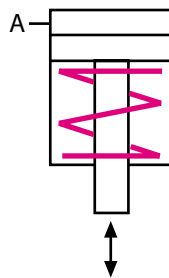
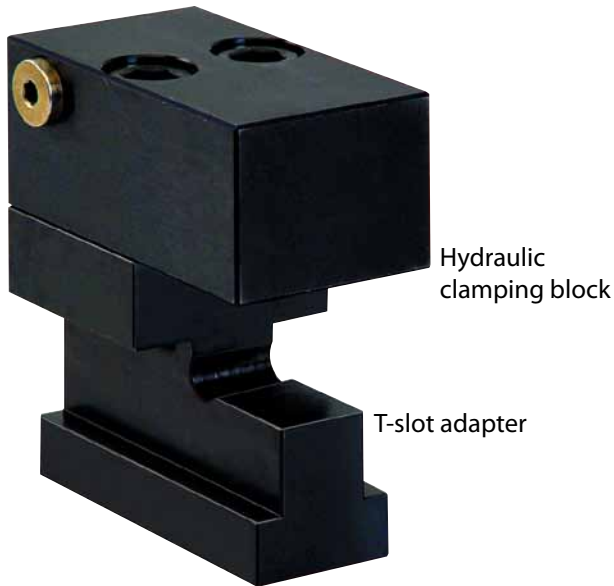


Sliding clamp single-acting



ROEMHELD
HILMA ■ STARK



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 sliding clamp is manually placed in the T-slot provided in the 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
- ◆ clamping force of between 19 and 78 kN
- ◆ easy fastening
- ◆ compensates for large clamping edge tolerances
- ◆ no colliding edges, smooth die positioning
- ◆ suitable for retrofit
- ◆ no need for die standardisation (width and depth)

For power units
please refer to product group 7

For accessories
please refer to product group 11

Recommended accessories:
Angular rotary coupling
Part no. 9280-043

Sliding
clamps



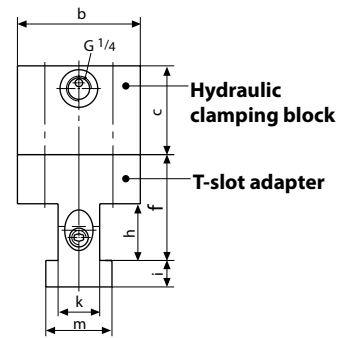
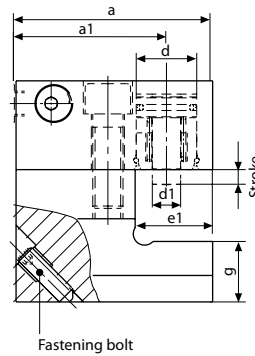
Sliding clamps fastened to bed and ram
of a double column press. Dies are
entered from the front using consoles.



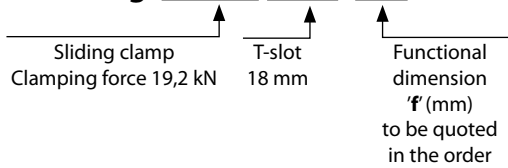
Sliding clamp single-acting

Sliding clamp complete

| T-slot (mm) | Clamping force (kN) | Part no. | Dim. 'f' min. | Dim. 'f' max. |
|-------------|---------------------|-------------|---------------|---------------|
| 18 | 19,2 | 8.2202.1850 | 42 | 90 |
| 22 | 19,2 | 8.2202.2250 | 50 | 106 |
| 22 | 32 | 8.2203.2250 | 50 | 106 |
| 22 | 50 | 8.2204.2250 | 50 | 106 |
| 28 | 32 | 8.2203.2850 | 55 | 106 |
| 28 | 50 | 8.2204.2850 | 55 | 112 |
| 28 | 78 | 8.2205.2850 | 60 | 117 |



Example of ordering: 8.2202.1850/ F60



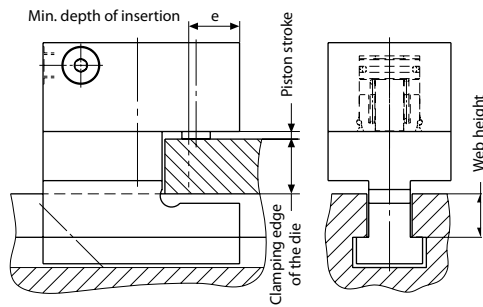
Functional dimension 'f':

