

# 7 MPa Work Support and Clamp Systems

## Clamps and Work Supports as a System

- Link Clamps, Swing Clamps, and Work Supports are designed to work as a system.
- Clamps and Work Supports work together at the same pressure.
- Sequencing is required and must occur above 2.5 MPa.
- Clamps do not need pressure reduction when clamping over a work support and operating in the range of 4 to 7 MPa. This applies even when Vektek extended arms are used.

Off the shelf Swing Clamp arms and Link Clamp levers designed to the correct length for clamping over work support centerline.

Swing Clamp arms can be found on page D-2 and Link Clamp Levers on page F-1.



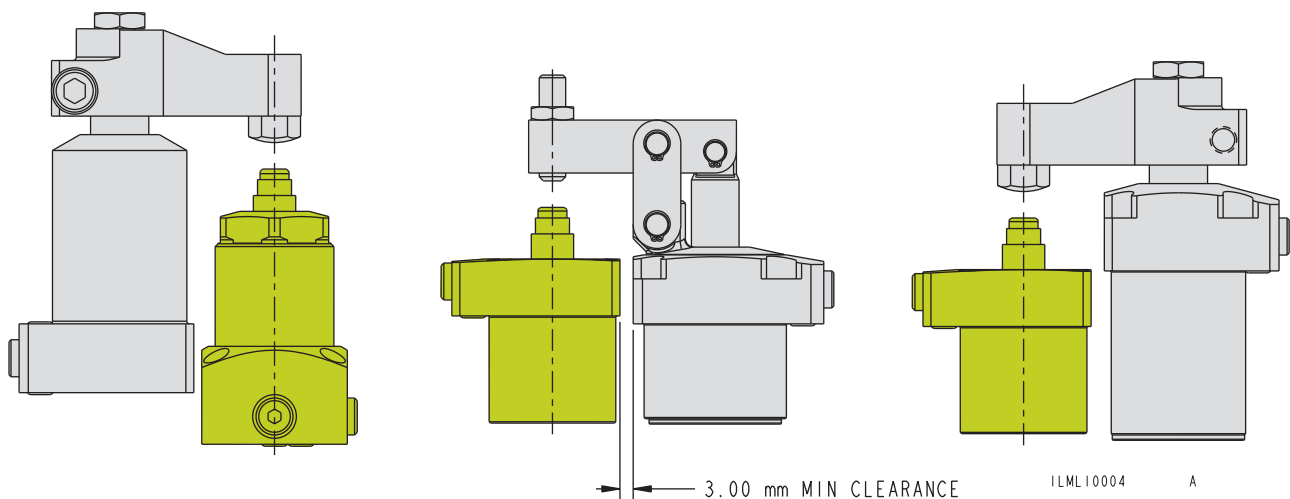
**Clamping Over Work Supports,  
Paired for your Convenience**

## Swing or Link Clamps Paired with the Right Work Support

Clamping Force (kN)	Swing Clamp Models	Bore Size	Link Clamp Models	Work Support Models	Work Support Capacity (kN)
0.9 - 1.7	L1-4X25-00	25	L1-6025-00	L1-0X12-00	4.0
1.6 - 3.2	L1-4X32-00	32	L1-6032-00	L1-0X15-00	5.5
2.6 - 5.1	L1-4X40-00	40	L1-6040-00	L1-0X16-00	10.0
4.3 - 7.6	L1-4X50-00	50	L1-6050-00	L1-0X20-00	16.0
6.9 - 12.6	L1-4X63-00	63	L1-6063-00	L1-0X22-00	26.0

Pairs deliver at least 1.5 to 1 Work Support to Clamp Capacity Ratio

**WARNING: Operating Work Supports above 7 MPa may damage the work support and will void warranty.**



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Clamp sequencing must always occur above 2.5 MPa.

Operating Pressure (MPa)	4.0 kN Work Support Work Support Capacity (kN)	25 Bore Swing Clamp Swing Clamp Force (kN)*	Swing Clamp to Work Support Support Capacity Ratio	25 Bore Link Clamp Link Clamp Force (kN)**	Link Clamp to Work Support Support Capacity Ratio
7.0	4.0	1.7	2.4	1.5	2.7
6.0	3.3	1.4	2.4	1.3	2.6
5.0	2.7	1.2	2.3	1.1	2.5
4.0	2.0	0.9	2.1	0.9	2.2

ILML10005-4.0 REV A      \*Using L9-1425-01 Arm      \*\*Using L9-1625-03 Lever

Operating Pressure (MPa)	5.5 kN Work Support Work Support Capacity (kN)	32 Bore Swing Clamp Swing Clamp Force (kN)*	Swing Clamp to Work Support Support Capacity Ratio	32 Bore Link Clamp Link Clamp Force (kN)**	Link Clamp to Work Support Support Capacity Ratio
7.0	5.5	3.2	1.7	2.9	1.9
6.0	4.6	2.7	1.7	2.5	1.8
5.0	3.7	2.3	1.6	2.0	1.9
4.0	2.8	1.8	1.6	1.6	1.8

