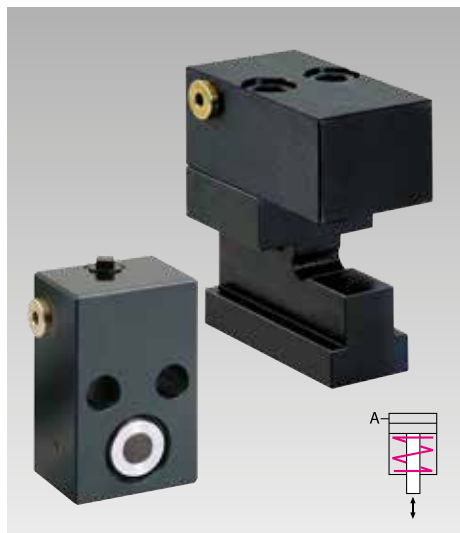




Sliding Clamps classic

single acting, with spring return

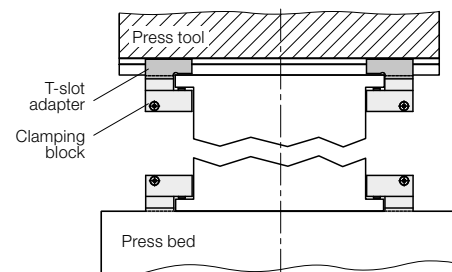
max. operating pressure 400 bar, clamping force from 19 to 78 kN



Advantages

- Optimum force transmission
- Clamping force from 19 kN up to 78 kN
- Easy mounting
- Suitable for large clamping edge tolerances
- No colliding edges when inserting the dies
- T-slot 18, 22, 28 and 36 mm are available
- Total stroke 8 and 12 mm
- Die standardisation with regard to the width and depth is not required
- Easy to retrofit

Installation option



Application

The "classic" sliding clamp is a very sturdy hydraulic clamping element, used with low space requirements for clamping and locking on machines and plants, on press bed and ram.

The use is possible at ambient temperatures up to a maximum of 120 °C.

Description

Manual positioning of the sliding clamp in the T-slots of the press ram or bed. Clamping on the die clamping edge by the application of hydraulic pressure to the piston and unclamping by spring force.

The "classic" sliding clamp consists of a hydraulic clamping block which will be fixed with two screws to a T-slot adapter.

The clamping block can also be directly screwed without T-slot adapter and can be ordered separately.



Application examples



Sliding clamp with T-slot adapter in press bed and ram, roller bars and carrying consoles for tool insertion

