ONE-TOUCH FASTENERS
ONE-TOUCH FASTENERS

QUARTER-TURN CLAMPS
Part No. QCTH / QCTHL / QCTHH

RETRACTABLE QUARTER-TURN CLAMPS
Part No. QCTHA

CAM RECEPTACLES
Part No. QCTH-N / QCTH-B

HEAVY DUTY QUARTER-TURN CLAMPS
Part No. QCTHS

RETRACTABLE HEAVY DUTY QUARTER-TURN CLAMPS
Part No. QCTHSA

SPACER
Part No. QCTHSA

LOCKING RECEPTACLE
Part No. QCTHS-B

KNOB-LOCKING PINS
Part No. QCWE

BUTTON-LOCKING PINS
Part No. QCBU / QCBUS

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Screwless! Time Saving!

ONE-TOUCH FASTENERS

Alternatives To Screws

Easy! Secure!

Kaizen for Frequent Setups!
Quick fasteners alternative to screws for quick changeover with no tools!
One-Touch Fasteners slash setup time and provide secure locking with easy operation.

Lineup

<table>
<thead>
<tr>
<th>QUARTER-TURN CLAMPS</th>
<th>RETRACTABLE QUARTER-TURN CLAMPS</th>
<th>HEAVY DUTY QUARTER-TURN CLAMPS</th>
<th>RETRACTABLE HEAVY DUTY QUARTER-TURN CLAMPS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Easy-to-read ON/OFF position</td>
<td>No interference by retractable shank</td>
<td>Clamping force 400N</td>
<td>Clamping force 400N Retractable shank</td>
</tr>
</tbody>
</table>

CAD Download: https://www.imao.biz/en
**QCTH / QCTHL / QCTHH**

**QUARTER-TURN CLAMPS**

<table>
<thead>
<tr>
<th>Type</th>
<th>Body</th>
<th>Shank</th>
<th>Pin</th>
<th>Knob</th>
<th>Spring</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTH</td>
<td>SUS303 stainless steel</td>
<td>S45C steel Electroless nickel plated</td>
<td>SUS304 stainless steel</td>
<td>Polyamide (glass fiber reinforced) Black SC513 stainless steel (Equivalent to SUS304)</td>
<td>Equivalent to SWOSC-V steel</td>
</tr>
<tr>
<td>QCTH-S</td>
<td>SUS303 stainless steel</td>
<td>SUS304 stainless steel</td>
<td>SUS304 stainless steel</td>
<td>SC513 stainless steel (Equivalent to SUS304)</td>
<td>SUS304 stainless steel</td>
</tr>
<tr>
<td>QCTH-SUS</td>
<td>SUS303 stainless steel</td>
<td>SUS304 stainless steel</td>
<td>SUS304 stainless steel</td>
<td>SC513 stainless steel (Equivalent to SUS304)</td>
<td>SUS304 stainless steel</td>
</tr>
<tr>
<td>QCTHL-S</td>
<td>SUS303 stainless steel</td>
<td>SUS304 stainless steel</td>
<td>SUS304 stainless steel</td>
<td>SC513 stainless steel (Equivalent to SUS304)</td>
<td>SUS304 stainless steel</td>
</tr>
<tr>
<td>QCTHH</td>
<td>SUS303 stainless steel</td>
<td>SUS304 stainless steel</td>
<td>SUS304 stainless steel</td>
<td>SC513 stainless steel (Equivalent to SUS304)</td>
<td>SUS304 stainless steel</td>
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</table>

★ Key Point
Easy-to-read ON/OFF position

**CAD Download**: https://www.imao.biz/en
### ONE-TOUCH FASTENERS

#### Specification Table

<table>
<thead>
<tr>
<th>Size</th>
<th>Proper Plate Thickness</th>
<th>D₂ (h9)</th>
<th>D₃ L</th>
<th>H₁</th>
<th>M</th>
<th>Dp</th>
<th>Clamping Force (N)</th>
<th>Proper Cam Receptacles</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTH</td>
<td>0525-10</td>
<td>6~10</td>
<td>5</td>
<td>14</td>
<td>25</td>
<td>6.5</td>
<td>M2×0.4 Depth 3</td>
<td>21</td>
</tr>
<tr>
<td>QCTH-S</td>
<td>0834-14</td>
<td>6~14</td>
<td>8</td>
<td>18</td>
<td>34</td>
<td>17</td>
<td>M3×0.5 Depth 4</td>
<td>28</td>
</tr>
<tr>
<td>QCTH-SUS</td>
<td>0834-20</td>
<td>12~20</td>
<td>8</td>
<td>18</td>
<td>34</td>
<td>17</td>
<td>M3×0.5 Depth 4</td>
<td>28</td>
</tr>
</tbody>
</table>

#### Feature

The QCTH, QCTH-S, and QCTH-L Series are part of the ONE-TOUCH FASTENER series, which is supplied with QCTH, QCTH-S, QCTH-L, QCTH-SUS, and QCTH-HH series of fasteners. These series are designed for easy installation and removal of fasteners.

#### How To Use

1. **Ensure that the knob is positioned at the "OFF" mark.**
2. **Insert the Quarter-Turn Clamp.**
3. **Turn the knob to the "ON" mark for clamping.** The knob clicks when it is clamped/unclamped. Note: For unclamping, follow back these steps.

#### Technical Information

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Heatresistant Temperature (°C)</th>
<th>Shear Strength (N)</th>
<th>Tensile Strength (N)</th>
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</thead>
<tbody>
<tr>
<td>QCTH</td>
<td>130</td>
<td>1800</td>
<td>1200</td>
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<td>QCTH-S</td>
<td>200</td>
<td>1800</td>
<td>1200</td>
</tr>
<tr>
<td>QCTH-L</td>
<td>0525-10</td>
<td>1800</td>
<td>1200</td>
</tr>
<tr>
<td>QCTH-SUS</td>
<td>0834-14</td>
<td>1800</td>
<td>1200</td>
</tr>
<tr>
<td>QCTH-HH</td>
<td>0834-20</td>
<td>1800</td>
<td>1200</td>
</tr>
</tbody>
</table>

### Contact Information

For CAD and other technical documents, please visit: [https://www.imao.biz/en](https://www.imao.biz/en)
### Application Example

**Changes of camera positions**

![QUARTER-TURN CLAMP QCTH0834-14]

**Changes of fixture plates**

![QUARTER-TURN CLAMPS QCTH0834-14]

![CAM RECEPTACLES QCTH0834-B]

### How To Install

**Equally Spaced**

![Equally Spaced](Image)

**Figure A**

![Diagram](Image)

**Figure B**

![Diagram](Image)

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>Figure</th>
<th>$d_1$</th>
<th>$T$</th>
<th>$d_2$</th>
<th>$d_3$</th>
<th>$Dp$</th>
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</thead>
<tbody>
<tr>
<td><strong>QCTH</strong> 0525-10</td>
<td>Over 6, 10 or less</td>
<td>A</td>
<td>6</td>
<td>—</td>
<td>4.4</td>
<td>2.4</td>
<td>21</td>
</tr>
<tr>
<td><strong>QCTH-S</strong></td>
<td>Over 6, 10 or less</td>
<td>A</td>
<td>6</td>
<td>—</td>
<td>4.4</td>
<td>2.4</td>
<td>21</td>
</tr>
<tr>
<td><strong>QCTHL-S</strong> 0834-14</td>
<td>Over 6, 14 or less</td>
<td>A</td>
<td>35</td>
<td>—</td>
<td>6.5</td>
<td>3.4</td>
<td>28</td>
</tr>
<tr>
<td><strong>QCTH-SUS</strong></td>
<td>Over 12, 20 or less</td>
<td>B</td>
<td>35</td>
<td>—</td>
<td>6.5</td>
<td>3.4</td>
<td>28</td>
</tr>
<tr>
<td><strong>QCTHH</strong> 0834-20</td>
<td>Over 6, 10 or less</td>
<td>A</td>
<td>35</td>
<td>—</td>
<td>6.5</td>
<td>3.4</td>
<td>28</td>
</tr>
</tbody>
</table>
**Accuracy**

**Machining Accuracy**

- Spacing Tolerance ±0.04

**Repeatability**

- Repeatability ±0.1

Locating Pin (Round)

Locating Pin (Diamond)

Spacing tolerance on both the subplate and the base plate should be ±0.04.

