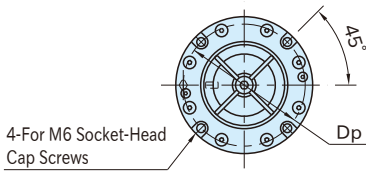


# AMCH-W

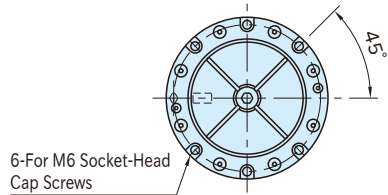
# PNEUMATIC OD HOLDING CLAMPS



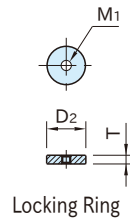
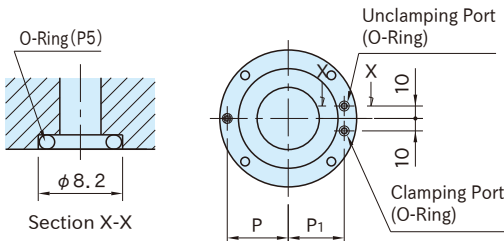
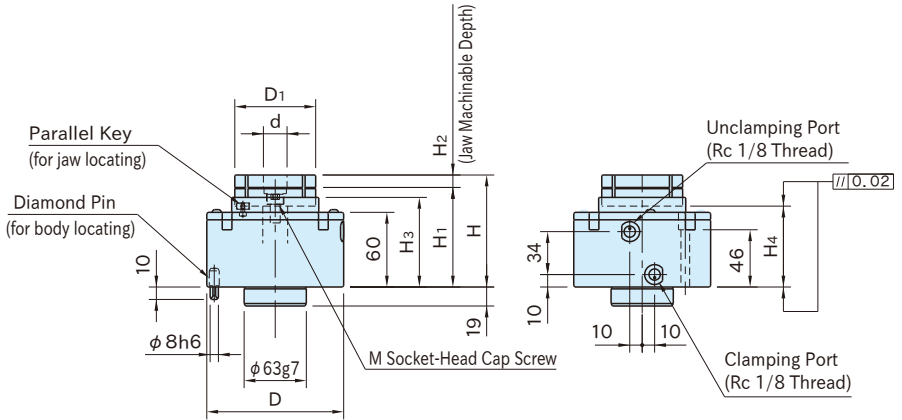
Body	Jaw
Steel(S45C) Electroless nickel plated	Aluminum(A7075) Anodized Blue



**AMCH080-5W**



**AMCH100-5W**



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

Part Number	D <sub>2</sub>	T	Furnished O-Ring	Operating Air Pressure(MPa)*)	Clamping Force (N)**)	Weight (kg)
<b>AMCH080-5W</b>	18	4	P5	0.5	4,000	4.2
<b>AMCH100-5W</b>	22	6			6,000	6

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

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

### Furnished Parts

- 1 of locking ring
- 2 of O-Ring
- 1 of diamond pin
- 1 of socket-head cap screw

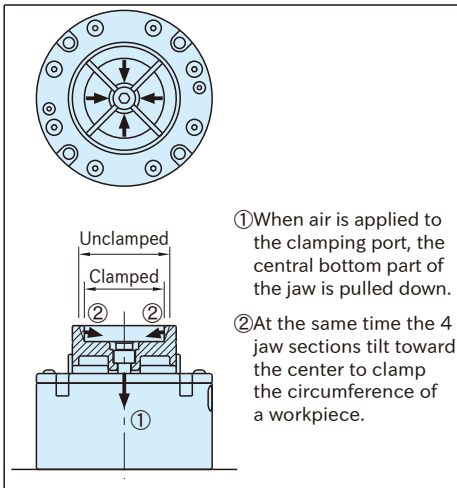
### Technical Data

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

### Notes

- Do not actuate clamping without a workpiece inserted to avoid damage and deformation.
- Do not machine the jaw beyond the machinable area.
- Changeable Jaws [CP121](#) are available.

### Features



- 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.