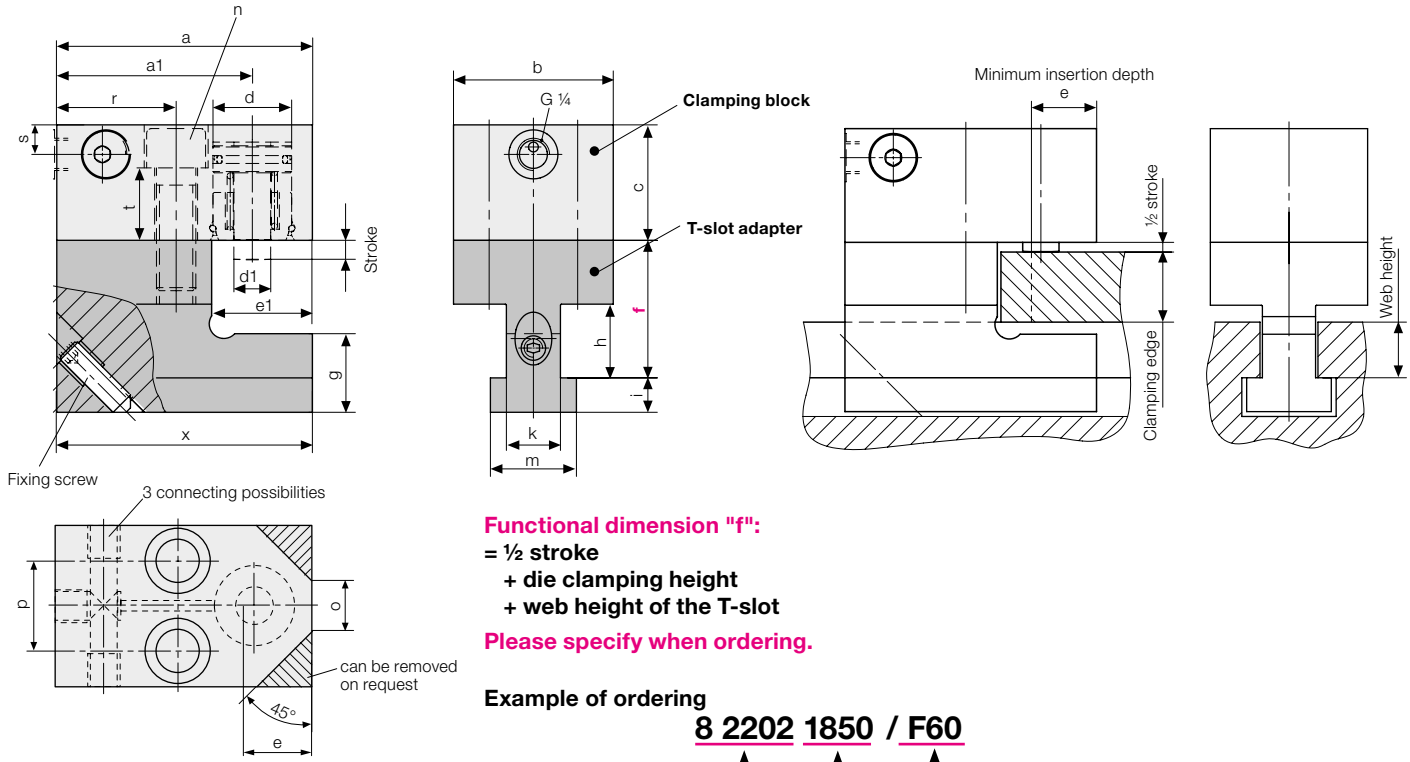


Clamping block separately mounted on bars, ball bars in the press bed, carrying consoles in front. Block cylinders and swing clamps for positioning

Technical data Dimensions

Sliding Clamp classic

Hydraulic sliding clamp complete, with T-slot adapter



Functional dimension "f":
= 1/2 stroke
+ die clamping height
+ web height of the T-slot
Please specify when ordering.

Example of ordering
8 2202 1850 / F60

Sliding clamp T-slot Functional dimension "f" [mm]
Clamping force: 19.6 kN 18 mm Please specify when ordering

T-slot as per DIN 650	[mm]	18	22	22	22	28	28	28
Clamping force at 400 bar	[kN]	19.6	19.6	32	50	32	50	78
Stroke	[mm]	8	8	8	8	8	8	12
Oil volume	[cm ³]	4	4	7	10	7	10	24
Dimension "f" min.	[mm]	42	50	50	50	55	55	60
Dimension "f" max.	[mm]	90	106	106	106	112	112	117
a	[mm]	95	95	104	111	104	111	132
a1	[mm]	77	77	81	85	81	85	99
b	[mm]	65	65	65	65	65	65	80
c	[mm]	40	40	47	50	47	50	75
d	[mm]	25	25	32	40	32	40	50
d1	[mm]	15	15	15	20	15	20	25
e (min. insertion depth)	[mm]	23	23	28	31	28	31	38
e1	[mm]	32	32	41	48	41	48	60
g	[mm]	24	32	32	32	42	42	42
h	[mm]	25	30	30	30	37	37	37
i	[mm]	10	14	14	14	18	18	18
k	[mm]	18	22	22	22	28	28	28
m	[mm]	28	35	35	35	44	44	44
n (screw DIN 912, 10.9)		M16	M16	M16	M16	M16	M16	M20
o	[mm]	18	18	20	20	20	20	28
p	[mm]	36	36	36	36	36	36	43
r	[mm]	50	50	50	50	50	50	57
s	[mm]	12	12	12	12	12	12	17.5
t	[mm]	24	24	29	32	29	32	53
x	[mm]	95	104	104	104	104	104	132
Clamping block with T-slot adapter								
Weight	[kg]	2.9	3.2	4.0	4.3	4.5	4.7	9.3
Part no.		822021850	822022250	822032250	822042250	822032850	822042850	822052850
Clamping block, separate (supplied without fixing screws)								
Weight	[kg]	1.6	1.6	2.0	2.3	2.0	2.3	4.9
Part no.		822021301	822021301	822031301	822041301	822031301	822041301	822051301

Please consult us if aggressive spray is used.
Max. operating pressure 400 bar, max. operating temperature 120 °C.
Further sizes and special versions are available on request.

