

# Wedge clamp, double acting without position monitoring

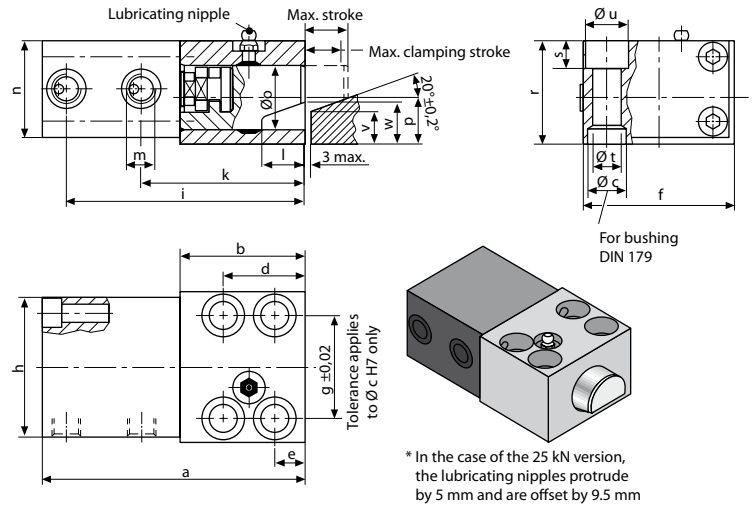
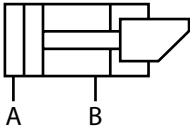


**ROEMHELD**  
HILMA ■ STARK

Wedge clamp, double acting  
for dies with tapered clamping edge

Clamping bolt with 20° bevel,  
design without proximity switch

Resistant to temperatures of up to 160°C  
(for higher temperatures, please consult us)



## \* Clamping force

This is the force that the clamping element applies to the workpiece at maximum operating pressure. The die is clamped on the fixture plate by means of this force. Under normal conditions, the external forces acting on the die (i.e. the ejecting force or die cushion force) shall not exceed the totality of the clamping forces of the elements.

## \*\* Perm. retention force

This is the holding power of clamping element and fastener (screw property class 8.8). The above data is based on the condition that the appropriate tightening torque has been applied, and that material and geometry of the fixtures are suitable for the purpose. It must be ensured that in cases of emergency, e.g. workpiece jammed in the die, the totality of the retention forces of the elements is not exceeded.

Max. clamping force * [kN]	25	50	100	160	250	400	630
Perm. retention force** [kN]	35	65	130	210	320	520	820
Screw property class 8.8							
Max. operating pressure [bar]	350	275	350	350	350	350	350
Cylinder-Ø [mm]	25	40	50	63	80	100	125
Max. stroke [mm]	20	25	25	30	32	40	40
Clamping stroke (from/to) [mm]	15 – 18	18 – 22	19 – 22	23 – 27	24 – 29	30 – 36	30 – 36
Max. oil consumption (cm <sup>3</sup> )	10	31	49	94	161	314	491
a [mm]	122	157	190	227	267	310	375
b [mm]	58	78	100	125	150	180	225
Ø c H7 x depth [mm]	18/7	26/9	30/11	35/11	48/13	55/16	62/16
d [mm]	38	46	58	75	78	95	108
e [mm]	14	16	20	25	26	32	38
f [mm]	70	95	120	150	200	240	280
g [mm]	48	65	85	106	140	180	210
h [mm]	65	85	100	125	160	200	230
i [mm]	111	146	177	210	246	285	344
k [mm]	76	102	127	151	184	215	272
l [mm]	20	25	26	32	40	45	50
m	G ¼	G ¼	G ¼	G ½	G ½	G ½	G ½
n [mm]	45	63	75	95	120	150	180
Ø o [mm]	30	40	55	70	80	100	125
p [mm]	21,5	28	37	49	55	75	85
r [mm]	48	65	80	105	125	160	190
s [mm]	13	18	20	26	32	38	44
Ø t [mm]	13	17	21	26	33	39	45
Ø u [mm]	20	26	32	40	48	57	66
v [mm]	15	18	25	30	30	50	60
w [mm]	19,5	23,5	30,5	37	38	60	70
Screw DIN 912-8.8 (4 pieces)	M 12	M 16	M 20	M 24	M 30	M 36	M 42
Tightening torque [Nm]	86	210	410	710	1450	2520	4050
Weight [kg]	2,4	5,8	10,6	21	40	74	125
<b>Part no.</b>	<b>4604 620</b>	<b>4604 621</b>	<b>4604 622</b>	<b>4604 623</b>	<b>4604 634</b>	<b>4604 635</b>	<b>4604 636</b>
<b>Accessories</b>							
Bushings DIN 179	12 x 12	17 x 16	21 x 20	26 x 20	32 x 25	38 x 30	44 x 30
<b>Part no.</b>	<b>3300 285</b>	<b>3300 287</b>	<b>3300 288</b>	<b>3300 289</b>	<b>3300 420</b>	<b>3300 430</b>	<b>3300 440</b>