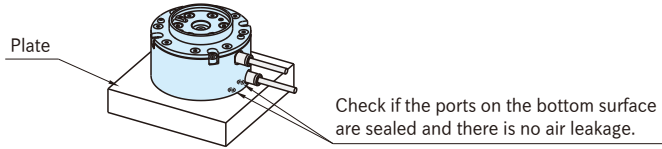
- The diaphragm clamping mechanism allows securely clamping a workpiece with 4 jaw sections.
- Different irregularly-shaped workpieces can be clamped.
- 0.15mm clamping stroke of each jaw section is perfect for clamping of lost-wax parts, die-cast parts, extruded parts, solid-drawn parts, prefinished parts, etc.

## How To Use

### ■ Body Mounting

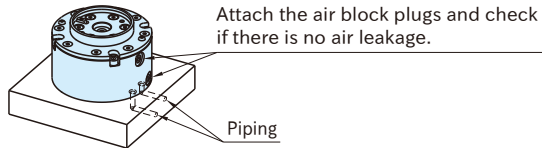
To Use with the Side Ports

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

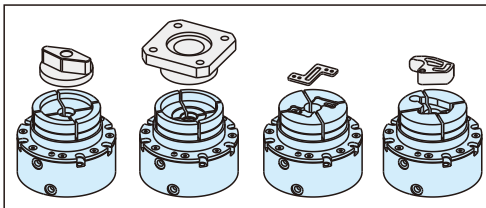
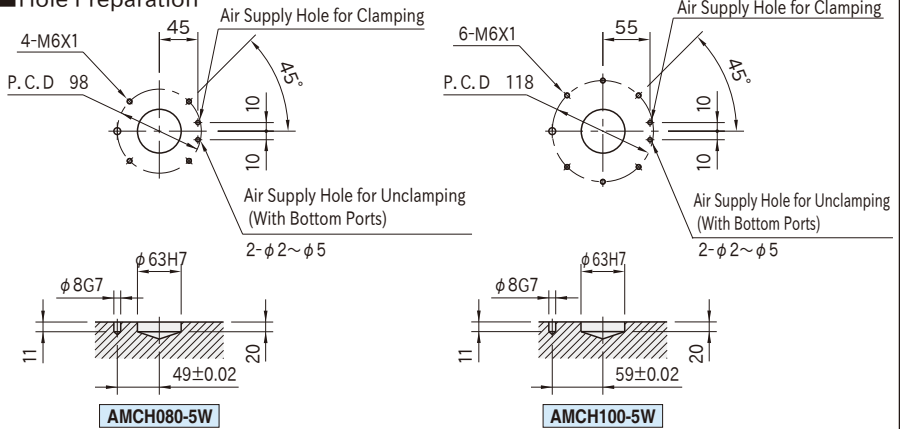


To Use with the Bottom Ports

- Attach the furnished o-rings to the bottom ports.
- Plate surface must be flat ( $\nabla 6.3$ ) 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

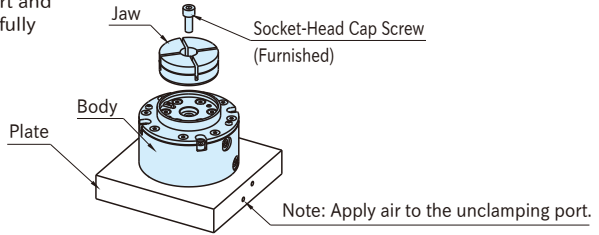


- Machinable jaws allow clamping workpieces of various shapes.
- Ideal way to hold workpieces for machining on small-size machining centers, tapping centers, small-size 5-axis machines, CNC rotary tables, etc.

Changeable Jaws **CP121** are available.

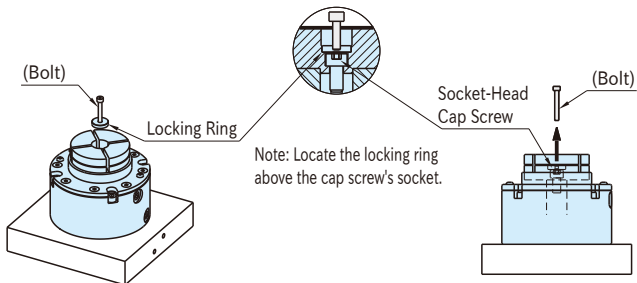
## ■ Jaw Setting

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

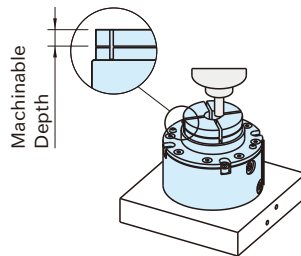


## ■ Jaw Machining

- 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.

