

Standard Round Bore

01/28/2025



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Standard Round Bore

PC-PPC-71

Standard Round Bore

01/28/2025

Table of Contents (continued)

82D40-2/82D63-5

Enclosed Pneumatic Power Clamps | Dual Arm | Features and Benefits | Technical Information

Base Model

Model	Description
82D40-2	40 mm Cylinder (G1/4 Port)
82D63-5	63 mm Cylinder (G1/4 Port)

Hand Lever

Hand Lever	Description
0	Hand Lever not available

Clamp Arms

B

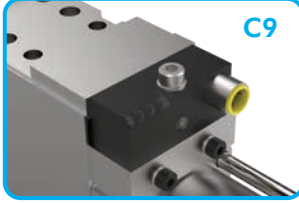
Description
Base model only. Order clamps arms separately. See below.

Clamp Arm Shaft

Clamp Arm Shaft	Description
23	includes long drive shaft ends on both sides fit for all clamping arms (standard)

Sensor

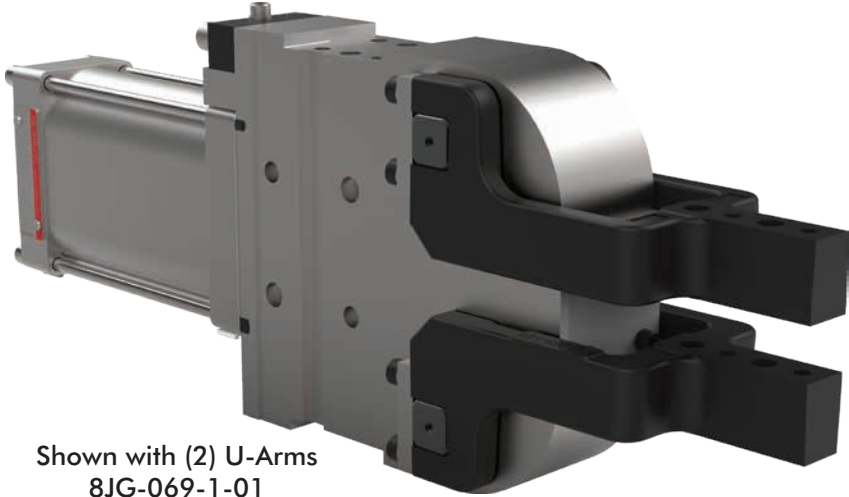
Sensor	Description
C9	includes Sensing System with M12x1 Connector (8EA-024-2) Standard




Opening Angle

Opening Angle	Opening Angle
0	180° (standard)
1	160°
2	140°
3	120°
4	100°
5	80°
6	60°
7	40°
8	20°

Reduced opening angles available upon request.




Shown with (2) U-Arms
8JG-069-1-01
(order separately)



82D63-5


Max Holding
400 Nm [295 ft-lb]
Max Clamping Torque
120 Nm [88 ft-lb]
at 5 bar [72 psi]



82D40-2

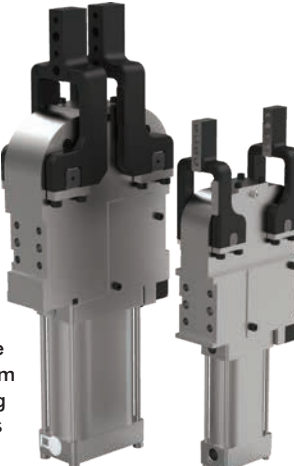
Max Holding
140 Nm [103 ft-lb]
Max Clamping Torque
60 Nm [44 ft-lb]
at 5 bar [72 psi]

U-type Central Clamping Arm




Model	Order No. (1 clamp arm)
82D40-223C900B	8JG-065-2-01
82D63-523C900B	8JG-069-1-01

Alternate Clamp Arm mounting positions



Lateral Clamping Arm

Clamp Arm Variants
Left Side, Right Side, Both Sides



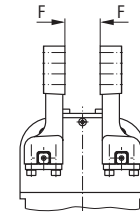
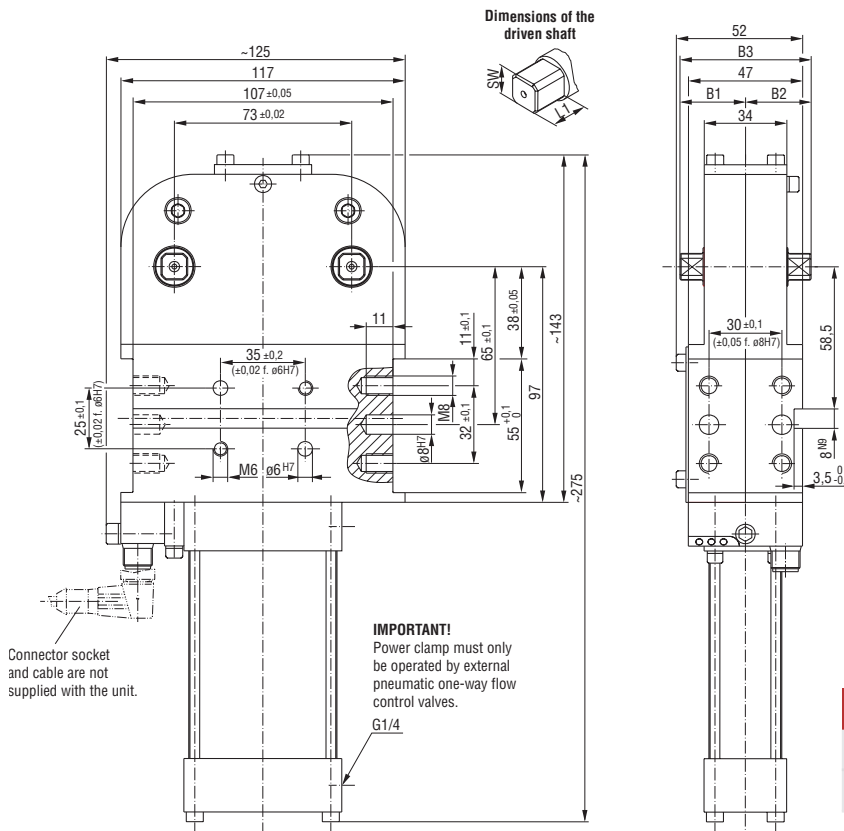
Model	Order No. (1 clamp arm)
82D40-223C900B	8JG-066-1-01
82D63-523C900B	8JG-070-1-01

82D40-2/82D63-5

Enclosed Pneumatic Power Clamps | Dual Arm | Dimensions

Model	Clamping position	Standard opening angle	Driveshaft	Max. holding torque Nm [ft-lb]	Clamping torque at 5 bar Nm [ft-lb]	Cylinder Ø mm [in]	Air consumption per double stroke at 5 bar dm ³ [ft ³]	Weight ~ kg [lbs]
82D40-223C900B	vertical	180°	lateral, both sides U-type clamping arms	55 [40]	55 [40]	40 [1.57]	1,2 [0.04]	2,5 [5.50]
82D63-523C900B				120 [88]	120 [88]	63 [2.48]	3,8 [0.13]	4,5 [9.90]

