



Pneumatic power clamps are especially suitable for clamping elements during welding, in the automotive industry or where it is necessary that the clamp does not take up a lot of space. Advantage of the clamp is that the parts moving rectilinearly are covered and are thereby protected from flying irons and dust. After clamping, the clamp is mechanically secured and there is no risk of loosening in the event of a compressed air failure.

Min. pressure	0,4 MPa
Max. pressure	0,6 MPa
Ambient temp.	+5°C to +45°C
Working medium	modified compressed air

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Piston diameter [mm]	32	50
Connections	G1/8"	G1/4"
Release angle [°]	105	90, 105, 135
Clamping moment (0.5 MPa) [Nm]	50	125
Locking torque of the clamped position [Nm]	75	400
Working pressure [MPa]	0,4 to 0,6	0,4 to 0,6
End position damping method	rubber stop (requires use of throttle valves on both threaded connections)	
Recommended min. clamping/release time [s]	1	1
Weight [kg]	0,98 (with the arm)	3,98 (with the arm)
Weight of the clamping arm [kg]	0,23	0,97

**Order codes**

18201 10 00 032 0105

Arm position		Piston diameter		Arm opening angle	
10	90° 	032	32 mm	0090	90°
20	180° 	050	50 mm	0105	105°
00	without arm 			0135	135° (only for ø50)

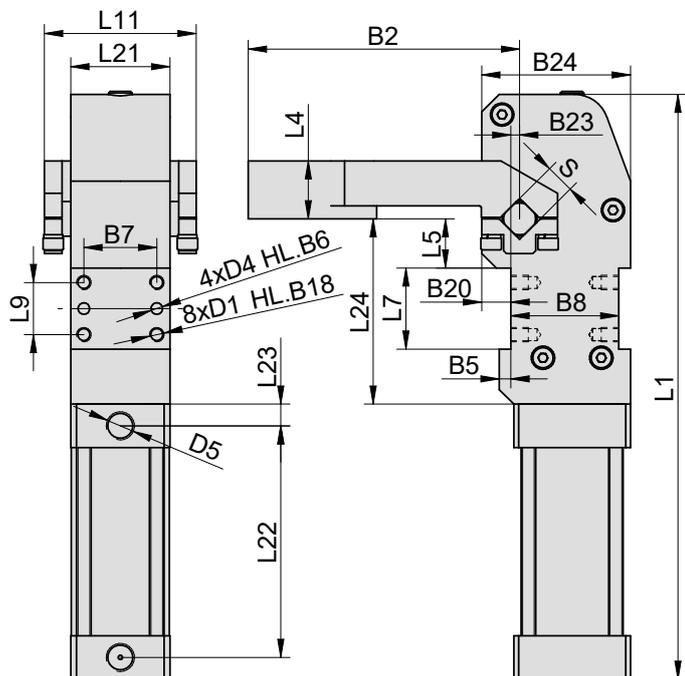
**i** In case of a position sensing request, please contact our technical department



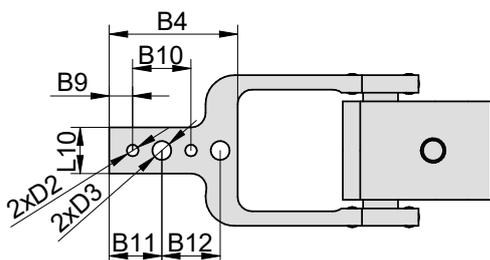
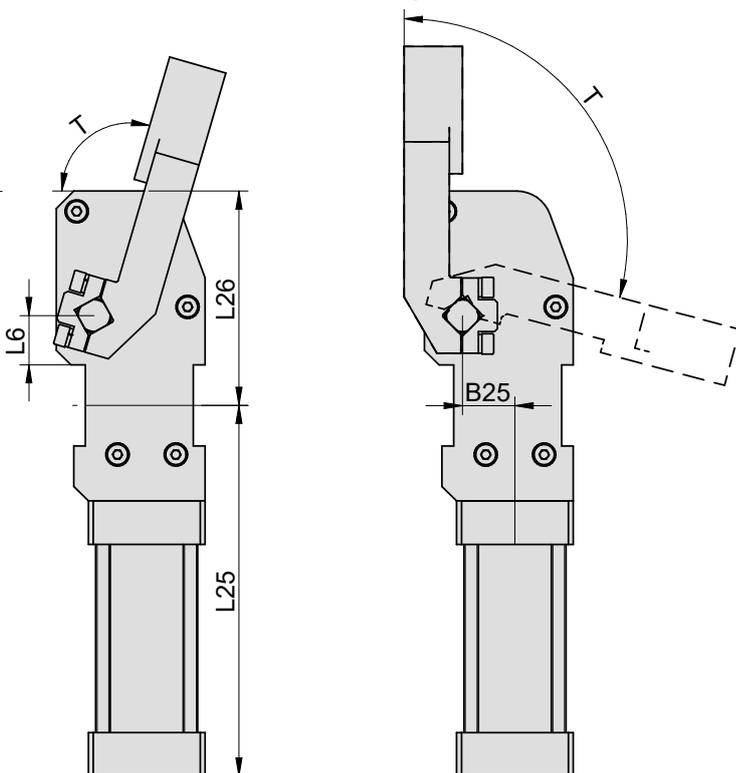
**Caution**

The clamp must be correctly adjusted in its working (clamped) position. The adjustment procedure is described on the next page.

Dimensions  
Arm position 90°



Arm position 180°



∅	B2	B4	B5	B6	B7*	B8 ±0,01	B9	B10 ±0,02	B11	B12 ±0,01	B18	B20	B23	B24	B25	D1	D2 H7	D3	D4 H7	D5	L1	L4 ±0,1
32	93	44	4	-	25	37	8	20	18	20	6	10	3	51	18	M5	4	6,5	-	G1/8"	199	20
50	144	65	6,5	12	30	93	9	30	24	30	13	10,5	13	108	32	M8	6	9	8	G1/4"	322	28

∅	L7 ±0,1	L9 ±0,1	L10	L11	L21	L22	L23	L24	L25	L26	S	T max.
32	28	18	16	52	34	80	7,5	64	128	74	10	105°
50	55	32	20	68	46	134	11	123	200	122	19	135°

\* Tolerance for plain holes ±0.02, for threaded holes ±0.01

Clamp adjusting

For the clamp to function properly, it is very important to ensure its correct adjustment. Correct adjustment ensures the best use of force, low wear and ensures self-locking of the clamp.

Setting procedure:

1. Fit the clamp with the necessary accessories – (clamping tools)
2. Bring the clamp into the closed state
3. Adjust the clamp grip so that it is closed with minimal play without clamping force (can be verified, for example, with paper)
4. Pre-tension the clamping device with screws, or support it with a shim of the thickness 1,5-2,3 mm (for air pressure 0,5 MPa)
5. Pre-tensioning (supporting) must respect the rotation arm in the center of gravity of the clamping device and the value of the

compressed air of the clamp. As the arm is extended, the pre-tensioning (supporting) also increases linearly

6. After test clamping, verify the self-locking of the clamp by releasing the compressed air. The clamps must hold clamped

If a too slim shim (low pre-tension) is used, the clamp will not be used sufficiently and the clamping force will be low.

If a too thick shim is used (significant preload), the clamp will not reach the self-locking clamping area and will again not achieve the necessary clamping force due to the low gear ratio of the link.