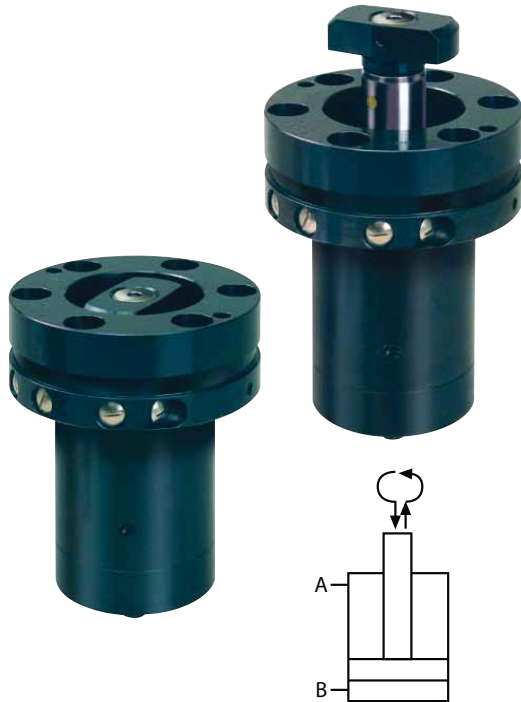


Swing sink clamping element double-acting



For power units
please see product group 7

For accessories
please see product group 11

Applications:

- integrated in press rams
- integrated in press beds
- in machine tools and equipment
- when the available space is limited
- when temperatures may reach 70° C

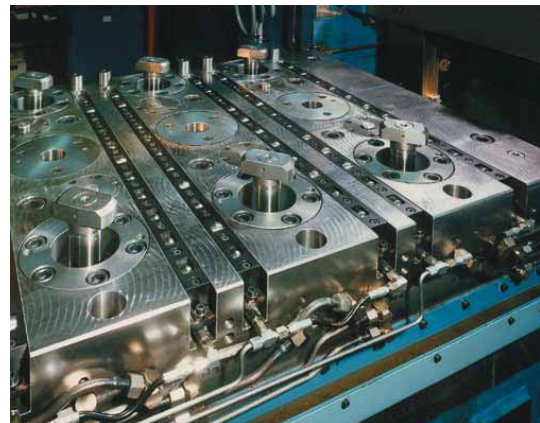
Design:

Double-acting swing sink clamp with 90° swing angle. The piston is guided by a guide pin in such a manner that during part of the stroke a 45° rotation is carried out. Un-clamping, change-over and clamping are monitored by inductive proximity switches. The swing mechanism is protected by a spring-loaded overload protection and equipped with emergency hand operation. The tie rod, piston and swing mechanism are hardened.

Special features:

- ◆ ideal power transmission
- ◆ compact design
- ◆ clamping force of between 60 and 164 kN
- ◆ position monitoring, emergency hand operation and overload protection combine to ensure high functional safety
- ◆ compensates for large clamping edge tolerances (± 1.5 mm)
- ◆ no colliding edges, smooth die positioning
- ◆ optimum use of ram and bed surfaces
- ◆ die clamping in barely accessible positions

Swing sink clamps fastened
in a double column press.
The tie rod is extended (swing position).
Easy feeding of dies by hydraulic roller bars
installed in the T-slots and lateral stops



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Swing sink clamping element double-acting

Clamping force at 400 bar (kN)	60	104	164
Clamping force at 100 bar (kN)	15	26	41
Piston Ø e (mm)	54	70	88
Piston rod Ø d (mm)	32	40	50
Swing stroke i (mm)	12	15	21
Clamping+lowering stroke h (mm)	42	54	65
Oil consumption clamping (cm³)	150	318	630
Oil consumption unclamping (cm³)	120	256	512
Max. volume flow (cm³/s)	15	32	63
a (mm)	128	160	192
b (mm)	158	197	242
c (mm)	82	104	126
f (mm)	M 24 x 1,5	M 30 x 1,5	M 36 x 1,5
g	G ¼	G ¾	G ¾
k (mm)	13	17	21
l (mm)	55	70	87
m (clamping edge) (mm)	18	23	28
n (mm)	53	68	85
o (mm)	20	26	33
p (mm)	13	18	22
q (mm)	34	42	52
r (mm)	65	80	95
s (mm)	70	86	103
t (mm)	104	130	156
u (mm)	30	38	45
v (mm)	50	61	72
w (mm)	38	47	59
x (mm)	5,5	8	8
y (mm)	70	86	103
z (mm)	21	24	29
(Emergency hand operation) SW1 (mm)	12	14	19
(Emergency hand operation) SW2 (mm)	6	8	10
Weight (kg)	7,4	14,7	25
with pipe connection			
Part no.	2154-160	2155-160	2156-160
with flanged connection			
Part no.	2154-200	2155-200	2156-200