**Caution**

Note the following cautions using QCTH-N QCTH-B QCTH-S QCTH-SUS QCTH-L QCTH-H 0525-10

- Any force over 600N or more on the tip of the shaft from any direction can damage the pin.

- The knob operating torque is 0.4 N·m. Note that the excessive operating torque over 2 N·m can damage the pin.

**Reference**

"How To Install" of QCTH-N QCTH-B QCTH-N-SUS QCTH-B-SUS Cam Receptacles
# QCTHA RETRACTABLE QUARTER-TURN CLAMPS

**Key Point**
No interference by retractable shank

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### Specifications

<table>
<thead>
<tr>
<th>Type</th>
<th>Body/Shank</th>
<th>Pin</th>
<th>Knob</th>
<th>Spring A</th>
<th>Spring B</th>
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</thead>
<tbody>
<tr>
<td>QCTHA</td>
<td>S45C steel Electroless nickel plated</td>
<td>SUS304 stainless steel</td>
<td>Polyamide (glass-fiber reinforced) Black</td>
<td>Equivalent to SWOSC-V steel</td>
<td>SUS304WPB stainless steel</td>
</tr>
<tr>
<td>QCTHA-S</td>
<td>SUS303 stainless steel</td>
<td>SUS304 stainless steel</td>
<td>SCS13 stainless steel (Equivalent to SUS304)</td>
<td>SUS304-CSP stainless steel</td>
<td></td>
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<tr>
<td>QCTHA-SUS</td>
<td>SUS303 stainless steel</td>
<td>SUS304 stainless steel</td>
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### Size and Dimensions

<table>
<thead>
<tr>
<th>Size</th>
<th>Proper Plate Thickness D (mm)</th>
<th>D1</th>
<th>D2</th>
<th>L</th>
<th>H1</th>
<th>H2</th>
<th>H3</th>
<th>M</th>
<th>Clamping Force (N)</th>
<th>Proper Cam Receptacles</th>
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<tbody>
<tr>
<td>QCTHA</td>
<td>0525-10</td>
<td>6~10</td>
<td>5</td>
<td>14</td>
<td>25</td>
<td>25</td>
<td>15.5</td>
<td>30</td>
<td>6.5</td>
<td>M2x0.4 Depth 3</td>
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<td>QCTHA-S</td>
<td>QCTH0525-N-SUS, QCTH0525-B-SUS</td>
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<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>QCTHA-SUS</td>
<td>QCTH0834-N, QCTH0834-B</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>0834-14</td>
<td>6~14</td>
<td>6~14</td>
<td>8</td>
<td>18</td>
<td>34</td>
<td>34</td>
<td>17</td>
<td>38</td>
<td>26.5</td>
<td>M3x0.5 Depth 4</td>
</tr>
</tbody>
</table>

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### Feature

![Diagram of Cam Receptacle](image)

The shank retracts at the unclamping position to enable operations without interference with the base plate.

When the pin contacts along the cam surface in the Cam Receptacle, the spring A gets compressed to press down the plate.

**Clamping Force**

### Technical Information

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Heat Resistant Temperature(C)</th>
<th>Shear Strength(N)</th>
<th>Tensile Strength(N)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTHA 0525-10</td>
<td>130</td>
<td>1800</td>
<td>1200</td>
</tr>
<tr>
<td>QCTHA 0834-14</td>
<td>3200</td>
<td></td>
<td>400</td>
</tr>
<tr>
<td>QCTHA-S 0525-10</td>
<td>200</td>
<td>1800</td>
<td>1200</td>
</tr>
<tr>
<td>QCTHA-SUS 0834-14</td>
<td>3200</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### How To Use

1. Ensure that the knob is positioned at the "OFF" mark and the shank is retracted.
2. Insert Retractable Quarter-Turn Clamp pressing the knob.
3. Turn the knob to the "ON" mark for clamping. The knob clicks when clamped. Turning the knob to the "OFF" position, the shank returns automatically to the unclamping position by the spring.

**Click! Clamping**

**Continuing on Next Page**
**Application Example**

**Changes of fixture plates**

[Diagram of fixture plates showing Unclamping Position and Clamping Position, with components labeled:

- RETRACTABLE QUARTER-TURN CLAMP QCTHA0525-10
- CAM RECEPTACLE QCTH0525-B

**Lock for doors**

[Diagram of a door lock mechanism with components labeled:

- RETRACTABLE QUARTER-TURN CLAMP QCTHA0525-10
- CAM RECEPTACLE QCTH0525-B

**Changes of suction grippers for transfer equipment**

[Diagram of a suction gripper mechanism with components labeled:

- RETRACTABLE QUARTER-TURN CLAMP QCTHA0525-10
- CAM RECEPTACLE QCTH0525-B

**CAD Download:** [https://www.imao.biz/en](https://www.imao.biz/en)
How To Install

**Part Number**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>Figure</th>
<th>( d \quad (+0.10) \quad (+0.06) )</th>
<th>( d_1 )</th>
<th>( d_2 )</th>
<th>( d_3 )</th>
<th>( Dp )</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTHA</td>
<td>0525-10</td>
<td>6</td>
<td>A</td>
<td>14</td>
<td>—</td>
<td>4.4</td>
<td>2.4</td>
</tr>
<tr>
<td>QCTHA-S</td>
<td>0834-14</td>
<td>Over 6, 10 or less</td>
<td>B</td>
<td>26</td>
<td>—</td>
<td>6.5</td>
<td>3.4</td>
</tr>
<tr>
<td>QCTHA-SUS</td>
<td>Over 6, 14 or less</td>
<td>B</td>
<td>18</td>
<td>35</td>
<td>—</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Accuracy**

**Machining Accuracy**

Spacing Tolerance ±0.04

Subplate

Base plate

Spacing Tolerance ±0.04

**Repeatability**

Repeatability ±0.1

Locating Pin

For higher accurate locating, use locating components.

**Reference**

"How To Install" of QCTH-N, QCTH-B, QCTH-N-SUS, QCTH-B-SUS Cam Receptacles

CAD Download: https://www.imao.biz/en
**QCTH-N / QCTH-B**  CAM RECEPTACLES

**QCTH-N**  (Thin-Plate Mount)  
**QCTH-N-SUS**  (Thin-Plate Mount, Stainless Steel)  
**QCTH-B**  (Embedded Mount)  
**QCTH-B-SUS**  (Embedded Mount, Stainless Steel)

---

### Part Number Specifications

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>D</th>
<th>H</th>
<th>T</th>
<th>W</th>
<th>A</th>
<th>M</th>
<th>T</th>
<th>Ml</th>
<th>Dp</th>
<th>Weight (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTH0525-N</td>
<td>Thin-Plate Mount</td>
<td>6−10</td>
<td>25</td>
<td>16</td>
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<td>22</td>
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<td>40</td>
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<tr>
<td>QCTH0525-N-SUS</td>
<td>Thin-Plate Mount</td>
<td>6−12</td>
<td>32</td>
<td>18</td>
<td>8</td>
<td>13</td>
<td>M20×1.5</td>
<td>10</td>
<td>30</td>
<td></td>
<td>55</td>
</tr>
<tr>
<td>QCTH0834-N</td>
<td>Embedded Mount</td>
<td>Over 10</td>
<td>25</td>
<td>9</td>
<td>5</td>
<td></td>
<td>M20×1.5</td>
<td>14</td>
<td>4.5</td>
<td>M2</td>
<td>21</td>
</tr>
<tr>
<td>QCTH0834-B-SUS</td>
<td>Embedded Mount</td>
<td>Over 12</td>
<td>32</td>
<td>11</td>
<td>8</td>
<td></td>
<td></td>
<td>20</td>
<td>5.5</td>
<td>M3</td>
<td>26</td>
</tr>
</tbody>
</table>

### Nut Specifications

- QCTH-N: Stainless steel
- QCTH-B: Electroless nickel plated
- QCTH-N-SUS: Stainless steel
- QCTH-B-SUS: Stainless steel

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**Supplied With**

- QCTH0525-B / QCTH0525-B-SUS: 3 of socket-head cap screws(stainless steel), M2×0.4-5L
- QCTH0834-B / QCTH0834-B-SUS: 3 of socket-head cap screws(stainless steel), M3×0.5-6L

**Installing Position**

- Cam Receptacle (Thin-Plate Mount)  
- Quarter-Turn Clamp  
- Cam Receptacle (Embedded Mount)
### How To Install

Locate the Cam Receptacle with the locating pin and fasten it with the nut.