82D40-223C900B



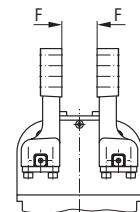
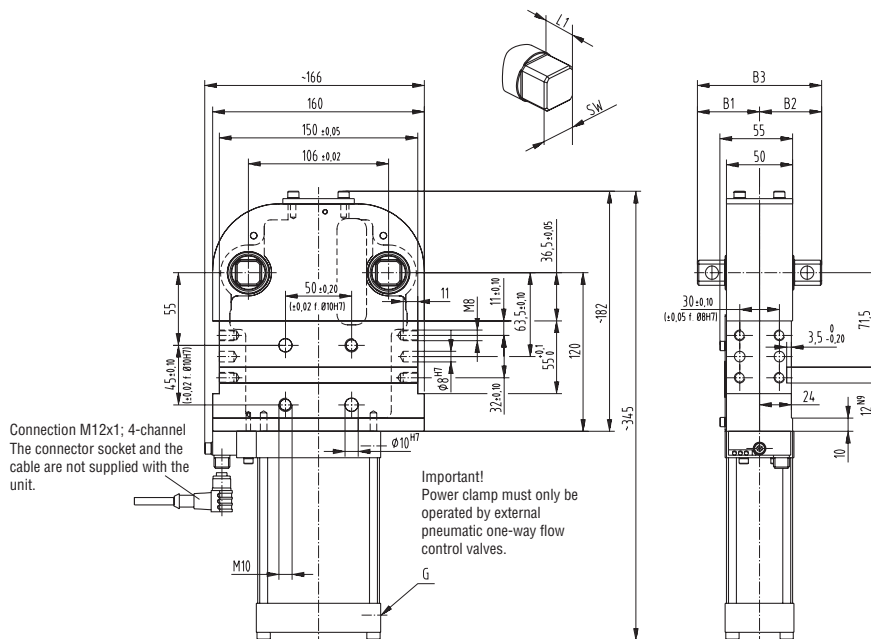
Safety notice:

The load on the clamping arms must always point towards the clamping direction. Single load of one arm is prohibited

Medium: air, max. 6 bar, operation with oil-free air is permissible

Model	B1	B2	B3	L1	SW	G
82D40-223C900B	30	30	60	12,5	11	1/4
82D63-523C900B	47	47	94	21	19	

82D63-523C900B



Safety notice:

The load on the clamping arms must always point towards the clamping direction. Single load of one arm is prohibited

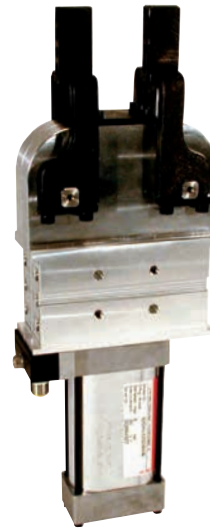
Medium: air, max. 6 bar, operation with oil-free air is permissible

U-ARMS CENTER (STEEL)

Enclosed Pneumatic Power Clamps | Dual Arm | Dimensions and Technical Specifications

- Clamping arm variants for **82D40-2**

Clamping arm variant U-type central clamping arm

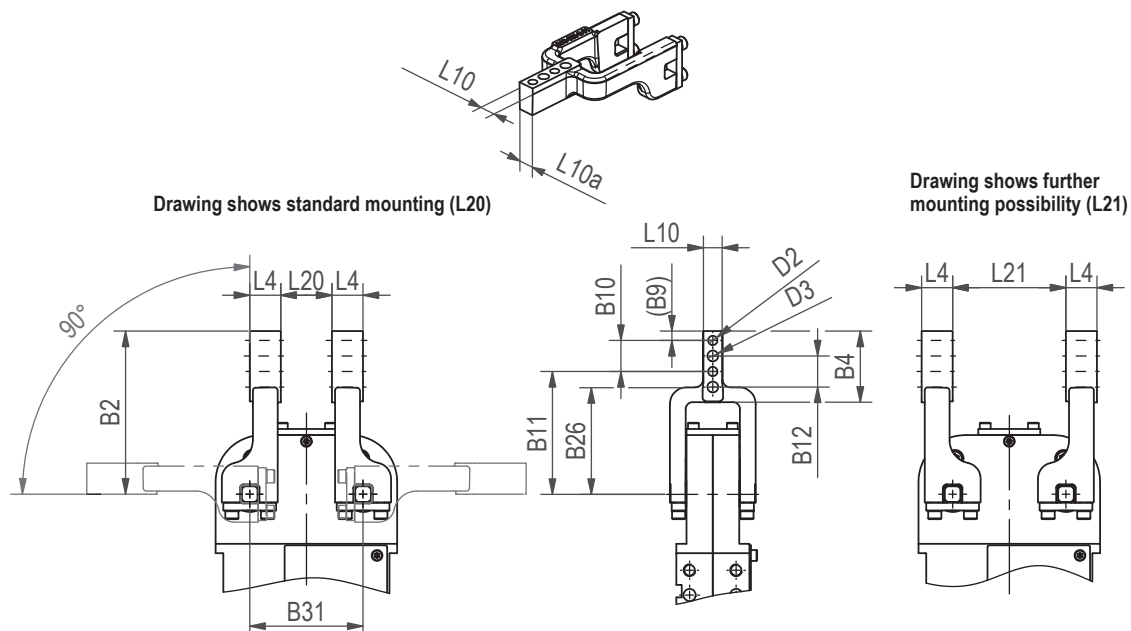


Base model with 2 U-type clamping arms, small gap between clamping arms

U-type central clamping arm | Technical Information

Model	Order no. for U-type clamping arm set (1 clamping arm)	Clamping position	Standard opening angle	B2	B4	B9	B10	B11	B12	B26
82D40-223C900B	8JG-065-2-01	vertical	180°	105	45,3	6	±0,02	+0,1	±0,2	20
										68,2

Model	Order no. for U-type clamping arm set (1 clamping arm)	B31	D2	D3	L4	L10	L10a	L20	L21
82D40-223C900B	8JG-065-2-01	±0,02	H7 ∅	∅		±1,1	~		
		73	6	7	20	12	11,3	33	73

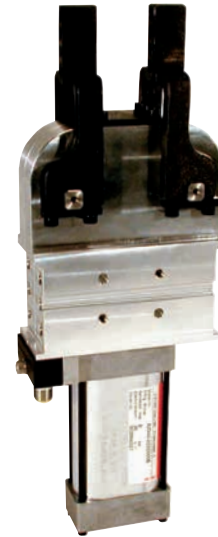


U-ARMS CENTER (STEEL)

Enclosed Pneumatic Power Clamps | Dual Arm | Dimensions and Technical Specifications

