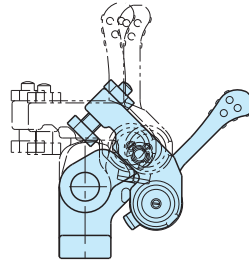
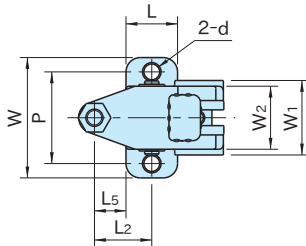
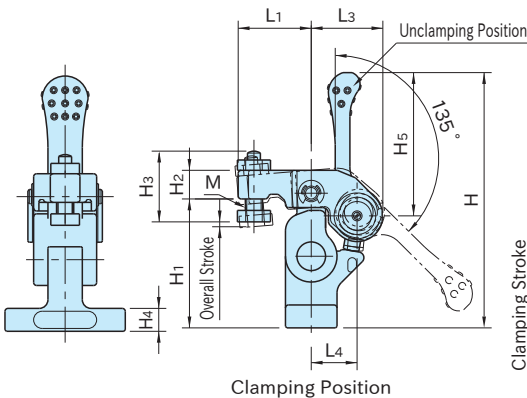




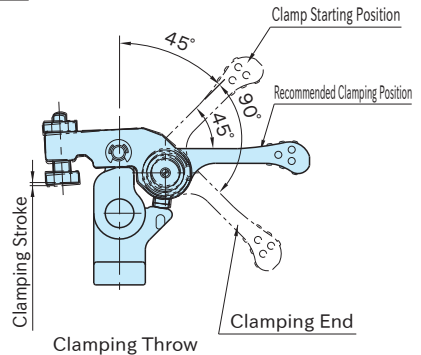
Body/Spindle	Arm/Joint	Cam Handle
S45C steel	SCM435 steel	SCM440 steel
Quenched and tempered	Quenched and tempered	Quenched and tempered
Black oxide finish	Black oxide finish	Black oxide finish



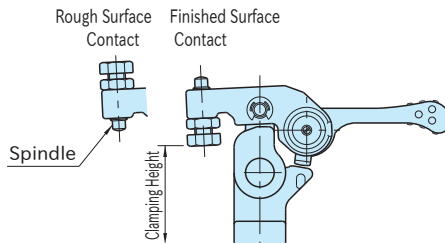
Unclamped



Clamping Position



Clamping Throw



Part Number	Clamping Height *)				Clamping Stroke	Overall Stroke	L ₂	L ₅	W	L	H ₄	d	P	H	L ₁	L ₃
	Finished Surface Contact		Rough Surface Contact													
	min.	max.	min.	max.												
QLRE100	32 (31.5~32.5)	40 (39.5~40.5)	35 (34.5~35.5)	43 (42.5~43.5)	1	1.5	20	11	42	18	8	5.5	32	89	25.5	25
QLRE150	37 (36.4~37.6)	48 (47.4~48.6)	42 (41.4~42.6)	53 (52.4~53.6)	1.2	1.8	25	14	52	22	10	6.6	40	109	32	31

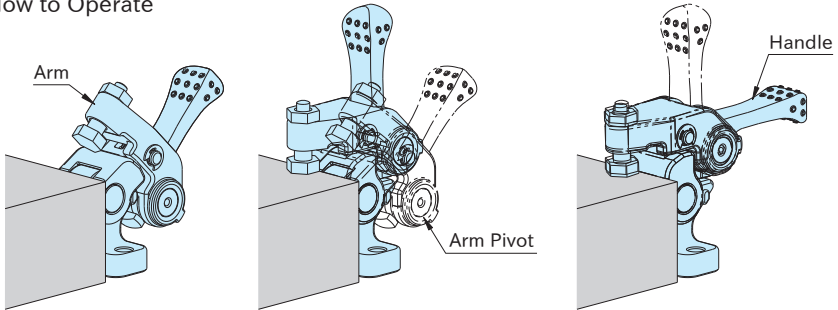
*) Clamping height can be adjusted. The parenthesised values denote actual clamping height.

Part Number	W ₁	W ₂	H ₂	H ₁	M	H ₃	H ₅	L ₄	Cam Handles Part Number	Allowable Operating Load (N)**)	Clamping Force (kN)	Clamping Mechanism	Weight (g)
QLRE100	26	22	10	45	M6×1	24	50	16	QLCA-05	100	0.7	Spiral Cam	244
QLRE150	32	28	12	55	M8×1.25	30.5	63	20	QLCA-06	150	1.1	Cam Angle: 4°	468

***) Allowable load to operate the handle

How To Use

How to Operate



1. Unclamped
Load a workpiece.

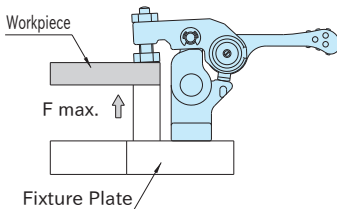
2. Clamping Setup
Set the arm in clamping position holding it at the arm pivot.

3. Clamping
Set the handle down to clamp the workpiece.
(For unclamping, follow the above steps back.)

Technical Information

Allowable Loads in Machining of Workpiece Bottom

Ensure that any force more than stated below is not applied.



Part Number	Allowable Force to Workpiece Bottom (per Clamp)
QLRE100	max. 5kN
QLRE150	max. 6kN

Performance Curve