![Locating Pin](image)

![Locating-Pin Hole](image)

### Part Number Details

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>(d_1)</th>
<th>(d_2)</th>
<th>(A) (±0.1)</th>
<th>(Lc) ((\pm 0.05))</th>
<th>M</th>
<th>Lf</th>
<th>Dp</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTH0525-N</td>
<td>Thin-Plate Mount</td>
<td>6~10</td>
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<td>+0.10</td>
<td>15</td>
<td>10.5</td>
<td>—</td>
<td>—</td>
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<tr>
<td>QCTH0525-N-SUS</td>
<td>Thin-Plate Mount</td>
<td>6~12</td>
<td>32</td>
<td>+0.05</td>
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<td>13</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>QCTH0834-N</td>
<td>Thin-Plate Mount</td>
<td>Over 10</td>
<td>26</td>
<td>—</td>
<td>+0.10</td>
<td>5</td>
<td>M2×0.4</td>
<td>21</td>
</tr>
<tr>
<td>QCTH0834-N-SUS</td>
<td>Thin-Plate Mount</td>
<td>Over 12</td>
<td>33</td>
<td>+0.05</td>
<td>20</td>
<td>6</td>
<td>M3×0.5</td>
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<td>QCTH0525-B</td>
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<td>—</td>
<td>14</td>
<td>10.5</td>
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<td>—</td>
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<td>QCTH0525-B-SUS</td>
<td>Embedded Mount</td>
<td>6~12</td>
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<td>—</td>
<td>14</td>
<td>10.5</td>
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<td>—</td>
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<tr>
<td>QCTH0834-B</td>
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<td>Over 10</td>
<td>26</td>
<td>—</td>
<td>+0.10</td>
<td>5</td>
<td>M2×0.4</td>
<td>21</td>
</tr>
<tr>
<td>QCTH0834-B-SUS</td>
<td>Embedded Mount</td>
<td>Over 12</td>
<td>33</td>
<td>+0.05</td>
<td>20</td>
<td>6</td>
<td>M3×0.5</td>
<td>26</td>
</tr>
</tbody>
</table>

### Reference

"Accuracy" of QCTHA, QCTH, QCTHL, QCTHH Quarter-Turn Clamps

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CAD Download: https://www.imao.biz/en
**QCTHS**

HEAVY DUTY QUARTER-TURN CLAMPS

![QCTHS0834-20](Plastic Knob)  ![QCTHS0834-20S](Metal Knob)

**Key Point**

Clamping force 400N

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Body</th>
<th>Shank</th>
<th>Pin</th>
<th>Knob</th>
<th>Spring A</th>
<th>Spring B</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTHS0834-20</td>
<td>SUS303 stainless steel</td>
<td>SKS3 steel Electroless nickel plated</td>
<td>SUS440C stainless steel</td>
<td>Polyamide (glass-fiber reinforced) Black</td>
<td>Equivalent to SWOSC-V steel</td>
<td>SUS304 stainless steel</td>
</tr>
<tr>
<td>QCTHS0834-20S</td>
<td></td>
<td>Quenched and tempered</td>
<td>SCS13 stainless steel (Equivalent to SUS304)</td>
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<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>Clamping Force (N)</th>
<th>Weight (g)</th>
<th>Proper Locking Receptacle</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTHS0834-20</td>
<td>6~20</td>
<td>400</td>
<td>121</td>
<td>QCTHS0834-B</td>
</tr>
<tr>
<td>QCTHS0834-20S</td>
<td></td>
<td></td>
<td>157</td>
<td></td>
</tr>
</tbody>
</table>

**Supplied With**

3 of socket-head cap screws(stainless steel), M3×0.5-6L

![QCTHS-B](LOCKING RECEPTACLE)
**Feature**

- **Knob**
- **Spring A**
- **Plate**
- **Shank**
- **Receptacle**
- **Ball**

When the cam groove moves along the ball inside the receptacle, the spring A gets compressed to press down the plate.

**How To Use**

1. Ensure that the knob is positioned at the "OFF" mark.
2. Insert the Heavy Duty Quarter-Turn Clamp.
3. Turn the knob to the "ON" mark for clamping. The knob clicks when it is clamped/unclamped. Note: For unclamping, follow back these steps.

**Technical Information**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Heatresistant Temperature (°C)</th>
<th>Shear Strength (N)</th>
<th>Tensile Strength (N)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTHS0834-20</td>
<td>130</td>
<td>4800</td>
<td>1600</td>
</tr>
<tr>
<td>QCTHS0834-20S</td>
<td>200</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Application Example**

Installation/removal of conveyer

LOCKING RECEPTACLE
QCTHS0834-B

HEAVY DUTY QUARTER-TURN CLAMPS
QCTHS0834-20

Continuing on Next Page
Application Example

Changes of mold

How To Install Quarter-Turn Clamp

When plate thickness is 6mm.

When plate thickness is over 6mm, 20mm or less.

Accuracy

Machining Accuracy

Spacing Tolerance ±0.04

Subplate

Base plate

Spacing Tolerance ±0.04

Repeatability

Repeatability ±0.1

Locating Pin (Round)

Locating Pin (Diamond)

For higher accurate locating, use locating pins.
QCTHSA  RETRACTABLE HEAVY DUTY QUARTER-TURN CLAMPS

QCTHSA0834-20 (Plastic Knob)
QCTHSA0834-20S (Metal Knob)

**Key Point**
No interference by retractable shank

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Body</th>
<th>Shank</th>
<th>Pin</th>
<th>Knob</th>
<th>Spring A</th>
<th>Spring B</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTHSA0834-20</td>
<td>SUS303 stainless steel</td>
<td>SKS3 steel Quenched and tempered</td>
<td>SUS420J2 stainless steel</td>
<td>Polyamide Black SC513 stainless steel (Equivalent to SUS304)</td>
<td>Equivalent to SWOSC-V steel</td>
<td>SUS304WPB stainless steel</td>
</tr>
<tr>
<td>QCTHSA0834-20S</td>
<td>SUS303 stainless steel</td>
<td>SKS3 steel Quenched and tempered</td>
<td>SUS420J2 stainless steel</td>
<td>Polyamide Black SC513 stainless steel (Equivalent to SUS304)</td>
<td>Equivalent to SWOSC-V steel</td>
<td>SUS304WPB stainless steel</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>Clamping Force (N)</th>
<th>Weight (g)</th>
<th>Proper Locking Receptacle</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTHSA0834-20</td>
<td>6~20</td>
<td>400</td>
<td>130</td>
<td>QCTHS0834-B</td>
</tr>
<tr>
<td>QCTHSA0834-20S</td>
<td>6~20</td>
<td>400</td>
<td>160</td>
<td></td>
</tr>
</tbody>
</table>

**QCTHS-B LOCKING RECEPTACLE**

3 of socket-head cap screws (stainless steel) M3×0.5-10L

**QCTHSA SPACER**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Weight (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTHSA34-03-SUS</td>
<td>14</td>
</tr>
</tbody>
</table>
Feature

The shank retracts at the unclamping position to enable operations without interference with the base plate.

When the cam groove moves along the ball inside the receptacle, the spring A gets compressed to press down the plate.

Technical Information

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Heatresistant Temperature (°C)</th>
<th>Shear Strength (N)</th>
<th>Tensile Strength (N)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCTHSA0834-20</td>
<td>130</td>
<td>3000</td>
<td>1600</td>
</tr>
<tr>
<td>QCTHSA0834-20S</td>
<td>200</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

How To Use

1. Ensure that the knob is positioned at the "OFF" mark.
2. Insert the clamp pressing the knob.
3. Turn the knob to the "ON" mark for clamping. The knob clicks when clamped. Turning the knob to the "OFF" position, the shank returns automatically to the unclamping position by the spring.

Application Example

Die Changing

Continuing on Next Page
Application Example

Guide Changing

RETRACTABLE HEAVY DUTY QUARTER-TURN CLAMPS
QCTHSA0834-20S

LOCKING RECEPTACLE
QCTH50834-B

How To Install

For 9mm-thick plate

Equally Spaced

For 9mm to 20mm-thick plate

Equally Spaced

With Spacer

For 6mm-thick plate

For 6mm to 9mm-thick plate

CAD Download: https://www.imao.biz/en
### Accuracy

**Machining Accuracy**

- Spacing Tolerance ±0.04

Spacing tolerance on both the subplate and the base plate should be ±0.04.