- Clamping arm variants for **82D63-5**

Clamping arm variant U-type central clamping arm

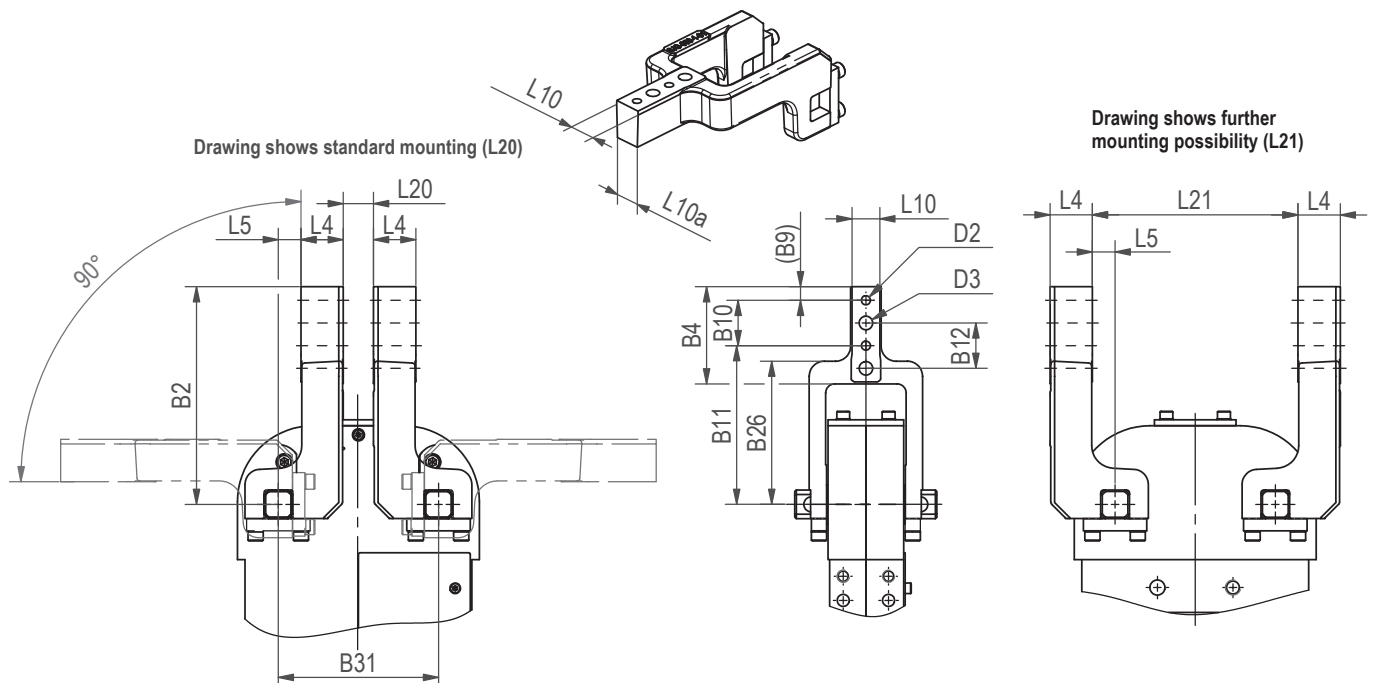


Base model with 2 U-type clamping arms, small gap between clamping arms

U-type central clamping arms | Technical Information

Model	Order no. for U-type clamping arm set (1 clamping arm)	Clamping position	Standard opening angle	B2	B4	B9	B10	B11	B12	B26
82D63-523C900B	8JG-069-1-01	vertical	180°	144	64,3	9	±0,02	+0,1	±0,2	95

Model	Order no. for U-type clamping arm set (1 clamping arm)	B31	D2	D3	L4	L5	L10	L10a	L20	L21
82D63-523C900B	8JG-069-1-01	±0,02	H7 ∅	∅	28	15	±1,2	~	20	136



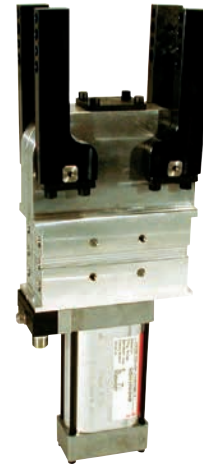
LATERAL (SIDE) ARMS

Enclosed Pneumatic Power Clamps | Dual Arm | Dimensions and Technical Specifications

- Clamping arm variants for **82D40-2**

Clamping arm variant

- Lateral clamping arm left
- Lateral clamping arm right
- Lateral clamping arm both sides



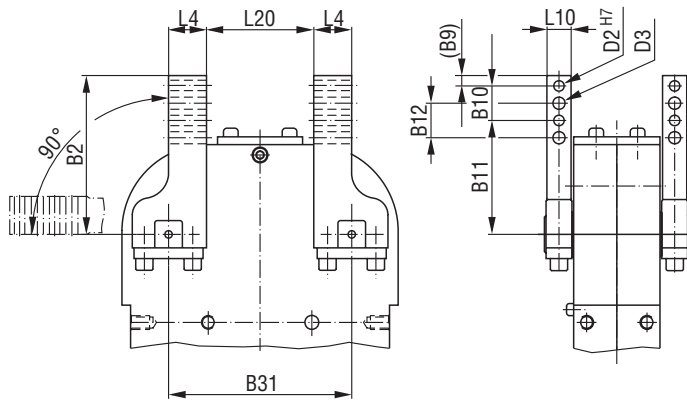
Base model with 4 lateral clamping arms, large gap between clamping arms

Lateral clamping arm | Technical Information

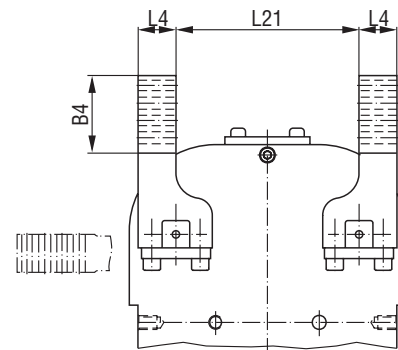
Model	Clamping arm variant	Order no. for 1 set of lateral clamping arms (1 clamping arm)	Clamping position	Standard opening angle	B2	B4	B9	B10	B11	B12
82D40-223C900B	lateral, left lateral, right lateral, both sides	8JG-066-1-01	vertical	180°	105	45	6	±0,02	+0,1	±0,2

Model	Clamping arm variant	Order no. for 1 set of lateral clamping arms (1 clamping arm)	B31	D2	D3	L4	L10	L20	L21
82D40-223C900B	lateral, left lateral, right lateral, both sides	8JG-066-1-01	±0,02	H7 ∅	∅		-0,1		
82D40-223C900B	lateral, left lateral, right lateral, both sides	8JG-066-1-01	73	6	7	20	12	33	73

Drawing shows standard mounting (L20) with four lateral clamp arms



Drawing shows further mounting possibility (L21)



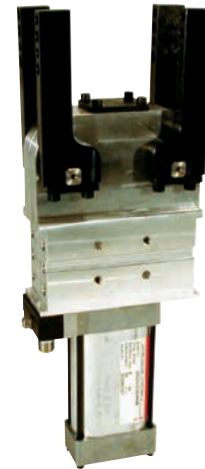
LATERAL (SIDE) ARMS

Enclosed Pneumatic Power Clamps | Dual Arm | Dimensions and Technical Specifications

- Clamping arm variants for **82D63-5**

Clamping arm variant

- Lateral clamping arm left
- Lateral clamping arm right
- Lateral clamping arm both sides



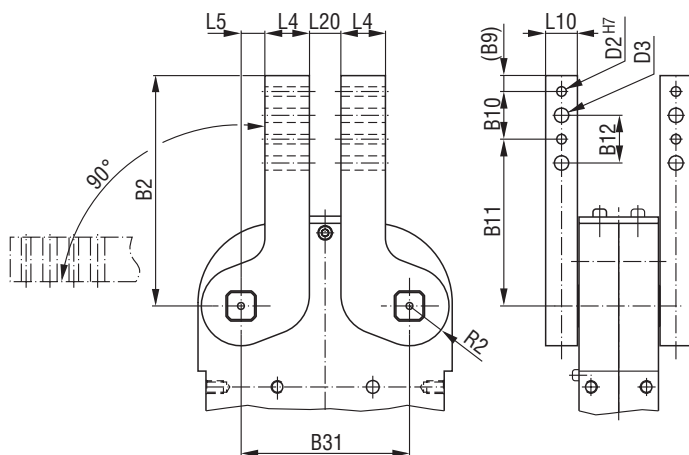
Base model with 4 lateral clamping arms, large gap between clamping arms

