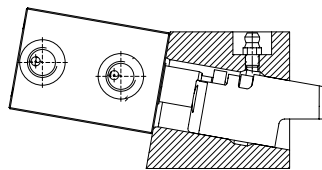
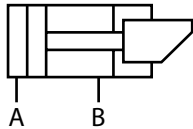


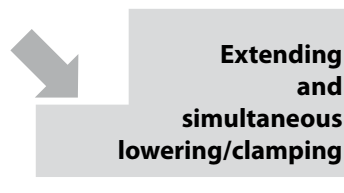
# Wedge clamp, double-acting, type A for dies with flat clamping edge



## Type A - Clamping force axially applied to the clamping edge



Clamping operation



### Please note

In case of incorrect operation of the wedge clamping element, the clamping bolt may fully retract into the guide housing and thus cause the upper die to fall off the slide.

When using wedge clamping elements on press slides or vertical presses it is recommended that multiple-circuit hydraulic supply of the clamping elements and pilot-controlled check valves are used in the clamping lines for securing hydraulic clamping.

The greasing intervals (high-temperature grease) should be scheduled in accordance with the operating conditions (at least once a week). **Greasing of the clamping bolt should only be made with the elements being retracted.**

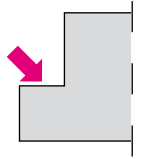
### Position monitoring

The integrated position monitoring system is coupled to the clamping bolt and signals:

1. Clamping bolt in home position
2. Clamping bolt in extended position

### Application:

- safe clamping of dies with flat clamping edge
- for clamping of dies in injection moulding machines
- for clamping of dies on press bed and slide



### Design:

Double-acting wedge clamp for clamping dies on the press bed or slide or for clamping dies in injection moulding machines according to Euromap standard.

The wedge clamp consists of a hydraulic block cylinder connected with a clamping bolt in a floating manner. Clamping cycle: the clamping bolt which is inclined by 5° performs an idle stroke and simultaneously a clamping stroke. The clamping bolt is lowered axially onto the clamping edge. The 5° angle of the housing has been determined so as to ensure that despite frictional engagement on the clamping edge the hydraulic pressure required for unclamping is sufficient.

Since the clamping force is vertically transmitted to the clamping point, only low transverse forces occur. The wedge clamp is available with or without position monitoring.

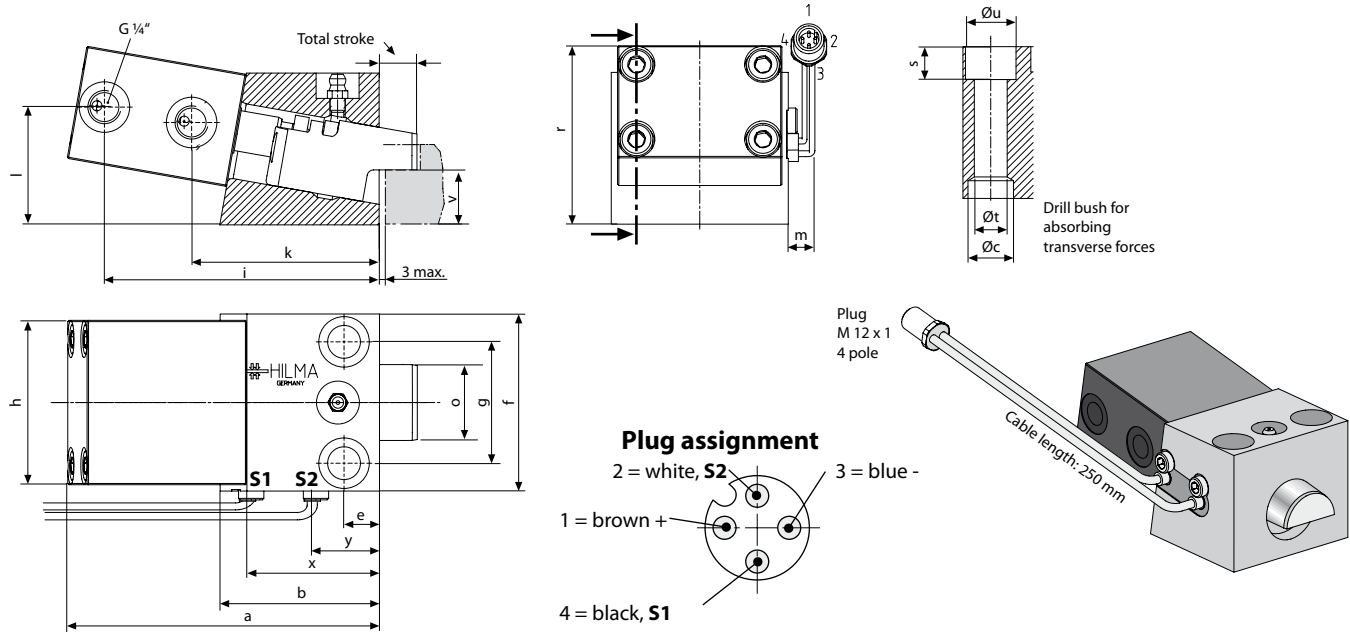
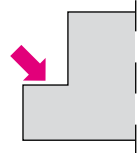
### Special features:

- ◆ transverse forces are absorbed by drill bushes; high functional reliability is ensured by position monitoring and automatic cycle
- ◆ rugged and compact design
- ◆ well-proven clamping element with high degree of safety and long service life
- ◆ retracting clamping bolt ensures unrestricted die change
- ◆ clamping and unclamping pressures are different





**Wedge clamp, double-acting**  
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**Standard mounting grid**

(comparable to wedge clamp 2.2400)

**Euromap mounting grid**

(comparable to wedge clamp 2.2460)

	35	60	120	35	60	120
<b>Perm. retention force (kN)</b>	<b>35</b>	<b>60</b>	<b>120</b>	<b>35</b>	<b>60</b>	<b>120</b>
<b>Screw property class 8.8</b>						
<b>Max. clamping pressure (bar)</b>	<b>50</b>	<b>50</b>	<b>50</b>	<b>50</b>	<b>50</b>	<b>50</b>
<b>Max. unclamping pressure (bar)</b>	<b>350</b>	<b>350</b>	<b>350</b>	<b>350</b>	<b>350</b>	<b>350</b>
Cylinder-Ø (mm)	25	40	50	25	40	50
Total stroke (mm)	20	25	25	20	25	25
Max. oil consumption (cm <sup>3</sup> )	10	32	50	10	32	50
Clamping stroke (mm)	12	16	17	12	16	17
a (mm)	123	160	197	123	176	197
Ø c H7 x depth (mm)	18H7 x 7	26H7 x 9	30H7 x 11	18H7 x 7	26H7 x 9	30H7 x 11
b (mm)	60	78	109	60	95	109
e (mm)	14	16	20	15	33	32
f (mm)	70	95	120	95	100	140
g (± 0,2 mm)	48	65	85	70	70	105
h (mm)	65	85	100	65	85	100
i (mm)	109	142	180	109	158	180
k (mm)	75	99	131	75	115	131
l (mm)	36	50	65	36	50	65
m (mm)	12	5	0	0	0	0
Ø o (mm)	30	40	55	30	40	55
r (mm)	60	81	103	60	81	103
s (mm)	13	17	20	13	17	20
Ø t (mm)	13	17	21	13	17	21
Ø u (mm)	20	26	32	20	26	32
v** (± 0,1) (mm)	22	25	35	22	25	35
x (mm)	52	68	100	52	85	100
y (mm)	27	29	75	27	45	75
Weight (kg)	2,5	6,0	11,0	2,5	6,0	11,0
<b>with position monitoring</b>						
<b>Part no. up to 100°C*</b>	<b>8.2403.5120</b>	<b>8.2404.5120</b>	<b>8.2405.5120</b>	<b>8.2403.5130</b>	<b>8.2404.5130</b>	<b>8.2405.5130</b>
<b>without position monitoring</b>						
<b>Part no. up to 160°C*</b>	<b>8.2403.5020</b>	<b>8.2404.5020</b>	<b>8.2405.5020</b>	<b>8.2403.5030</b>	<b>8.2404.5030</b>	<b>8.2405.5030</b>
<b>Accessories Drill bushes DIN 179</b>	12 x 12	17 x 16	21 x 20	12 x 12	17 x 16	21 x 20
<b>Part no.</b>	<b>3300 285</b>	<b>3300 287</b>	<b>3300 288</b>	<b>3300 285</b>	<b>3300 287</b>	<b>3300 288</b>

\* Temperatures up to 250°C on request \*\* Clamping edge height: on request to Euromap standard, tolerance ± 0.1 mm