**Repeatability**

- Repeatability ±0.1

For higher accurate locating, use locating pins.

### Reference

"How To Install Receptacle" of QCTHS-B LOCKING RECEPTACLE.
QCTHS-B  LOCKING RECEPTACLE

Part Number  Weight (g)  Proper Heavy Duty Quarter-Turn Clamps  Proper Retractable Heavy Duty Quarter-Turn Clamps
QCTHS0834-B  19  QCTHS0834-20  QCTHS0834-20S  QCTHSA0834-20  QCTHSA0834-20S

Supplied With
3 of low head cap screws (stainless steel), M3×0.5-6L

Installing Position
HEAVY DUTY QUARTER-TURN CLAMPS  LOCKING RECEPTACLE

How To Install Receptacle
Plate thickness should be 9mm or more.

Reference
"Accuracy" of QCTHS  QCTHSA Heavy Duty Quarter-Turn Clamps

CAD Download: https://www.imao.biz/en
# QCWE KNOB-LOCKING PINS

**Key Point**

Secure clamping with wedge

<table>
<thead>
<tr>
<th>Type</th>
<th>Body</th>
<th>Shank</th>
<th>Knob</th>
<th>Ball</th>
<th>Spring</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCWE</td>
<td>S45C steel Electroless nickel plated</td>
<td>S45C steel Electroless nickel plated</td>
<td>Polyamide (glass-fiber reinforced) Black</td>
<td>SUS440C stainless steel Quenched and tempered</td>
<td>SUS304WPB stainless steel</td>
</tr>
<tr>
<td>QCWE-S</td>
<td>SUS303 stainless steel</td>
<td>SUS4002 stainless steel</td>
<td>SCS13 stainless steel (Equivalent to SUS304)</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Size</th>
<th>Proper Plate Thickness</th>
<th>D1 (h9)</th>
<th>D2</th>
<th>D3</th>
<th>L</th>
<th>H</th>
<th>H1</th>
<th>M</th>
<th>Dp</th>
<th>Clamping Force%(N)</th>
<th>Proper Recectacle</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCWE</td>
<td>6~10</td>
<td>6</td>
<td>14</td>
<td>25</td>
<td>25</td>
<td>19.5</td>
<td>24.5</td>
<td>6.5</td>
<td>21</td>
<td>30</td>
<td>QCBU0608-M12</td>
</tr>
<tr>
<td>QCWE-S</td>
<td>6~14</td>
<td>10</td>
<td>18</td>
<td>34</td>
<td>34</td>
<td>21.5</td>
<td>27.5</td>
<td>10</td>
<td>28</td>
<td>50</td>
<td>QCBU1012-M16</td>
</tr>
<tr>
<td>QCWE-SUS</td>
<td>12~20</td>
<td>10</td>
<td>18</td>
<td>34</td>
<td>34</td>
<td>21.5</td>
<td>27.5</td>
<td>31</td>
<td>10</td>
<td>50</td>
<td>QCBU1012-M16</td>
</tr>
</tbody>
</table>

**QCWE (Plastic Knob)**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Weight (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCWE0625-10</td>
<td>40</td>
</tr>
<tr>
<td>QCWE1034-14</td>
<td>95</td>
</tr>
<tr>
<td>QCWE1034-20</td>
<td>100</td>
</tr>
</tbody>
</table>

**QCWE-S (Metal Knob)**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Weight (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCWE0625-10S</td>
<td>50</td>
</tr>
<tr>
<td>QCWE1034-14S</td>
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<tr>
<td>QCWE1034-20S</td>
<td>130</td>
</tr>
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</table>

**QCWE-SUS (Stainless Steel)**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Weight (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCWE0625-10-SUS</td>
<td>50</td>
</tr>
<tr>
<td>QCWE1034-14-SUS</td>
<td>120</td>
</tr>
<tr>
<td>QCWE1034-20-SUS</td>
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**Supplied With**

<table>
<thead>
<tr>
<th>QCWE</th>
<th>QCWE-S</th>
<th>QCWE-SUS</th>
<th>Part Numbers</th>
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</thead>
<tbody>
<tr>
<td>0625-10</td>
<td>1034-14</td>
<td>1034-20</td>
<td>QCWE0625-10, QCWE0625-10S, QCWE0625-10-SUS</td>
</tr>
<tr>
<td>1034-14</td>
<td>1034-20</td>
<td></td>
<td>QCWE1034-14, QCWE1034-14S, QCWE1034-14-SUS</td>
</tr>
</tbody>
</table>

3 of socket-head cap screws(stainless steel), M2×0.4-5L
3 of socket-head cap screws(stainless steel), M3×0.5-6L

**CAD Download**: https://www.imao.biz/en
The wedge of the locking pin pushes out the ball onto the taper of the receptacle, for clamping of the two plates.

### How To Use

1. Ensure that the knob is positioned at the "OFF" mark.
2. Insert the Knob-Locking Pin.
3. Turn the knob to the "ON" mark for clamping. The knob turns lightly by spring force. Note: For unclamping, follow back these steps.

### Technical Information

<table>
<thead>
<tr>
<th>Size</th>
<th>Heatresistant Temperature(°C)</th>
<th>Shear Strength (N)</th>
<th>Tensile Strength (N)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCWE</td>
<td>130</td>
<td>3000</td>
<td>500</td>
</tr>
<tr>
<td>1034-14</td>
<td></td>
<td>9000</td>
<td>1500</td>
</tr>
<tr>
<td>1034-20</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>QCWE-S</td>
<td>200</td>
<td>3000</td>
<td>500</td>
</tr>
<tr>
<td>0625-10</td>
<td></td>
<td>9000</td>
<td>1500</td>
</tr>
<tr>
<td>1034-14</td>
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<td></td>
</tr>
<tr>
<td>1034-20</td>
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<td></td>
</tr>
</tbody>
</table>

### Application Example

Changes of attachments for conveyor

Continuing on Next Page
### Application Example

Changes of star wheels and guide plates

![Diagram of KNOB-LOCKING PINNS QCWE1034-14 and BALL-LOCK RECEPTACLES QCBU1012-M16]

### How To Install

**Equally Spaced**

![Diagram of installation process](#)

**Figure A**

<table>
<thead>
<tr>
<th>Plate</th>
<th>d</th>
<th>d₁</th>
<th>T (±0.2)</th>
<th>d₂</th>
<th>d₃</th>
<th>Dp</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>2.5</td>
<td></td>
<td></td>
<td>6</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Plate</th>
<th>d</th>
<th>d₁</th>
<th>T (±0.2)</th>
<th>d₂</th>
<th>d₃</th>
<th>Dp</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>2.5</td>
<td></td>
<td></td>
<td>6</td>
<td></td>
<td></td>
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</tbody>
</table>

**Figure B**

<table>
<thead>
<tr>
<th>Size</th>
<th>Proper Plate Thickness</th>
<th>Figure</th>
<th>d (±0.2 ≤)</th>
<th>d₁</th>
<th>T (±0.2)</th>
<th>d₂</th>
<th>d₃</th>
<th>Dp</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCWE</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>QCWE-S</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>QCWE-SUS</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>0625-10</td>
<td>6</td>
<td>A</td>
<td>14</td>
<td>—</td>
<td>6</td>
<td>4.4</td>
<td>2.4</td>
<td>21</td>
</tr>
<tr>
<td>Over 6, 10 or less</td>
<td>B</td>
<td>14</td>
<td>—</td>
<td>6</td>
<td>4.4</td>
<td>2.4</td>
<td>21</td>
<td></td>
</tr>
<tr>
<td>1034-14</td>
<td>6</td>
<td>A</td>
<td>18</td>
<td>26</td>
<td>—</td>
<td>6</td>
<td>4.4</td>
<td>2.4</td>
</tr>
<tr>
<td>Over 6, 14 or less</td>
<td>B</td>
<td>18</td>
<td>35</td>
<td>—</td>
<td>6.5</td>
<td>3.4</td>
<td>28</td>
<td></td>
</tr>
<tr>
<td>1034-20</td>
<td>12</td>
<td>A</td>
<td>18</td>
<td>35</td>
<td>12</td>
<td>6.5</td>
<td>3.4</td>
<td>28</td>
</tr>
<tr>
<td>Over 12, 20 or less</td>
<td>B</td>
<td>18</td>
<td>35</td>
<td>12</td>
<td>6.5</td>
<td>3.4</td>
<td>28</td>
<td></td>
</tr>
</tbody>
</table>

**CAD Download**: https://www.imao.biz/en
**Accuracy**

- **Machining Accuracy**
  - Spacing Tolerance ±0.1
  - Subplate
  - Base plate

  Spacing tolerance on both the subplate and the base plate should be ±0.1.

