

QLSWC

SWING CLAMPS



(Black Oxide Finish)

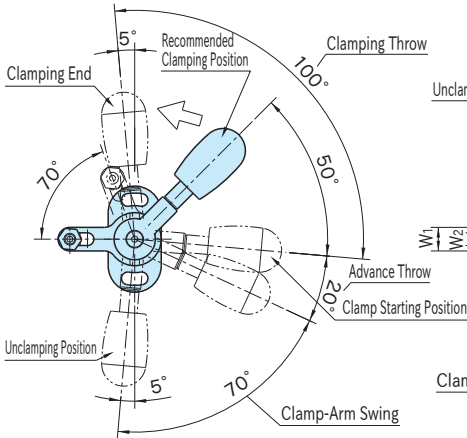
(Electroless Nickel Plated)

On Request

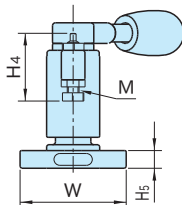
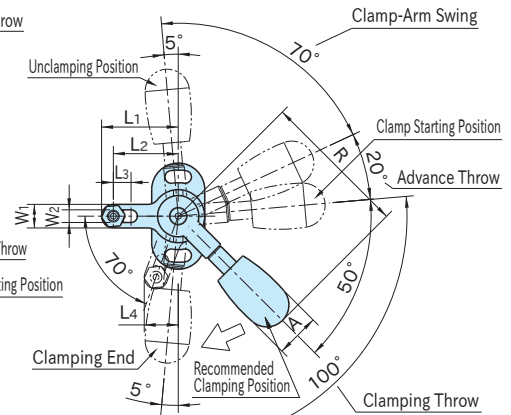


Type	Body/Handle/Clamping Spindle	Arm	Cam Shaft	Knob
QLSWC	S45C steel Quenched and tempered Black oxide finish	SCM440 steel Quenched and tempered Black oxide finish	SCM415 steel Quenched and tempered Black oxide finish	Phenolic plastic Black
QLSWC-NP	S45C steel Quenched and tempered Electroless nickel plated	SCM440 steel Quenched and tempered Electroless nickel plated	SCM415 steel Quenched and tempered Electroless nickel plated	

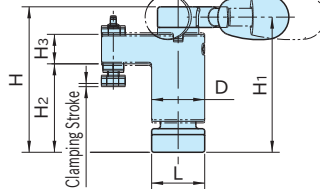
Counterclockwise Clamping



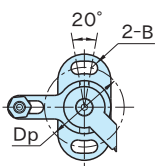
Clockwise Clamping



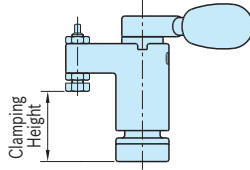
Rough Surface Contact



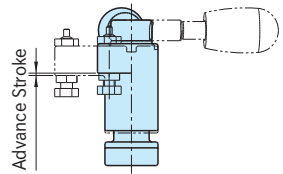
Finished Surface Contact



Mounting Holes



Clamping Height



Advance Stroke

Part Number	Clamping Direction	Clamping Height *)				Clamping Stroke	Advance Stroke	L ₂	L ₃	L ₁	L ₄	W	L	H ₅	B
		Finished Surface Contact		Rough Surface Contact											
		Min.	Max.	Min.	Max.										
QLSWC100R	CW	22.8	24.8	22.4	24.4	1	0.8	22	6	26	11.5	36	18	6	4.3
QLSWC100L	CCW	(22.3~23.3)	(24.3~25.3)	(21.9~22.9)	(23.9~24.9)										
QLSWC150R	CW	31.3	33.3	32.2	34.2	1.4	1.1	30		35	15.3	45	23	8	5.3
QLSWC150L	CCW	(30.6~32)	(32.6~34)	(31.5~32.9)	(33.5~34.9)										
QLSWC200R	CW	32.5	39	33.5	40	1.5	1.4	37	8	45	20.7	65	30	12	8.4
QLSWC200L	CCW	(31.7~33.2)	(38.2~39.7)	(32.7~34.2)	(39.2~40.7)										
QLSWC300R	CW	36.5	46	39	48.5	1.9	1.7	45		55	25.4	85	40	15	10.5
QLSWC300L	CCW	(35.5~37.4)	(45~46.9)	(38~39.9)	(47.5~49.4)										

Part Number	D _p	H	D	W ₁	W ₂	H ₃	H ₂	M	H ₄	R	A	H ₁	Allowable Operating Load (N)**	Clamping Force (kN)	Clamping Mechanism
QLSWC100R	27	49	18	8	4.3	10	30	M 4×0.7	22.8	50	15	45.8	100	1.1	Spiral Cam Cam Angle: 5°
QLSWC100L															
QLSWC150R															
QLSWC150L	34	66	23	10	5.3	14	40	M 5×0.8	28.5	63	20	61.3	150	1.8	Spiral Cam Cam Angle: 5°
QLSWC200R	48	82	30	16	8.4	18	50	M 8×1.25	45.5	80	26	76.5	200	2.2	
QLSWC200L															
QLSWC300R	64	100	40	20	10.4	22	60	M10×1.5	57	100	33	93	300	3.5	Spiral Cam Cam Angle: 4°
QLSWC300L															

QLSWC (Black oxide finish)

QLSWC-NP (Electroless nickel)

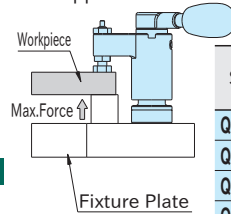
Part Number	Weight (g)	On Request	
		Part Number	Weight (g)
QLSWC100R	112	QLSWC100R-NP	112
QLSWC100L		QLSWC100L-NP	
QLSWC150R	250	QLSWC150R-NP	250
QLSWC150L		QLSWC150L-NP	
QLSWC200R	570	QLSWC200R-NP	570
QLSWC200L		QLSWC200L-NP	
QLSWC300R	1200	QLSWC300R-NP	1200
QLSWC300L		QLSWC300L-NP	

*) Clamping height can be adjusted. The parenthesised values denote clamping height range.

**) Allowable load to operate the handle.

Technical Information

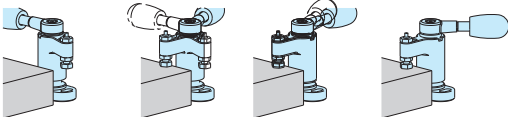
■ Allowable Loads in Machining of Workpiece Bottom
Ensure that any force more than stated below is not applied.



Series	Allowable Force To Workpiece Bottom (Per Clamp)
QLSWC100	max.2.3kN
QLSWC150	max.3.6kN
QLSWC200	max.3.7kN
QLSWC300	max.5.6kN

How To Use

■ Operation of CW Type (Invert the operation for CCW type.)



1. Unclamped Load or unload a part.

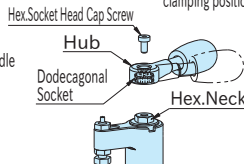
2. Arm Swing
Turn the handle to set the clamp arm in position.

3. Clamping Setup
Continue turning the handle to set the spindle close to the part.

4. Clamping
Turn the handle to the recommended clamping position.

■ How to Change Handle Position

The dodecagonal socket in the hub of the handle allows changing the handle position by 30°.



Performance Curve

