



( CCW Clamping )  
( With Handle )



( CW Clamping )  
( Without Handle )



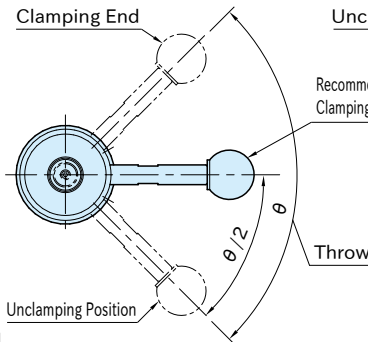
( CW Clamping )  
( With Handle )

Note: Clamping Pins or Screws must be ordered separately.

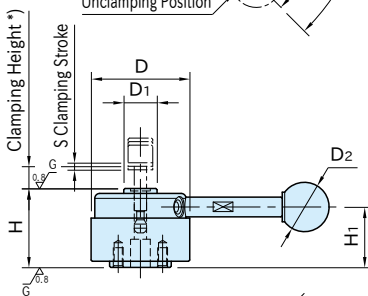
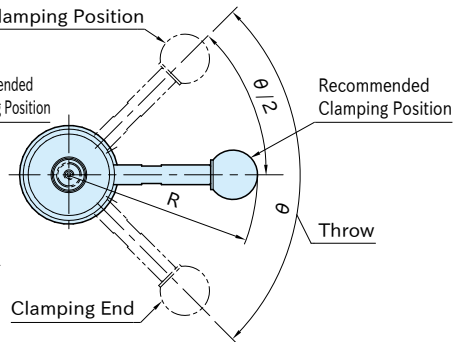
★Key Point  
Easy clamping without screws.

Body	Handle Shank	Ball Knob
SCM440 steel Quenched and tempered Black oxide finish	S45C steel Black oxide finish	ABS resin Black

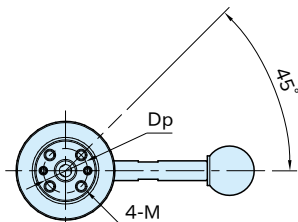
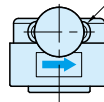
Counterclockwise Clamping



Clockwise Clamping

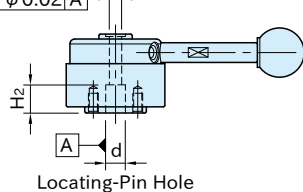


M1-3 Handle Mounting Holes  
(Angle between 2 holes:30°)  
3 Options of Handle Mounting Position



$\phi 0.02$  A

d (Clamping-Pin or Clamping-Screw Setting Hole)



Type	S	d (G6)	d <sub>1</sub> (F7)	H <sub>2</sub>	D <sub>1</sub>	H (±0.01)	D	θ	Dp	M
<b>QLPD150</b>	1.5	8	5	10	13.5	32	40	90°	18	M4×0.7 Depth 8
<b>QLPD200</b>	2	12	8	13	18	40	50	110°	25	M6×1 Depth 9

Type	M <sub>1</sub>	H <sub>1</sub>	Clamping Force (kN)	Clamping Mechanism	Recommended Workpiece Thickness Tolerance **)
<b>QLPD150</b>	M5×0.8	24.5	0.9	Spiral Cam Cam Angle: 4°	±0.3
<b>QLPD200</b>	M6×1	30.7	2.5		±0.5

■ With Handle

Part Number	Clamping Direction	R	D <sub>2</sub>	Allowable Operating Load(N) ***)	Weight (g)
<b>QLPD150R</b>	CW	76.5	20	150	245
<b>QLPD150L</b>	CCW				
<b>QLPD200R</b>	CW	111.5	25	200	470
<b>QLPD200L</b>	CCW				

■ Without Handle \*\*\*\*)

Part Number	Clamping Direction	Weight (g)
<b>QLPD150NR</b>	CW	220
<b>QLPD150NL</b>	CCW	
<b>QLPD200NR</b>	CW	420
<b>QLPD200NL</b>	CCW	

\* ) Grip length of **QLPD-X** Clamping Pin (workpiece thickness)

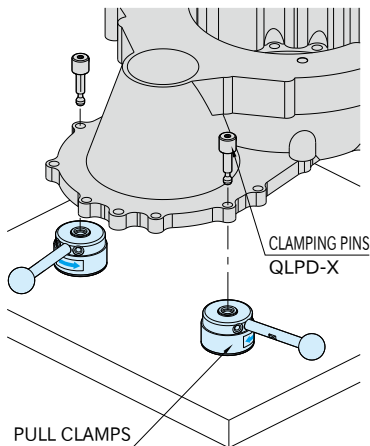
\*\* ) Maintaining these recommended tolerances allows minimizing the variation of handle position in the clamping mode in clamping with the use of the Clamping Pin.

\*\*\* ) Allowable load to operate the handle.

\*\*\*\* ) The handle must be ordered separately.

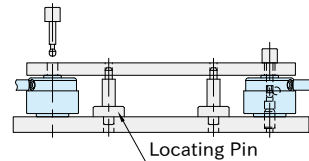
- **QLSL** STANDARD HANDLES
- **QLTL** ADJUSTABLE-TORQUE HANDLES

**How To Use**



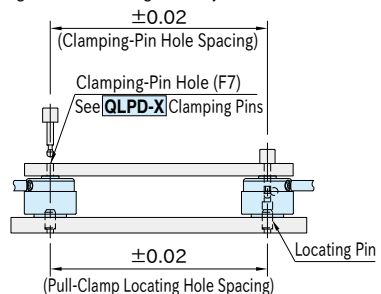
■ How to Locate Workpiece

1. Basic Method



2. Method for clamping and locating a workpiece at a time

Give an accuracy shown below to the hole spacing to generate a locating accuracy of ±0.08.

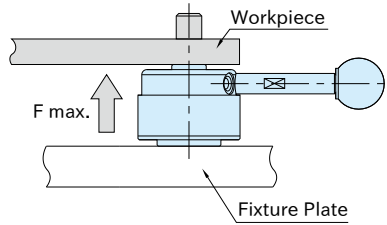


## Technical Information

### Allowable Loads in Machining of Workpiece Bottom


Ensure that a force more than indicated below is not applied to the workpiece bottom.

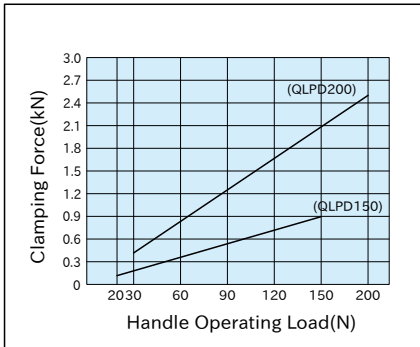
Type	Allowable Force To Workpiece Bottom (Per Clamp)
QLPD150	max.2 kN
QLPD200	max.5.5kN



## Performance Curve


### QLSL STANDARD HANDLES

 The performance curves shown below do not denote the guaranteed performance.



### QLTL ADJUSTABLE-TORQUE HANDLES

Use a force gauge when measuring handle-operating loads.

 The performance curves shown below do not denote the guaranteed performance.

