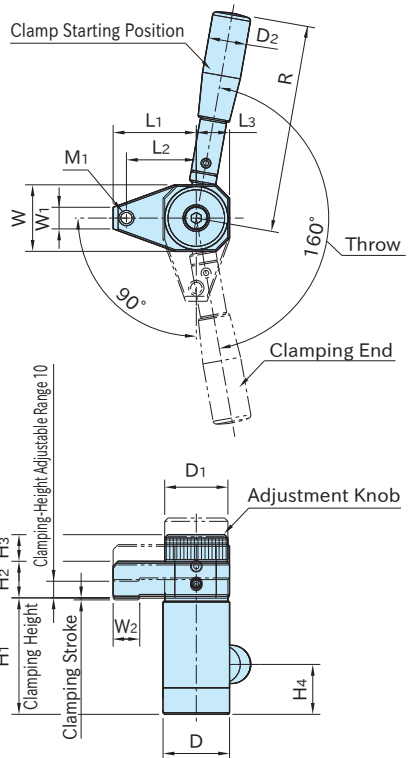
Clamp that works in two steps :
adjusting clamping position with the adjustment knob,
and tightening the clamp arm with the handle

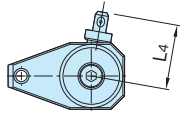
Body/Cam/Handle	Bolt	Clamp Arm/Holder/ Handle Shank	Adjustment Knob	Handle
SCM440 steel Quenched and tempered Black oxide finish	SCM435 steel Quenched and tempered Black oxide finish	S45C steel Quenched and tempered Black oxide finish	S45C steel Black oxide finish	Phenolic plastic Black

Counterclockwise Clamping

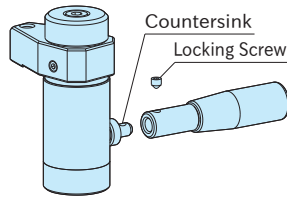


Clockwise Clamping





When Handle Is Removed



The handle can be removed by loosening the locking screw. To keep the handle mounted permanently, make sure that the locking screw is fully tightened.

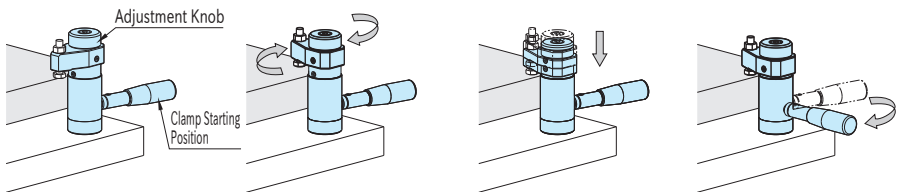
Part Number	Clamping Direction	Clamping Stroke	H ₁ Clamping Height	W ₁	W ₂	M ₁	L ₂	L ₁	L ₃	D	M	D _p	H	
QLSWH400R	CW	1.2	70~80	13	16	M 8×1.25	42	50	20	40	M6×1	Depth 12	28	120
QLSWH400L	CCW													
QLSWH500R	CW	1.6	80~90	18	24	M12×1.75	48	60	25	50	M8×1.25	Depth 16	35	137
QLSWH500L	CCW													

Part Number	W	H ₂	D ₁	H ₃	R	D ₂	H ₄	L ₄	Allowable Operating Load (N) *	Clamping Force (kN)	Clamping Mechanism	Weight (kg)
QLSWH400R	40	22	38	16	125	23	30	39	600	3.5	Spiral Cam Cam Angle: 2°	1.1
QLSWH400L												
QLSWH500R	50	25	48	20	160	28	38	47		6	2	
QLSWH500L												

*) Allowable load to operate the handle

How To Use

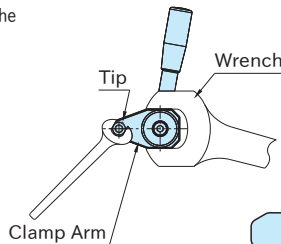
■ Operation of CW Type (Invert the operation for CCW type.)