Lateral clamping arms | Technical Information

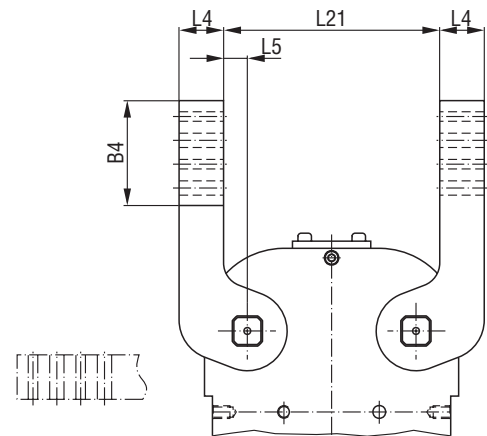
Model	Clamping arm variant	Order no. for 1 set of lateral clamping arms (1 clamping arm)	Clamping position	Standard opening angle	B2	B4	B9	B10	B11	B12
82D63-523C900B	lateral, left lateral, right lateral, both sides	8JG-070-1-01	vertical	180°	144	74	9	30	105	30

Model	Clamping arm variant	Order no. for 1 set of lateral clamping arms (1 clamping arm)	B31	D2	D3	L4	L5	L10	L20	L21	R2
82D63-523C900B	lateral, left lateral, right lateral, both sides	8JG-070-1-01	±0,02	H7 ∅	∅	28	15	20	20	136	28

Drawing shows standard mounting (L20) with four lateral clamp arms



Drawing shows further mounting possibility (L21)

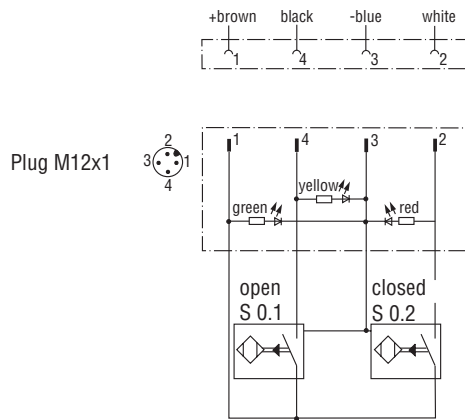


82D40-2/82D63-5

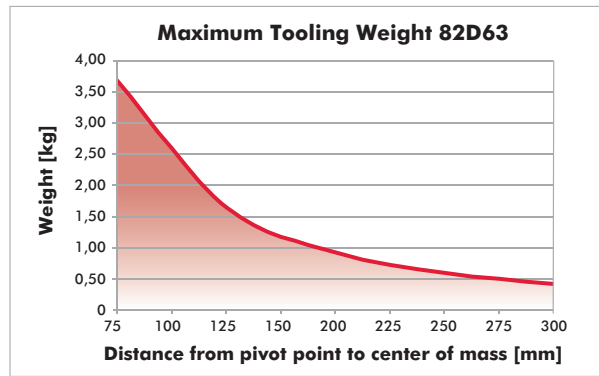
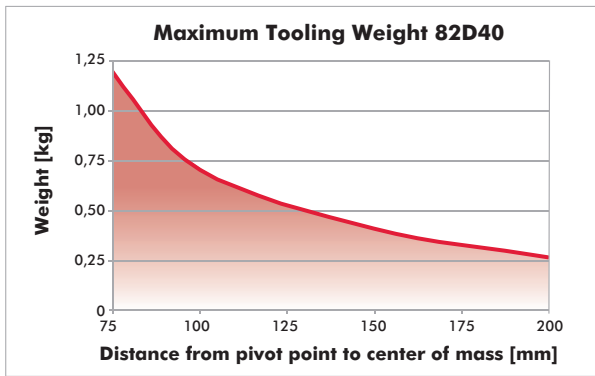
Enclosed Pneumatic Power Clamps | Dual Arm | Technical Specifications

Wiring diagram of electrical sensing system

Sensing system immune to interference from d.c. arc welding and a.c. arc welding

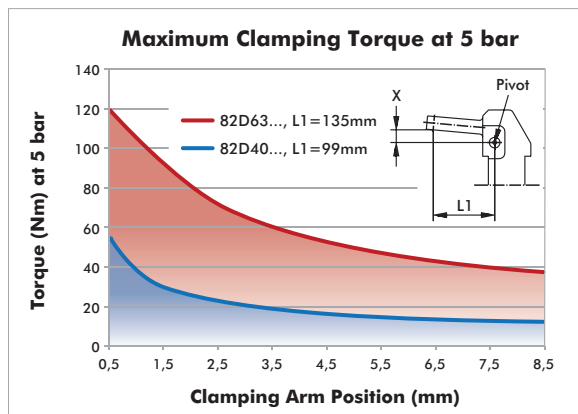


Concept guideline (with reference to axis of clamping arm rotation)



All details apply under an air pressure of 6 bar and opening and closure times of 1 second each

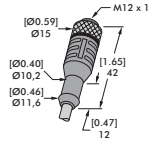
Diagram of clamping torque



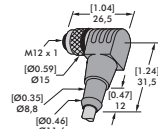
82D40-2/82D63-5 ACCESSORIES

Enclosed Pneumatic Power Clamps | Dual Arm | Ordering Information

Clamping Arms		Order no. for Structural component		Comment
Clamping are variant	Clamping position	82D40-223C900B	82D63-523C900B	
U-central	vertical	8JG-065-1-01	8JG-069-1-01	sets of U-type clamping arms consist of clamping arm, links and screws
lateral right/left	vertical	8JG-066-1-01¹⁾	8JG-070-1-01²⁾	sets of lateral clamping arms consist of 1) clamping arm, links and screws 2) clamping arm and set screws you need 2 sets of clamping arms
lateral both sides	vertical	8JG-066-1-01¹⁾	8JG-070-1-01²⁾	you need 4 sets of clamping arms



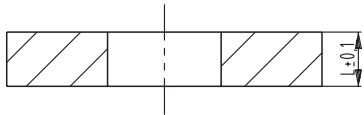
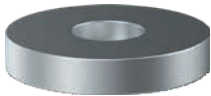
Connector socket
M12x1 straight, 5-pin



Connector socket
M12x1 angular, 4-pin

Connector Cable (includes 1 connector socket & 5 m cable)	Order no. for Structural component	
	82D40-223C900	82D63-523C900
Connector socket M12x1 straight, 5-pin	8EL-002-1	8EL-002-1
Connector socket M12x1 angular, 4-pin	8EL-003-1	8EL-003-1

Opening Angle Limiter	Order no. for Structural component			
	82D40-223C900		82D63-523C900	
Angle	Length	Order No.	Length	Order No.
180° (Standard)	11,4mm	8CE-342-1	14,4mm	8CE-362-1
160°	15,1mm	8CE-340-1	20,0mm	8CE-360-1
140°	18,5mm	8CE-338-1	24,8mm	8CE-358-1
120°	22,2mm	8CE-336-1	29,6mm	8CE-356-1
100°	25,8mm	8CE-334-1	34,3mm	8CE-354-1
80°	28,0mm	8CE-332-1	39,0mm	8CE-352-1
60°	33,0mm	8CE-330-1	43,8mm	8CE-350-1
40°	37,0mm	8CE-328-1	49,1mm	8CE-348-1
20°	41,8mm	8CE-326-1	56,2mm	8CE-346-1



Shim Plates (for clamping arm)	Fit for model 82D40-2								Fit for model 82D63-5									
	Model	A1	A2	D2	D3	B9	B10	B12	L10	Model	A1	A2	D2	D3	B9	B10	B12	L10
	82ZB-SH4001		0,1							82ZB-SH5001		0,1						
	82ZB-SH4002		0,2							82ZB-SH5002		0,2						
	82ZB-SH4005	42	0,5	6,5	7	6	20	20	12	82ZB-SH5005	65	0,5	6,5	9	10	30	30	16
	82ZB-SH4010		1,0							82ZB-SH5010		1,0						
	82ZB-SH4020		2,0							82ZB-SH5020		2,0						
	82ZB-SH4050		5,0							82ZB-SH5050		5,0						

