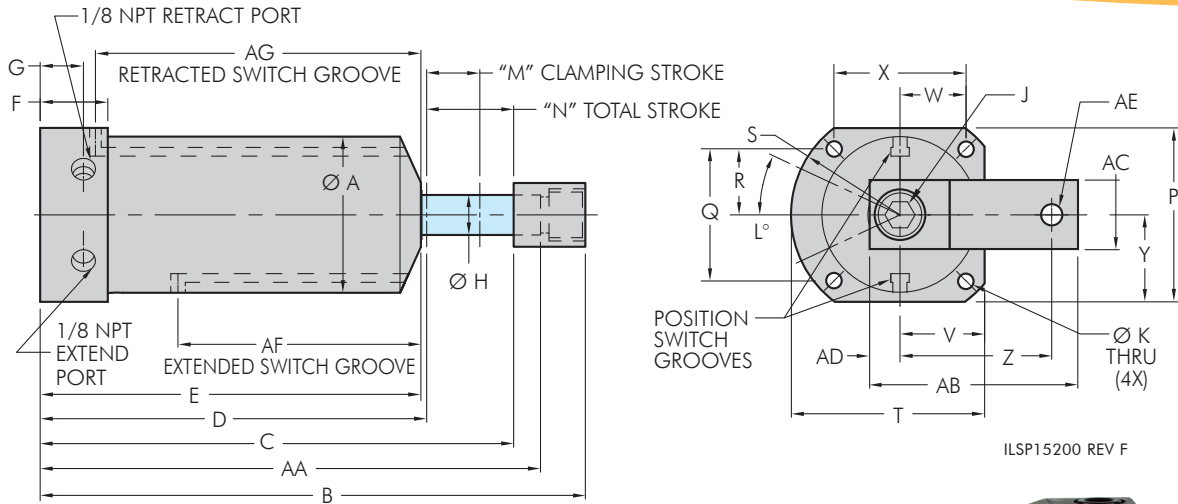


Swing Clamps

Bottom Flange Specifications



ILSP15200 REV F

B-4

Swing Direction	Bottom Flange Swing Clamp Model Numbers					
RIGHT HAND	P1-5041-00	P1-5071-00	P1-5111-00	P1-5141-00	P1-5201-00	P1-5241-00
LEFT HAND	P1-5047-00	P1-5077-00	P1-5117-00	P1-5147-00	P1-5207-00	P1-5247-00
STRAIGHT	P1-5049-00	P1-5079-00	P1-5119-00	P1-5149-00	P1-5209-00	P1-5249-00
Bore	0.500	0.875	1.125	1.500	2.000	2.500
Ø A	1.19	1.56	1.81	2.25	2.69	3.19
B	4.86	5.48	5.48	8.24	8.24	8.20
C	4.36	4.79	4.79	7.11	7.11	7.07
D	3.67	3.97	3.97	5.61	5.61	5.57
E	3.59	3.91	3.91	5.47	5.47	5.47
F	0.84	0.91	0.91	0.97	0.97	0.97
G	0.56	0.56	0.56	0.62	0.62	0.62
Ø H	0.25	0.50	0.50	0.63	0.63	0.75
J	8-32 x .5	5/16-18 x .5	5/16-18 x .5	3/8-24 x .75	3/8-24 x .75	3/8-24 x .75
Ø K	0.17	0.19	0.19	0.22	0.22	0.28
L°	23	25	25	25	25	25
M RIGHT HAND	0.40	0.47	0.47	0.75	0.75	0.75
LEFT HAND	0.40	0.47	0.47	0.75	0.75	0.75
STRAIGHT	0.69	0.82	0.82	1.50	1.50	1.50
N	0.69	0.82	0.82	1.50	1.50	1.50
P	1.44	1.75	2.00	2.50	2.87	3.40
Q	1.10	1.37	1.55	1.90	2.21	2.61
R	0.55	0.69	0.78	0.95	1.10	1.30
S	0.94	1.19	1.31	1.56	1.81	2.13
T	1.67	2.06	2.28	2.78	3.24	3.81
V	0.73	0.87	0.97	1.22	1.43	1.68
W	0.55	0.69	0.78	0.95	1.10	1.30
X	1.10	1.37	1.55	1.90	2.21	2.61
Y	0.72	0.88	1.00	1.25	1.44	1.70
Z	1.13	1.50	1.50	2.18	2.18	2.43
AA	4.59	5.02	5.02	7.56	7.56	7.56
AB	1.59	2.19	2.19	2.99	2.99	3.31
AC	0.38	0.63	0.63	0.75	0.75	0.87
AD	0.31	0.44	0.44	0.44	0.44	0.50
AE	8-32	1/4 - 20	1/4 - 20	3/8 - 16	3/8 - 16	3/8 - 16
AF	2.12	2.37	2.37	3.87	3.87	3.87
AG	2.91	3.16	3.16	4.66	4.66	4.66
Effective Piston Area (sq. in.)* -- See * statment for right						
Extend	0.20	0.60	1.00	1.77	3.14	4.91
Retract	0.15	0.40	0.80	1.46	2.83	4.47
Air Usage (cu. in.) Per complete cycle	0.25	0.80	1.50	5.00	9.00	14.00