$\frac{1}{2}$ stroke
+ height of die clamping edge
+ web height of T-slot
= dimension 'f'

| T-slot as per DIN 650 (mm) | 18 | 22 | 22 | 22 | 28 | 28 | 28 |
|------------------------------------|------|------|-----|-----|-----|-----|-----|
| Clamping force at 400 bar (kN) | 19,2 | 19,2 | 32 | 50 | 32 | 50 | 78 |
| Stroke (mm) | 8 | 8 | 8 | 8 | 8 | 8 | 12 |
| Oil consumption (cm ³) | 4 | 4 | 7 | 10 | 7 | 10 | 24 |
| a (mm) | 95 | 95 | 104 | 111 | 104 | 111 | 132 |
| a1 (mm) | 77 | 77 | 81 | 85 | 81 | 85 | 99 |
| b (mm) | 65 | 65 | 65 | 65 | 65 | 65 | 80 |
| c (mm) | 40 | 40 | 47 | 50 | 47 | 50 | 75 |
| d (mm) | 25 | 25 | 32 | 40 | 32 | 40 | 50 |
| d1 (mm) | 15 | 15 | 15 | 20 | 15 | 20 | 25 |
| e (mm) | 23 | 23 | 28 | 31 | 28 | 31 | 38 |
| e1 (mm) | 32 | 32 | 41 | 48 | 41 | 48 | 60 |
| g (mm) | 24 | 32 | 32 | 32 | 42 | 42 | 42 |
| h (mm) | 25 | 30 | 30 | 30 | 37 | 37 | 37 |
| i (mm) | 10 | 14 | 14 | 14 | 18 | 18 | 18 |
| k (mm) | 18 | 22 | 22 | 22 | 28 | 28 | 28 |
| m (mm) | 28 | 35 | 35 | 35 | 44 | 44 | 44 |
| Weight (kg) | 2,9 | 3,2 | 3,6 | 3,9 | 4,2 | 4,5 | 7,5 |

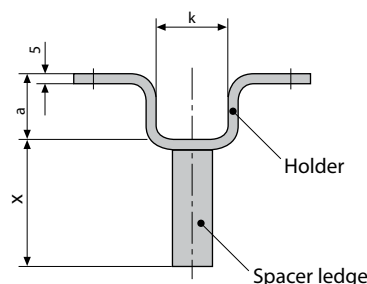
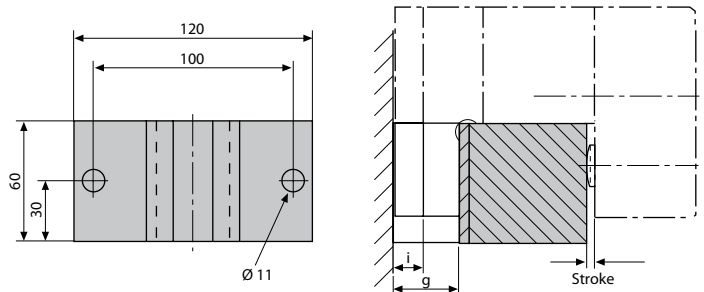
Max. operating pressure 400 bar

Please consult us if aggressive spray is used



Parking station accommodates the clamping element during die change

| T-slot as per DIN 650 (mm) | 18 | 22 | 28 |
|--|-------------|-------------|-------------|
| a (mm) | 25 | 33 | 43 |
| k (mm) | 30 | 37 | 46 |
| i (mm) | 10 | 14 | 18 |
| g (mm) | 24 | 32 | 42 |
| Parking station complete with to DIN holder and ledge | | | |
| Part no. | 8.2754.1850 | 8.2754.2250 | 8.2754.2850 |
| Holder Part no. | 2754-180 | 2754-220 | 2754-280 |
| Spacer ledge Part no. | 2754-500 | 2754-500 | 2754-500 |



Distance 'x':

