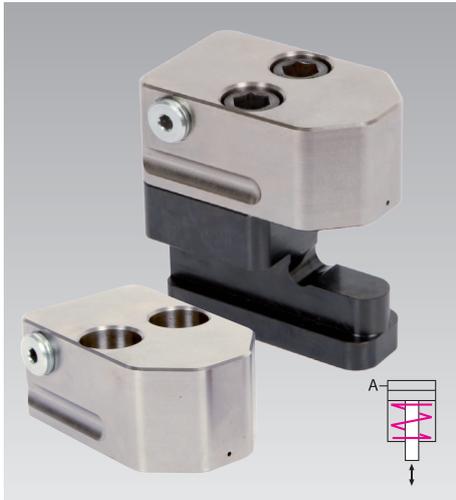




Sliding Clamps compact

single acting, with spring return

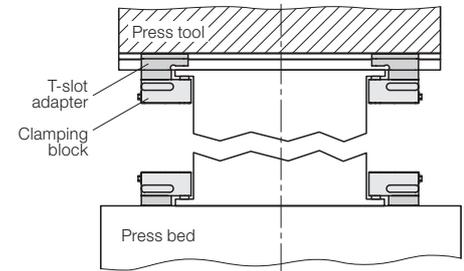
max. operating pressure 400 bar, clamping force from 19 kN to 78 kN



Advantages

- High clamping force in combination with small size and low weight
- Ergonomic T-slot adapter for easy insertion
- High-quality surface protection on the clamping block
- Clamping block rounded and thus optimum adaptation in narrow construction spaces
- Safe handling by special recessed grip
- T-slot 14, 18, 22 and 28 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 "compact" sliding clamp is a hydraulic clamping element, used with minimum space requirements for clamping and locking on machines and plants, on press bed and ram. Due to the manageable and rounded design, "compact" sliding clamps are especially suitable where space is limited as, for example, on high-speed punching presses. 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 "compact" sliding clamp consists of a hydraulic clamping block which will be fixed with two screws to a T-slot adapter.

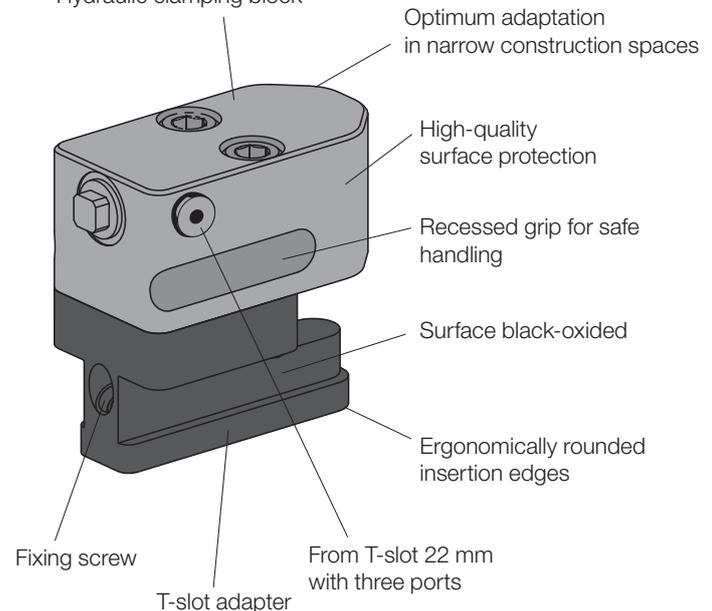
The clamping block can also be directly screwed without T-slot adapter and can be ordered separately.