max. operating pressure 400 bar

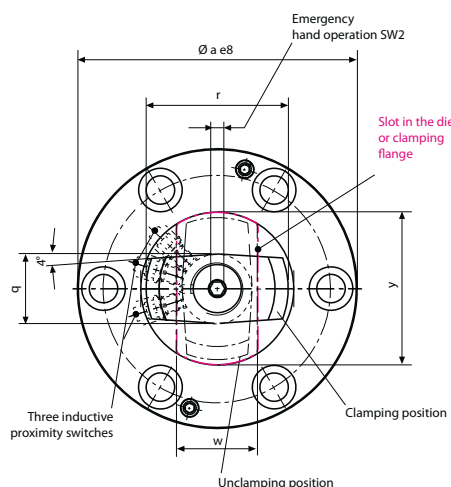
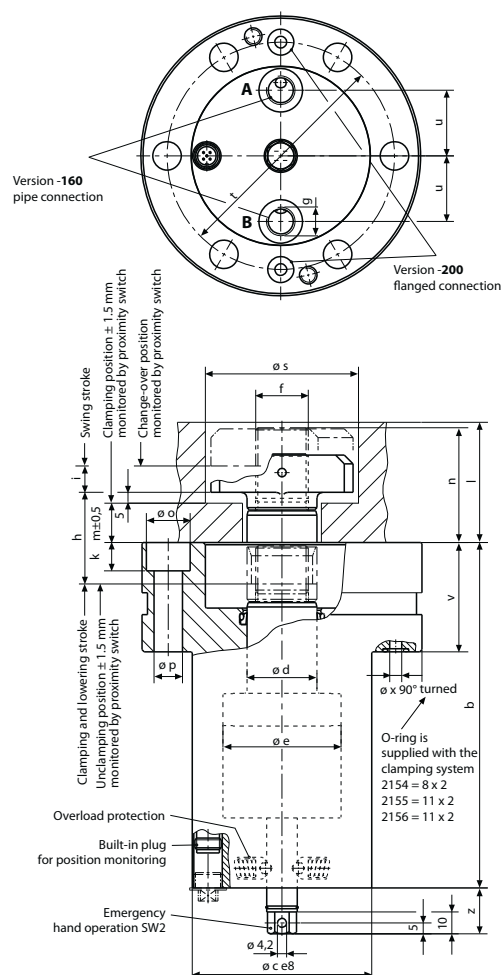
Other sizes and special versions are available on request.

Swing sink clamping element for clamping edge m = 50 mm

m (mm)	50	50	50
h (mm)	74	81	87
b (mm)	190	224	264
n (mm)	85	95	107
l (mm)	87	97	109
Oil consumption clamping (cm³)	222	420	764
Oil consumption unclamping (cm³)	174	342	601
with pipe connection			
Part no.	8.2154.8059	8.2155.8047	8.2156.8023
with flanged connection			
Part no.	8.2154.8082	8.2155.8050	8.2156.8027

Please note!

Access to one of the two emergency hand controls SW1 or SW 2 is essential.



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Swing sink clamping element double-acting



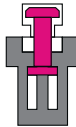
Function

The piston is guided by a guide pin in such a manner that during part of the stroke a 45° rotation is carried out just before reaching and just after leaving the piston upper end position. The rotation is always anti-clockwise, no matter whether the piston extends or retracts.