- **Repeatability**
  - Repeatability ±0.25
  - Locating Pin (Round)
  - Locating Pin (Diamond)

  For higher accurate locating, use locating pins.
# QCBU / QCBUS BUTTON-LOCKING PINS

**Wedge**

- **QC**BU (Standard)
- **QC**BU-SUS (Stainless Steel)
- **QC**BUS (Cylindrical)
- **QC**BUS-SUS (Cylindrical, Stainless Steel)

## Key Point
- Secure clamping with wedge

### Specifications

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Body</th>
<th>Button</th>
<th>Ball</th>
<th>Coiled Spring</th>
<th>Snap Ring</th>
<th>O-Ring</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCBU</td>
<td>S45C steel</td>
<td>S45C steel</td>
<td>Electroless nickel plated</td>
<td></td>
<td></td>
<td>FKM fluororubber</td>
</tr>
<tr>
<td>QCBUS</td>
<td>Electroless nickel plated</td>
<td>Electroless nickel plated</td>
<td>SUS440C stainless steel Quenched and tempered</td>
<td></td>
<td>Stainless steel</td>
<td></td>
</tr>
<tr>
<td>QCBU-SUS</td>
<td>SUS303 stainless steel</td>
<td>SUS420J2 stainless steel</td>
<td>SUS304WPB stainless steel</td>
<td></td>
<td></td>
<td>FKM fluororubber</td>
</tr>
<tr>
<td>QCBUS-SUS</td>
<td>SUS303 stainless steel</td>
<td>SUS420J2 stainless steel</td>
<td>SUS304WPB stainless steel</td>
<td></td>
<td></td>
<td>FKM fluororubber</td>
</tr>
</tbody>
</table>

### Dimensions

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>D</th>
<th>M</th>
<th>D1</th>
<th>L</th>
<th>L1</th>
<th>H2</th>
<th>W</th>
<th>Clamping Force</th>
<th>Proper Receptacles</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCBU</td>
<td>6~10</td>
<td>6</td>
<td>M 8x1.25</td>
<td>12</td>
<td>21</td>
<td>19</td>
<td>6</td>
<td>10</td>
<td>30</td>
<td>QCBU0608-M12</td>
</tr>
<tr>
<td>QCBUS</td>
<td>6~10</td>
<td>6</td>
<td>M 8x1.25</td>
<td>12</td>
<td>21</td>
<td>19</td>
<td>6</td>
<td>10</td>
<td>30</td>
<td>QCBU0608-M12SUS</td>
</tr>
<tr>
<td>QCBU-SUS</td>
<td>6~16</td>
<td>10</td>
<td>M12x1.5 (Fine Thread)</td>
<td>16</td>
<td>23.5</td>
<td>21.5</td>
<td>12</td>
<td>13</td>
<td>50</td>
<td>QCBU1012-M16</td>
</tr>
<tr>
<td>QCBUS-SUS</td>
<td>6~16</td>
<td>10</td>
<td>M12x1.5 (Fine Thread)</td>
<td>16</td>
<td>23.5</td>
<td>21.5</td>
<td>12</td>
<td>13</td>
<td>50</td>
<td>QCBU1012-M16SUS</td>
</tr>
</tbody>
</table>

**Note:** Dimensions are approximate and may vary slightly. Always refer to the original source for the most accurate information.

**Image:** [Image Link](https://www.imao.biz/en)
### One-Touch Fasteners

**QCBU (Standard)**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>D₂</th>
<th>D₃</th>
<th>H</th>
<th>H₁</th>
<th>H₃</th>
<th>d</th>
<th>Weight (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCBL0608-10</td>
<td>25</td>
<td>8</td>
<td>22</td>
<td>18</td>
<td>5.5</td>
<td>—</td>
<td>30</td>
</tr>
<tr>
<td>QCBL1012-16</td>
<td>35</td>
<td>11</td>
<td>34.5</td>
<td>29</td>
<td>7</td>
<td>3</td>
<td>75</td>
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</table>

**QCBU-SUS (Stainless Steel)**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>D₂</th>
<th>D₃</th>
<th>H</th>
<th>H₁</th>
<th>H₃</th>
<th>Weight (g)</th>
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</thead>
<tbody>
<tr>
<td>QCBL0608-10</td>
<td>23</td>
<td>8</td>
<td>26</td>
<td>18</td>
<td>5.5</td>
<td>30</td>
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<tr>
<td>QCBL1012-16</td>
<td>32</td>
<td>12</td>
<td>39.5</td>
<td>29</td>
<td>7</td>
<td>75</td>
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</tbody>
</table>

**QCBUS (Cylindrical)**

<table>
<thead>
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<th>D₃</th>
<th>H</th>
<th>H₁</th>
<th>H₃</th>
<th>Weight (g)</th>
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<tbody>
<tr>
<td>QCBS0608-10</td>
<td>12</td>
<td>8</td>
<td>22</td>
<td>17.5</td>
<td>11.5</td>
<td>30</td>
</tr>
<tr>
<td>QCBS1012-16</td>
<td>16</td>
<td>11</td>
<td>34.5</td>
<td>28</td>
<td>16</td>
<td>50</td>
</tr>
</tbody>
</table>

**QCBUS-SUS (Cylindrical, Stainless Steel)**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>D₂</th>
<th>D₃</th>
<th>H</th>
<th>H₁</th>
<th>H₃</th>
<th>Weight (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCBS0608-10SUS</td>
<td>12</td>
<td>8</td>
<td>22</td>
<td>17.5</td>
<td>11.5</td>
<td>30</td>
</tr>
<tr>
<td>QCBS1012-16SUS</td>
<td>16</td>
<td>11</td>
<td>34.5</td>
<td>28</td>
<td>16</td>
<td>50</td>
</tr>
</tbody>
</table>

**Feature**

- Button
- Plate
- Ball
- Wedge
- Receptacle

The wedge of the locking pin pushes out the ball onto the taper of the receptacle, for clamping of the two plates.

**Technical Information**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Heat-resistant Temperature (°C)</th>
<th>Shear Strength (N)</th>
<th>Tensile Strength (N)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCBL0608-10</td>
<td>180</td>
<td>3000</td>
<td>500</td>
</tr>
<tr>
<td>QCBL1012-16</td>
<td>9000</td>
<td>1500</td>
<td></td>
</tr>
</tbody>
</table>

**How To Use**

1. Insert the pin pressing the button.
2. When the button is released, plates are clamped.
3. For removal, pull out the pin pressing the button.

**QCBU-M**

**Ball-Lock Receptacles**

---

**Note**

For cylindrical types, prepare handles or knobs separately to facilitate the operation. Use of cylindrical type requires handles or knobs separately to operate the product properly.

---

Continuing on Next Page
Application Example

Changes of star wheels and guide plates

Installation and removal of stopper plate for rolls

Installation and removal of hopper

CAD Download: https://www.imao.biz/en
## How To Install

### Fixed Installation

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>Figure</th>
<th>M</th>
<th>$d_2$</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCBU 0608-10</td>
<td>6</td>
<td>A</td>
<td>M 8×1.25</td>
<td>—</td>
</tr>
<tr>
<td>QCBUS 1012-16</td>
<td>Over 6, 10 or less</td>
<td>B</td>
<td>M12×1.5</td>
<td>13</td>
</tr>
</tbody>
</table>

### Unfixed Installation (Except QCBUS QCBUS-SUS type)

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>Figure</th>
<th>$d_1$ ($^\circ$)</th>
<th>$d_2$</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCBU 0608-10</td>
<td>6</td>
<td>C</td>
<td>8</td>
<td>—</td>
</tr>
<tr>
<td>QCBU-SUS 1012-16</td>
<td>Over 6, 10 or less</td>
<td>D</td>
<td>13</td>
<td>—</td>
</tr>
<tr>
<td>QCBU 0608-10</td>
<td>Over 6, 16 or less</td>
<td>C</td>
<td>12</td>
<td>—</td>
</tr>
<tr>
<td>QCBU-SUS 1012-16</td>
<td>Over 6, 16 or less</td>
<td>D</td>
<td>17</td>
<td>—</td>
</tr>
</tbody>
</table>

---

Continuing on Next Page
## Accuracy

### Machining Accuracy

Spacing tolerance on both the subplate and the base plate should be ±0.1.

