

Sliding clamp, mechanical with integral high-pressure spindle



ROEMHELD
HILMA ■ STARK



Applications:

- for clamping and locking dies on press beds and rams
- on beds of machine tools
- when the available space is limited

Function:

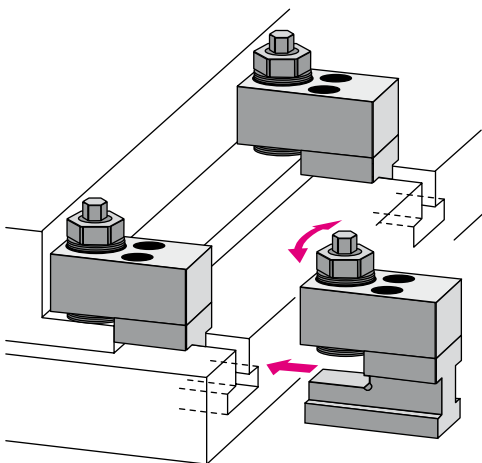
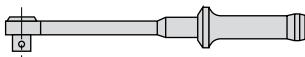
The sliding clamp is manually placed in the T-slots and screwed against the die clamping edge. Once the high-pressure spindle has been adjusted to suit the height of the clamping edge, the clamping force is built up by turning the hexagon nut (SW 1) in a clockwise direction. The clamping force achieved depends on the tightening torque selected with the torque wrench

Special features:

- ◆ suitable for retrofit
- ◆ compact design and easy handling
- ◆ clamping force of between 40 and 80 kN
- ◆ high clamping force with low torque
- ◆ compensates for large clamping edge tolerances
- ◆ no colliding edges, smooth die positioning
- ◆ no need for die standardisation (width and depth)
- ◆ self-locking by patented wedge system

Accessory

Torque wrench 20 - 100 Nm
Part no. 9.3792.6610



Note:

Before applying the tightening torque, the high-pressure spindle must be screwed against the clamping edge so that there is no play.
If the parts are not rigid, tighten the high-pressure spindle using the hexagon nut (SW 2) until there is no play.



Mechanical sliding clamps fastened to a machine bed.

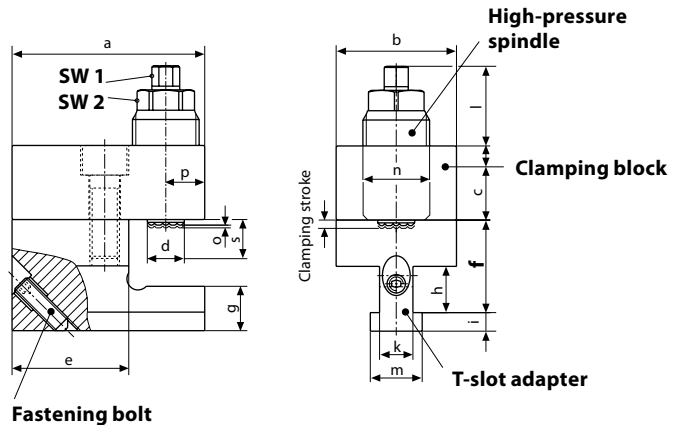
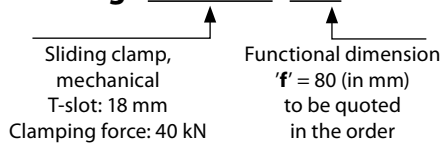


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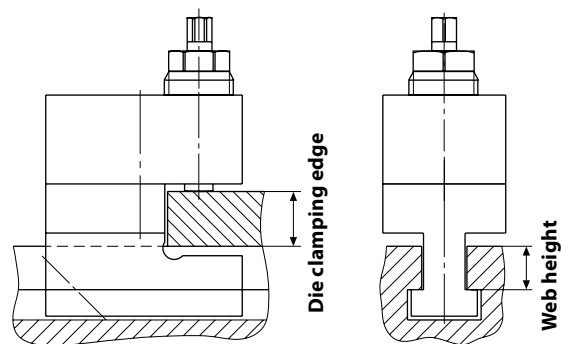
T-slot DIN 650 (mm)	18	22	28
Clamping force (kN)	40	40	80
Clamping stroke (mm)	1,5	1,5	2,2
Max. tightening torque (Nm)	45	45	90
a (mm)	104	104	126
b (mm)	65	65	80
c (mm)	40	40	50
d (mm)	19	19	28
e (mm)	63	63	72
g (mm)	50 - 106	56 - 106	72 - 131
f min. - max. (mm)	24	32	42
h (mm)	25	30	37
i (mm)	10	14	18
k (mm)	18	22	28
l (mm)	50	50	60
m (mm)	28	35	44
n (mm)	M 36 x 3	M 36 x 3	M 48 x 3
p (mm)	21	21	27
Max. travelling path s (mm)	30	30	35
SW 1 (mm)	13	13	17
SW 2 (mm)	30	30	41
Weight (kg)	3,7	4,0	6,5
Part no.	2212-185	2212-225	2213-285

Special versions are available on request.

Example of ordering: 2212-185/ F80

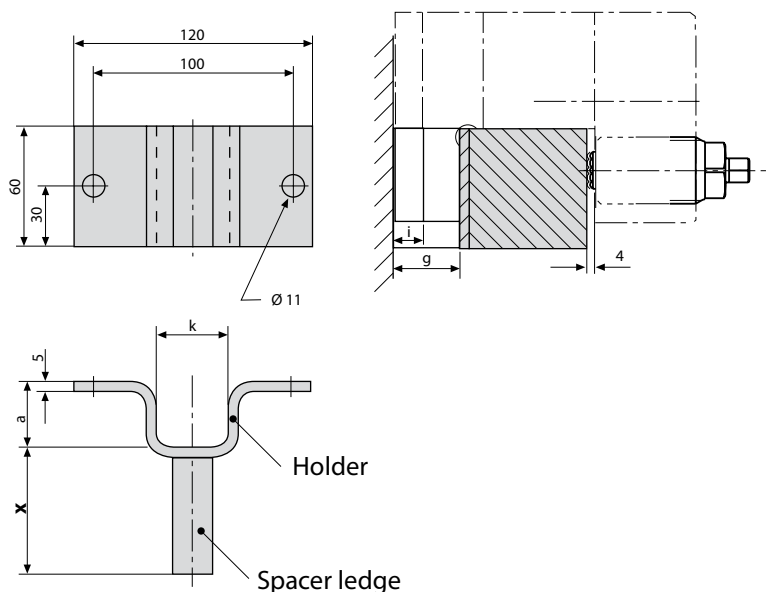


Functional dimension 'f':
die clamping edge
+ web height of T-slot
+ 4 mm
= dimension 'f'



Parking station accommodates the clamping element during die change

T-slot 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, with holder and spacer 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':
 $x = f + i - g - 4 \text{ mm}$

Dimension x to be quoted in the order