

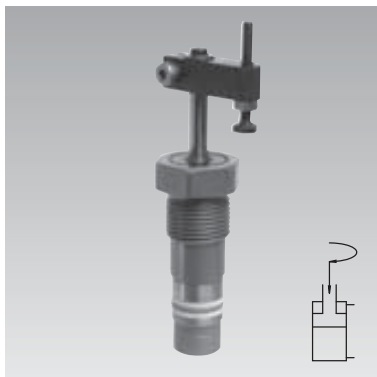


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Issue 12-10 E

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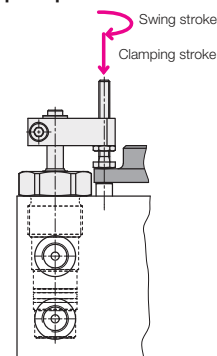
Mini Swing Clamps with Sturdy Swing Mechanism threaded-body type, double acting, max. operating pressure 150 bar



Advantages

- Minimum dimensions
- Double-acting function
- Sturdy swing mechanism
- Oil supply through drilled channels
- Built-in housing of tube connecting thread available
- Installation as cartridge type by accessory flange
- Simple fixing of clamping arm
- Clamping arm for clamping with minimum deformation available
- Unimpeded loading and unloading of the fixture
- Mounting position: variable
- Standard FKM seals
- Maintenance free

Clamping principle



Application

Hydraulic swing clamps are used for clamping of workpieces, when it is essential to keep the clamping area free of straps and clamping components for unrestricted workpiece loading and unloading.

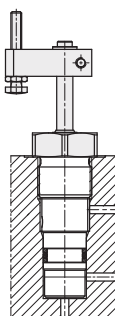
Mini swing clamps are particularly suitable for machining of thin-walled workpieces, which require only little clamping forces.

Mini swing clamps are an interesting alternative for pneumatic clamping elements, since they require less space.

Installation and connecting possibilities

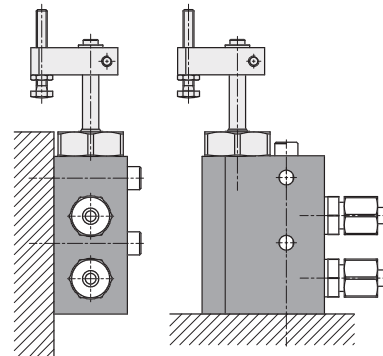
Threaded-body type

for horizontally-drilled channels



Pipe thread

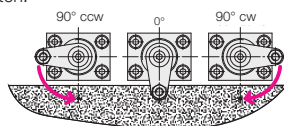
with accessory built-in housing



Description

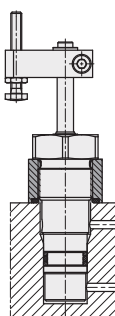
This double-acting mini swing clamp works as pull-type cylinder where a part of the total stroke is used to swing the piston.

Clockwise and counterclockwise versions are available with an swing angle of 90, 60 and 45 degrees. The 0 degree version can be used as push and pull-type cylinder with anti-rotation piston.



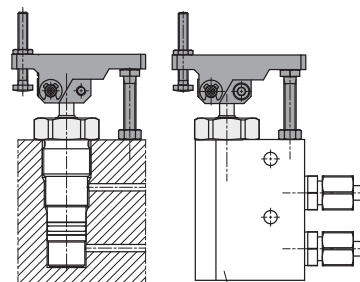
The clamping arms are locked on the piston rod. A safety screw avoids axial displacement.

Installation as cartridge type with accessory fixing flange



Threaded-body type with accessory clamping strap

for clamping with minimum deformation



Accessory
Built-in housing

Important notes

- Considerable injuries can be caused to fingers during clamping and unclamping in the effective area of the clamping arm. Remedy: protection device with electrical locking.
- Operating conditions, tolerances and other data see data sheet A 0.100.

