



ROEMHELD
HILMA ■ STARK

Issue 11-18 E

B 1.8801

Swing Clamps with Reinforced Swing Mechanism

top flange, position monitoring optional,
double acting, max. operating pressure 500 bar

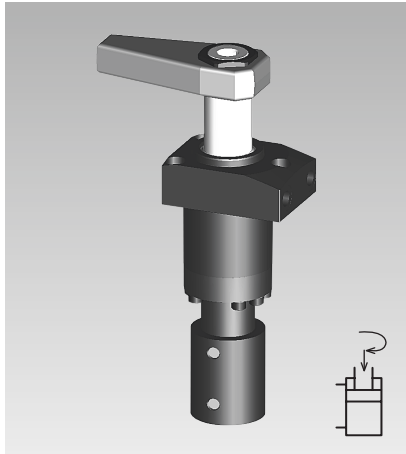


Figure with position monitoring

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. Due to the sturdy swing mechanism and the extended switch rod they are particularly suited for

- Clamping fixtures with workpiece loading via handling systems
- Transfer lines
- Test systems for motors, gears, axes, etc.
- Automatic manufacturing systems
- Assembly lines

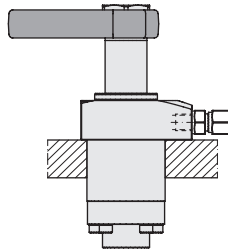
Description

This line is a further development of the proved ROEMHELD swing clamps with the aim to improve process safety in linked clamping systems. The most important data are as follows:

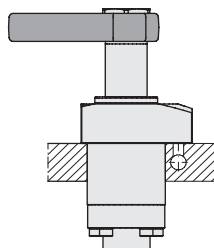
1. Omission of the overload protection device
In the case of a slight collision with the clamping arm during loading and unloading of the fixture, the angular position of the clamping arm will be maintained. Less critical are the weight of the clamping arm or an increased swing speed.
2. Reinforced swing mechanism
The reinforced swing mechanism endures a collision of the clamping arm with the workpiece during clamping up to a pressure of 100 bar.
3. FKM wiper
This wiper has a high chemical resistance when using aggressive cutting fluids.
4. Further types of bodies
Flange at the bottom: data sheet B 1.8811
Threaded-body type: data sheet B 1.892

Connecting possibilities

Pipe thread

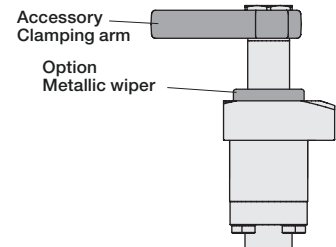


Drilled channels

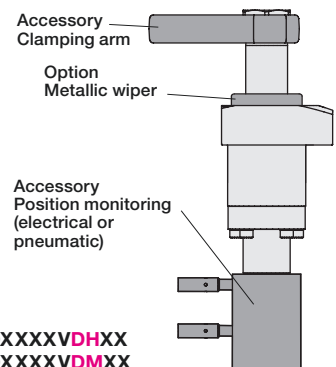


Versions

DH, DM: without switch rod



MH, MM: with switch rod



Part numbers

Without switch rod, without metallic wiper:	189XXXXVDHXX
Without switch rod, with metallic wiper:	189XXXXVDMXX
With switch rod, without metallic wiper:	189XXXXVMHXX
With switch rod, with metallic wiper:	189XXXXVMMXX

Options

Switch rod for position monitoring

The helix rod protrudes through the cover and allows thereby a pneumatic or electrical monitoring of the piston position outside the swarf area. As an accessory a pneumatic position monitoring is available; the brass control slide being displaced in a stainless housing. The slide opens and closes bore holes, so that a pressure switch or a differential pressure switch can signal the position "Clamped" and "Unclamped". It is also possible to realise this monitoring directly in the fixture body by means of drilled channels. An electrical position monitoring with inductive proximity switches is also available (see page 2).

Metallic wiper

This wiper protects the FKM wiper against mechanical damage, e.g. by hot swarf. The swing clamp body is prepared for mounting of the metallic wiper. The wiper consists of a radially floating wiping disk and a retaining disk which will be pressed onto the existing collar.