### Repeatability

Repeatability is ±0.25 for both fixed and unfixed installations.

For higher accurate locating, use locating pins.
**QCBU-M**  
**BALL-LOCK RECEPTACLES**

**Stainless Steel**

Heat resistance: **180°C**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>d (mm)</th>
<th>D (mm)</th>
<th>M</th>
<th>H</th>
<th>Weight (g)</th>
<th>Proper Knob-Locking Pins</th>
<th>Proper Button-Locking Pins</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCBU0608-M12</td>
<td>6 or more</td>
<td>6</td>
<td>16</td>
<td>M12X1.5 (Fine Thread)</td>
<td>15</td>
<td>9</td>
<td>QCWE0625-10</td>
<td>QCBU0608-10, QCBUS0608-10</td>
</tr>
<tr>
<td>QCBU0608-M12SUS</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>QCWE0625-10S</td>
<td>QCBU0608-10-SUS</td>
</tr>
<tr>
<td>QCBU1012-M16</td>
<td></td>
<td>10</td>
<td>20</td>
<td>M16X1.5 (Fine Thread)</td>
<td>17</td>
<td>13</td>
<td>QCWE1034-14, QCWE1034-14S</td>
<td>QCBU1012-16, QCBUS1012-16</td>
</tr>
<tr>
<td>QCBU1012-M16SUS</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>QCWE1034-20, QCWE1034-20S</td>
<td>QCBU1012-16-SUS</td>
</tr>
</tbody>
</table>

**Nut (Stainless Steel)**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>M1</th>
<th>T</th>
<th>W</th>
</tr>
</thead>
<tbody>
<tr>
<td>NDX12-NUT-SUS</td>
<td>M12X1.5 (Fine Thread)</td>
<td>6</td>
<td>19</td>
</tr>
<tr>
<td>NDX16-NUT-SUS</td>
<td>M16X1.5 (Fine Thread)</td>
<td>8</td>
<td>24</td>
</tr>
</tbody>
</table>

**Installation Wrench**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Body</th>
</tr>
</thead>
<tbody>
<tr>
<td>PW16</td>
<td>S45C steel Black oxide finish</td>
</tr>
</tbody>
</table>

**Order Separately**

CAD Download: [https://www.imao.biz/en](https://www.imao.biz/en)
### How To Install

![Diagram of installation](image)

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>Figure</th>
<th>M</th>
<th>d1</th>
<th>d2 (±0.1)</th>
<th>H1</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCBU-M</td>
<td>6~10</td>
<td>A</td>
<td>—</td>
<td>13</td>
<td>16</td>
<td>—</td>
</tr>
<tr>
<td>QCBU-M-SUS</td>
<td>Over 10</td>
<td>B</td>
<td>M12x1.5 (Fine Thread)</td>
<td>—</td>
<td>15.5</td>
<td>—</td>
</tr>
<tr>
<td>QCBU-M</td>
<td>6~10</td>
<td>A</td>
<td>—</td>
<td>17</td>
<td>20</td>
<td>—</td>
</tr>
<tr>
<td>QCBU-M-SUS</td>
<td>Over 10</td>
<td>B</td>
<td>M16x1.5 (Fine Thread)</td>
<td>—</td>
<td>17.5</td>
<td>—</td>
</tr>
</tbody>
</table>

### Without Ball-Lock Receptacle

With additional work to plate of 8mm or more thickness, Button-Locking Pins and Knob-Locking Pins can be used directly on the plate made of hard steel such as S45C.

![Diagram of thick plate installation](image)

<table>
<thead>
<tr>
<th>Dimensions</th>
<th>Proper Knob-Locking Pins</th>
<th>Proper Button-Locking Pins</th>
</tr>
</thead>
<tbody>
<tr>
<td>d3 (±0.1)</td>
<td>d4 (±0.2)</td>
<td>T (±0.1)</td>
</tr>
<tr>
<td>6</td>
<td>8 or more</td>
<td>4.9 (6.6)</td>
</tr>
<tr>
<td>10</td>
<td>12.5 or more</td>
<td>5 (7.2)</td>
</tr>
</tbody>
</table>

### Reference

"Accuracy" of QCWE Knob-Locking Pins and QCBU/QCBS Button-Locking Pins
# QCPC PIN HOLDING CLAMPS

**QCPC**

*(OFF position)*

**QCPC-S**

*(ON position)*

**QCPC-SUS**

★ **Key Point**

Pin clamping design enables space-saving application.

## Type

<table>
<thead>
<tr>
<th>Type</th>
<th>Body</th>
<th>Knob</th>
<th>Ball</th>
<th>Spring</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCPC</td>
<td>S45C steel Electroless nickel plated</td>
<td>Polymide (glass-fiber reinforced) Black</td>
<td>SUS440C stainless steel Quenched and tempered</td>
<td>SUS304WPB stainless steel</td>
</tr>
<tr>
<td>QCPC-S</td>
<td>SUS303 stainless steel</td>
<td>SUS303 stainless steel (Equivalent to SUS304)</td>
<td>SUS303 stainless steel</td>
<td>SUS304WPB stainless steel</td>
</tr>
<tr>
<td>QCPC-SUS</td>
<td>SUS304WPB stainless steel</td>
<td>SUS304WPB stainless steel</td>
<td>SUS304WPB stainless steel</td>
<td>SUS304WPB stainless steel</td>
</tr>
</tbody>
</table>

## Specifications

<table>
<thead>
<tr>
<th>Size</th>
<th>Proper Plate Thickness</th>
<th>d</th>
<th>D1 (h9)</th>
<th>D2</th>
<th>D3</th>
<th>H</th>
<th>H1</th>
<th>M</th>
<th>Clamping Force (N)</th>
<th>Proper Clamping Pins</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCPC</td>
<td>0625-10</td>
<td>6 ~ 10</td>
<td>6</td>
<td>14</td>
<td>25</td>
<td>25</td>
<td>23</td>
<td>6.5</td>
<td>M2 X 0.4 Depth 3</td>
<td>21</td>
</tr>
<tr>
<td>QCPC-S</td>
<td>0834-14</td>
<td>6 ~ 14</td>
<td>8</td>
<td>18</td>
<td>34</td>
<td>34</td>
<td>28</td>
<td>10</td>
<td>M3 X 0.5 Depth 4</td>
<td>28</td>
</tr>
</tbody>
</table>

## Material

<table>
<thead>
<tr>
<th>QCPC-M</th>
<th>CLAMPING PINS</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCPC</td>
<td>QCPC-S</td>
</tr>
</tbody>
</table>

## Supplied With

- QCPC: QCPC-S QCPC-SUS 0625-10
  - 3 of socket-head cap screws (stainless steel), M2 X 0.4-5L
- QCPC: QCPC-S QCPC-SUS 0834-14
  - 3 of socket-head cap screws (stainless steel), M3 X 0.5-6L

---

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**Feature**

Four balls hold the Clamping Pin to pull the plate for clamping.

**Technical Information**

<table>
<thead>
<tr>
<th>Size</th>
<th>Heatresistant Temperature (°C)</th>
<th>Shear Strength (N)</th>
<th>Tensile Strength (N)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCPC</td>
<td>130</td>
<td>1100</td>
<td>250</td>
</tr>
<tr>
<td></td>
<td>0625-10</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>0834-14</td>
<td></td>
<td></td>
</tr>
<tr>
<td>QCPC-S</td>
<td>0625-10</td>
<td>1800</td>
<td>400</td>
</tr>
<tr>
<td>QCPC-SUS</td>
<td>0834-14</td>
<td>200</td>
<td>1800</td>
</tr>
</tbody>
</table>

**How To Use**

1. Ensure that the knob is positioned at the "OFF" mark and put Pin Holding Clamp over the Clamping Pin.

2. Turn the knob to the "ON" mark for clamping.

Note: For unclamping, follow back these steps.

