

Wedge clamps

jaw face smooth or serrated



Material:

Wedge and jaw segments carbon steel.

Version:

Wedge and jaw segments hardened, black.

Sample order:

nIm 04524-2208

Note:

The functioning principle make the wedge clamps ideal for series clamping. The wedge form can exert high clamping forces. These wedge clamps can be mounted in grid holes or T-slots. Tightening the socket screw moves the wedge down and the jaws out pressing the workpieces against the fixtures fixed stops. The wedge has a slightly elongated hole allowing for movement to compensate for tolerances.

Spread width:

M8 = ±0.5 mm

M10 = ±1.0 mm

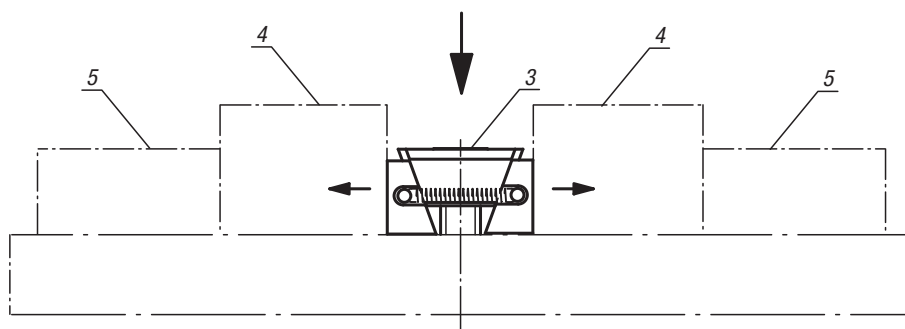
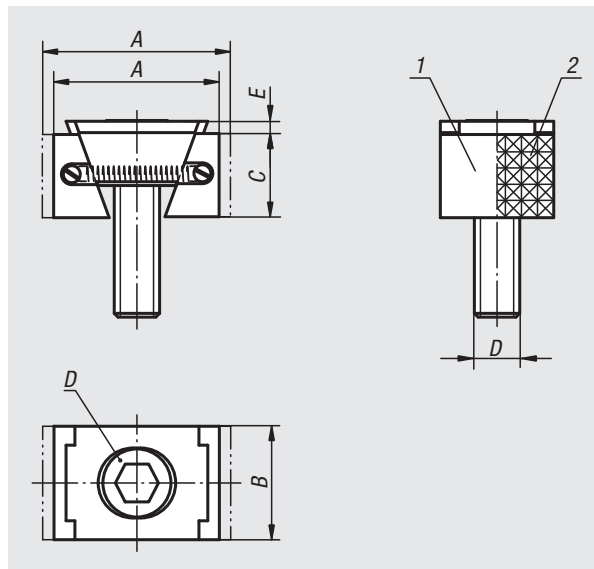
M12 = ±1.0 mm

M16 = ±1.5 mm

Drawing reference:

D) DIN 6912 cap screw

- 1) Jaw face smooth
- 2) Jaw face serrated
- 3) Wedge clamps
- 4) Workpiece
- 5) Fixed stop



Wedge clamps, narrow version

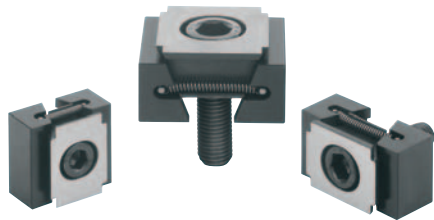
Order No. smooth	Order No. serrated	A min.	A max.	B	C	D	E	Clamping force max. kN	Tightening torque max. Nm
04524-1108	04524-2108	30,5	33,5	24	15	M8X25	2	15	25
04524-1110	04524-2110	32	37	28	19	M10X25	3,5	20	49
04524-1112	04524-2112	44	49,5	30	22	M12X40	3,5	30	85
04524-1116	04524-2116	55	62	40	29	M16X60	4	50	210

Wedge clamps, wide version

Order No. smooth	Order No. serrated	A min.	A max.	B	C	D	E	Clamping force max. kN	Tightening torque max. Nm
04524-1208	04524-2208	30,5	33,5	30	15	M8X25	2	15	25
04524-1210	04524-2210	32	37	38	19	M10X25	3,5	20	49
04524-1212	04524-2212	44	49,5	48	22	M12X40	3,5	30	85
04524-1216	04524-2216	55	62	48	29	M16X60	4	50	210

Wedge clamps

machinable



Material:

Wedge and jaw segments carbon steel.

