

JAWS FOR INTERNAL FORM HOLDING [AMWFH-I] Instructions

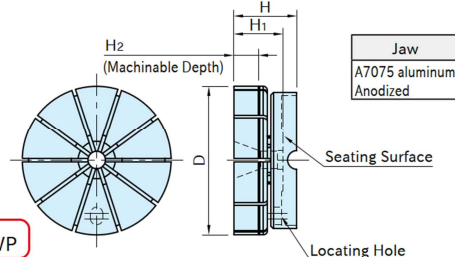
For Safe operation of the AMWFH-I, please read this instructions carefully before using.

Please keep this instruction manual handy for future reference.

※Please read the AMWFH-WP instruction together

⚠ Precautions

Do not actuate clamping without a workpiece to avoid damage and deformation.

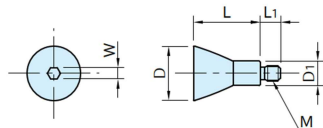


★Key Point
Machinable jaws for AMWFH-WP

Part Number	D	H	H ₁	H ₂	Weight (kg)	Pneumatic Clamping Modules	Tapered Screws	Clamping Pins
AMWFH105-120I	120	51	40	20	1	AMWFH105-WP	AMWFH105-120IB	AMWFH105-M 8S
AMWFH140-160I	160	59	48	25	2.1	AMWFH140-WP	AMWFH140-160IB	AMWFH140-M12S

AMWFH-IB

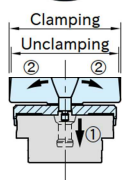
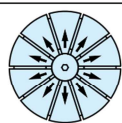
TAPERED SCREWS FOR INTERNAL FORM HOLDING



Part Number	D	L	M	L ₁	D ₁	W	Weight (g)	Jaws
AMWFH105-120IB	29	36	M 8x1.25	11	13.2	6	85	AMWFH105-120I
AMWFH140-160IB	33	43	M12x1.75	15	18	10	140	AMWFH140-160I

Body
SCM435 steel
Quenched and tempered
Electroless nickel plated

Feature



- ① The Tapered Screw is pulled down by supplying air to the turbo port.
- ② The 10 jaw sections expand to clamp the internal form of workpiece.

- The jaw sections expanded by the tapered surface hold the workpiece securely.
- Various shapes can be held.
- The allowable expansion diameter is 0.6 mm, making it ideal for lost wax, die cast, extruded, drawn, and premachined workpieces.

Technical Information

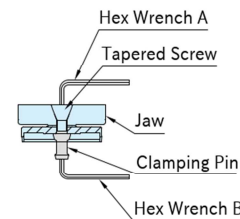
- Workpiece locating repeatability: ±0.03
- Jaw locating repeatability: ±0.02

How To Use

■ Jaw Mounting

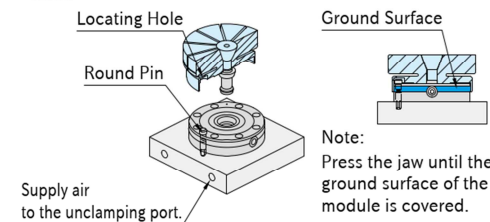
1. Fix Clamping Pin

- Fix clamping pin with the Tapered Screw.



2. Mount on Clamping Module

- Supply air to the unclamping port and mount the jaw.
- Mount the jaw by inserting the round pin into the locating hole.

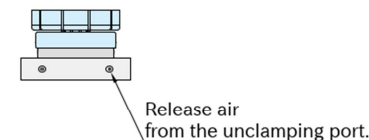


Jaw	Clamping Pin	Tapered Screws	Hex Wrench A	Hex Wrench B
AMWFH105-120I	AMWFH105-M 8S	AMWFH105-120IB	Size 6	Size 6
AMWFH140-160I	AMWFH140-M12S	AMWFH140-160IB	Size 10	Size 10

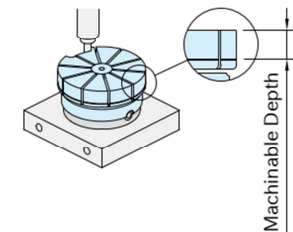
For mounting instruction of Clamping Module, see [AMWFH-WP](#) datasheet.

■ Jaw Machining

1. Release air from the unclamping port. The Tapered Screw is pulled down and the jaw expands.

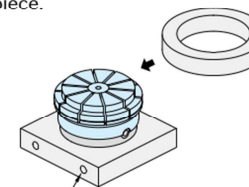


2. Machine the jaw to the contours of workpiece. Keep the machinable depth.

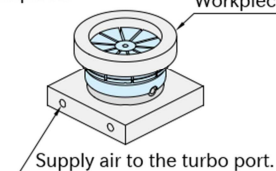


■ Workpiece Loading

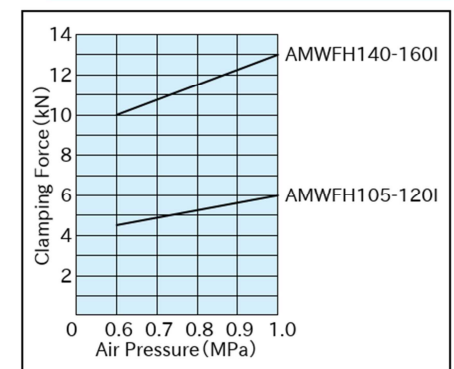
1. Supply air to the unclamping port and load the workpiece.