Application examples



Sliding clamp with T-slot adapter in press bed and ram

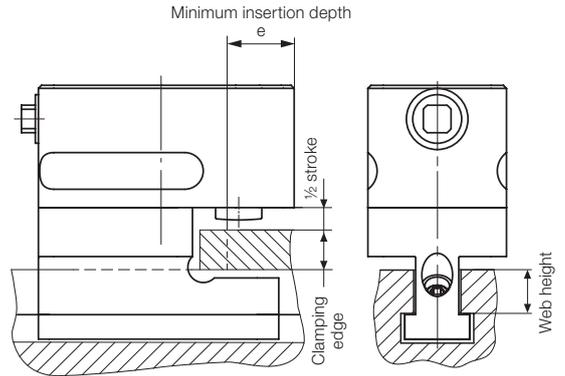
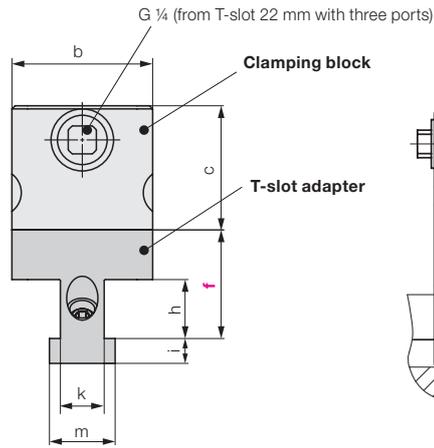
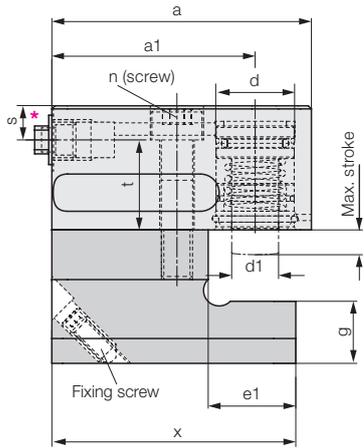
Hydraulic clamping block



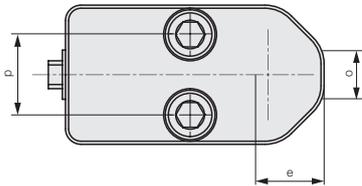
Technical data Dimensions

Sliding clamp compact

Hydraulic sliding clamp complete, with T-slot adapter



* From T-slot 22 mm with hydraulic ports at the rear and at the side



Functional dimension "f":

= 1/2 stroke
+ die clamping height
+ web height of the T-slot

Please specify when ordering.

Example of ordering

8 2202 1855 / F60

Sliding clamp

Clamping force: 19.6 kN

T-slot

18 mm

Functional dimension "f" [mm]

Please specify when ordering

T-slot as per DIN 650	[mm]	14	18	22	22	28	28
Clamping force at 400 bar	[kN]	19.6	19.6	32	50	50	78
Stroke	[mm]	8	8	8	8	8	12
Oil volume	[cm ³]	4	4	7	10	10	24
Dimension "f" min.	[mm]	30	41	50	50	55	60
Dimension "f" max.	[mm]	75	90	106	106	112	117
a	[mm]	83	83	104	111	111	132
a1	[mm]	65	65	81	85	85	99
b	[mm]	45	45	65	65	65	80
c	[mm]	40	40	47	50	50	75
d	[mm]	25	25	32	40	40	50
d1	[mm]	15	15	15	20	20	25
e (min. insertion depth)	[mm]	22	22	28	31	31	38
e1	[mm]	28	33	41	48	48	60
g	[mm]	20	24	32	32	42	42
h	[mm]	19	25	30	30	37	37
i	[mm]	8	10	14	14	18	18
k	[mm]	14	18	22	22	28	28
m	[mm]	21	28	35	35	44	44
n (screw DIN 912, 10.9)		M10	M10	M16	M16	M16	M20
o	[mm]	18	18	20	20	20	28
p	[mm]	26	26	36	36	36	43
r	[mm]	40	40	50	50	50	57
s	[mm]	11	11	12	12	12	17.5
t	[mm]	29	29	29	32	32	53
x	[mm]	78	83	104	104	104	132
Clamping block with T-slot adapter							
Weight	[kg]	1.5	2.9	3.6	3.9	4.5	7.5
Part no.		822021455	822021855	822032255	822042255	822042855	822052855
Clamping block, separate							
Weight	[kg]	0.7	0.7	2.0	2.3	2.3	4.9
Part no.		822021305	822021305	822031305	822041305	822041305	822051305

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

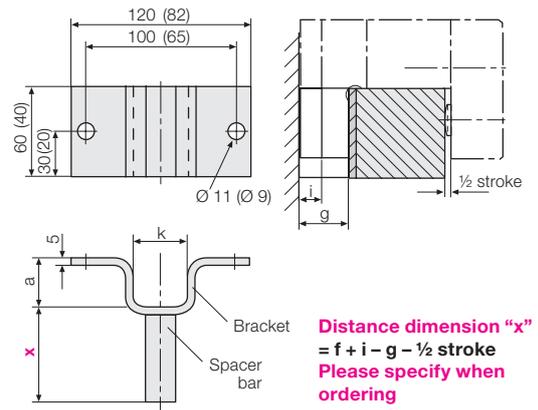
accommodates the sliding clamp during die change