Technical data

Dimensions • Accessories

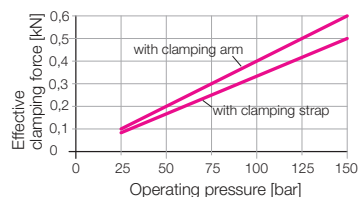
Technical data

Piston Ø	[mm]	10
Rod Ø	[mm]	6
Swing stroke	[mm]	10
Clamping stroke	[mm]	8
Total stroke	[mm]	18
Effective piston area		
Clamping	[cm ²]	0.5
Unc clamping	[cm ²]	0.78
Required oil per stroke		
Clamping	[cm ³]	0.91
Unc clamping	[cm ³]	1.42
Max. oil flow rate		
Clamping	[cm ³ /s]	6
Unc clamping	[cm ³ /s]	10
Min. operating pressure	[bar]	25
Max. operating pressure	[bar]	150
Max. pulling force	[kN]	0.75
Effective clamping force	[kN]	see diagram
Weight	[kg]	0.12

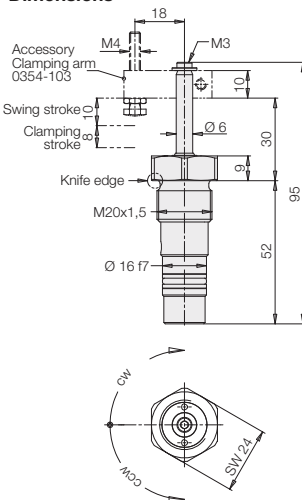
Part numbers

Swing angle	Swing direction	Part no.
90°	CW	1848-115
90°	CCW	1848-125
60°	CW	1848-135
60°	CCW	1848-145
45°	CW	1848-155
45°	CCW	1848-165
0°	-	1848-105

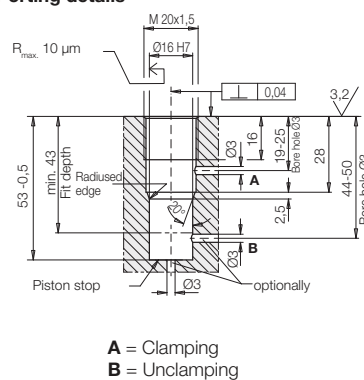
Clamping force diagram



Dimensions

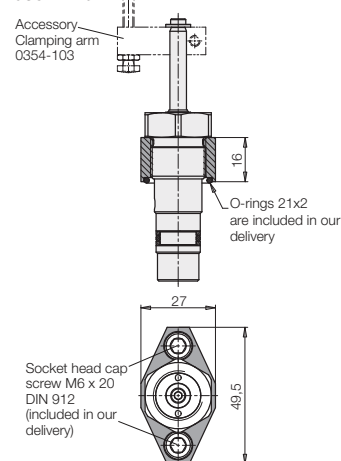


Porting details

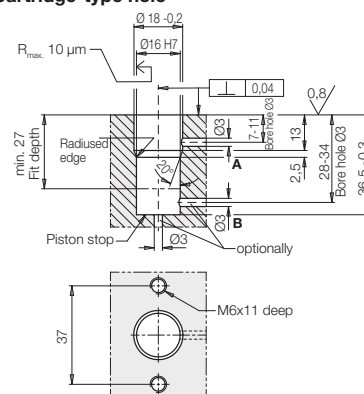


Accessory

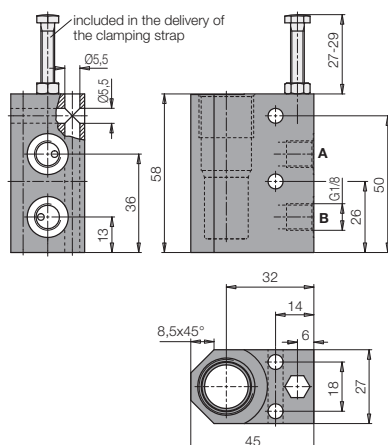
Fixing flange
0354-410



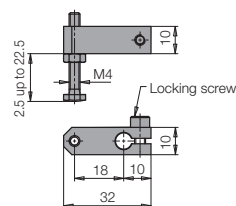
Cartridge-type hole



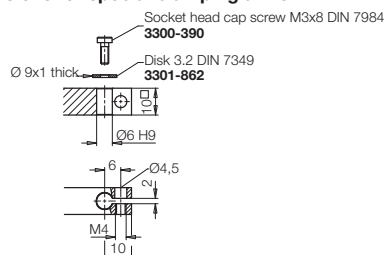
Accessory
Built-in housing
0346-710



Accessory
Clamping arm
0354-103



Dimensions for special clamping arms



Accessory
Clamping strap
for clamping with
0354-230