Bottom Flange Swing Clamp

* See graphs on page B-7 for clamp curves and extended arm performance force. It is recommended that the clamp position be set at about 50% of the clamp stroke. These devices should be positioned in no less than 1/2 second.

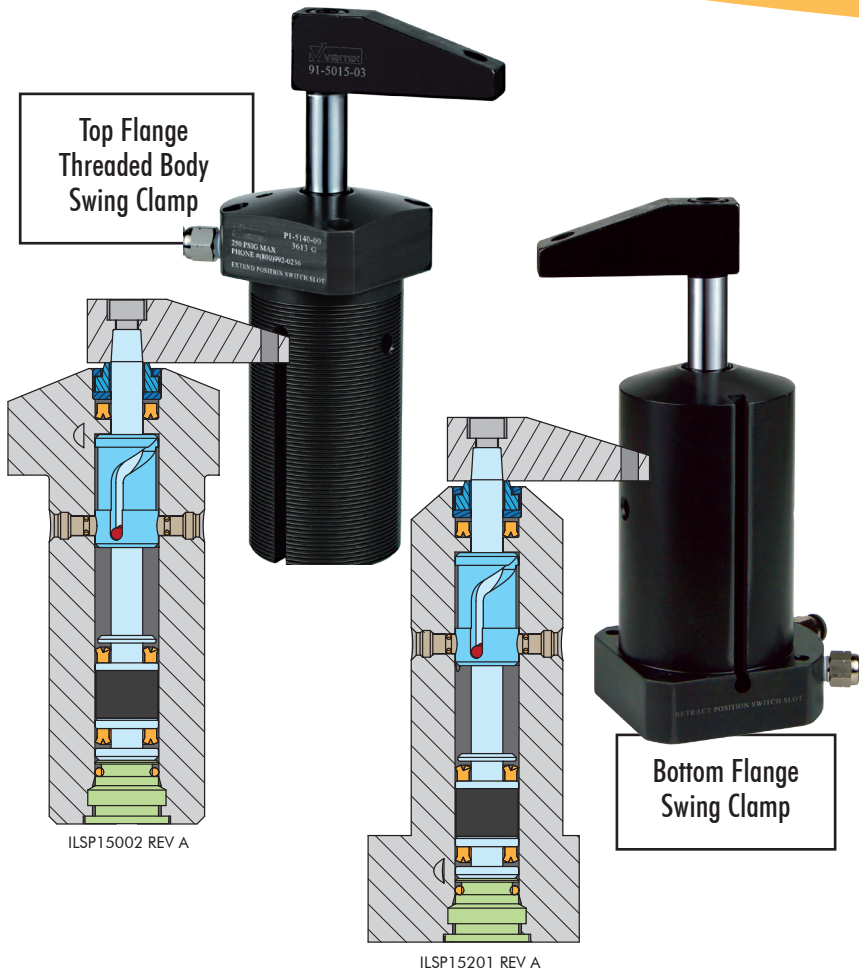
These recommendations apply when using the standard arm. When using the extended or large custom arms, allow 1 second for positioning.



