**Fixture clamp with fixed jaw**

max. clamping force 15 kN, jaw width 65 mm, double acting, max. operating pressure 250 bar

### Advantages
- Very compact design
- High rigidity and precision
- Strokes 5 and 45 mm
- Double-acting function
- Fixtures without tubes possible
- Exchangeable jaws
- Pneumatic contact or seat control in the fixed jaw possible
- Good swarf protection
- Port for central lubrication
- Mounting position: variable

### Application
The fixture clamps are used for machining of dimensionally stable workpieces in single or multiple clamping fixtures. Due to their compact design they can be arranged in a very limited space. Fixture clamps are especially suitable for series manufacturing in automated mode. The double-acting cylinder function combined with central lubrication and good swarf protection guarantees a high process safety.

### Description
The fixture clamp with fixed jaw consists of a very small basic body with integrated hydraulic cylinder which actuates the movable jaw. All threads and ports are at the bottom to allow a space-saving arrangement of several clamping points in a very limited space. If fixing from below is not possible an adaptor plate for manifold mounting or tube connection is available. As accessory also blanks of clamping jaws are available for adaptation to the workpiece contour. The fixed jaw can be equipped with a pneumatic seat control.

### Important notes
The fixture clamp is only suitable for exterior clamping. Lubricate at the latest after 500 clamping cycles the clamping slide via the central lubrication. Never use the complete clamping stroke to guarantee safe clamping of the workpiece. Max. operating temperature 80 °C. Operating conditions and other data see data sheet A 0.100.

### Function
- Fixing from above with accessory adaptor plate
- Drilled channels
- Connecting insert

### Fixing from below
- Drilled channels

### Accessories
Fixed jaw, clamping jaws and adaptor plate are not included in the delivery of the fixture clamp and have to be ordered separately as accessory.

### Application example
Clamping fixture for a pedal of a freight vehicle.
Part no. 4413101

Technical data

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
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<tbody>
<tr>
<td>Clamping force max. [kN]</td>
<td>15</td>
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<tr>
<td>Clamping stroke [mm]</td>
<td>5</td>
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<tr>
<td>Jaw width [mm]</td>
<td>65</td>
</tr>
<tr>
<td>Max. flow rate [cm³/s]</td>
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Stroke volume

- Clamping [cm³]: 4
- Unclamping [cm³]: 3

Weight approx. [kg]: 5.05

Adaptor plate (accessory)

<table>
<thead>
<tr>
<th>Parameter</th>
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<tr>
<td>Weight approx. [kg]</td>
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Clamping force max. [kN]: 15

Clamping stroke [mm]: 5

Jaw width [mm]: 65

Max. flow rate [cm³/s]: 40

Stroke volume

- Clamping [cm³]: 4
- Unclamping [cm³]: 3

Weight approx. [kg]: 5.05

Adaptor plate (accessory)

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<tbody>
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<td>Weight approx. [kg]</td>
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Subject to modifications.

Actual issue see www.roemheld-group.com Römheld GmbH
Part no. 4413131

Technical data

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<td>Jaw width [mm]</td>
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<td>Stroke volume Clamping [cm³]</td>
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<td>Unclamping [cm³]</td>
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Adaptor plate (accessory)

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<td>Part no.</td>
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Clamping force diagram

(Height of the clamping jaw 25 mm)

Accessory: adaptor plate

View from below

A = Clamping
B = Unclamping
S = Central lubrication
L = Air for seat control

Accessory: adaptor plate

View from above

M8 x 9 deep (4x)
G1/8 (4x)
M8 x 10 deep (8x)
O-ring 8 x 1.5 Part no. 3000275 (included in the delivery)
Socket head cap screw M8 x 25 Part no. 3301583 (included in the delivery)

Seat control closed with threaded pin
For socket head cap screw M8 DIN EN ISO 4762

Römheld GmbH
Actual issue see www.roemheld-group.com

Subject to modifications
Accessories

Accessory - clamping jaws

Versions: Clamping jaw blanks
Material: 16 MnCr5 smooth

Clamping jaw: Part no. 3548080

Fixed jaw: Part no. 3548081

Max. height of the clamping jaws X
at max. operating pressure of 250 bar
Fixing screws: M8x25 - 12.9
Part no. 3300 700

Self-made clamping jaws
Clamping jaws and fixed jaws are manufactured according to the contour of the workpiece to be clamped.
The max. height of the clamping jaw X at 250 bar operating pressure is indicated in the below chart.
If the operating pressure is lower, the clamping jaws and the fix jaws can be designed higher as per the below diagram.

Max. height of the clamping jaw X
as a function of the operating pressure

Important note
The clamping jaws must always be supported by the provided support, since the fixing screws are not in the position to compensate the generated clamping forces.

Fixing of the clamping jaws

Subject to modifications