1. Load a workpiece.
2. Turn the adjustment knob for the clamp arm to rotate 90°.
3. Continue turning the adjustment knob for the clamp arm to go down against the workpiece, for temporary clamping.
4. Turn the handle for full clamping. (For unclamping, follow the above steps back)

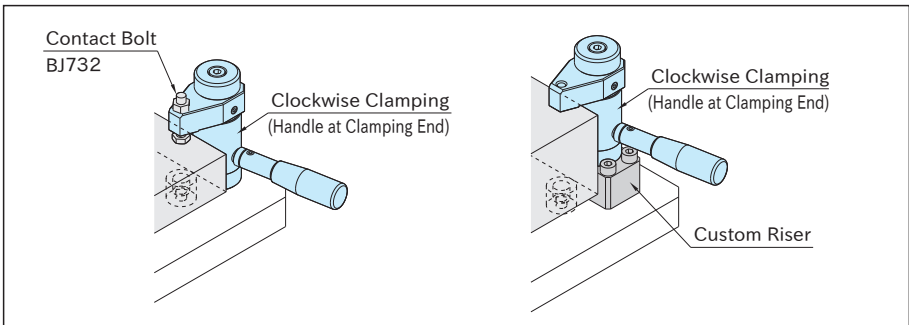
■ Tip Installation

When installing a tip on the clamp arm, lock the clamp arm using a wrench to prevent it from receiving any torque.



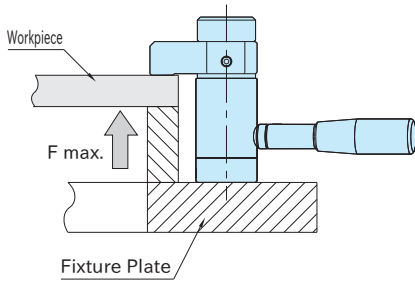
Continuing to next page

Application Example



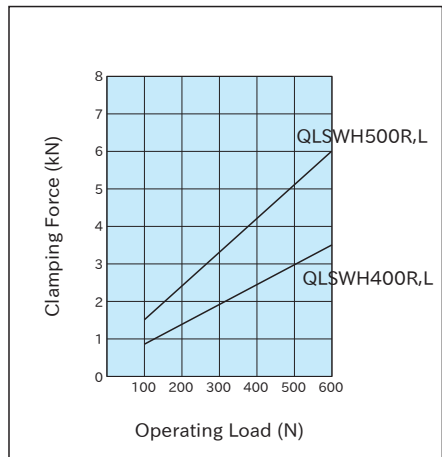
Technical Information

■ Allowable Loads in Machining of Workpiece Bottom



Type	Allowable Force To Workpiece Bottom (Per Clamp)
QLSWH400	max. 8kN
QLSWH500	max.14kN

Performance Curve



Custom Clamp Arm
Recommended Dimensions

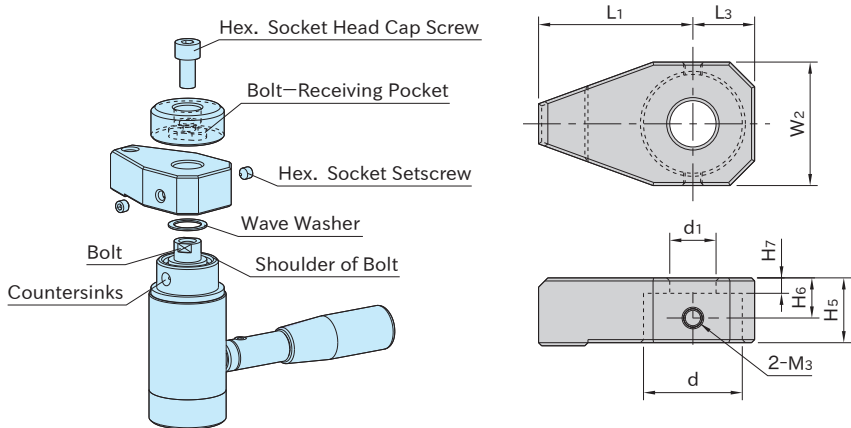
Type	L ₁ (Max.)	L ₃	W ₂	H ₅	d (F8)	d ₁	H ₇ (±0.1)	M ₃	H ₆
QLSWH400	50	20	40	21	32	15	5	M6×1	13
QLSWH500	60	25	50	24	41	19	6	M8×1.25	15

Clamp Arm Installation / Removal

To install a clamp arm,

1. Place the wave washer on the shoulder of the bolt and then fit the clamp arm onto the bolt.
2. Place the adjustment knob onto the bolt getting the bolt fitted into the bolt - receiving pocket in the adjustment knob, and then lock the adjustment knob using a hex. socket head cap screw.
3. Align the countersinks on the side of the holder with the setscrew holes on the side of the clamp arm, and then lock them using the hex. socket setscrews.

To remove the clamp arm, follow the above steps back.



Clamp Arm Customization Examples