Metallic wiper
optional

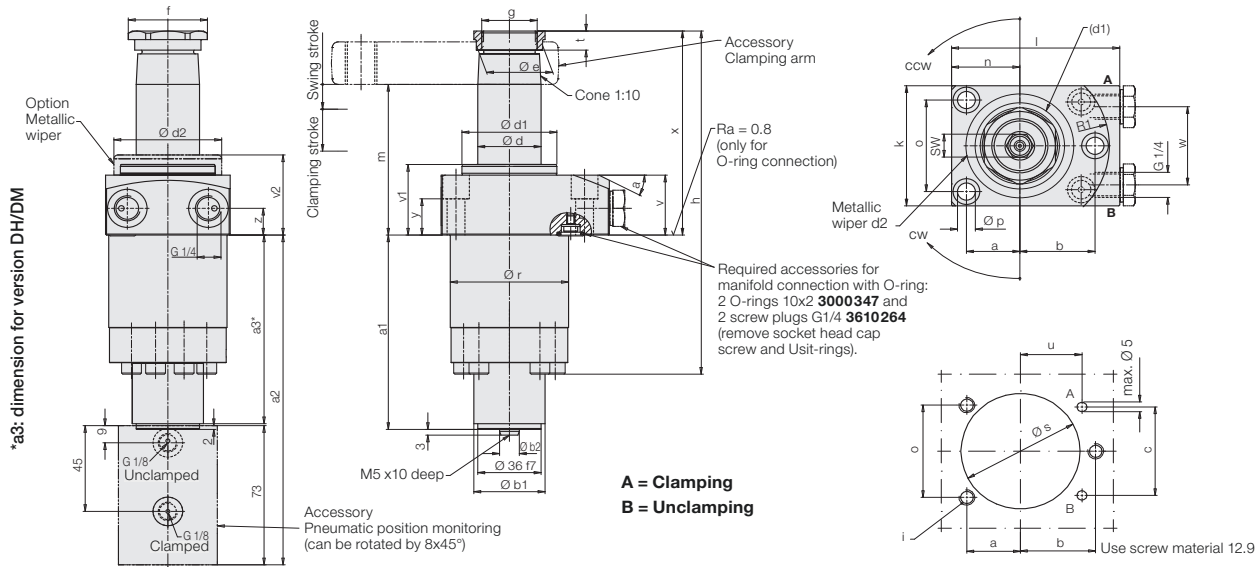
Important notes

Due to the missing overload protection device, assembly and disassembly of the clamping arm has to be made carefully despite the reinforced swing mechanism. When tightening and untightening the fixing nut, the clamping arm or the hexagon socket in the piston has to be backed up. It is recommended to effect tightening and untightening in the swivel area. Frequent collisions with the clamping arm in radial direction have to be avoided.

For interpretation of the pneumatic pressure we recommend to use a differential switch. Parallel connection for up to 8 swing clamps is possible. For a greater number there are special solutions. Please contact us.

Further important notes see data sheet B 1.880.

Dimensions Technical data • Accessories

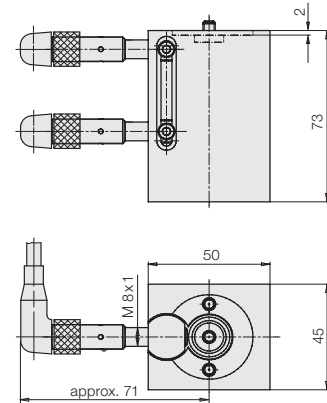


Clamping stroke	[mm]	22	20	20
Swing stroke	[mm]	13	16	18
Total stroke	[mm]	35	36	38
Operating pressure, min.	[bar]	30	30	30
Max. oil flow rate	[cm³/s]	20	36	55
Oil volume / stroke	[cm³]	15.8	25.4	43.8
Oil volume / return stroke	[cm³]	41.2	66.6	114.2
α	[°]	27	26	25
a	[mm]	27	37	42
a1	[mm]	102	116	128
a2	[mm]	173	187	199
a3*	[mm]	92	103	103
b	[mm]	38	50	55
Ø b1	[mm]	36	45	45
Ø b2 f7	[mm]	10	12	12
c	[mm]	46	62	75
Ø d	[mm]	32	40	50
Ø d1	[mm]	48	60	70
Ø d2	[mm]	54.5	75	87
Ø e	[mm]	33.5	45	55.5
f	[mm]	40	55	68
g	[mm]	M28x1.5	M35x1.5	M45x1.5
h	[mm]	181	204	207
i	[mm]	M 8	M 10	M 12
k	[mm]	63	85	95
l	[mm]	85	110	125
m -1	[mm]	79	80	82
n	[mm]	34.5	47	55
o	[mm]	48	65	72
Ø p	[mm]	9	11	14
Ø r -0.1	[mm]	59.8	79.8	89.8
R1	[mm]	45.3	59.5	66
Ø s +1	[mm]	60	80	90
t	[mm]	10	11	12
u	[mm]	31	40	45
v	[mm]	31.4	29.4	29.4
v1	[mm]	37	35	35
v2	[mm]	42	40	40
w	[mm]	41	55	70
x	[mm]	107	114	122
y	[mm]	19	15	14
z	[mm]	14	12	12
SW	[mm]	12	17	17

	Part no.	Part no.	Part no.
Swing direction 90° cw	1895 303 VXX35	1896 303 VXX36	1897 303 VXX38
Swing direction 90° ccw	1895 403 VXX35	1896 403 VXX36	1897 403 VXX38
0 degree	1895 443 VXX35	1896 443 VXX36	1897 443 VXX38
XX: Version	DH/DM = without/with metallic wiper without switch rod		
	MH/MM = without/with metallic wiper with switch rod		

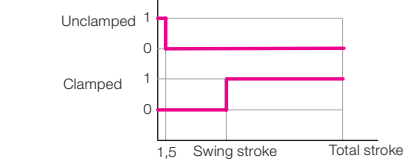
Accessories	Part no.	Part no.	Part no.
Pneumatic position monitoring, complete	0353808	0353809	0353810
Electrical position monitoring			
– without switch	0353815	0353813	0353813
– with standard switch and angle plug	0353814	0353811	0353811
Metallic wiper, complete (spare part)	0341 100	0341 101	0341 102

Accessory: Electrical position monitoring



Function charts

Pneumatic monitoring



Elektrische Kontrolle



Code numbers for available swing angles Swing angle (±1°)

Swing angle (±1°)	Part no.
90°	189X X0X VXXXXX
60°	189X X2X VXXXXX
45°	189X X3X VXXXXX

Clamping force diagrams and other accessories: see data sheet B 1.880. Further proximity switches: see data sheet B 1.552.