Spare Parts	Order no. for Structural component	
	82D40-2	82D63-5
Cylinder	8PW-016-1	8PW-024-2
Integrated sensing system C9 Connector plug M12x1	8EA-024-2	8EA-024-2

84A

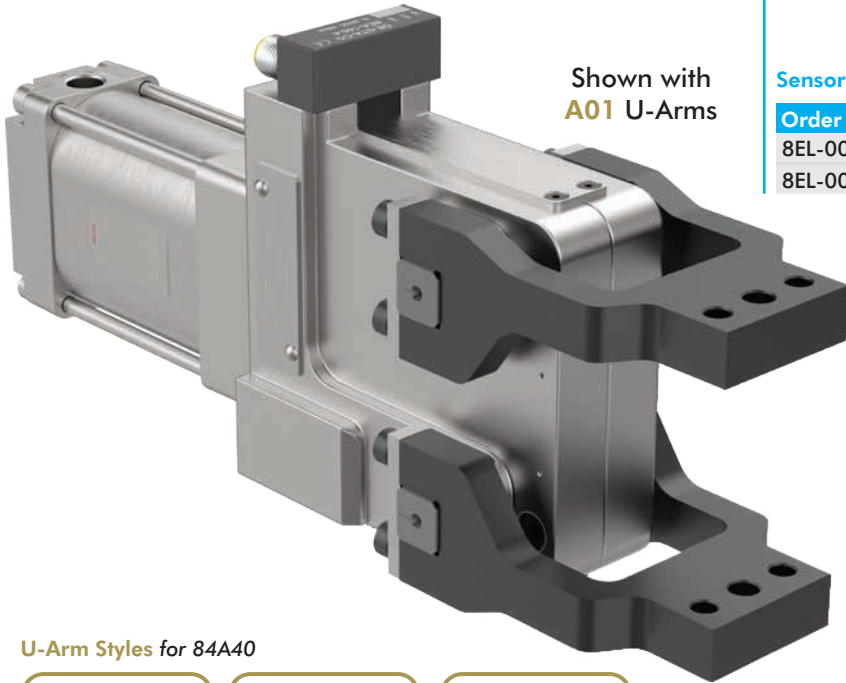
Enclosed Pneumatic Power Clamps | Dual Arm, Tolerance Compensation | Ordering Information

84A 50-1 A01 L8

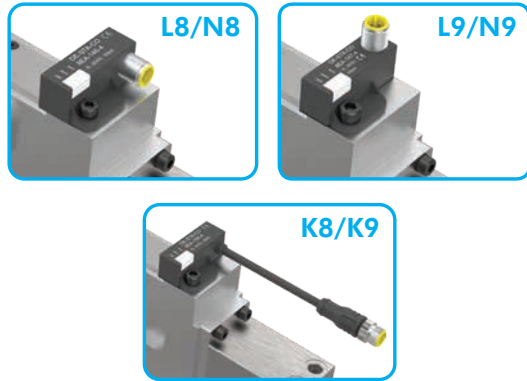
Size	Description
40-1	32 mm Cylinder (G1/8 Port)
50-1	50 mm Cylinder (G1/4 Port)

U-Arm Style	Description
000	Without Clamping Arms
A01	Double Tip, Surface Clamping
A02	Single Tip, Point Clamping
A03	Double Tip, Surface Clamping (Standard Profile 84A40, Wide Profile 84A50)
A04	Double Tip, Surface Clamping, Wide Profile for 84A50 only

Shown with
A01 U-Arms

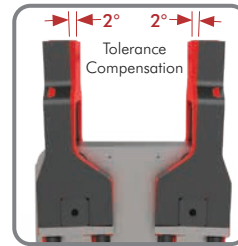


Sensor	Description
00	Without Sensing System
L8	PNP Sensor with In-line M12x1 Connector (8EA-146-4-B)
N8	NPN Sensor with In-line M12x1 Connector (8EA-154-4-B)
L9	PNP Sensor with 90° M12x1 Connector (8EA-147-4-B)
N9	NPN Sensor with 90° M12x1 Connector (8EA-155-4-B)
K8	PNP Sensor with M12x1 Cable Connector (8EA-158-4-B)
K9	NPN Sensor with M12x1 Cable Connector (8EA-167-4-B)



Sensor Cables Order separately

Order No.	Description
8EL-002-1	M12x1, Straight, 5-pin Connector w/5 m [16 ft.] Cable
8EL-003-1	M12x1, Angular, 4-pin Connector w/5 m [16 ft.] Cable



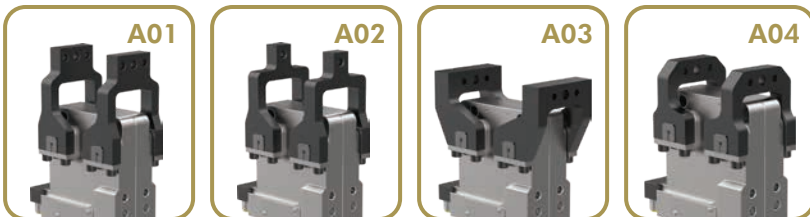
Dual Arm Compensation

- 2° of tolerance compensation per clamp arm
- Compensates for variable sheet metal thicknesses
- There is no need for shimming

