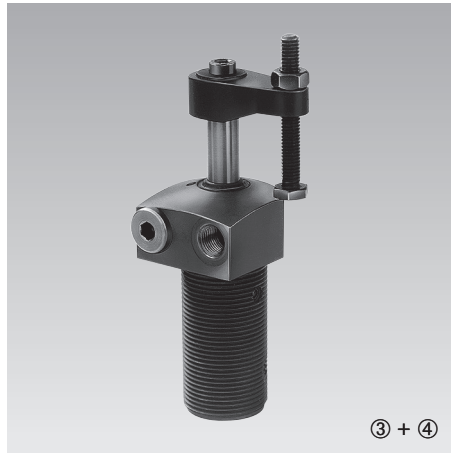
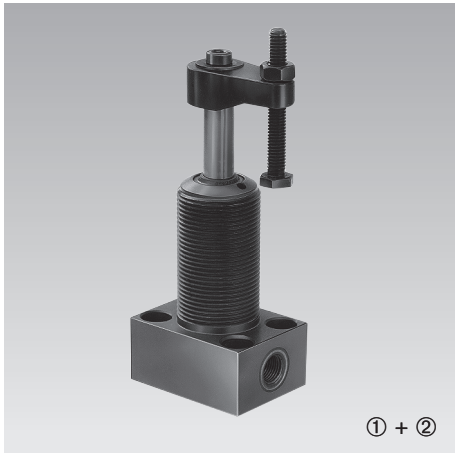




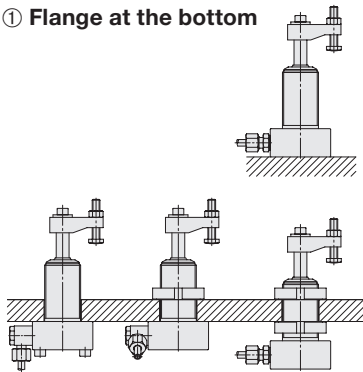
Compact Swing Clamps

bottom flange, top flange, threaded-body type,
single acting, max. operating pressure 350 bar

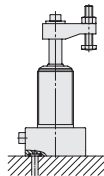


Connecting types

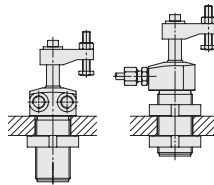
① Flange at the bottom



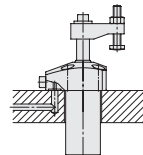
② Flange at the bottom with O-ring sealing



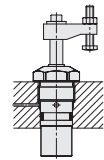
③ Flange at the top



④ Flange at the top with O-ring sealing



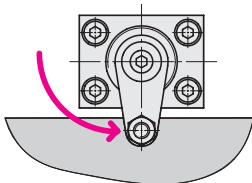
⑤ Threaded-body type



FKM wiper
standard

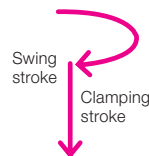
Application

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.



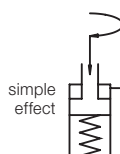
Function

This hydraulic clamping element is a pull-type cylinder where a part of the total stroke is used to swing the piston.



Version

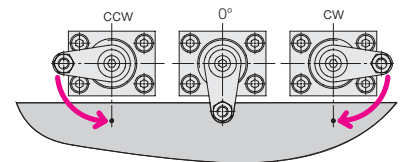
Only single-acting elements are available.



Double-acting elements see data sheet B 1.8491.

Swing direction

The units are available with clockwise and counterclockwise swing motion or without swing motion (0°)



Adjustable swing direction

The swing direction of each swing clamp can also be changed, as described in the operating instructions.

Standard swing angles

are 45°, 60° and 90° ± 2°.

Special angles on request.

Other variants, as e.g. versions with metallic wiper on request.

0°-Version

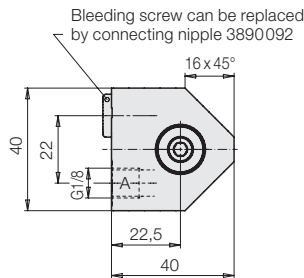
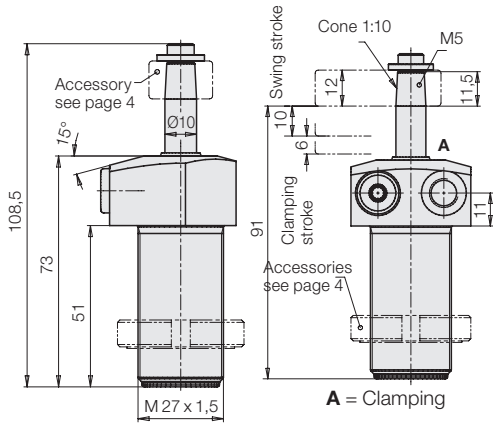
Use as pure pull-type cylinder with a piston which is secured against torsion and which allows eccentric load as per clamping force diagram.

