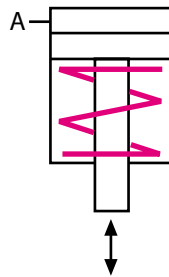


# Angular clamp single acting



**ROEMHELD**  
HILMA ■ STARK



For power units  
please refer to product group 7

For accessories  
please refer to product group 11

## Applications:

- on press beds and rams
- on machines and equipment for clamping and locking
- when the available space is limited
- when temperatures may reach 120° C

## Function:

The angular clamp is manually placed in the T-slot provided in press ram or bed.

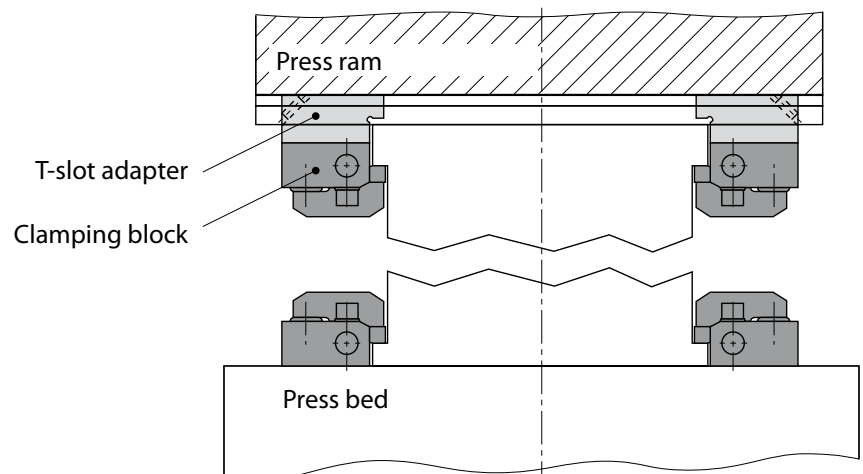
The die is clamped on its clamping edge by applying hydraulic pressure to the piston and mechanically unclamped by spring return.

The clamping block may also be fastened directly, without a T-slot adapter.

## Special features:

- ◆ ideal power transmission
- ◆ compact design
- ◆ easy fastening
- ◆ suitable for small clamping edges
- ◆ suitable for retrofit
- ◆ no need for die standardisation (width and depth)

## Example of application

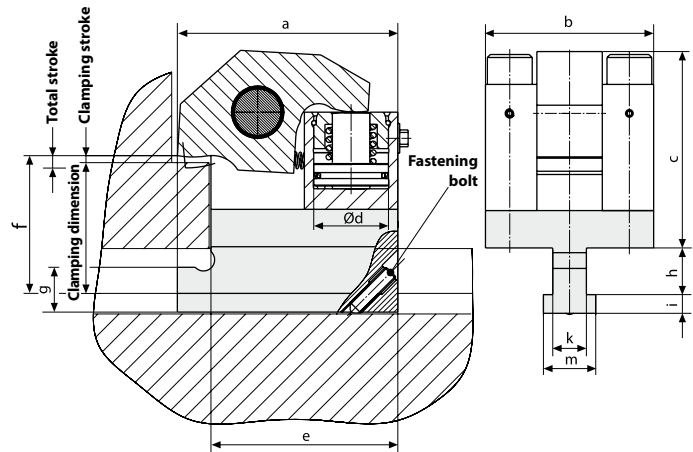




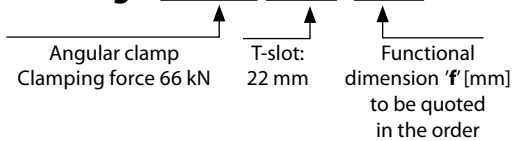
## Angular clamp single acting

### Angular clamp complete with T-slot adapter

T-slot [mm]	Clamping force [kN]	Part no.	Dim. 'f' min.	Dim. 'f' max.
18	40	8.2312.1802	61	90
22	40	8.2312.2202	66	95
28	40	8.2312.2802	73	101
18	66	8.2314.1811	71	91
22	66	8.2314.2211	76	96
28	66	8.2314.2811	83	103
28	110	8.2315.2811	97	157
36	110	8.2315.3611	107	167



### Example of ordering: : 8.2314.2211/ F110



T-slot as per DIN 650 [mm]	18	22	28	18	22	28	28	36
Clamping force at 400 bar [kN]	40	40	40	66	66	66	110	110
Clamping force at 100 bar [kN]	10	10	10	16,5	16,5	16,5	27,5	27,5
Total stroke [mm]	5,5	5,5	5,5	6	6	6	6	6
Clamping stroke [mm]	2,5	2,5	2,5	3	3	3	3	3
Clamping dimension [mm]	±1	±1	±1	±1,5	±1,5	±1,5	±1,5	±1,5
Oil consumption [cm <sup>3</sup> ]	6,5	6,5	6,5	10	10	10	16	16
a [mm]	101	101	101	118	118	118	147	147
b [mm]	75	75	75	90	90	90	120	120
c max. (for 'f' min.) [mm]	93	93	93	106	106	106	133	133
d [mm]	32	32	32	40	40	40	50	50
e [mm]	85	85	85	100	100	100	125	125
g [mm]	24	32	42	24	32	42	41	53
h [mm]	25	30	37	25	30	37	37	47
i [mm]	10	14	18	10	14	18	18	23
k [mm]	18	22	28	18	22	28	28	36
m [mm]	28	35	44	28	35	44	44	54
Weight [kg]	4,0	4,4	4,8	6,4	6,7	7,4	14,2	15,5

max. operating pressure 400 bar  
Please consult us if aggressive spray is used

Recommended accessories:

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

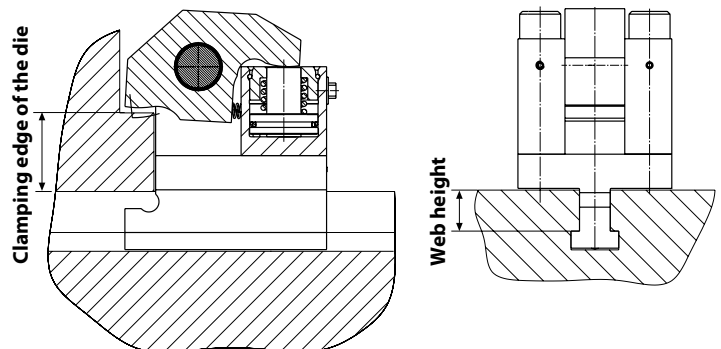
**Part no. 9208-176**

For easier handling when changing dies.

Max. operating pressure: 400 bar.

### Functional dimension 'f':

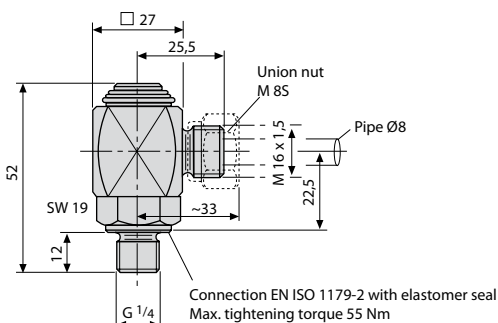
clamping stroke  
+ height of die clamping edge  
+ web height of T-slot  
= dimension 'f'



### Please note:

Further dimensions with other clamping forces and T-slots are available on request.

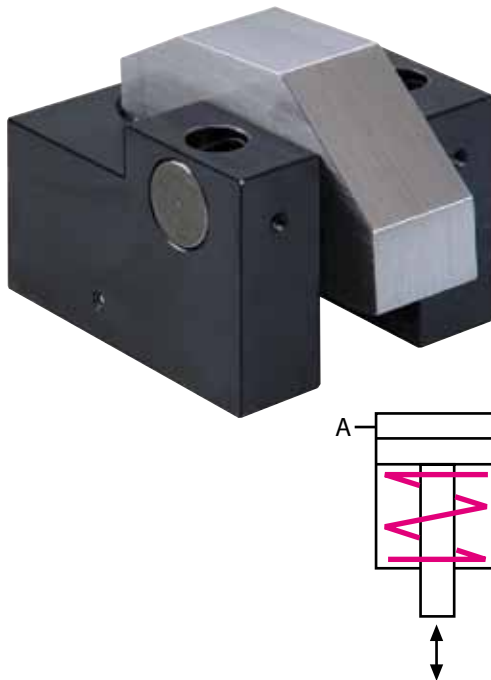
The angular clamp may also be fastened directly, without a T-slot adapter. Position monitoring using laterally installed proximity switches on request.



# Clamping block - Angular clamp single acting with spring return



**ROEMHELD**  
HILMA ■ STARK



## Applications:

- on press beds and rams
- on machines and equipment for clamping and locking
- when the available space is limited

## Function:

The workpiece is clamped on its clamping edge by applying hydraulic pressure to the piston and mechanically unclamped by spring return.

The clamping block may be fastened by screwing it directly to the press bed or flexibly so that it may be moved in combination with a T-slot adapter in the T-slots of a press bed or ram.

## Hydraulic clamping block without T-slot adapter

<b>Clamping force at 400 bar [kN]</b>	<b>40</b>	<b>66</b>	<b>110</b>
<b>Clamping force at 100 bar [kN]</b>	<b>10</b>	<b>16,5</b>	<b>27,5</b>
Total stroke [mm]	5,5	6	6
Clamping stroke [mm]	2,5	3	3
Clamping dimension [mm]	20,5 ± 1	25 ± 1,5	32 ± 1,5
Oil consumption [cm <sup>3</sup> ]	6,5	10	16
a [mm]	101	118	147
b [mm]	75	90	120
c [mm]	80	88	108
d [mm]	32	40	50
e [mm]	85	100	125
h [mm]	62,5	67,5	85,0
k [mm]	25	35	55
o [mm]	12,5	16,5	22,0
p [mm]	50	64	90
r [mm]	20	25	30
s [mm]	13	13	20
t [mm]	32	38	45
Weight [kg]	2,6	4,0	8,6
<b>Part no.</b>	<b>8.2312.0101</b>	<b>8.2314.0501</b>	<b>8.2315.0501</b>

max. operating pressure: 400 bar  
Other sizes are available on request.  
Please consult us if aggressive fluids are used.  
Fastening screws are not included.

With position control for version 40 kN **Part no. 8.2312.0104**  
for version 66 kN **Part no. 8.2314.0504**

