

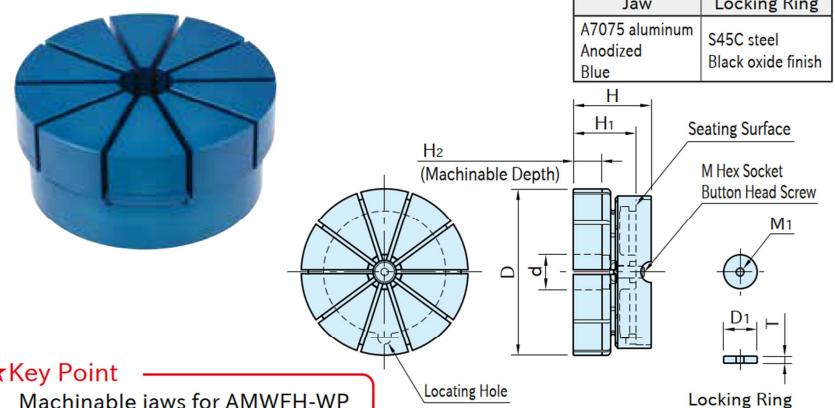
JAWS FOR EXTERNAL FORM HOLDING [AMWFH-O] Instructions

For Safe operation of the AMWFH-O, 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.

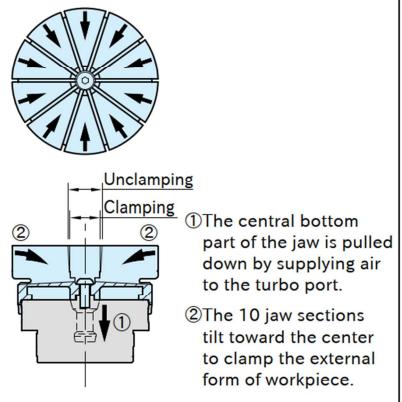


★Key Point

Machinable jaws for AMWFH-WP

Part Number	D	d	H	H ₁	H ₂	M	M ₁	D ₁	T	Weight (kg)	Pneumatic Clamping Modules	Clamping Pins
AMWFH105-1200	120	25	56	45	20	M 8×20L Across Flats 5	M6×1	24	5	1	AMWFH105-WP	AMWFH105-M 8S
AMWFH140-1600	160	29	64	53	25	M12×25L Across Flats 8	M8×1.25	28	6	2.2	AMWFH140-WP	AMWFH140-M12S

Feature



- The diaphragm clamping mechanism allows to clamp the workpiece securely with 10 jaw sections.
- Various shapes can be held.
- The allowable compression diameter is 0.6 mm, making it ideal for lost wax, die cast, extruded, drawn, and premachined workpieces.

Supplied With

- 1 of Locking Ring
- 1 of Hex Socket Button Head Screw

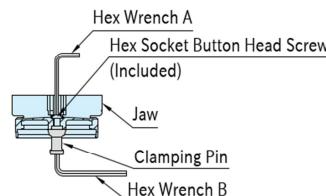
Technical Information

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

How To Use

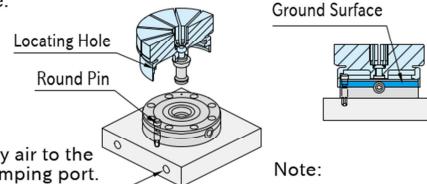
Jaw Mounting

- Fix Clamping Pin
 - Fix clamping pin with the furnished button head screw.



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.

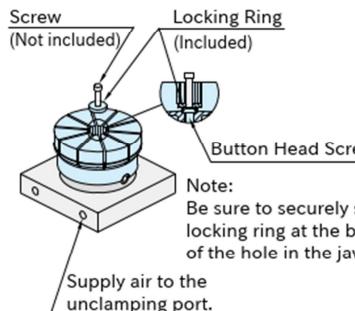


Note:
Press the jaw until the ground surface of the module is covered.

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

Jaw Machining

- Set the locking ring in the jaw.
(Using a screw facilitates setting.)

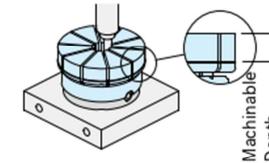


Note:
Be sure to securely set the locking ring at the bottom of the hole in the jaw.

- Release air from the unclamping port and clamp the locking ring by spring force of the module.
Remove the screw from the locking ring after clamping.