Important notes

Operating conditions, tolerances and other data see data sheet A 0.100.

It is absolutely necessary to follow the instructions for venting of the spring area on data sheet G 0.110.

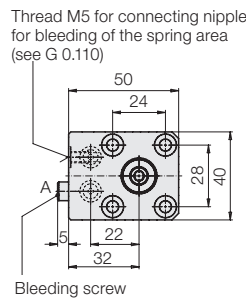
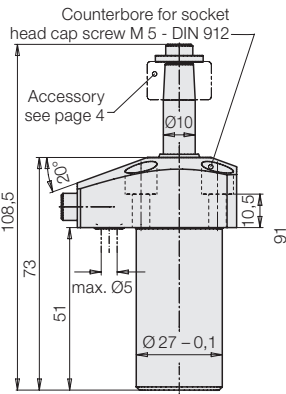
③ Flange at the top



Weight: 0,35 kg

Swing angle	Swing direction	Part no.
0°	—	1849003
90°	cw	1849013
90°	ccw	1849023
60°	cw	1849033
60°	ccw	1849043
45°	cw	1849053
45°	ccw	1849063

④ Flange at the top with O-ring sealing

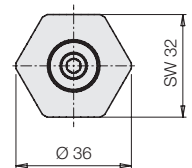
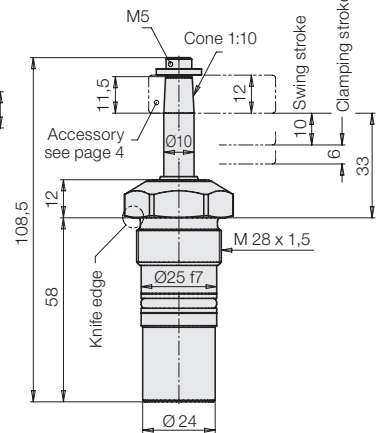


Weight: 0,42 kg

Swing angle	Swing direction	Part no.
0°	—	1849004
90°	cw	1849014
90°	ccw	1849024
60°	cw	1849034
60°	ccw	1849044
45°	cw	1849054
45°	ccw	1849064

Spare O-ring (FKM)
7 x 1,5

⑤ Threaded-body type



Max. seating torque Nm 100

Weight: 0,27 kg

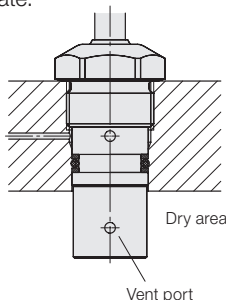
Swing angle	Swing direction	Part no.
0°	—	1849005
90°	cw	1849015
90°	ccw	1849025
60°	cw	1849035
60°	ccw	1849045
45°	cw	1849055
45°	ccw	1849065

7.2 Flange with O-ring sealing

The connecting nipple 3610035 which fits to thread M5 is suitable for a plastic hose ND 6.

7.3 Threaded-body type

The air filter is integrated in the lower part of the housing. If the cylinders are mounted in plates as per drawing below (see figure), liquids must not penetrate.



Installation in a pocket hole is only possible, if a vent hole is provided in a determined area (see drawing). Also this bore hole has to be protected against penetration of liquids.

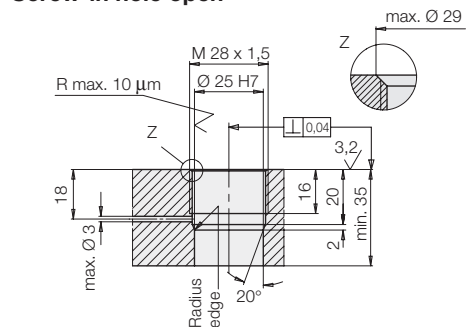
8. Bleeding

Air in the oil prolongs the clamping time considerably and leads to function troubles. Therefore bleeding has to be effected during start up, as described as follows for the different types.

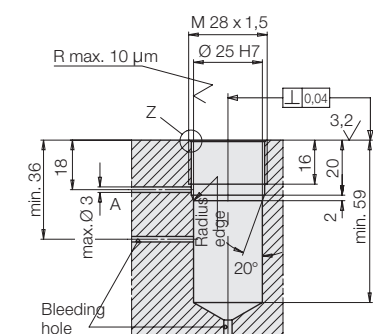
8.1 Flange at the bottom and at the top
Loosen carefully the union nut of the tube at low oil pressure and pump until bubblefree oil comes out. Retighten the union nut.

8.2 Flange with O-ring sealing
Loosen carefully the socket head cap screw M5 at low oil pressure and pump until bubble-free oil comes out. Retighten the screw.