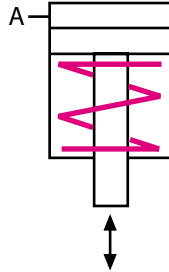
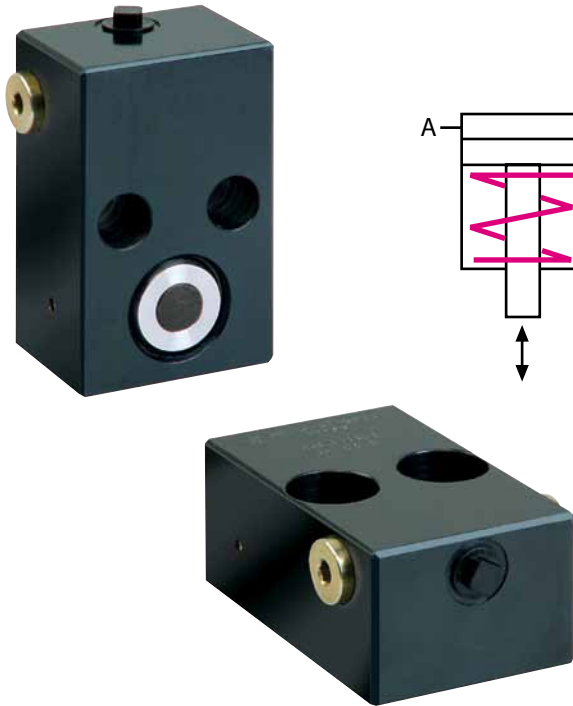
$x = f + i - g - \frac{1}{2}$ stroke
Dimension x to be quoted in the order

For suitable power units, please refer to product group 7
For hydraulic hoses, please refer to product group 11

Clamping block - Sliding clamp single-acting with spring return



ROEMHELD
HILMA ■ STARK



Applications:

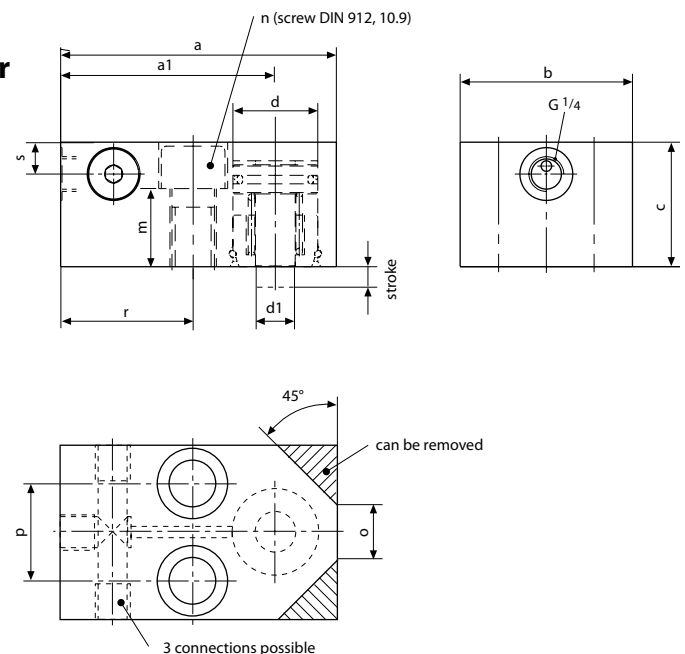
- on press beds and rams
- on machines and equipment for clamping and locking
- when the available space is limited

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 to stationary spacer ledges or in combination with a T-slot adapter for clamping workpieces in the T-slots of a press bed or ram.

Hydraulic clamping block without T-slot adapter

| Clamping force at 400 bar (kN) | 19,2 | 32 | 50 | 78 |
|--------------------------------|--------------------|--------------------|--------------------|--------------------|
| Stroke (mm) | 8 | 8 | 8 | 12 |
| Oil cons. (cm ³) | 4 | 7 | 10 | 24 |
| a (mm) | 95 | 104 | 111 | 132 |
| a1 (mm) | 77 | 81 | 85 | 99 |
| b (mm) | 65 | 65 | 65 | 80 |
| c (mm) | 40 | 47 | 50 | 75 |
| d (mm) | 25 | 32 | 40 | 50 |
| d1 (mm) | 15 | 15 | 20 | 25 |
| m (mm) | 24 | 29 | 32 | 53 |
| n (mm) | M 16 | M 16 | M 16 | M 20 |
| o (mm) | 18 | 20 | 20 | 28 |
| p (mm) | 36 | 36 | 36 | 43 |
| r (mm) | 50 | 50 | 50 | 57 |
| s (mm) | 12,0 | 15,0 | 16,5 | 22,0 |
| Weight (kg) | 1,6 | 2,0 | 2,3 | 4,9 |
| Part no. | 8.2202.1301 | 8.2203.1301 | 8.2204.1301 | 8.2205.1301 |



Max. operating pressure: 400 bar.
Fastening screws M16 or M20, DIN 912, 10.9 are not included.