

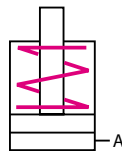
Built-in piston, single-acting with spring return



ROEMHELD
HILMA ■ STARK



Original size



Applications:

- in clamping bars and blocks
- for workpiece and die clamping and locking
- when the available space is narrow and shallow

Function:

Plunger piston single-acting with integral pull-back spring, stroke limitation and fastening screw as a subassembly which cannot be dismantled.

Sealing ring made from PTFE, O-ring as static seal.

The piston is hardened and ground. On request, a wiper ring is supplied for installation in the housing.

Special seals are available on request.

Special features:

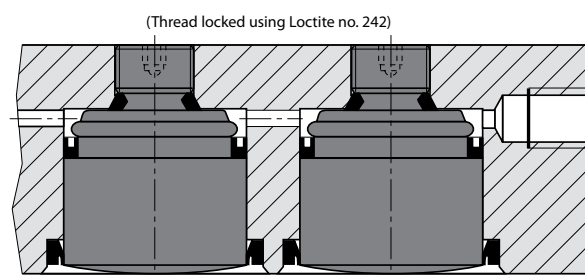
- ◆ low installation height
- ◆ very compact design
- ◆ extremely low overall height, despite pull-back spring and fully utilisable stroke
- ◆ easily replaceable
- ◆ high power density

For power units
please see product group 7

For accessories
please see product group 11

Example of application

Built-in piston integrated in a clamping bar





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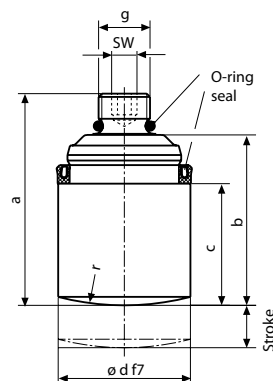
Clamping force at 250 bar (kN)	12,25	20	31,25	48,75
Clamping force at 100 bar (kN)	4,9	8	12,5	19,5
Min. spring return force (N)	130	200	230	400
Piston Ø d (mm)	25	32	40	50
Stroke (mm)	8	8	8	12
Total oil consumption (cm³)	4	7	10	24
a (mm)	40	47	50	75
b (mm)	32,5	34,5	36	56
c (mm)	23,5	25	26	43
e (mm)	11,5	14	19,5	24
f (mm)	32	42	47	58
g (mm)	G ⅛	G ¼	G ⅜	G ½
r (mm)	50	100	150	200
SW (mm)	4	6	6	8
Tightening torque (Nm)	10	20	25	30
Weight (kg)	0,10	0,17	0,28	0,59
Part no.	1072-010	1073-010	1074-010	1075-020
Wiper ring Part no.	5700-001	5700-002	5700-003	5700-004
Set of seals Part no.	5700-005	5700-006	5700-007	5700-008
Mounting sleeve Part no.	5700-009	5700-010	5700-011	5700-012

max. operating pressure 250 bar

Please note

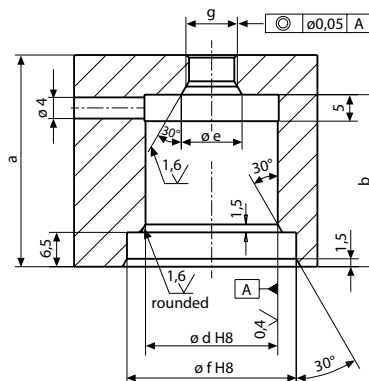
Lateral forces should be less than 5% of clamping forces.
To ensure perfect operation, the installation dimensions and surface qualities must be strictly observed.
Use an Allan key for assembly and dismantling.
Replace the O-ring after dismantling.
The max. service temperature is 80°C.
Lock the thread using Loctite no. 242.

Built-in piston

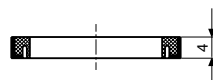


Drilled location hole

Hydraulic oil supply through holes drilled in the base.
Only one oil port is required.



Wiper ring



Mounting sleeve for built-in piston and wiper ring