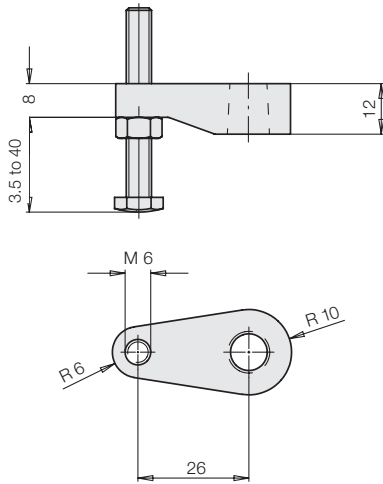
8.3 Threaded-body type
There is no possibility for bleeding at the element itself. Remedy: plug the oil channels in the fixture body at the end. If required, loosen the plugs carefully and pump at low oil pressure until bubblefree oil comes out. Retighten the plugs.



Screw-in hole closed

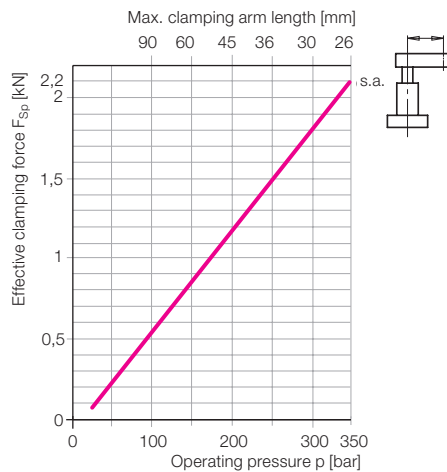


Clamping arm assembly, complete max. 350 bar



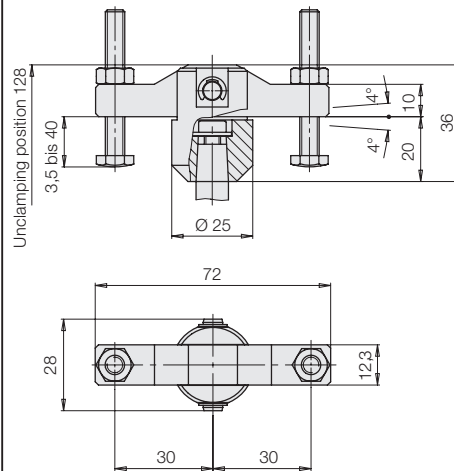
Part no. 0354057

Clamping force diagram



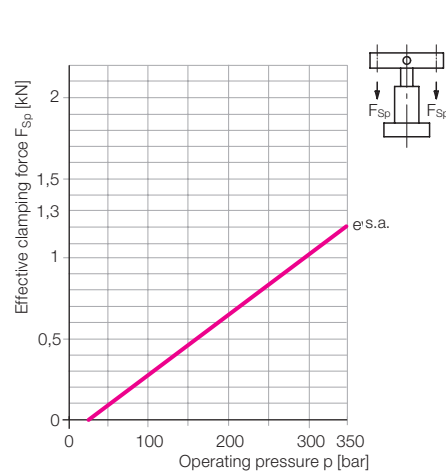
Double clamping arm, complete

Contact bolt – M 6 x 45
Part no. 3614138



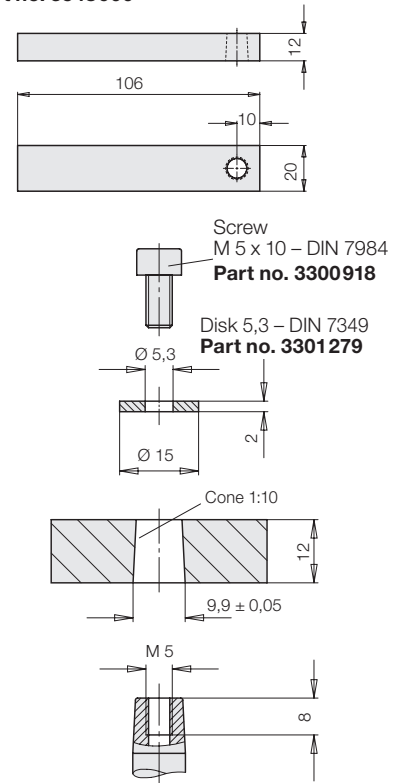
Part no. 0354082

Clamping force diagram

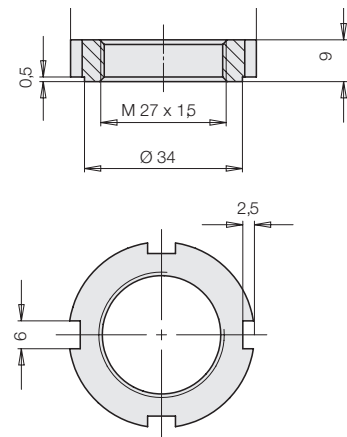


Connecting dimensions for special clamping arms

Clamping arm - blank
Part no. 3548900



Flange nut as per DIN 1804



Part no. 3527076

Tube male stud coupling for G1/8

ND [bar]	Designation	Part no.
250	D 8L G 1/8 ED	9208075
500	D 8S G 1/8 ED	9208164

Thread reducing adaptor

ND [bar]	Designation	Part no.
400	GWR 1/8 – 1/4	3613003

Arrangement of the different connecting types