1. Unclamping position

The piston is completely retracted. This permits an easy die change, as no parts project over the bed level. Proximity switch 2S1 monitors this position.



2. Change-over position for clamping

Valves Y1 and Y2 are energised, and pressure is applied to piston side B. The tie rod passes through the slot of the clamping point and is then rotated by 45°. Proximity switch 2S2 monitors this position.



3. Clamping position

Valves Y1 and Y2 are de-energised, and pressure is applied to piston rod side A. The tie rod makes a further 45° rotation and is now transversely above the clamping point. *The die is clamped.* Proximity switch 2S3 monitors this position. Once the clamping pressure has been reached the power unit will be switched off by pressure switch 1S2. In the event of a fall in pressure, the power unit is switched on by the pressure switch and builds up to the required clamping pressure.



4. Change-over position for unclamping

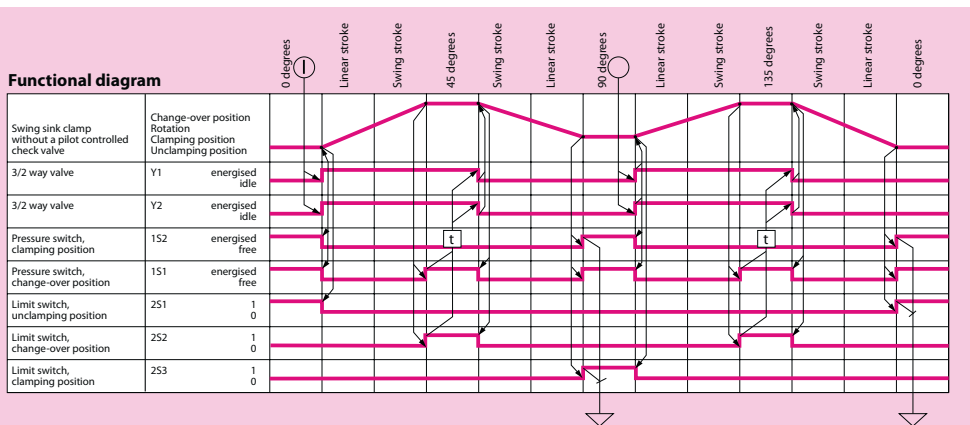
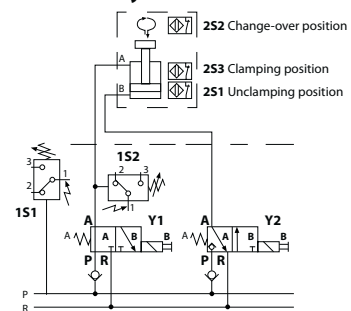
Valves Y1 and Y2 are energised, and pressure is applied to piston side B. The tie rod is extended and then again rotated by 45°. Proximity switch 2S2 monitors this position.



5. Unclamping position

Valves Y1 and Y2 are de-energised, and pressure is applied to piston rod side A. The tie rod makes a further 45° rotation and passes through the slot of the clamping point as far as the end position. Proximity switch 2S1 monitors this position. *The die is unclamped.*

Hydraulic schematics



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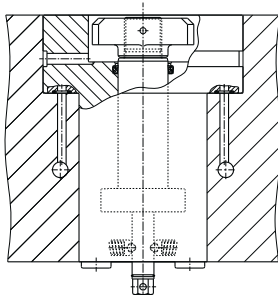


Swing sink clamping element double-acting

Recommended installation

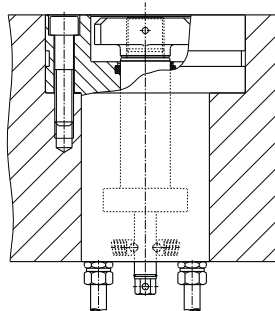
In order to ensure ease of servicing, two alternatives are offered for connecting the swing sink clamps.