2. Supply air to the turbo port and clamp the workpiece.



Performance Curve



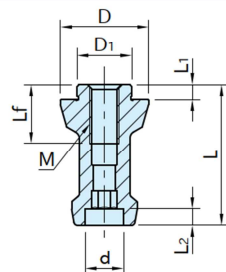
AMWFH-M

CLAMPING PINS

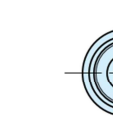
IMAO



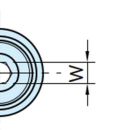
(Locating, Round) (Locating, Diamond) (Clamping)



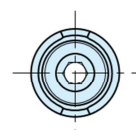
Body
SCM415 Steel
Carburized-
hardened
Black oxide finished



AMWFH-MT
(Round)



AMWFH-MS
(Clamping)



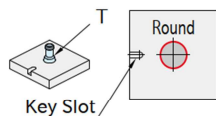
AMWFH-MD
(Diamond)

Part Number	Type	M	D ₁	L ₁	D	L	d	L ₂	W	L _f	Weight (g)	Pneumatic Clamping Modules
AMWFH105-M 8T	Round	M 8×1.25	15g6	4	24.2	38.5	10.5	4.5	6	16	55	AMWFH105-WP
AMWFH105-M 8D	Diamond		15 _{-0.1}		24							
AMWFH105-M 8S	Clamping		15 _{-0.1}		24							
AMWFH140-M12T	Round	M12×1.75	25g6	5	34.2	51.5	16.5	6.5	10	24	170	AMWFH140-WP
AMWFH140-M12D	Diamond		25 _{-0.1}		34							
AMWFH140-M12S	Clamping		25 _{-0.1}		34							
AMWFH140-M16T	Round	M16×2	25g6	5	34.2	51.5	18.5	7.5	12	30	140	AMWFH140-WP
AMWFH140-M16D	Diamond		25 _{-0.1}		34							
AMWFH140-M16S	Clamping		25 _{-0.1}		34							

How To Use

Use of Single Pin

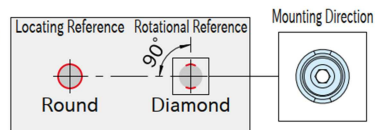
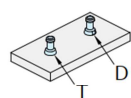
Type T Round Pin: 1 pc



Use of 2 Pins

Type T Round Pin: 1 pc

Type D Diamond Pin: 1 pc

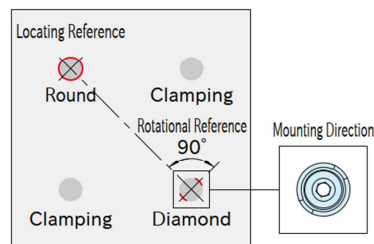
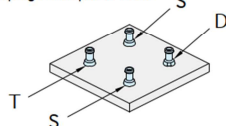


Use of 4 or More Pins

Type T Round Pin: 1 pc

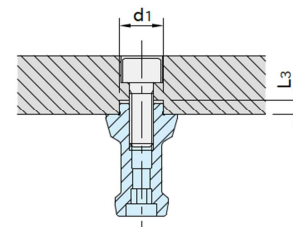
Type D Diamond Pin: 1 pc

Type S Non-Locating Clamping Pin: 2 pcs or more



How To Use

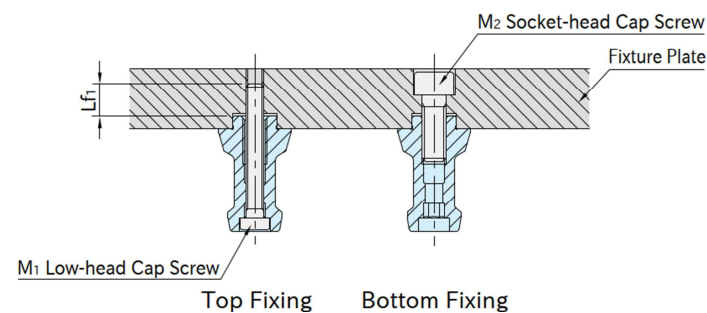
Mounting Hole Dimension



Size	d ₁ (H7)	L ₃
AMWFH105-M8	15	4.5
AMWFH140-M12	25	5.5
AMWFH140-M16	25	5.5

Note: The tolerance of d₁ for Type S non-locating Clamping Pin is ± 0.1 .

How To Install

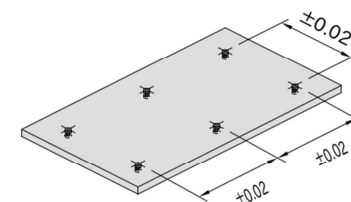


Size	M ₁	L _{f1}	M ₂
AMWFH105-M8	M 6×1 -45L	11	M 8
AMWFH140-M12	M10×1.5 -60L	15	M12
AMWFH140-M16	M12×1.75-65L	21	M16

The screws should be prepared by the customer.
The length of screw differs by the thickness of fixture plate.

Spacing Tolerance

Should be ± 0.02 for Type T and D Locating Pins. The required tolerance for Type S non-locating Clamping Pin is ± 0.1 .



IMAO CORPORATION

[CONTACT US]

Export Sales Team

<https://www.imao.com/en/contact-us/>