Version:

Wedge and jaw segments tempered, black.

Sample order:

nIm 04524-3110

Note:

These wedge clamps have extra long jaws. This extra material allows the jaws to be machined to suit the form of the workpiece.

The functioning principle makes the wedge clamps ideal for series clamping. The wedge form can exert high clamping forces.

These wedge clamps can be mounted in grid holes or T-slots.

Tightening the socket screw moves the wedge down and the jaws out, pressing the workpieces against the fixtures' fixed stops.

The wedge has a slightly elongated hole allowing for movement to compensate for tolerances.

Spread width:

M8 = ± 0.5 mm

M10 = ± 1.0 mm

M12 = ± 1.0 mm

M16 = ± 1.5 mm

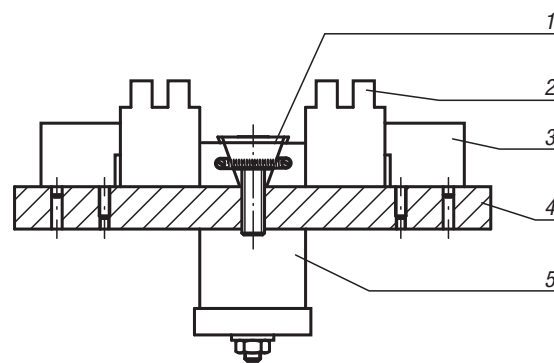
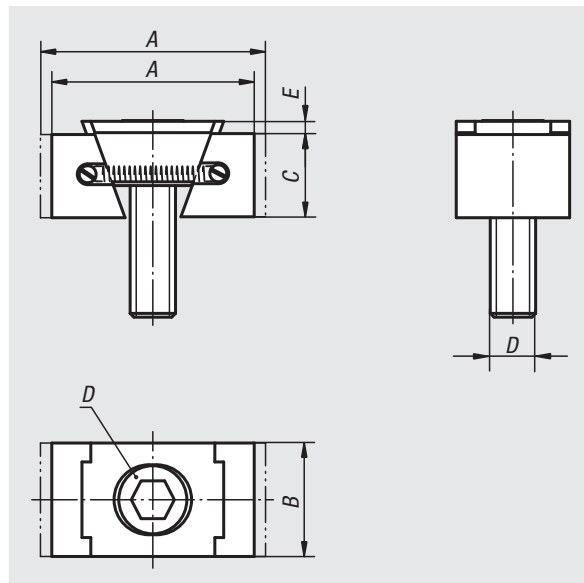
Attention:

These wedge clamps have a machining allowance per jaw of 3 mm for version M8 and 5 mm for versions M10, M12 and M16.

Drawing reference:

D) DIN 6912 cap screw

- 1) wedge clamps
- 2) workpiece
- 3) fixed stop
- 4) base plate
- 5) hydraulic/pneumatic cylinder



Order No.	Version	A min.	A max.	B	C	D	E	Clamping force max. kN	Tightening torque max. Nm
04524-3108	narrow	36,5	39,5	24	15	M8X25	2	11	19
04524-3110	narrow	42	47	28	19	M10X25	3,5	15	37
04524-3112	narrow	54	59,5	30	22	M12X40	3,5	23	65
04524-3116	narrow	65	72	40	29	M16X60	4	38	160
04524-3208	wide	36,5	39,5	30	15	M8X25	2	11	19
04524-3210	wide	42	47	38	19	M10X25	3,5	15	37
04524-3212	wide	54	59,5	48	22	M12X40	3,5	23	65
04524-3216	wide	65	72	48	29	M16X60	4	38	160