U-Arm Styles for 84A40



U-Arm Styles for 84A50

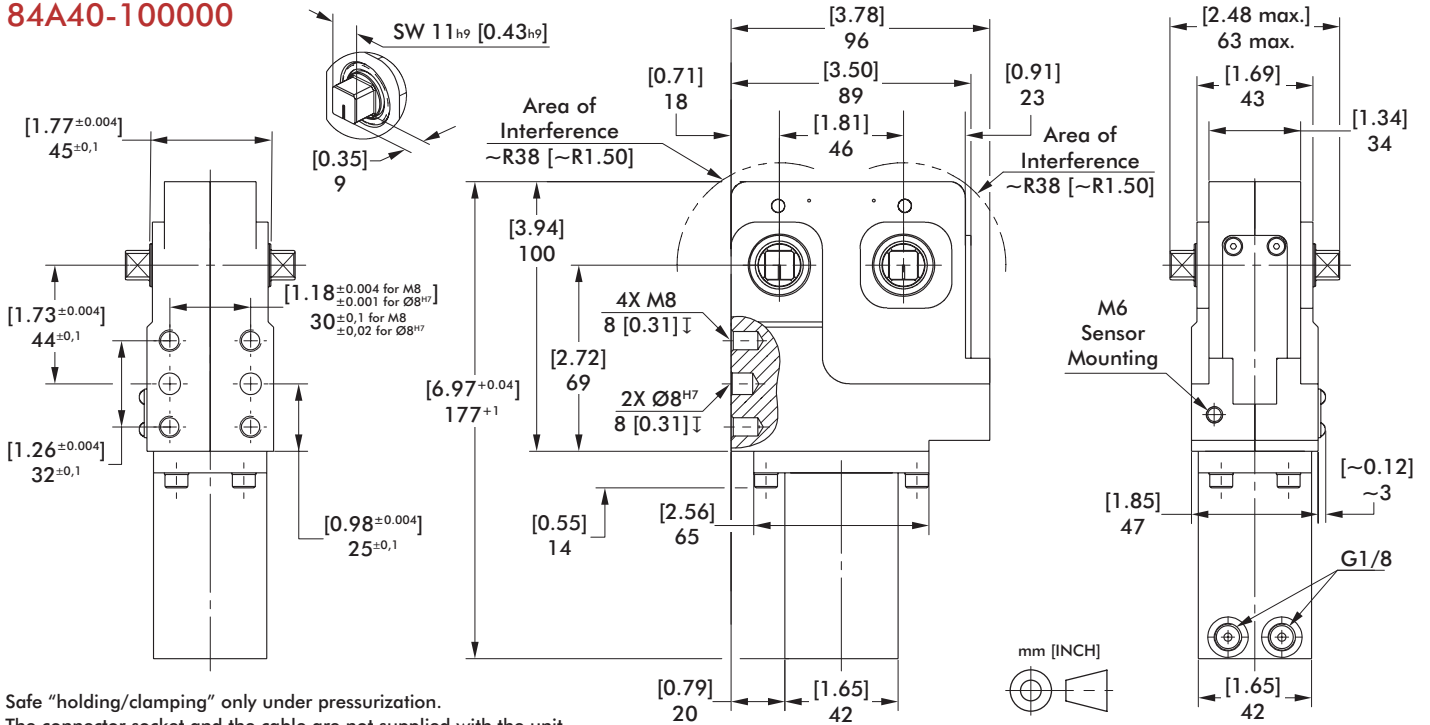


84A40-1

84A50-1

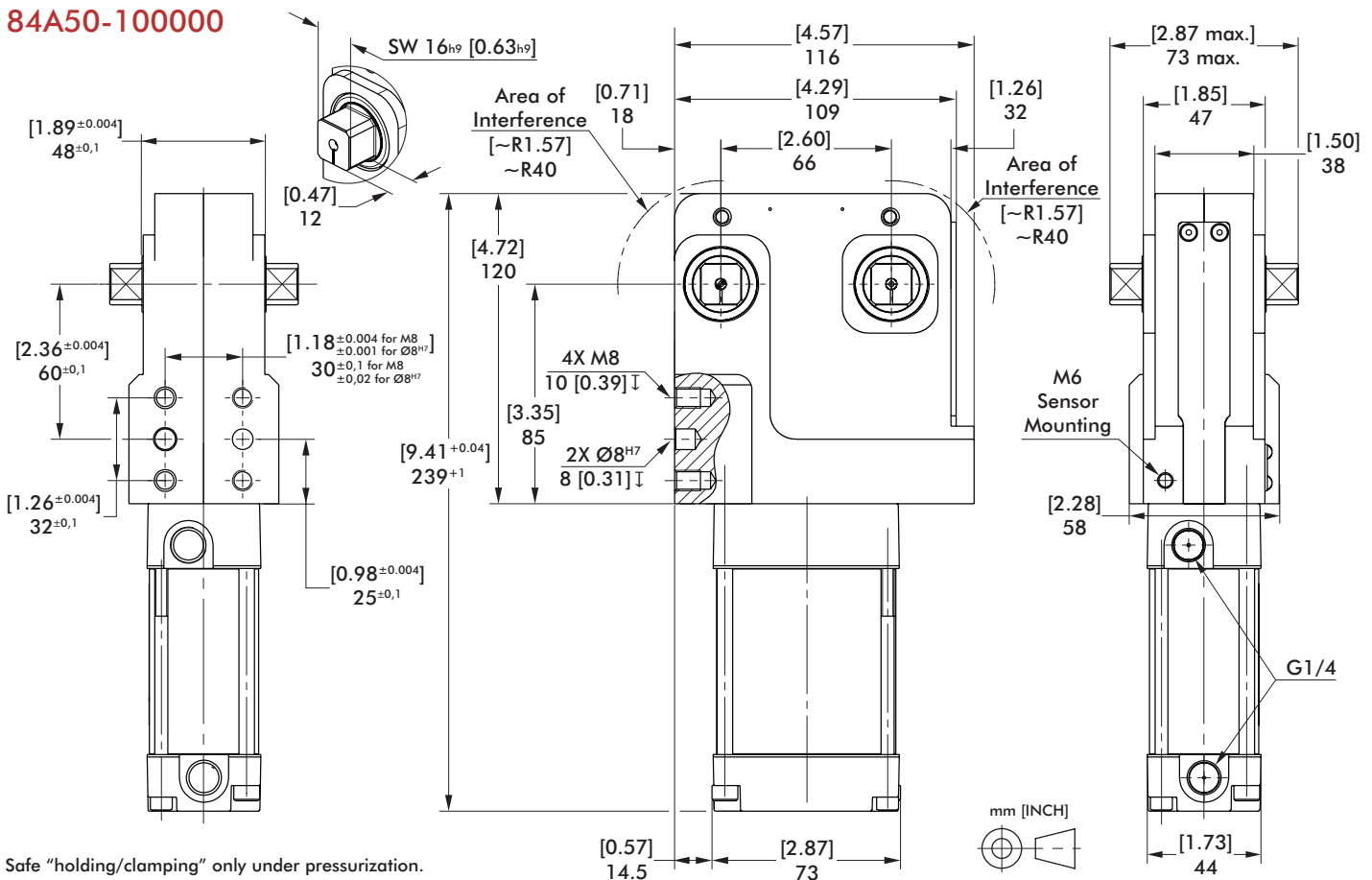
Enclosed Pneumatic Power Clamps | Dual Arm, Tolerance Compensation | Dimensions

84A40-100000



Safe "holding/clamping" only under pressurization.
 The connector socket and the cable are not supplied with the unit.
 Power by compressed air, max. 6 bar operation with oil-free air is permissible.

84A50-100000

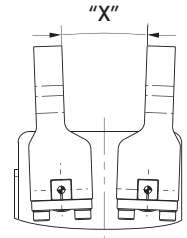
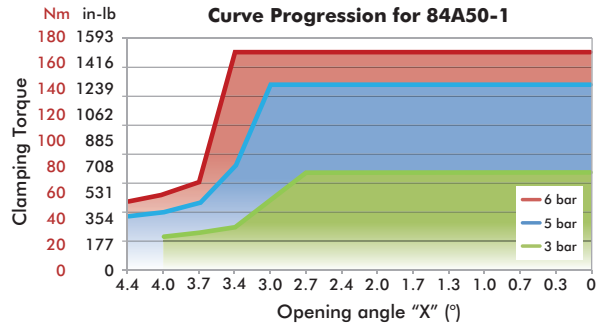
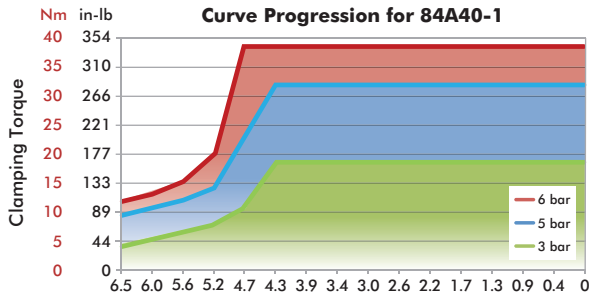


Safe "holding/clamping" only under pressurization.
 The connector socket and the cable are not supplied with the unit.
 Power by compressed air, max. 6 bar operation with oil-free air is permissible.

