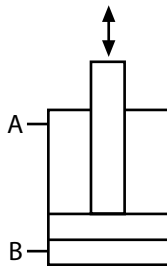


# Pull clamping element with T-slot double-acting



For power units  
please see product group 7

## Applications:

- installation in press rams
- installation in press bed
- integrated in spacer plate
- when the available space is limited

## Function:

The pull clamping element with a T-slot facilitates significantly the standardisation of dies using T-slot bars or T-nuts which are fastened to the die.

The hydraulic oil is fed either through the drilled holes in the bed and the ram or through pipes.

The tie rod and the piston are hardened and ground, and the hydraulic system is protected against dirt by wiper rings.

## Special features:

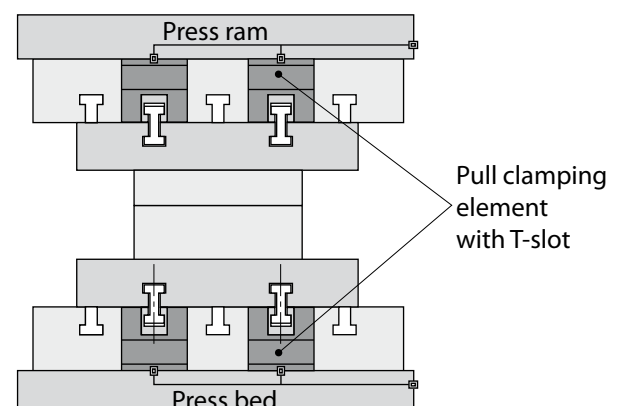
- ◆ installation directly in the bed or in the ram
- ◆ compact design
- ◆ dies are easily adaptable
- ◆ the bed and ram can also be used for manual clamping
- ◆ ideal power transmission with centrally arranged clamping elements
- ◆ optimum use of bed and ram surfaces

## Example of application:

Die clamping in a press

Ram: Clamping of the upper die using double T-slot bars

Bed: Clamping of the lower die using firmly mounted T-slot bars





## Pull clamping element with T-slot double-acting

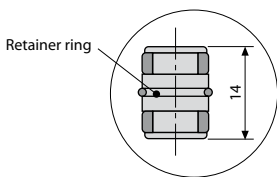
For T-slot to DIN 650	18	22	28
<b>Clamping force at 400 bar (kN)</b>	<b>55,2</b>	<b>76</b>	<b>144</b>
Clamping force at 100 bar (kN)	13,8	19	36
Piston $\varnothing l$ (mm)	70	80	105
Piston rod $\varnothing d$ H7/f7 (mm)	56	63	80
Stroke (mm)	6	6	6
Oil consumption clamping (cm <sup>3</sup> )	9	12	22
Oil consumption unclamping (cm <sup>3</sup> )	23	30	52
a (mm)	18	22	28
b (mm)	30	37	46
c e 8 (mm)	110	130	166
e (mm)	96	106	110
f (mm)	14	18	22
g (mm)	M12	M16	M20
h (mm)	21	23	27
k (mm)	111	125	135
n (mm)	15,5	19,5	25,5
o (mm)	31,1	36,2	46,7
p $\pm 0,05$ (mm)	15	15	15
Weight (kg)	6,1	9,5	16,6
<b>Connection lengthways to the T-slot</b>			
Part no.	<b>2354-060</b>	<b>2355-060</b>	<b>2356-060</b>
<b>Connection crosswise to the T-slot</b>			
Part no.	<b>2354-065</b>	<b>2355-065</b>	<b>2356-065</b>

max. operating pressure 400 bar

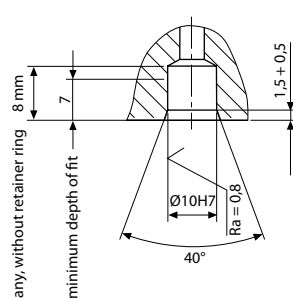
Other sizes and special versions are available on request.

### Plug-in connector for flanged connection Part no. 9210-132 (is supplied with the clamping element)

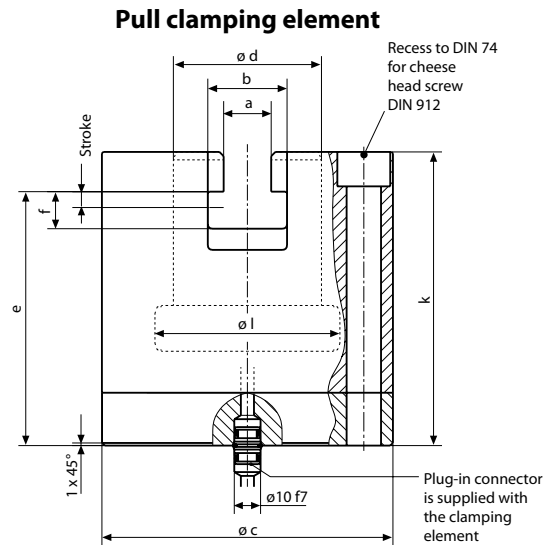
#### Plug-in connector



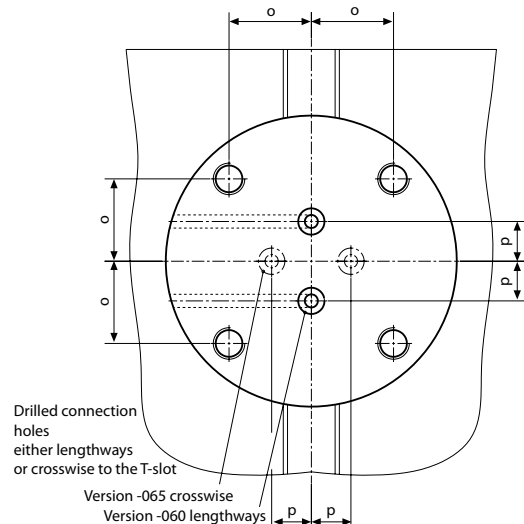
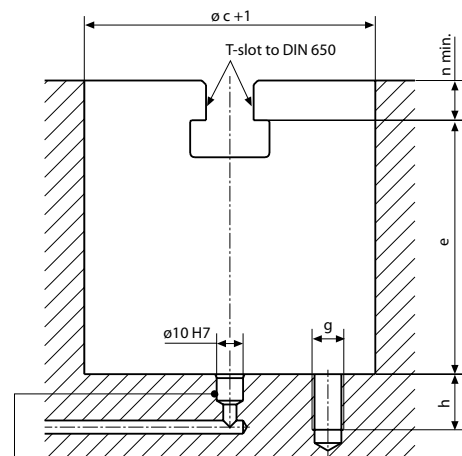
#### Accommodation space



Type of drilled connection hole for plug-in connector



#### Drilled location hole



### Important information

Make sure that the T-slot of the clamping piston is subject to an axial load only. The T-nut must be in contact over its complete surface. Transverse loads must be avoided.

In view of the surface ratio of the pull clamping elements, only check valves having a minimum ratio of 3.5 : 1 may be used for maintaining the clamping force.