



**ROEMHELD**  
HILMA ■ STARK

Issue 12-16 E

## WZ 2.2097

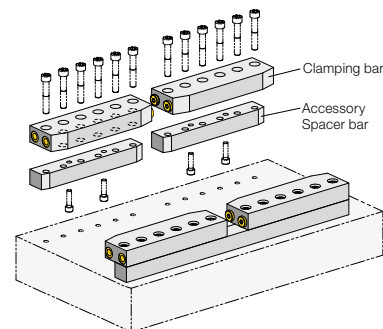
### Clamping Bars

double acting, with built-in pistons  
clamping force up to 116 kN, piston stroke 8 mm



#### Advantages

- Piston stroke 8 mm
- Arrangement in series of several clamping bars with plug-in connectors
- Flat and compact design
- Fully resilient stroke limitation
- Easy installation
- Easy to retrofit



#### Application

The clamping bars are used permanently installed on press beds and rams, on machines and plants for clamping and locking.

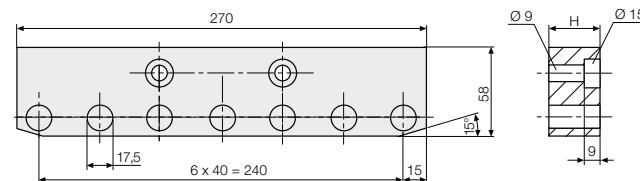
#### Description

The clamping bar is directly screwed on the press bed or ram using a spacer bar. Clamping is carried out on the die clamping edge by applying hydraulic pressure to the port of the 2, 3 or 6 pistons which are arranged side by side with a pressure medium. Unclamping is made by pressurising the port B. Hydraulic oil is supplied through G 1/4 ports provided on both sides. Flat design with die inlet chamfer.

#### Accessories

##### Spacer bar

to obtain the required clamping edge height

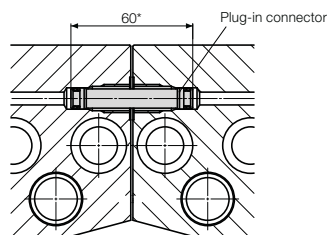


All dimensions in mm

|                   |      |           |           |           |
|-------------------|------|-----------|-----------|-----------|
| Height Z          | [mm] | 28        | 53        | 75        |
| for clamping edge | [mm] | 25 ± 1.5  | 50 ± 1.5  | 72 ± 1.5  |
| Part no.          |      | 520710024 | 520710032 | 520710081 |

Other heights on request

#### Plug-in connector



Other dimensions on request

Plug-in connectors for clamping bars arranged in series.

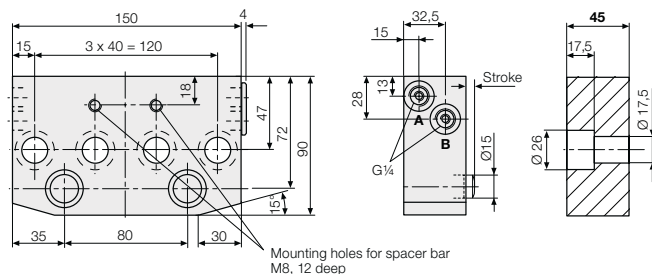
When using several clamping bars in a row, the hydraulic ports are connected by means of pipes or plug-in connectors (see figure).

**Part no. 805300040**

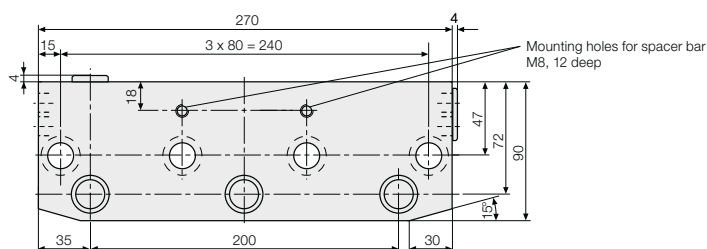
Subject to modifications

## Technical data Dimensions

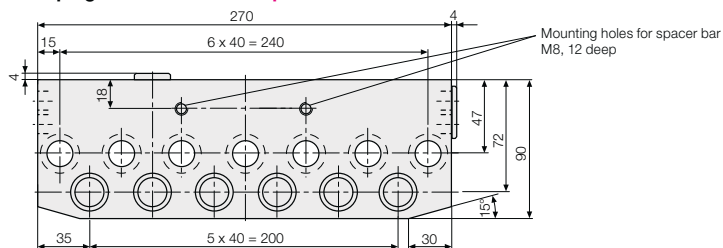
### Clamping bars with 2 built-in pistons



### Clamping bars with 3 built-in pistons



### Clamping bars with 6 built-in pistons



All dimensions in mm

### Technical data

|   |       |           |           |           |
|---|-------|-----------|-----------|-----------|
| Clamping force at max. operating pressure | [kN]  | 38.6      | 58        | 116       |
| Max. operating pressure                   | [bar] | 400       | 400       | 400       |
| Clamping force at 100 bar                 | [kN]  | 9.65      | 14.5      | 29        |
| No. of pistons                            |       | 2         | 3         | 6         |
| Piston/piston rod Ø                       | [mm]  | 25/15     | 25/15     | 25/15     |
| Stroke                                    | [mm]  | 8         | 8         | 8         |
| Oil volume clamping                       | [cm³] | 7.8       | 11.6      | 23.2      |
| Weight                                    | [kg]  | 4.1       | 7.4       | 8.9       |
| Part no.                                  |       | 820970650 | 820970450 | 820970850 |