

JAWS FOR EXTERNAL FORM HOLDING [AMWFH-O] Instructions

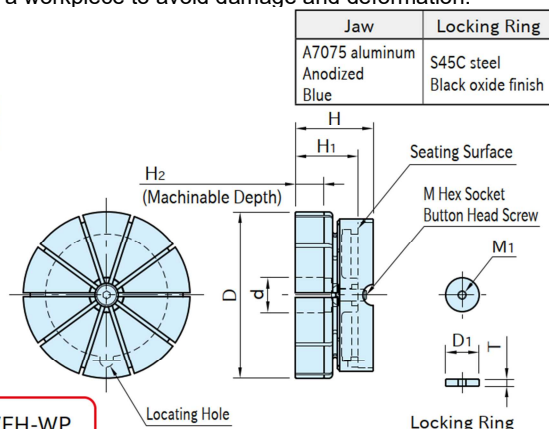
For Safe operation of the AMWFH-O, please read this instructions carefully before using.

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.

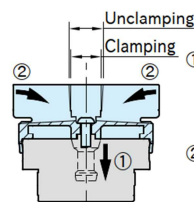
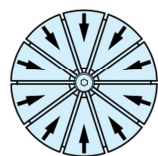


★Key Point

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
AMWFH105-120O	120	25	56	45	20	M 8×20L Across Flats 5	M6×1	24	5	1	AMWFH105-WP	AMWFH105-M 8S
AMWFH140-160O	160	29	64	53	25	M12×25L Across Flats 8	M8×1.25	28	6	2.2	AMWFH140-WP	AMWFH140-M12S

Feature



- ①The central bottom part of the jaw is pulled down by supplying air to the turbo port.
- ②The 10 jaw sections tilt toward the center to clamp the external form of workpiece.

- 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

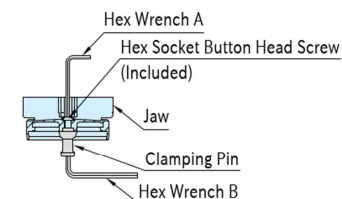
- Workpiece locating repeatability: ±0.03
- Jaw locating repeatability: ±0.02

How To Use

■ Jaw Mounting

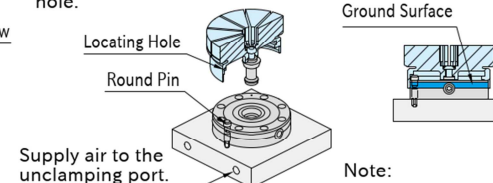
1. Fix Clamping Pin

- Fix clamping pin with the furnished button head 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.



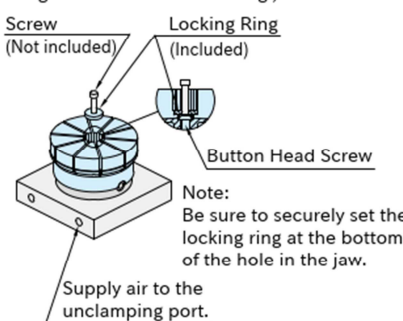
Note:
Press the jaw until the ground surface of the module is covered.

Jaw	Clamping Pin	Hex Wrench A	Hex Wrench B
AMWFH105-120O	AMWFH105-M 8S	Size 5	Size 6
AMWFH140-160O	AMWFH140-M12S	Size 8	Size 10

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

■ Jaw Machining

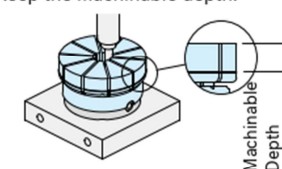
1. Set the locking ring in the jaw. (Using a screw facilitates setting.)



2. 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.

