

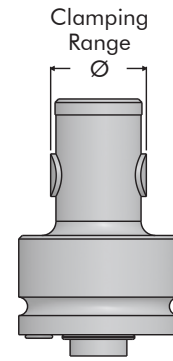
Special Use Clamps

Centering Clamp, Small Bore – 2 Point Contact

Double Acting

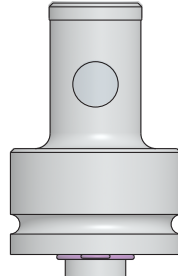
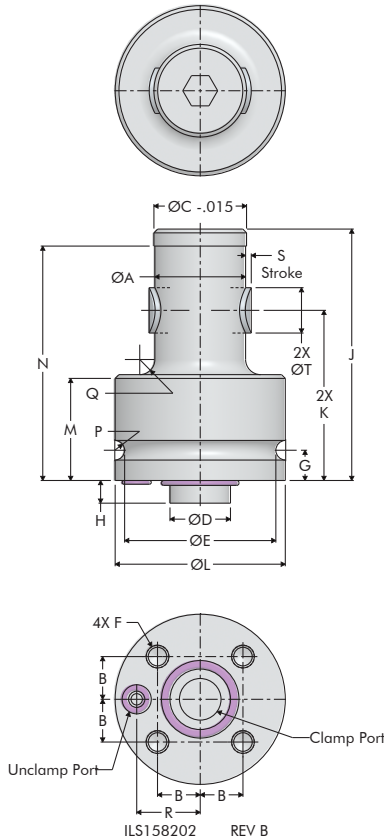
- Often used when trying to locate using 2 bores on the same part. Use the 3 point Centering Clamp for the first bore, the 2 point unit for the second bore. This allows for minimal part variance of the second bore in a third "clocking" axis, while centralizing both. Functioning similar to using round and diamond locators.
- Bore clamp with 2 point used for concentric positioning of a bore.
- Capable of moving a part approximately 0.100" after the part is placed over the center mandrel.
- The clamping points retract for easy loading, then expand hydraulically to center the bore.
- Positional repeatability of $\pm .001$ ".
- Compact design keeps the cylinder out of the way and below the part.

- May be manifold mounted as shown or purchase the optional Mounting Plate for bolt-down or access to porting when mounting.
- Fits bore sizes from 1" to 2.17".
- Can be used to center a slot, keyway or other non-round feature. Requires the use of fixed stops and or additional clamps to resist movement.

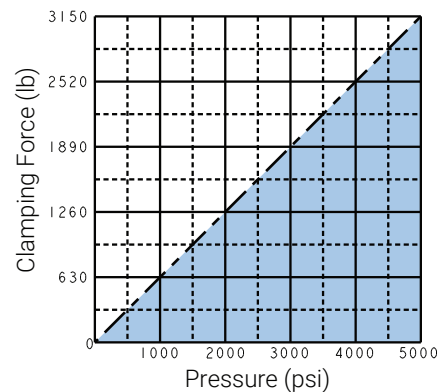


ILS158201 REV B

E-3



Model No.	Clamp Force at 5000 psi (lbs.)	Clamping Points	Clamping Range Ø (in.)	Repeatability \pm (in.)	Oil Capacity (cu. in.)		Weight (lbs.)
					Extend	Retract	
Double Acting (D/A) Cylinders actuated hydraulically both directions.							
15-8210-00	3150	2	.98 - 1.14	.001	.10	.08	.97
15-8211-00			1.10 - 1.26				.99
15-8212-00			1.26 - 1.42				1.01
15-8213-00			1.42 - 1.57				1.27
15-8214-00			1.54 - 1.69		.10	.06	1.30
15-8215-00			1.65 - 1.81				1.33
15-8216-00			1.77 - 1.93				1.37
15-8217-00			1.89 - 2.05				1.40
15-8218-00			2.01 - 2.17				1.44



*Clamp force is the specified force divided by the number of clamping points 1/2 force per point.

Model No.	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R	S	T
15-8210-00			.965															
15-8211-00	.95		1.083						2.62				2.46					
15-8212-00			1.240															
15-8213-00			1.398															
15-8214-00		.445	1.516	.6297	1.575	M6-1.0 x .47	.315	.236		1.77	1.772	1.06		.10	.16	.661	.12	.47
15-8215-00	1.38		1.634	.6293					2.56				2.24					
15-8216-00			1.752															
15-8217-00			1.870															
15-8218-00			1.988															