

Wedge clamp, double acting without position monitoring

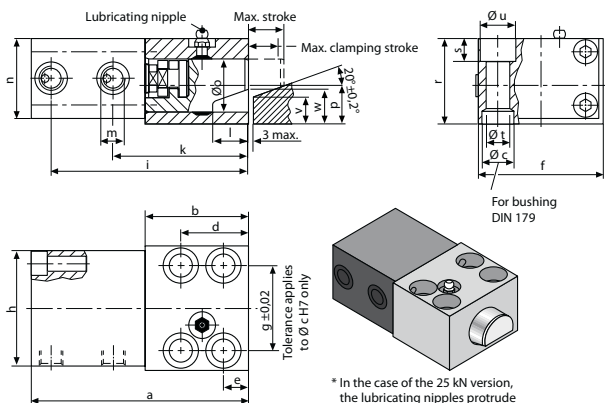
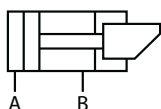


ROEMHELD
HILMA ■ STARK

Wedge clamp, double acting
for dies with tapered clamping edge

Clamping bolt with 20° bevel,
design without proximity switch

Resistant to temperatures of up to 160°C
(for higher temperatures, please consult us)



* In the case of the 25 kN version,
the lubricating nipples protrude
by 5 mm and are offset by 9.5 mm

* Clamping force

This is the force that the clamping element applies to the workpiece at maximum operating pressure. The die is clamped on the fixture plate by means of this force. Under normal conditions, the external forces acting on the die (i.e. the ejecting force or die cushion force) shall not exceed the totality of the clamping forces of the elements.

** Perm. retention force

This is the holding power of clamping element and fastener (screw property class 8.8). The above data is based on the condition that the appropriate tightening torque has been applied, and that material and geometry of the fixtures are suitable for the purpose. It must be ensured that in cases of emergency, e.g. workpiece jammed in the die, the totality of the retention forces of the elements is not exceeded.

Max. clamping force * [kN]	25	50	100	160	250	400	630
Perm. retention force** [kN]	35	65	130	210	320	520	820
Screw property class 8.8							
Max. operating pressure [bar]	350	275	350	350	350	350	350
Cylinder-Ø [mm]	25	40	50	63	80	100	125
Max. stroke [mm]	20	25	25	30	32	40	40
Clamping stroke (from/to) [mm]	15 – 18	18 – 22	19 – 22	23 – 27	24 – 29	30 – 36	30 – 36
Max. oil consumption (cm³)	10	31	49	94	161	314	491
a [mm]	122	157	190	227	267	310	375
b [mm]	58	78	100	125	150	180	225
Ø c H7 x depth [mm]	18/7	26/9	30/11	35/11	48/13	55/16	62/16
d [mm]	38	46	58	75	78	95	108
e [mm]	14	16	20	25	26	32	38
f [mm]	70	95	120	150	200	240	280
g [mm]	48	65	85	106	140	180	210
h [mm]	65	85	100	125	160	200	230
i [mm]	111	146	177	210	246	285	344
k [mm]	76	102	127	151	184	215	272
l [mm]	20	25	26	32	40	45	50
m	G ¼	G ¼	G ¼	G ½	G ½	G ½	G ½
n [mm]	45	63	75	95	120	150	180
Ø o [mm]	30	40	55	70	80	100	125
p [mm]	21,5	28	37	49	55	75	85
r [mm]	48	65	80	105	125	160	190
s [mm]	13	18	20	26	32	38	44
Ø t [mm]	13	17	21	26	33	39	45
Ø u [mm]	20	26	32	40	48	57	66
v [mm]	15	18	25	30	30	50	60
w [mm]	19,5	23,5	30,5	37	38	60	70
Screw DIN 912-8.8 (4 pieces)	M 12	M 16	M 20	M 24	M 30	M 36	M 42
Tightening torque [Nm]	86	210	410	710	1450	2520	4050
Weight [kg]	2,4	5,8	10,6	21	40	74	125
Part no.	4604 620	4604 621	4604 622	4604 623	4604 634	4604 635	4604 636
Accessories							
Bushings DIN 179	12 x 12	17 x 16	21 x 20	26 x 20	32 x 25	38 x 30	44 x 30
Part no.	3300 285	3300 287	3300 288	3300 289	3300 420	3300 430	3300 440