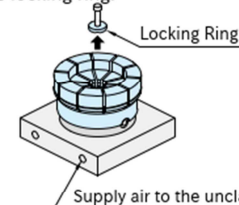


3. Machine the jaw to the contours of workpiece. Keep the machinable depth.

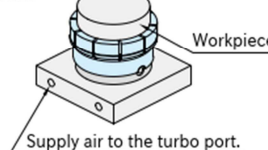


■ Workpiece Loading

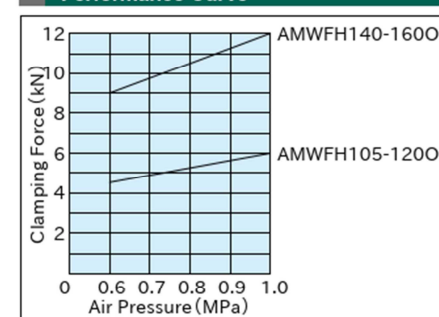
1. Supply air to the unclamping port and remove the locking ring.



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



Performance Curve



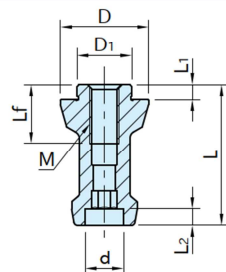
AMWFH-M

CLAMPING PINS

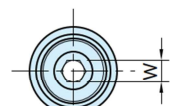
IMAO



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

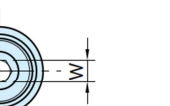


Body
SCM415 Steel
Carburized-
hardened
Black oxide finished



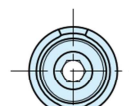
AMWFH-MT

(Round)



AMWFH-MS

(Clamping)



AMWFH-MD

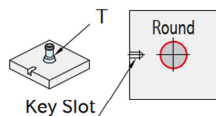
(Diamond)

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

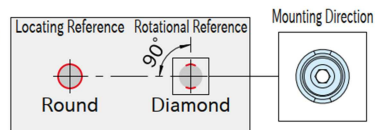
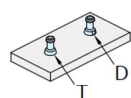
Type T Round Pin: 1 pc



Use of 2 Pins

Type T Round Pin: 1 pc

Type D Diamond Pin: 1 pc

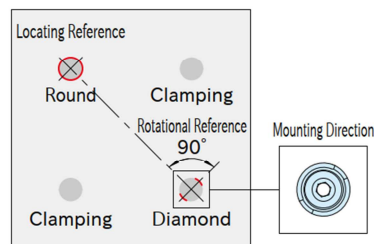
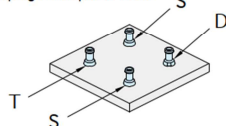


Use of 4 or More Pins

Type T Round Pin: 1 pc

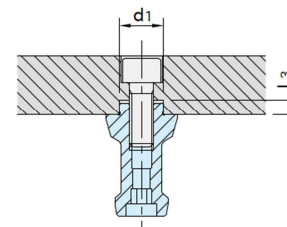
Type D Diamond Pin: 1 pc

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



How To Use

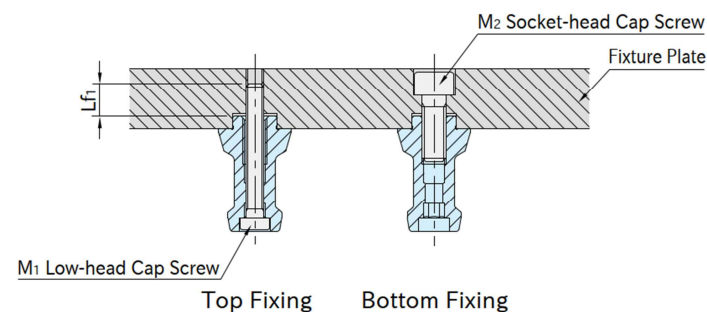
Mounting Hole Dimension



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

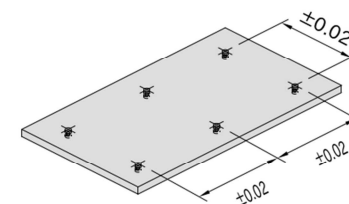


Size	M ₁	L _{f1}	M ₂
AMWFH105-M8	M 6×1 -45L	11	M 8
AMWFH140-M12	M10×1.5 -60L	15	M12
AMWFH140-M16	M12×1.75-65L	21	M16

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 .



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