Parking station

accommodates the sliding clamp during die change

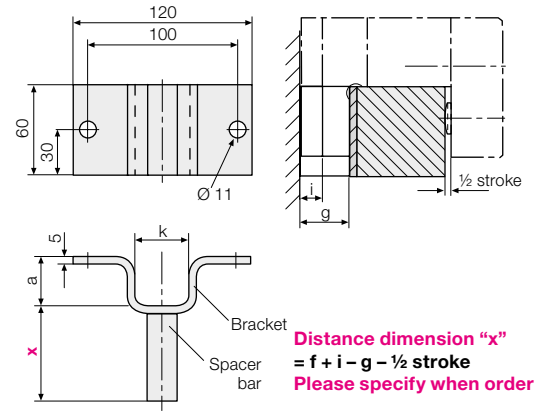
T-slot as per DIN 650 [mm]	18	22	28
a [mm]	25	33	43
k [mm]	30	37	46
i [mm]	10	14	18
g [mm]	24	32	42

Parking station complete (with bracket and spacer bar)

Part no. 82754 1850 82754 2250 82754 2850

Bracket
Part no. 2754 180 2754 220 2754 280

Spacer bar
Part no. 2754 500 2754 500 2754 500

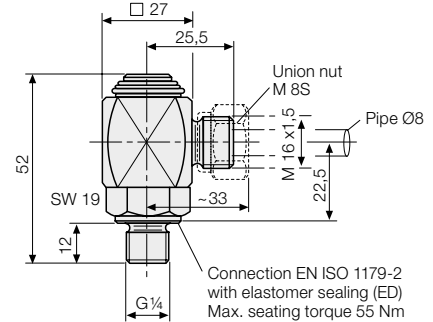


Distance dimension "x"
= f + i - g - 1/2 stroke
Please specify when ordering

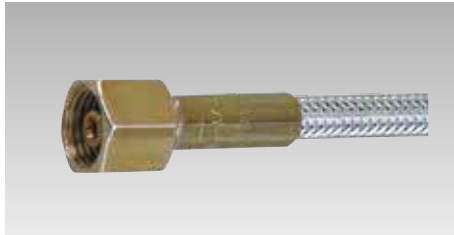
Angular rotary coupling (M 8S / G 1/4)

Part no. 9208 176

For easier handling when changing dies.
Max. operating pressure 400 bar

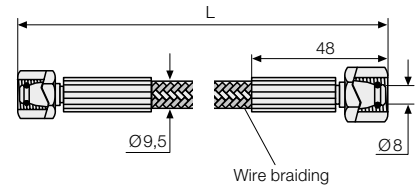


High-pressure hoses ND4



Technical data

Burst pressure [bar]	2000
Smallest bending radius [mm]	100
Further information see DIN 20066	



Notes on high pressure hoses

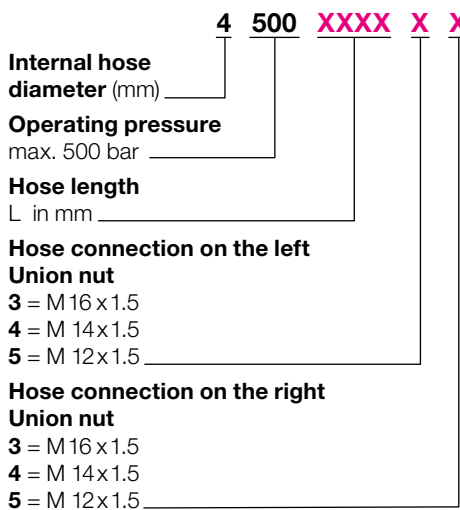
The freely selectable hose lengths should be generously dimensioned, in order to avoid kinking, abrasion marks, torsion, tensile and compressive stress and unacceptable bending radii. Protect against hot swarf.

Preferred lengths of the type 4500XXXX33

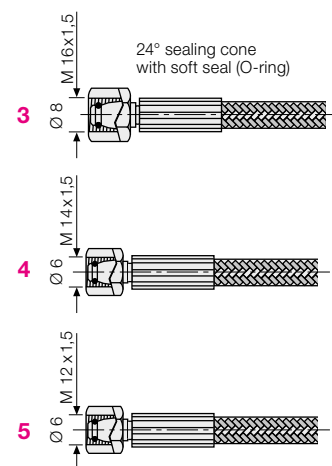
at both sides with hose connection
Union nut M 16 x 1.5 mm

Length [mm]	Part no.
600	27001 0131
800	27001 0133
1200	27001 0137
1600	27001 0141

Code for part numbers for variable lengths and connections

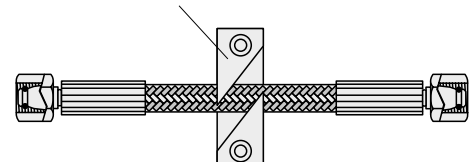


Hose connections on the left/right



Accessories

Hose holder made from Delrin
Part no. 550650003



Hydraulic power units

see product group 7

Hydraulic accessories

see product group 11