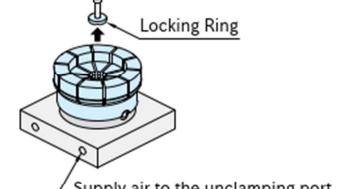


- Machine the jaw to the contours of workpiece.
Keep the machinable depth.

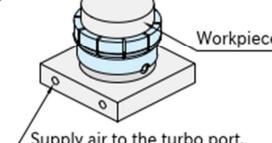


Workpiece Loading

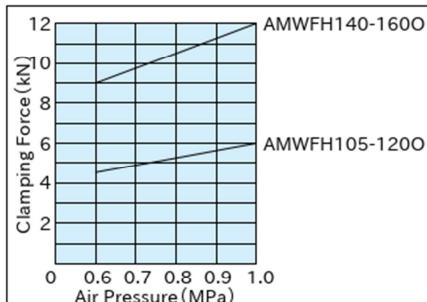
- Supply air to the unclamping port and remove the locking ring.



- Load the workpiece and supply air to the turbo port.

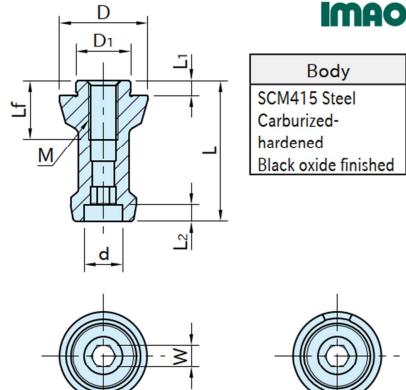


Performance Curve



AMWFH-M

CLAMPING PINS



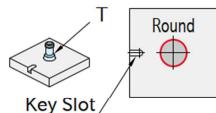
AMWFH-MT
(Round) **AMWFH-MS**
(Clamping) **AMWFH-MD**
(Diamond)

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											
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											
AMWFH140-M16T	Round	M16×2	25g6	34.2	34.2	18.5	7.5	12	30	140		AMWFH140-WP
AMWFH140-M16D	Diamond		25 ^{0.1}		34							
AMWFH140-M16S	Clamping											

How To Use

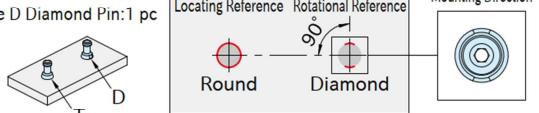
■ Use of Single Pin

Type T Round Pin: 1 pc



■ Use of 2 Pins

Type T Round Pin: 1 pc
Type D Diamond Pin: 1 pc

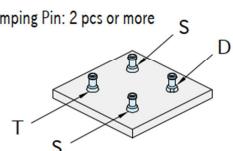


■ Use of 4 or More Pins

Type T Round Pin: 1 pc

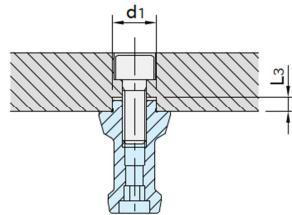
Type D Diamond Pin: 1 pc

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



How To Use

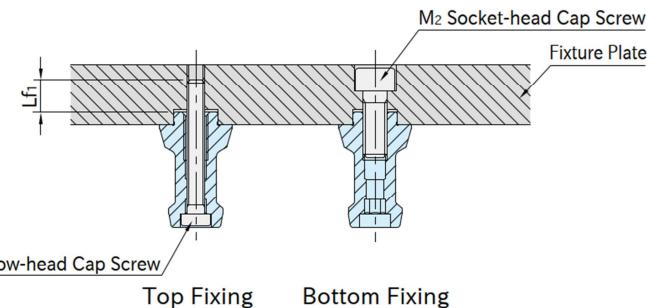
■ Mounting Hole Dimension



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

Note: The tolerance of d₁ for Type S non-locating Clamping Pin is $^{+0.1}$.

■ How To Install



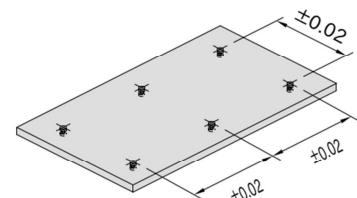
Size	M ₁	L _{f1}	M ₂
AMWFH105-M8	M 6×1	-45L	M 8
AMWFH140-M12	M10×1.5	-60L	M12
AMWFH140-M16	M12×1.75	-65L	M16

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 .



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