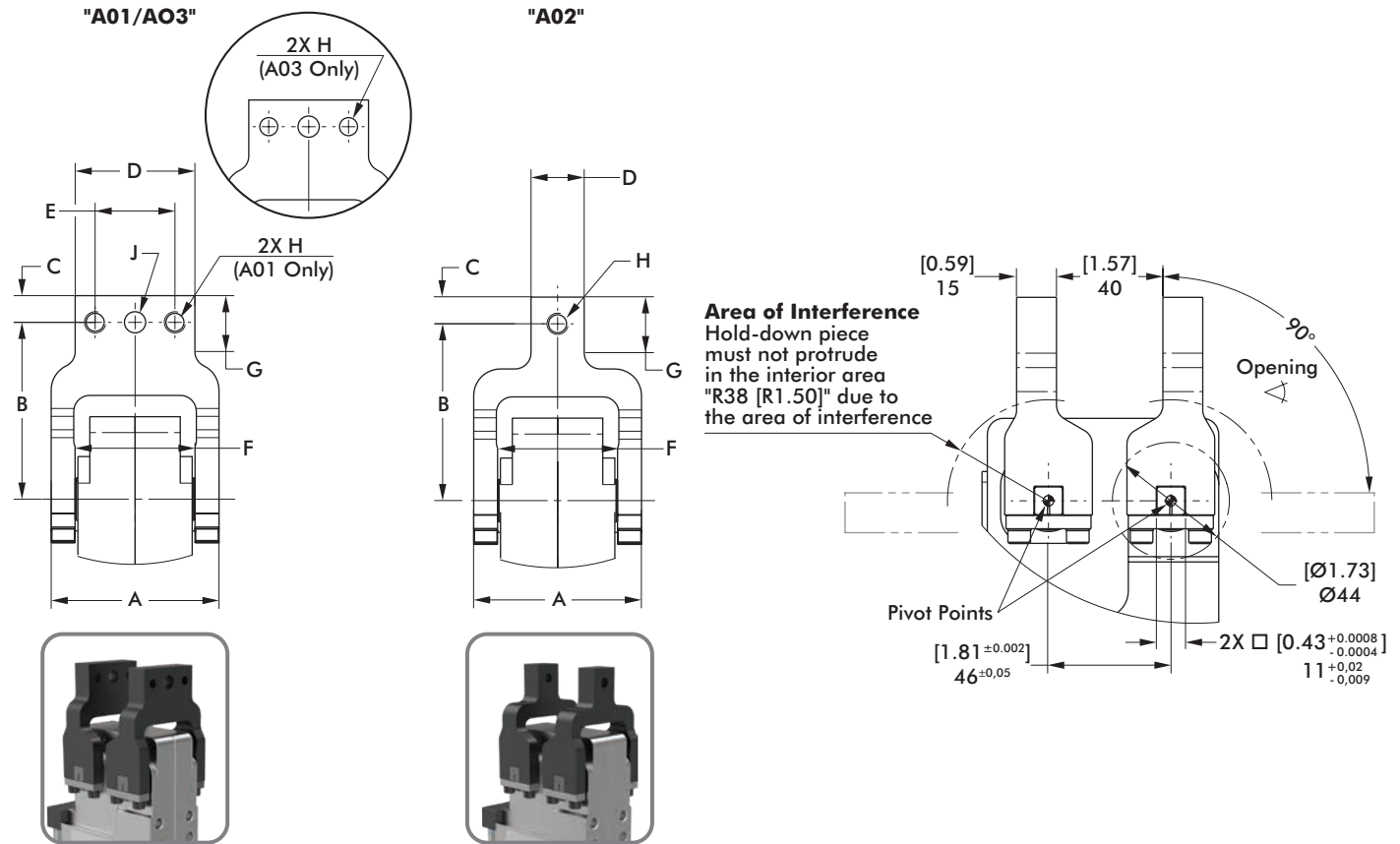
84A

Enclosed Pneumatic Power Clamps | Dual Arm, Tolerance Compensation | Technical Specifications

Model	Connection	Max. Holding Torque at 5 bar [72psi] Nm [in-lb]	Max. Clamping Torque at 5 bar [72psi] Nm [in-lb]	Piston Ø mm [in]	~Weight kg [lbs]	Air Consumption per double stroke at 5 bar [72 psi] liter [in ³]
84A40-1.....	G1/8	29 [257]	29 [257]	40 [1.57]	1,5 [3.31]	0,45 [27]
84A50-1.....	G1/4	136 [1200]	136 [1200]	50 [1.97]	2,4 [5.29]	0,72 [44]

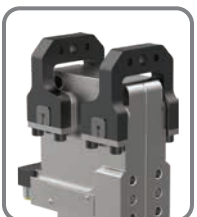
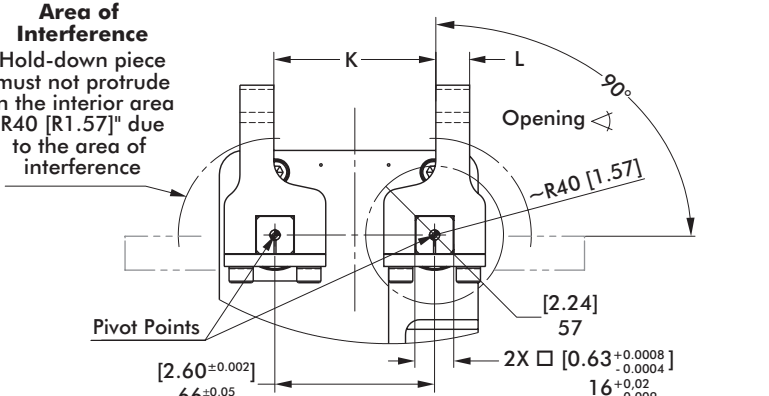
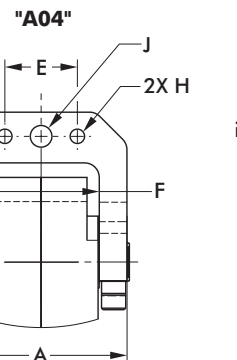
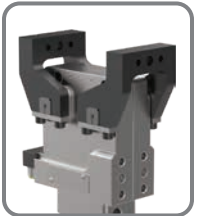
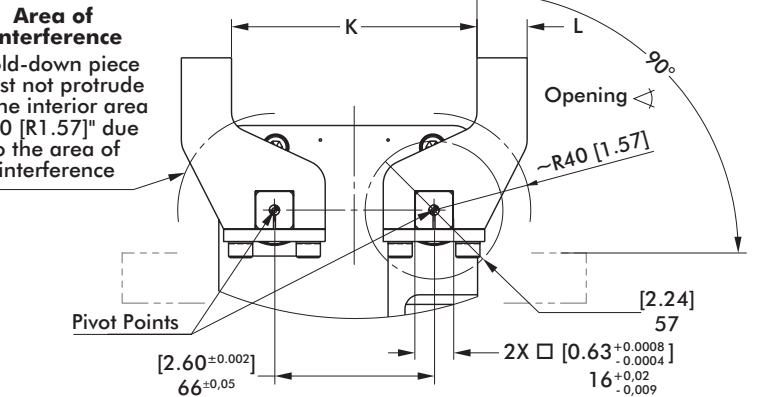
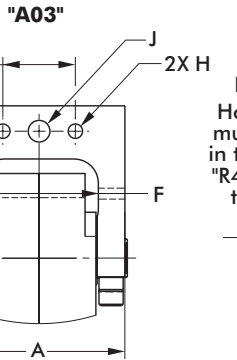
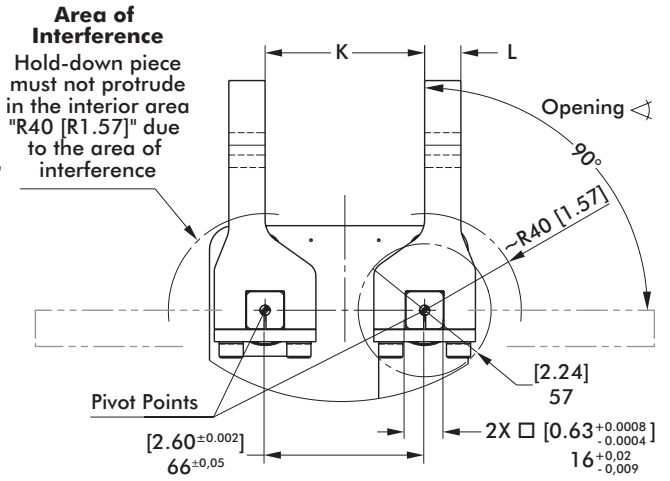
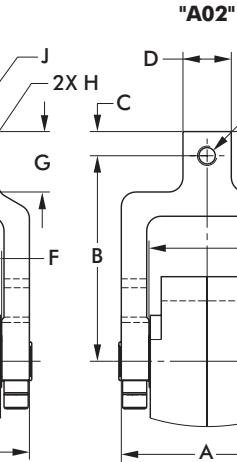
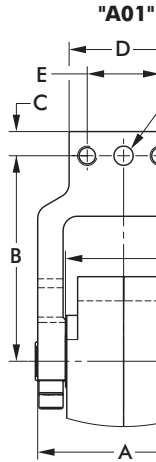