**Application Example**

Changes of guides around star wheels

PIN HOLDING CLAMP
QCPC0625-10-SUS

CLAMPING PIN
QCPC0625-M4-SUS

Continuing on Next Page
**Application Example**

Changes of static electricity removal brush

CLAMPING PIN
QCPC0625-M4-SUS

PIN HOLDING CLAMP
QCPC0625-10-SUS

---

**How To Install**

<table>
<thead>
<tr>
<th>Size</th>
<th>Proper Plate Thickness</th>
<th>Figure</th>
<th>d₁ (+0.10) (+0.05)</th>
<th>d₂</th>
<th>d₃</th>
<th>d₄</th>
<th>Dp</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCPC0625-10</td>
<td>Over 6, 10 or less</td>
<td>B</td>
<td>26</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>QCPC-S</td>
<td>Over 6, 14 or less</td>
<td>B</td>
<td>35</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>QCPC-SUS</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

---

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**Accuracy**

- **Machining Accuracy**

  Spacing Tolerance ±0.1

  Spacing tolerance on both the subplate and the base plate should be ±0.1.

- **Repeatability**

  Repeatability ±0.25

  For higher accurate locating, use locating pins.

**Note**

Rotation of either sub plate or base plate can get Pin Holding Clamp unclamped, when one pair of the clamp and the clamping pin is used. Prepare a stop in such application.
QCOW / QCOWS SNAP-IN CLAMPS

QCOW (Stainless Steel)

QCOWS (Cylindrical, Stainless Steel)

★ Key Point
Quick & easy snap-in operation

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>Clamping Force (N)</th>
<th>Weight (g)</th>
<th>Proper Clamping Pin</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCOW 0616-10SUS</td>
<td>3~10</td>
<td>6</td>
<td>65</td>
<td>QCPC0625-M4-SUS</td>
</tr>
<tr>
<td>QCOWS0616-10SUS</td>
<td>3~27</td>
<td></td>
<td>50</td>
<td></td>
</tr>
</tbody>
</table>

QCOW SPACERS

QCOW (Stainless Steel)

QCOWS (Cylindrical, Stainless Steel)

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Proper Plate Thickness</th>
<th>H (±0.05)</th>
<th>Weight (g)</th>
<th>Proper Snap-In Clamps</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCOW0616-04-SUS</td>
<td>6</td>
<td>4</td>
<td>2.5</td>
<td></td>
</tr>
<tr>
<td>QCOW0616-05-SUS</td>
<td>5</td>
<td>5</td>
<td>3</td>
<td>QCOW0616-10SUS</td>
</tr>
<tr>
<td>QCOW0616-06-SUS</td>
<td>4</td>
<td>6</td>
<td>3.5</td>
<td>QCOW0616-10SUS</td>
</tr>
<tr>
<td>QCOW0616-07-SUS</td>
<td>3</td>
<td>7</td>
<td>4</td>
<td>QCOWS0616-10SUS</td>
</tr>
</tbody>
</table>

QCPC-M CLAMPING PINS

Spacers
SUS303 stainless steel

CAD Download: https://www.imao.biz/en
Feature

Four balls hold the Clamping Pin to pull the plate for clamping.

Technical Information

- Heatresistant Temperature: 180°C
- Mechanical Strength

1. Shear Strength: 1100N
2. Tensile Strength: 250N

How To Use

1. Put Snap-In Clamp over the Clamping Pin. No need to push the button.
2. Clamped instantly as the pin is inserted.
3. For unclamping, push the button and pull the clamp.

Application Example

Changes of retainers of conveyor
SNAP-IN CLAMP

QCOWS0616-10SUS

CLAMPING PIN

QCPC0625-M4-SUS

Continuing on Next Page

CAD Download: https://www.imao.biz/en
### Application Example

Fixing of sliding unit

- **CLAMPING PIN**
  - QCPC0625-M4-SUS

- **SNAP-IN CLAMP**
  - QCOW0616-10SUS

### How To Install

For 3 to 10mm-thick plate

- **M16×1 (Fine Thread)**

For over 10mm-thick plate

- **M16×1 (Fine Thread)**

CAD Download: https://www.imao.biz/en
**Accuracy**

**Machining Accuracy**

Spacing tolerance on both the subplate and the base plate should be ±0.1.

**Repeatability**

Repeatability ±0.25

For higher accurate locating, use locating pins.
**QCPC-M CLAMPING PINS**

**Rohs** Stainless Steel Heat resistance: 180°C

**QCPC0625-M4-SUS**  **QCPC0834-M5-SUS**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>D  (5.0)</th>
<th>M</th>
<th>H</th>
<th>W</th>
<th>Weight (g)</th>
<th>Proper Pin Holding Clamps</th>
<th>Proper Snap-In Clamps</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCPC0625-M4-SUS</td>
<td>6</td>
<td>M4 x 0.7</td>
<td>7.6</td>
<td>5</td>
<td>2</td>
<td>QCPC0625-10</td>
<td>QCOW0616-10SUS</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>QCPC0625-10S</td>
<td>QCOW0616-10SUS</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>QCPC0625-10-SUS</td>
<td></td>
</tr>
<tr>
<td>QCPC0834-M5-SUS</td>
<td>8</td>
<td>M5 x 0.8</td>
<td>8.7</td>
<td>7</td>
<td>3</td>
<td>QCPC0834-14</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>QCPC0834-14S</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>QCPC0834-14-SUS</td>
<td></td>
</tr>
</tbody>
</table>

Note: Refer to the product pages of clamps for machining accuracy and repeatability.

### How To Install

**Standard Installation**

![Diagram of standard installation](image)

**Space-Saving Installation**

Prepare a counterbored hole with depth 0.5±0.1 on the surface where Clamping Pin to be mounted directly contacts with the bottom surface of the clamp.

**Pin Holding Clamp**

![Diagram of pin holding clamp](image)

**Snap-In Clamp**

![Diagram of snap-in clamp](image)

**Part Number**  **M₁**  **d**

- QCPC0625-M4-SUS M4 x 0.7 7
- QCPC0834-M5-SUS M5 x 0.8 9

**CAD Download**: https://www.imao.biz/en
QCHC-N  HOLE HOLDING CLAMPS

Wedge

QCHC-N-3  QCHC-N-6

Key Point
Receptacle is not required.

Technical Information

| Part Number     | Proper Base Plate Thickness | Proper Plate Thickness | D  | M    | D1 | D2 | H  | L  | H1 | L1 | L2 | H2 | W  | W1 | Clamping Force(N) | Weight (g) |
|-----------------|-----------------------------|------------------------|----|------|----|----|----|----|----|----|----|----|----|-------------------|------------|
| QCHC0612N-3-SUS | 3                          | 3~8                    | 6.5| M12X1 (Fine Thread) | 23 | 6.5| 40 | 12.5| 32 | 6.5 | 10.5 | 5.5 | 10  | 19  | 3                | 41         |
| QCHC0612N-6-SUS | 6                          |                        | 32 | 6.5  | 29 | 9.5 | 13.5| 29 | 6.5 | 11  | 7   | 14  | 24  | 6                | 88         |
| QCHC0816N-3-SUS | 3                          | 3~12                   | 8.5| M16X1 (Fine Thread) | 32 | 10 | 51 | 16.5| 41.5| 6.5 | 14  | 7   | 14  | 24  | 6                | 88         |
| QCHC0816N-6-SUS | 6                          |                        | 48 | 8.5  | 38 | 9.5 | 14  | 38 | 9.5 | 14  | 7   | 14  | 24  | 6                | 88         |

Part Number     | Heat Resistant Temperature (°C) | Shear Strength (N) | Tensile Strength (N) |
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>QCHC0612N-3-SUS</td>
<td>180</td>
<td>200</td>
<td>150</td>
</tr>
<tr>
<td>QCHC0612N-6-SUS</td>
<td></td>
<td>400</td>
<td>300</td>
</tr>
<tr>
<td>QCHC0816N-3-SUS</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>QCHC0816N-6-SUS</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
The tapered shank expanded by the wedge pushes out the edge of the hole on the base plate, and the two plates are clamped.