ILML10005-5.5 REV A      \*Using L9-1432-01 Arm      \*\*Using L9-1632-03 Lever

Operating Pressure (MPa)	10 kN Work Support Work Support Capacity (kN)	40 Bore Swing Clamp Swing Clamp Force (kN)*	Swing Clamp to Work Support Support Capacity Ratio	40 Bore Link Clamp Link Clamp Force (kN)**	Link Clamp to Work Support Support Capacity Ratio
7.0	10.0	5.1	2.0	4.5	2.2
6.0	8.3	4.4	1.9	3.9	2.1
5.0	6.7	3.7	1.8	3.2	2.1
4.0	5.0	2.9	1.7	2.6	1.9

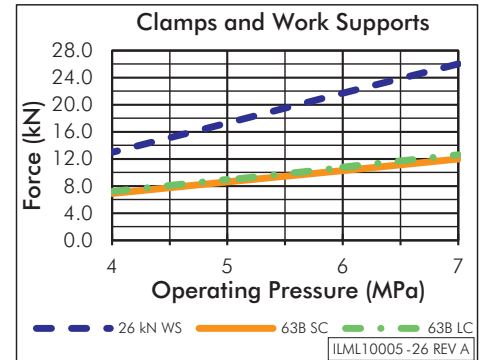
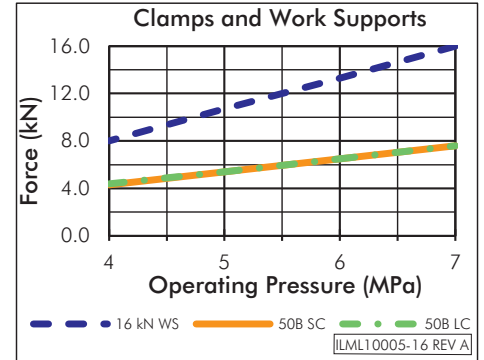
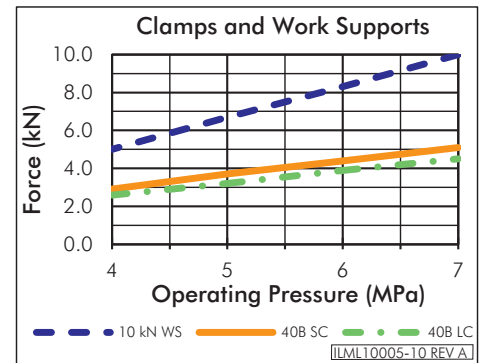
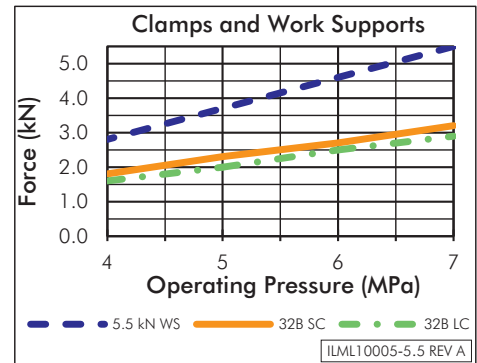
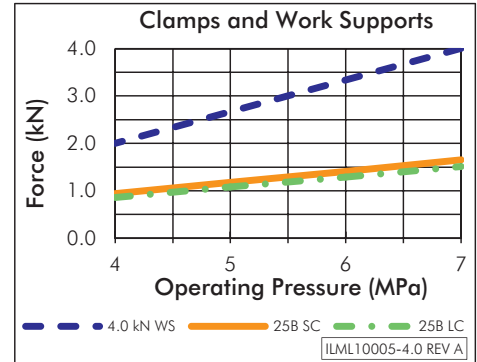
ILML10005-10 REV A      \*Using L9-1440-01 Arm      \*\*Using L9-1640-03 Lever

Operating Pressure (MPa)	16 kN Work Support Work Support Capacity (kN)	50 Bore Swing Clamp Swing Clamp Force (kN)*	Swing Clamp to Work Support Support Capacity Ratio	50 Bore Link Clamp Link Clamp Force (kN)**	Link Clamp to Work Support Support Capacity Ratio
7.0	16.0	7.6	2.1	7.6	2.1
6.0	13.3	6.5	2.0	6.5	2.0
5.0	10.7	5.4	2.0	5.4	2.0
4.0	8.0	4.3	1.9	4.4	1.8

ILML10005-16 REV A      \*Using L9-1450-01 Arm      \*\*Using L9-1650-03 Lever

Operating Pressure (MPa)	26 kN Work Support Work Support Capacity (kN)	63 Bore Swing Clamp Swing Clamp Force (kN)*	Swing Clamp to Work Support Support Capacity Ratio	63 Bore Link Clamp Link Clamp Force (kN)**	Link Clamp to Work Support Support Capacity Ratio
7.0	26.0	12.0	2.2	12.6	2.1
6.0	21.7	10.3	2.1	10.8	2.0
5.0	17.3	8.6	2.0	9.0	1.9
4.0	13.0	6.9	1.9	7.2	1.8

ILML10005-26 REV A      \*Using L9-1463-01 Arm      \*\*Using L9-1663-03 Lever



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