U-Type Central Clamping Arms (Aluminum) - For Size 84A40



Arm Model No.	Arm Order No.	Weight kg [lbs]	A ± 0,5 [± 0.02]	B ± 0,1 [± 0.004]	C - 0,05 [- 0.002]	D	E + 0,2 [+ 0.008]	F	G	ØH	ØJ
A01	8AM801-40-066	0,17 [0.37]	[2.48] 63,1	[2.62] 66,5	[0.39] 10	45 [1.77]	30 [1.18] ± 0,1 [± 0.004]	[1.78] 45,1	[0.83] 21	M8	8 ^{H7} [0.31 ^{H7}]
A03	8AM803-40-001						30 [1.18] ± 0,02 [± 0.008]			[0.24 ^{H7}] 6 ^{H7}	9 [0.35]
A02	8AM802-40-066	0,14 [0.31]				20 [0.79]	--			M8	--

U-Type Central Clamping Arms (Aluminum) - For Size 84A50

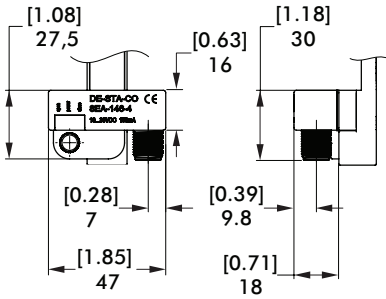


Arm Model No.	Arm Order No.	Weight kg [lbs]	A ±0,5 [±0.02]	B ±0,1 [±0.004]	C -0,05 [-0.002]	D	E ±0,2 [+0.008]	F	G	ØH	ØJ	K	L
A01	8AM801-50-085	[0.97] 0,44	[2.80] 71	[3.35] 85	[0.39] 10	[1.77] 45	30 [1.18] ±0,1 [±0.004]	[1.89] 48,1	[0.98] 25	M8	[0.31] 8 ^{H7}	[2.60] 66	[0.59] 15
A02	8AM802-50-085	[0.9] 0,41		[0.79] 20	--	--	[2.60 ±0.002] 66 ±0,05		2X □ [0.63 ±0.0008 / -0.0004] 16 ±0,02 / -0,009				
A03	8AM803-50-001	[1.1] 0,5		[2.07] 52,5	[0.41] 10,5	--	30 [1.18] ±0,02 [±0.008]	--	[0.24 ^{H7}] 6 ^{H7}	[0.35] 9	[4.00] 101.5	[0.82] 20.75	
A04	8AM804-50-001	[0.79] 0,36		[2.05] 52	[0.39] 10	--	30 [1.18] ±0,02 [±0.008]	--	[0.24 ^{H7}] 6 ^{H7}	[0.35] 9	[2.64] 67	[0.55] 14	

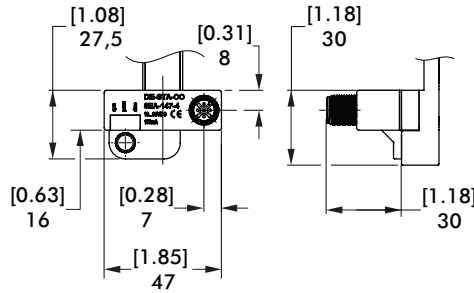
84A

Enclosed Pneumatic Power Clamps | Dual Arm, Tolerance Compensation | Dimensions

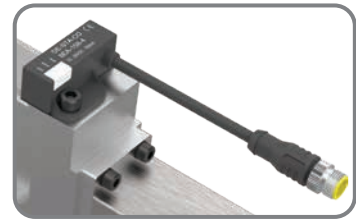
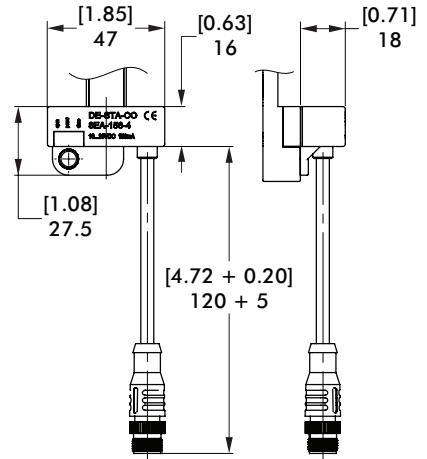
L8, N8 Inductive Sensing System



L9, N9 Inductive Sensing System with 90° Connector

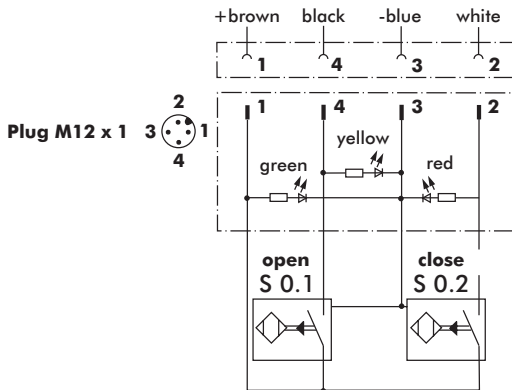


K8, K9 Inductive Sensing System with Pigtail Connector



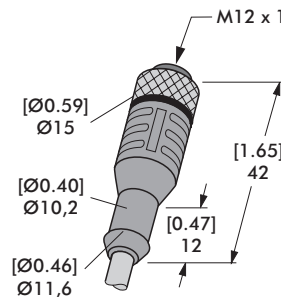
Inductive Sensor Wiring Diagram

Sensing system immune to interference from AC / DC arc welding.

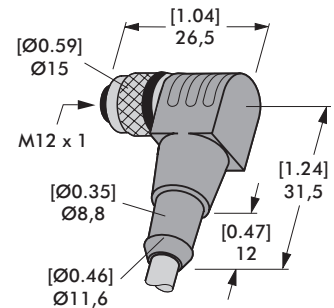


Sensor Cable Accessories

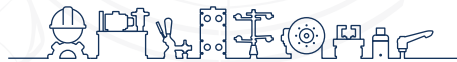
Sensor Cables (1 connector & 5m cable)	Order no.
M12x1 connector, straight, 5-pin	8EL-002-1
M12x1 connector, 90° angular, 4-pin	8EL-003-1



Straight Cable
8EL-002-1



Angular Cable
8EL-003-1



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