**How To Use**

1. Insert Hole Holding Clamp pressing the button.

2. The slitted part on the shank expands once the button is released, and the plate is clamped.

3. For unclamping, push the button and pull the clamp.

**Application Example**

Changes of holder plates

HOLE HOLDING CLAMP QCHC0612N-3-SUS

Continuing on Next Page
**How To Install**

1. Screw Hole Holding Clamp into the plate until the end of threaded part comes out of the plate.
2. Insert the clamp pushing the button.
3. Adjust the clamp until the both plates get contacted, and then lock the clamp with the nut.

**Mounting Hole on Plate**

Use hard metals such as stainless steels for the base plate.

**Part Number**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>M</th>
<th>T₁</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCHC0612N</td>
<td>M12×1</td>
<td>3~8</td>
</tr>
<tr>
<td>(Fine Thread)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>QCHC0816N</td>
<td>M16×1</td>
<td>3~12</td>
</tr>
<tr>
<td>(Fine Thread)</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Accuracy**

**Machining Accuracy**

Spacing tolerance on both the subplate and the base plate should be ±0.1.

**Repeatability**

Repeatability ±0.25

**Locating Pin**

For higher accurate locating, use locating pins.
QCBA / QCBAS  BALL-LOCK CLAMPING RECEPTACLES

QCBA0816 (Standard)
Part Number | Clamping Force (N) | Weight (g)
---|---|---
QCBA0816A | 7 | 30
QCBA0816B | 15 | 30

QCBAS0820 (Safety Lock)
Part Number | Clamping Force (N) | Weight (g)
---|---|---
QCBAS0820A | 7 | 65
QCBAS0820B | 15 | 65

QCBA0816-M5  BALL-LOCK CLAMPING PINS
Part Number | Weight (g)
---|---
QCBA0816-M5 | 7
**Feature**

- Clamping Pin
- Clamping Force: 7N, 15N
- Balls

The 3 balls pull in the clamping pin.

**Technical Information**

- Heat resistance 180°C
- Mechanical Strength

- Shear Strength 1800N
- Tensile Strength 1800N (at active safety lock)

**How To Operate Safety Lock**

- Turn in the arrowhead direction pushing the locking knob.
- Note: To release the safety lock, follow the steps back.

**How To Check Safety Lock**

- Inactive Mode
- Active Mode

When the mark lines on the end of the locking knob are aligned, the safety lock is active.

**Application Example**

**Changes of chuck of handling machines**

- BALL-LOCK CLAMPING RECEPTACLES
- BALL-LOCK CLAMPING RECEPTACLES (Safety Lock)
- BALL-LOCK CLAMPING PINS

**End fixing of sliding units**

- BALL-LOCK CLAMPING RECEPTACLE
- BALL-LOCK CLAMPING PIN

Continuing to next page

CAD Download: https://www.imao.biz/en
How To Install (Standard)

For installation in a subplate of thickness ranging from 6mm to 10mm, use a nut for fastening.

For installation in a subplate of thickness over 10mm, use a screw-in method.

How To Install (Safety Lock)

For installation in a subplate of thickness ranging from 6mm to 10mm, use a nut for fastening.

For installation in a subplate of thickness ranging from 10mm to 32mm, use a screw-in method.
How To Install (Ball-Lock Clamping Pins)

Plate thickness should be 6mm or more.

Accuracy

Machining Accuracy

Spacing Tolerance ±0.1

Subplate

Spacing Tolerance ±0.1

Base plate

Repeatability

Repeatability ±0.25

Locating Pin (Round)

Locating Pin (Diamond)

For higher accurate locating, use locating pins.

6mm Plate

M5×0.8

Over 6mm Plate

M5×0.8 depth 6
QCMA MAGNET-LOCK CLAMPING RECEPTACLE

 QCMA-M MAGNET-LOCK CLAMPING PIN

**QCMA0612A**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Clamping Force (N)</th>
<th>Weight (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCMA0612A</td>
<td>7</td>
<td>12</td>
</tr>
</tbody>
</table>

**Related Product**

**PW** Plunger Wrench

**Order Separately** Nut (Stainless Steel)

**NDX12-NUT-SUS**

**QCMA0612-M4**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Weight (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCMA0612-M4</td>
<td>2</td>
</tr>
</tbody>
</table>

**Body**

- SUS304 stainless steel
- Neodymium

**Magnet**

**Body**

- S45C steel
- Electroless nickel plated
Feature

Magnet-Lock Clamping Pin

Magnet

The magnet pulls in the clamping pin.

Application Example

Installation/removal of maintenance cover plate of machines

Magnet-Lock Clamping Pin

QCMA0612-M4

Magnet-Lock Clamping Receptacle

QCMA0612A

Technical Information

- Heat resistance 80°C
- Mechanical Strength
  Shear Strength 900N
**How To Install Magnet-Lock Clamping Receptacle**

For installation in a subplate of thickness ranging from 6mm to 10mm, use a nut for fastening.

![Diagram showing installation of Magnet-Lock Clamping Receptacle for 6mm and 10mm thicknesses.](image)

For installation in a subplate of thickness over 10mm, use a screw-in method.

![Diagram showing installation of Magnet-Lock Clamping Receptacle for thick subplates.](image)

**How To Install Magnet-Lock Clamping Pin**

For installation in a subplate of thickness ranging from 2mm to 6mm, use a nut for fastening.

![Diagram showing installation of Magnet-Lock Clamping Pin for 2mm to 6mm thicknesses.](image)

For installation in a subplate of thickness over 6mm, use a screw-in method.

![Diagram showing installation of Magnet-Lock Clamping Pin for thick subplates.](image)
Accuracy

Machining Accuracy

Repeatability

Repeatability ±0.25

Spacing tolerance on both the subplate and the base plate should be ±0.1.

For higher accurate locating, use locating pins.

Installation Wrench

Use this wrench for installation and removal of the parts below.

- QCBU-M (QCBU-M-SUS) BALL-LOCK RECEPTACLES
- QCBA (QCBS) BALL-LOCK CLAMPING RECEPTACLES
- QCMA MAGNET-LOCK CLAMPING RECEPTACLE

Order Separately

Part Number

PW16

Body

S45C Steel
Black oxide finish
## QCSJ SHAFT COUPLING CLAMP

### Key Point
Multipurpose coupling element

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Clamping Force(N)</th>
<th>Weight(g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCSJ0514A</td>
<td>90</td>
<td>25</td>
</tr>
</tbody>
</table>

### Note
Spring pins are not supplied.

## QCSJ-S / QCSJ-B CAM RECEPTACLES

### Body
SCM440 steel
Quenched and tempered
Electroless nickel plated

### Table
<table>
<thead>
<tr>
<th>Part Number</th>
<th>Weight(g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>QCSJ0514-S</td>
<td>10</td>
</tr>
<tr>
<td>QCSJ0514-B</td>
<td>8</td>
</tr>
</tbody>
</table>

### Supplied With
QCSJ0514-B: 2 of socket-head cap screws (stainless steel), M2×0.4-5L

### Note
Spring pins to mount QCSJ0514-S are not supplied.
**Feature**

- Shaft
- Spring
- Pin
- Cam Receptacle

When the pin contacts along the cam surface in Cam Receptacle, the spring gets compressed to clamp the shafts.

**Technical Information**

- Heatresistant Temperature: 200°C
- Mechanical Strength

- Shear Strength: 1800N
- Tensile Strength: 1200N

**How To Use**

1. Insert the shaft into the keyway of Cam Receptacle.

2. Turn the shaft or block for 90° to clamp. The element clicks when clamped. For unclamping, follow back these steps.

**Application Example**

Changes of thrust pads

- SHAFT COUPLING CLAMP QCSJ0514A
- CAM RECEPTACLE QCSJ0514-S

Continuing on Next Page
Application Example

Changes of riser

With Riser

Without Riser

SHAFT COUPLING CLAMP
QCSJ0514A

CAM RECEPTACLE
QCSJ0514-B

How To Install Shaft Coupling Clamp

Fix with a spring pin.

CAD Download: https://www.imao.biz/en
How To Install Cam Receptacle (Shaft Mount)

Fix with a spring pin.

Note

Pay attention to the direction of holes for spring pins.

Repeatability

Repeatability ±0.08

Prepare male and female fittings for higher accurate locating.