Flanged connection



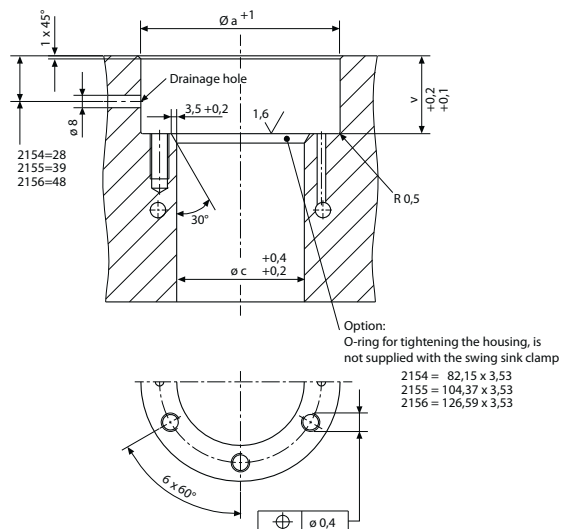
Hydraulic oil is fed through the drilled holes in the bed and in the ram. There are no exposed conduits or screw fittings. O-rings supplied with the clamping element provide for tight fitting. Easy installation, ease of servicing.

Pipe connection



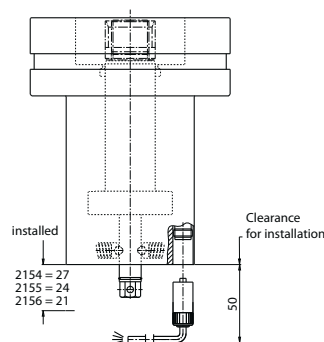
Pipes are recommended in applications where screw fittings are easily accessible and where pipes do not impede installation and dismantling of the swing sink clamps.

Drilled hole for flanged or pipe connection



Flanged connection requires a plain and neat surface. The drainage hole may be drilled in any position provided that spray and separating agent can drain off freely.

Connection of the monitoring system for clamping and unclamping position



The three proximity switches are connected to the base of the swing sink clamp through a connecting lead with a screw coupling [IP 67]. The connecting lead is not supplied with the swing sink clamp and it has a separate part number, see page 6. Further installation may be carried out using a distribution block with an LED display.

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Swing sink clamping element double-acting



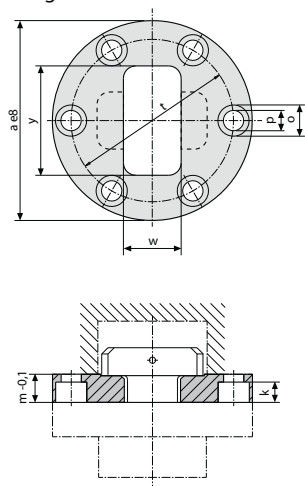
Accessories Flange

as a clamping point for installation in press dies

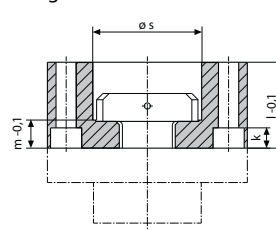
for clamping element type	2154-160 2154-200	2155-160 2155-200	2156-160 2156-200
a (mm)	128	160	192
k (mm)	13	17	21
l (mm)	55	70	87
m (mm)	18	23	28
o (mm)	20	26	33
p (mm)	13	18	22
s (mm)	70	86	103
t (mm)	104	130	156
w (mm)	38	47	59
y (mm)	70	86	103
Part no.	5700-016	5700-017	5700-018

for clamping element type	2154-160	2155-160	2156-160
	2154-200	2155-200	2156-200
a (mm)	128	160	192
k (mm)	13	17	21
l (mm)	55	70	87
m (mm)	18	23	28
o (mm)	20	26	33
p (mm)	13	18	22
s (mm)	70	86	103
t (mm)	104	130	156
w (mm)	38	47	59
y (mm)	70	86	103
Part no.	5700-019	5700-020	5700-021