Swing Clamps

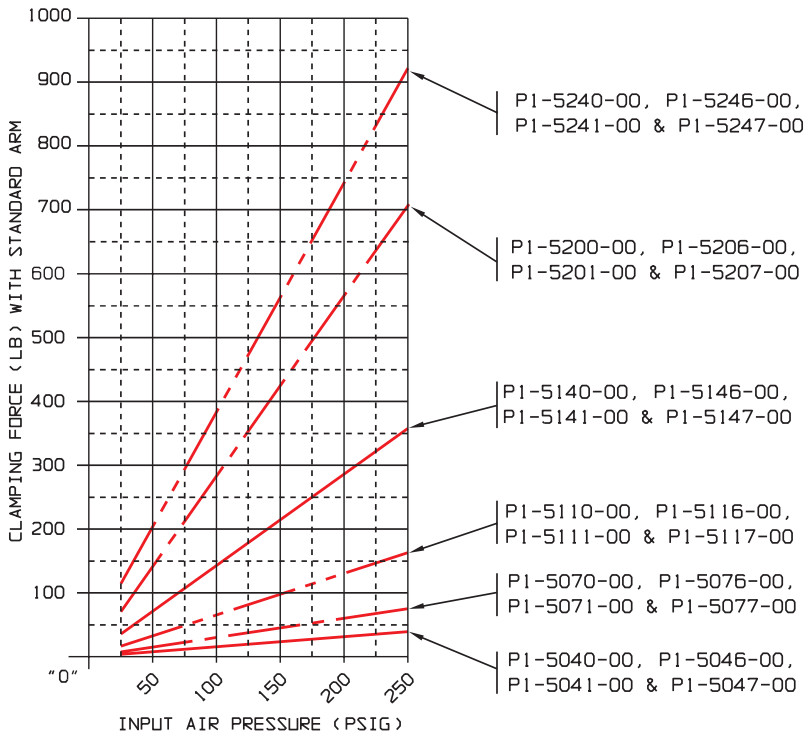
Standard Features

B-2



- Arms swing 90°.
- Our cap screw arm design is available. You may modify our arm, or we have provided you with dimensions to make your own.
- Special wipers and swept-line cylinder tops help keep chips from packing and coolant contaminants from entering the swing clamp.
- Swing clamp bodies are wrought aluminum alloy with PHC™ (Pneumatic Hardcoat) coating on all external and internal surfaces. This gives the clamps extended life.
- Plungers are carbon steel with hard chrome plating. The guide bushings are hardened alloy steel.
- All dynamic seals are internally lubricated and made from a specially compounded elastomer to promote smooth break away and low operational drag.
- Six bore sizes are available in two mounting styles to best adapt to your application.
- All models are available in straight pull and left or right swings.
- Magnetic pistons are standard on all models, allowing you to use position-indicating sensors.
- Position sensors mount within the clamp's space envelope so sensor usage doesn't encroach on the clamp's mounting envelope.
- Position sensors have an LED indicator to reduce setup time.
- All swing clamps have internal orifices to prevent cam damage caused from over accelerating the clamp.
- VektorAir™ clamps are double acting to reduce mounting envelope and prevent non-return and slow return problems inherent with single acting clamps.
- To determine whether a straight pull, left or right swing should be specified, imagine viewing the arm from above during the clamping stroke. Arms moving clockwise are right hand swings, counter-clockwise are left hand swings.

Product Clamping Forces



ILSP15001 REV D

800-992-0236

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