

HYDRAULIC, FIXED CLAMP HEIGHT, ROCKER STYLE LEDGE CLAMPS



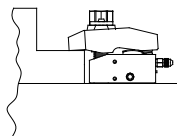
Use Ledge Clamps (Fixed Clamp Height Rocker Clamps) with dies having a clamp plate that sticks out from the die body or has a large slot.

WHEN TO USE FIXED CLAMP HEIGHT ROCKER CLAMPS:

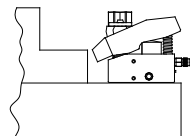
Use Fixed Clamp Height Rocker Clamps with dies having an open ledge clamp plate or a slot in the die large enough to accommodate the clamp nose for full clamp engagement. Ledge brackets, bars, or ears may also be added to dies in some applications to accommodate the clamps and/or plates milled to set a common clamp height.

If systems are setup to have hydraulics removed during stamping, Hydra Mechanical (L style) clamps (with a mechanical lock) should be selected. If a dedicated hydraulic system is considered, the Fully Hydraulic clamps (with either multiple upper zone control or check valves) may be the preferred choice.

Clamp model and quantity should be selected to provide a total clamping force greater than the total (static and dynamic) force applied to the system during use.



Clamp securing die. Pistons are partially extended and providing force before reaching end of stroke.

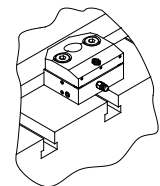


Clamp actuated away from die. Pistons are fully extended.

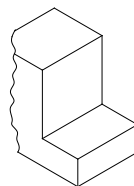
HOW THEY WORK:

Ledge Clamps are moved into position with the lower body stop set against the die plate (gaps between clamp and die/slot allow movement) or may be permanently mounted on one side to act as a side stop.

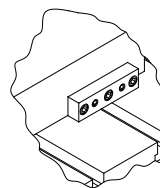
When hydraulic pressure is applied, the clamp nose moves downward onto the plate, clamping the die. Hydraulic pressure is maintained during operation, or the Locking Nut (L style) is engaged to allow removal of clamp hydraulic pressure during stamping. To unclamp, hydraulic pressure is removed and clamps open under internal spring force. (Note: Reapplication of hydraulics is required to unlock the Locking Clamps (L) prior to releasing pressure and unclamping).



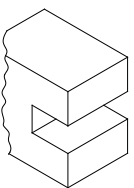
Underplate



Parallel with Ledge

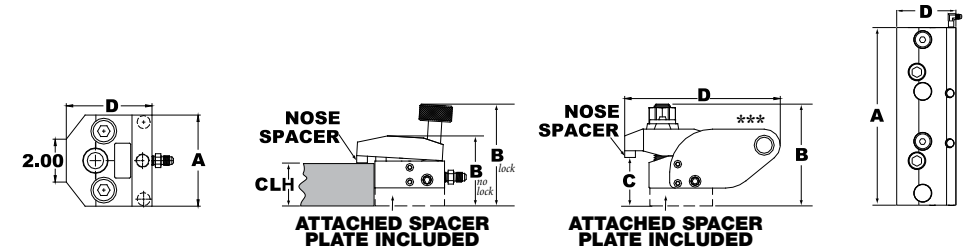


Bolt-on Bar



Parallel with Slot

STANDARD CLAMP CONFIGURATIONS



***HANDLES (H) AVAILABLE ON ALL MODELS	Model 425	Model 425L	Model 428	Model 428L	Model 126	Model 126L	Model 128	Model 128L	
Clamping Force at 5,000 PSI	8,000 lbs.		10,000 lbs.		22,000 lbs.		26,000 lbs.		
T-Nut Spacing	N/A		N/A		6"		6"		
A	4.25" no handle 4.50" with handle		4.25" no handle 4.50" with handle		12"		12"		
B**	CLH*	NO LOCK	LOCK (L)	NO LOCK	LOCK (L)	NO LOCK	LOCK (L)	NO LOCK	LOCK (L)
	.50"	2.75"	4.25"	3.75"	4.25"	2.75"	4.25"	3.75"	4.25"
	.75"	2.75"	4.25"	3.75"	4.25"	2.75"	4.25"	3.75"	4.25"
	1.00"	2.75"	4.25"	3.75"	4.25"	2.75"	4.25"	3.75"	4.25"
	1.25"	3.00"	4.50"	3.75"	4.25"	3.00"	4.50"	3.75"	4.25"
	1.50"	3.25"	4.75"	4.00"	4.50"	3.25"	4.75"	4.00"	4.50"
	1.75"	3.50"	5.00"	4.25"	4.75"	3.50"	5.00"	4.25"	4.75"
2.00"	3.75"	5.25"	4.50"	5.00"	3.75"	5.25"	4.50"	5.00"	
2.50"	4.25"	5.75"	5.00"	5.50"	4.25"	5.75"	5.00"	5.50"	
**	**	**	**	**	**	**	**	**	
C	Jaw Opening to Match CLH* + .18" gap		Jaw Opening to Match CLH* + .18" gap		Jaw Opening to Match CLH* + .18" gap		Jaw Opening to Match CLH* + .18" gap		
D	4.00" no handle 7.25" with handle		4.75" no handle 7.25" with handle		4.00" no handle 7.25" with handle		4.75" no handle 7.25" with handle		
Weight (approx.)	8 lbs.		12 lbs.		25 lbs.		35 lbs.		



*CLH= Clamping height – Nominal Clamp Plate Thickness. Clamp provided with "C" open dimension to allow for .090" die lifter rail clearance and gap for moving clamp in and out of position. Clamping height is based on standard JIC T-Slot dimensions. T-Slot dimensions are typically neck height .875" for 3/4" slot and 1.00" for 1" slot.

** B = Product Height Dimension is related to clamp height needed for clamp plate thickness. Stock sizes listed, but others are easily available. Allow 1/2" more for nominal variations.

***Handles (H) available on all models. Contact PFA for details.

Example: 8,000 lb. die. Use 8,000 clamp such as Model 425, clamp plate thickness (CLH) is 1.0" and has 3/4 T-Slot.

Clamp Style	Model Number	Clamp Height*	Slot Type
	See chart above	Clamp Plate Thickness (CLH)	3/4" slot = 3/4 1" slot = 1
RC	425LH	1.0	3/4

Locking (L) and Handle (H) are added directly after the main model number. Examples are 425, 425L, 425H and 425LH.

Part No: **RC-425LH-1.0-3/4**