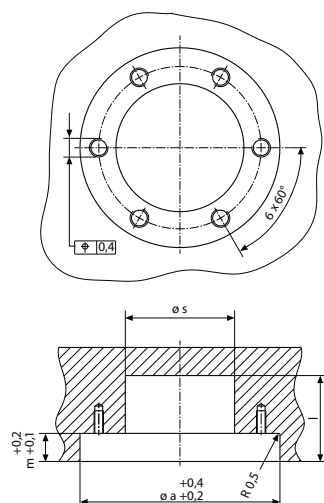
Flange



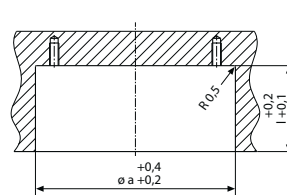
Flange



Location hole



Location hole



Subject to technical modification

For more accessories, please see product group 11

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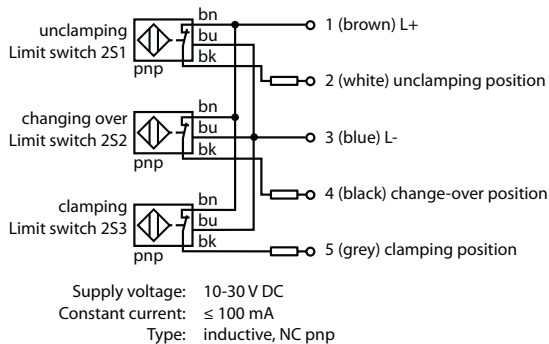
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Swing sink clamping element double-acting

Electrical installation

Pin assignment for three-wire proximity switches



Distribution block with LED display for connecting 4 clamping elements

Easy installation.
LED display of the unclamping, change-over
and clamping position of each clamping element.

Scope of delivery: 1 distribution block
4 coupler plugs, 5 poles
1 coupler plug, 16 poles

Wiring of output plug:

- Pin 1 = L+
- Pin 2 = L
- Pin 3 = 1L
- Pin 4 = 1U
- Pin 5 = 1S
- Pin 6 = 2L
- Pin 7 = 2U
- Pin 8 = 2S
- Pin 9 = 3L
- Pin 10 = 3U
- Pin 11 = 3S
- Pin 12 = 4L
- Pin 13 = 4U
- Pin 14 = 4S
- Pin 15 = free
- Pin 16 = free

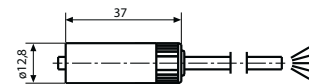
L = Unclamping position
U = Change-over position
S = Clamping position

Hydraulic installation

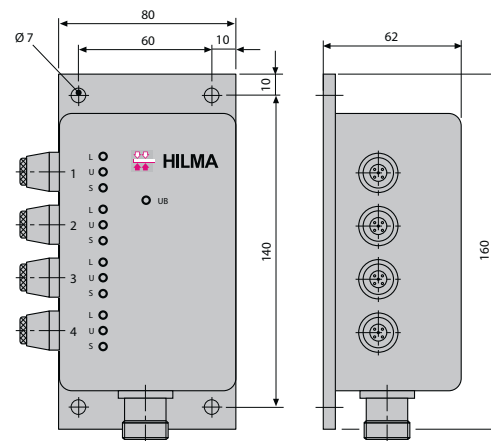
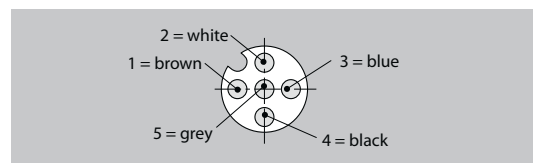
Read the operating instructions before commissioning the system.

Adjust the displacement of the power unit so that clamping and unclamping cycles between 10 and 30 seconds are obtained. In order to prevent the swing mechanism from premature wear, the dynamic pressure at port B should not exceed 50 bar while the tie rods retract through the slot. Swing sink clamps which are grouped together should be connected to distribution blocks, in order to avoid series connection. Use pipes with larger diameter for connection to the power unit.

5-pole connecting lead with screw coupling



Cable length 5 m	Part no.	5700-013
Cable length 10 m	Part no.	5700-014



Part no.	5700-015
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If in doubt, please send the installation plan to be reviewed. Provide a pressure gauge connection in every hydraulic circuit for adjustment and to check operational data. Other parameters and recommendations for hydraulic installation of die clamping systems, are given in chapter no. 1 "General information".

Please note

The full stroke of the piston must be realised, otherwise the swing mechanism may be damaged.

Subject to technical modification

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