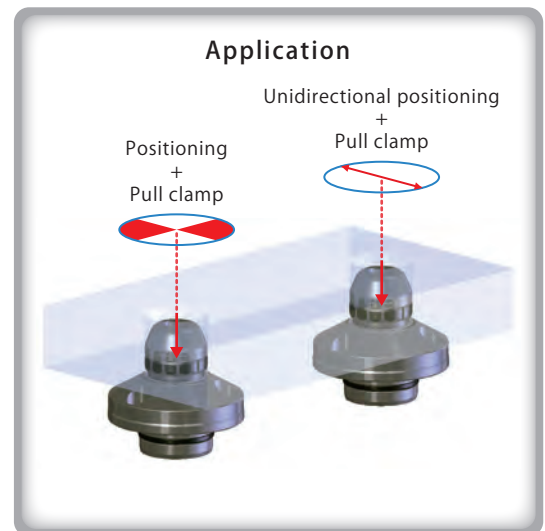


Put positioning with high precision and clamping all in one!

## Datum hole clamp

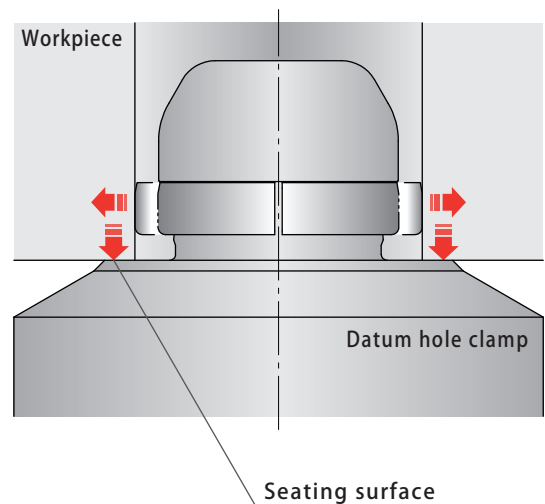


- **Clamp with a positioning function.**

Both positioning with high precision and clamping are put into our compact datum hole clamp. It positions workpiece hole while pulling work piece down to the seating surface.

- **Minimising a base plate.**

Clamps are located below workpiece. So, there is nothing over and along the surface of workpiece. It make it possible that a base plate is minimised. When it is in use for machine tool jig, only one chucking is needed to process workpiece from all the 5 faces.



- **No need to add seating surface.**

No need to add seating surface because its already available.

- **small design, easy seating.**

This one is designed so small that even if the installation plate is a little bit thin, it is being able to be installed. But there is no worry about the amount of clamping power and positioning. It has strong clamping power and high positioning accuracy.

※ We have standard product that is hole clamp only for a clamping and expansion locating pin only for a positioning.

This is the part of an example made in the past.  
When you have it in mind that the specification, measurement is except for our range, let our sales representative know.

● Specifications

Model No.			VHY
Workpiece hole diameter	mm	φ 22	
Clamping diameter	At release position(Max)	mm	φ 21.865
	At lock position(Min)	mm	φ 22.08
	Idling (Min)	mm	φ 22.14
Full stroke	mm	1.5	
Stroke pulling workpiece	mm	0.3	
Repetitive locating accuracy	mm	0.005	
Clamping force*1	At 2.5MPa	N	100
	At 5.0MPa	N	300
	At 7.0MPa	N	450
Expansion force*2	At 2.5MPa	N	1230
	At 5.0MPa	N	2880
	At 7.0MPa	N	4200
Cylinder area	At lock position	cm <sup>3</sup>	0.33
	At release position	cm <sup>3</sup>	0.43
Operating hydraulic pressure	MPa	2.5 ~ 7.0	
Operating temperature	°C	0 ~ 70	
Useable fluid	General hydraulic oil equivalent to ISO-VG-32		
Allowable thrust loading*3	kN	3.0	

Note

- \*1. Clamping force indicates the force pressing workpiece on the seating surface. The numbers on left graph is calculated in terms of the coefficient friction.
  - \*2. Expanding force indicates the force that line the workpiece hole .
  - \*3. Allowable thrust load indicates the maximum withstanding load. If the thrust load exceeds the maximum, malfunction or damage is likely.
1. Clamping force vary according to the material · surface roughness · smoothness of the workpiece. Please do the running test and adjust the appropriate supplied pressure before use.

● External dimensions

- ※1. This drawing is the reference. Detail measurement is not on this drawing.
- ※2. This drawing indicates the release position(diameter shrinking).

