



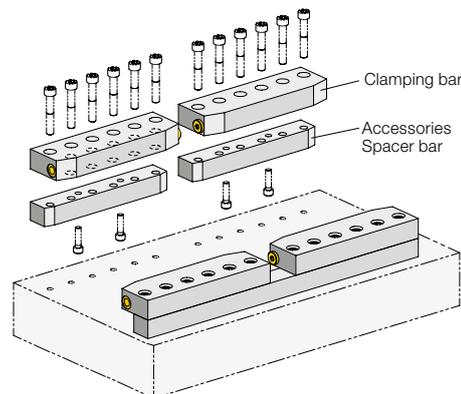
## Clamping Bars

single acting with spring return, with built-in pistons  
clamping force up to 116 kN, piston stroke 8 mm



### Advantages

- Piston stroke 8 mm
- Arrangement in series of several clamping bars with plug-in connectors
- Version with and without check valve
- Flat and compact design
- Fully resilient stroke limitation
- Easy installation
- Easy to retrofit



### Application

The clamping bars are used permanently installed on press beds and rams, on machines and plants for clamping and locking.

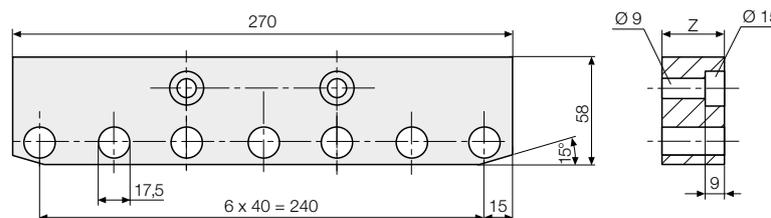
### Description

The clamping bar is directly screwed on the press bed or ram using a spacer bar. Clamping is carried out on the die clamping edge by applying hydraulic pressure to the 2, 3 or 6 pistons which are arranged side by side with a pressure medium and mechanical unclamping by a spring return. Hydraulic oil is supplied through G 1/4 ports provided on both sides. Flat design with die inlet chamfer.

### Accessories

#### Spacer bar

to obtain the required clamping edge height



All dimensions in mm

Height Z	[mm]	28	53	75
for clamping edge	[mm]	25 ± 1.5	50 ± 1.5	72 ± 1.5
<b>Part no.</b>		<b>520710024</b>	<b>520710032</b>	<b>520710081</b>

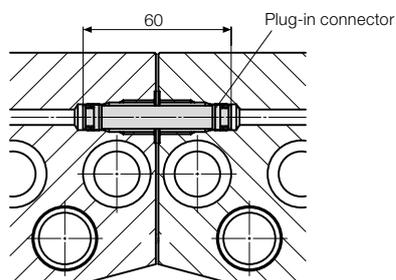
Other heights on request

### Application example



Retrofit to an existing double-column press. Die insertion facilitated by chamfered spacer bars and ball bars.

### Plug-in connector



Other dimensions on request

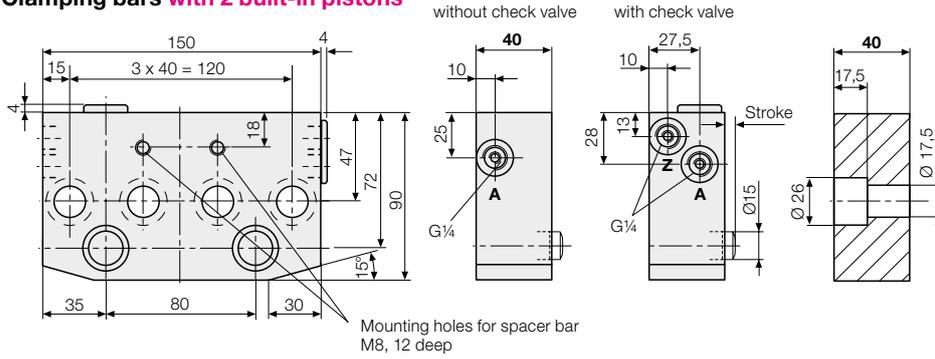
Plug-in connectors for clamping bars arranged in series.

When using several clamping bars in a row, the hydraulic ports are connected by means of pipes or plug-in connectors (see figure).

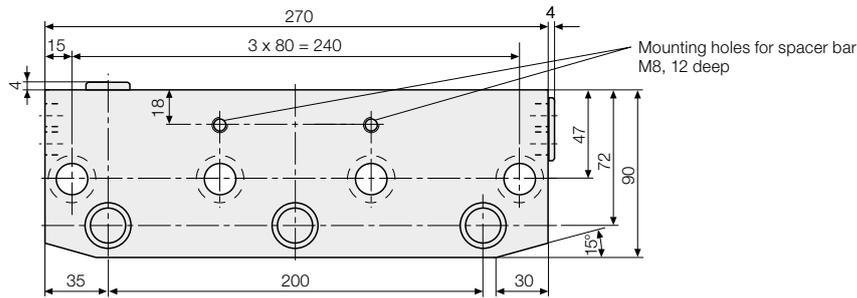
**Part no. 805300040**

# Technical data Dimensions

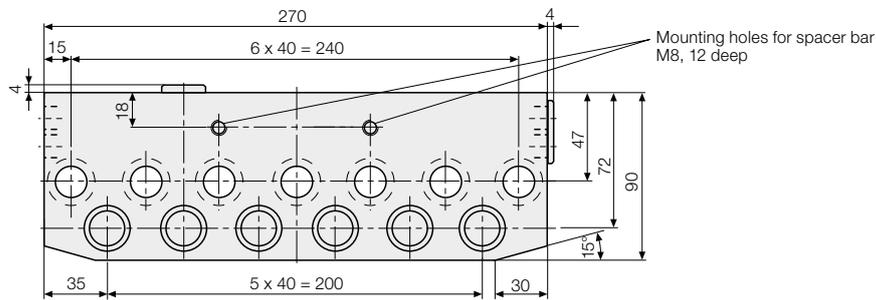
## Clamping bars with 2 built-in pistons



## Clamping bars with 3 built-in pistons



## Clamping bars with 6 built-in pistons



All dimensions in mm

## Technical data

<b>Clamping force at max. operating pressure</b>	<b>[kN]</b>	<b>38.6</b>	<b>58</b>	<b>116</b>
<b>Max. operating pressure</b>	<b>[bar]</b>	<b>400</b>	<b>400</b>	<b>400</b>
<b>Clamping force at 100 bar</b>	<b>[kN]</b>	<b>9.65</b>	<b>14.5</b>	<b>29</b>
No. of pistons		2	3	6
Piston/Piston rod Ø	[mm]	25/15	25/15	25/15
Stroke	[mm]	8	8	8
Oil volume clamping	[cm³]	7.8	11.6	23.2
Weight	[kg]	3.5	6.9	7.2
<b>without check valve</b>	<b>Part no.</b>	<b>820960650</b>	<b>820960450</b>	<b>820960850</b>
<b>with check valve</b>	<b>Part no.</b>	<b>820960750</b>	<b>820960550</b>	<b>820961050</b>