T-slot as per DIN 650 [mm]	14	18	22	28
a [mm]	21	25	33	43
k [mm]	23	30	37	46
i [mm]	8	10	14	18
g [mm]	20	24	32	42

Parking station complete (with bracket and spacer bar)

	Part no.	82754 1450	82754 1850	82754 2250	82754 2850
Bracket	Part no.	82754 1400	2754 180	2754 220	2754 280
Spacer bar	Part no.	50495 1400	2754 500	2754 500	2754 500

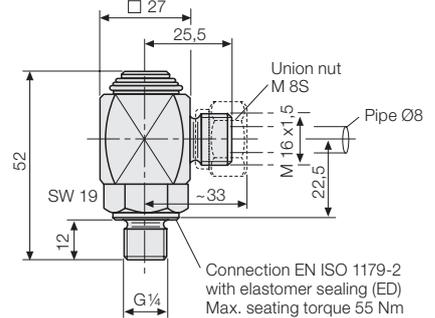
Values in brackets for 14 mm T-slots



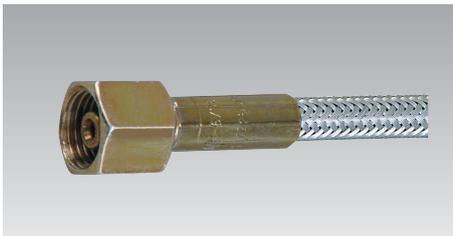
Angular rotary coupling (M 8S / G 1/4)

Part no. 9208176

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

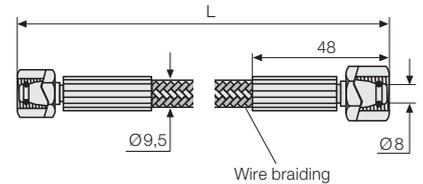


High-pressure hoses ND4



Technical data

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



Notes on high pressure hoses

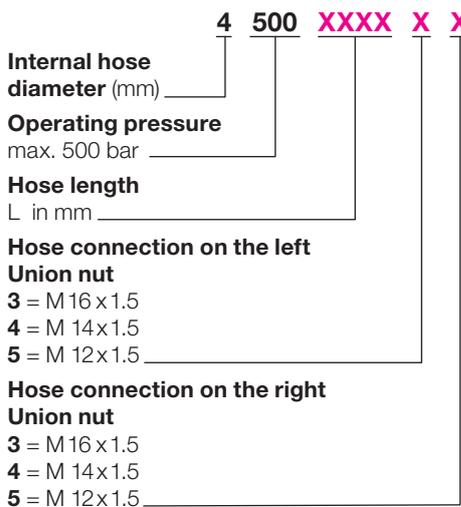
The freely selectable hose lengths should be generously dimensioned, in order to avoid kinking, abrasion marks, torsion, tensile and compressive stress and unacceptable bending radii. Protect against hot swarf.

Preferred lengths of the type 4500XXXX33

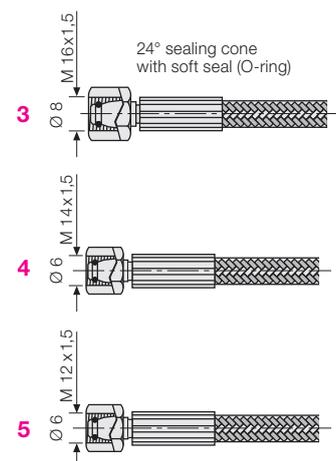
at both sides with hose connection
Union nut M 16 x 1.5 mm

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

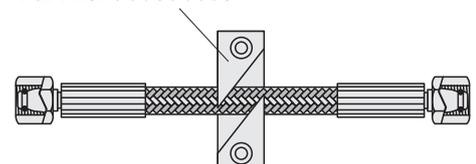


Hose connections on the left/right



Accessories

Hose holder made from Delrin
Part no. 550650003



Hydraulic power units

see product group 7

Hydraulic accessories

see product group 11