

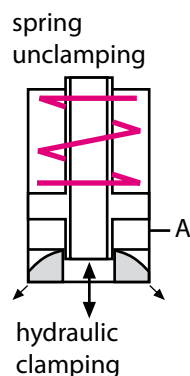
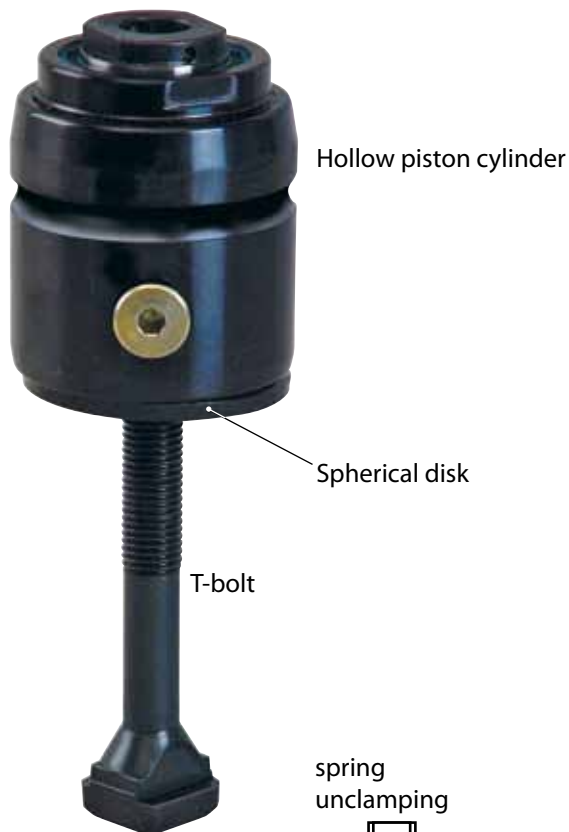
Hollow piston cylinder, single-acting

• hydraulic clamping • spring unclamping



ROEMHELD

HILMA ■ STARK



Applications:

- on press beds and rams
- on machines and equipment for clamping and locking
- when the available space is limited
- when temperatures may reach 120° C

Function:

The sliding clamp is manually placed on the clamping edge of the die. The die is clamped by applying hydraulic pressure to the piston and mechanically unclamped by spring return.

The T-bolt clamps the die on the clamping surface of the press ram or bed.

Special features:

- Spherical disk for optimum adaptation to the clamping surface
- T-bolt, pinned
- ideal power transmission
- convenient and compact design with gripping surface
- clamping force of between 60 and 104 kN
- large clamping stroke
- no colliding edges, smooth die positioning
- suitable for retrofit
- hardened and ground piston
- easy fastening
- fully utilisable stroke

For power units
please refer to product group 7

For accessories
please refer to product group 11

Recommended accessories:

Angular rotary coupling

Part no. 9208-043

Hollow piston cylinders
fastened to the
press ram





Hollow piston cylinder, single-acting

• hydraulic clamping • spring unclamping

Hollow piston cylinder complete with T-bolt , adjusted and pinned

Dimension 'f' to be quoted in the order

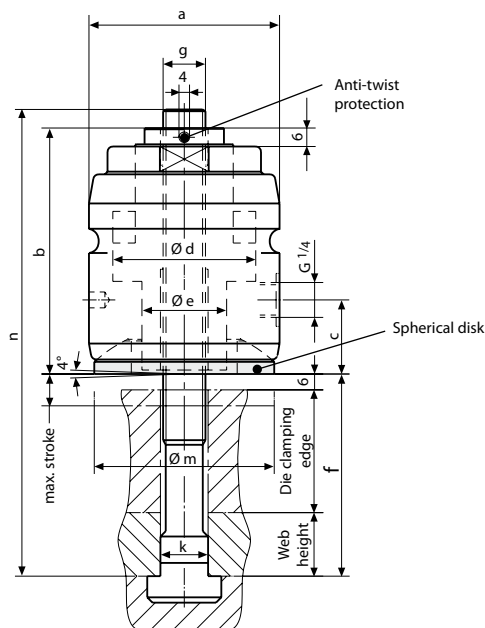
for T-slot (mm)	18	22	28	36
Clamping force at 400 bar (kN)	60	60	104*	104*
Spring return force min. (N)	320	320	570	570
Piston-Ø d (mm)	54	54	70	70
Stroke (mm)	12	12	12	12
Total oil consumption (cm³)	18	18	32	32
a (mm)	72	72	90	90
b (mm)	93	93	105	105
c (mm)	28	28	24	24
g (mm)	M 16	M 20	M 24	M 30
k (mm)	18	22	28	36
m (mm)	68	68	78	78
Weight (kg)	2,39	2,67	4,77	5,29

Part no. 8.2134.1802 8.2134.2202 8.2135.2802 8.2135.3602

max. operating pressure 400 bar *160 kN on request

Example of ordering: 8.2134.1802/ F110

Hollow piston cylinder T-slot Functional dimension
Clamping force: 60 kN 18 mm 'f' (mm)
to be quoted in the order



Hollow piston cylinder without a T-bolt

Part no.	8.2134.0102	8.2134.1102	8.2135.0102	8.2135.1102
Weight (kg)	2,1	2,09	3,67	3,49

Dimension 'f' =
die clamping edge
+ web height + ½ stroke

T-bolt, detached

for T-slot (mm)	18	22	28	36
Length n (mm)	160	200	250	250
Strength	8.8	8.8	8.8	8.8
Weight (kg)	0,29	0,58	1,10	1,8

Part no. 5700022 5700023 5700024 5700048

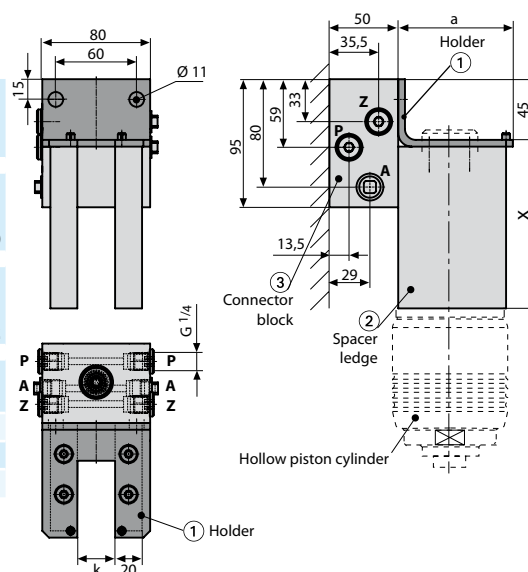
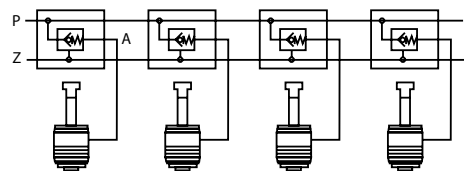
If hollow piston cylinder and T-bolt are supplied separately, adjust them to suit dimension 'f' and secure them.

Parking station which accommodates the clamping element during die change

① Complete holder (holder, spacer ledge and connector block) Part no.	8.2753.1850	8.2753.2250	8.2753.2850	8.2753.3650
① Holder with spacer ledges fastened (without a connector block) Part no.	8.2753.1830	8.2753.2230	8.2753.2830	8.2753.3630
③ Connector block with integral check valve Part no.	8.2753.4002	8.2753.4002	8.2753.4002	8.2753.4002
① Separate holder for hollow piston cylinder	2134	2134	2135	2135
Width of T-slot k (mm)	18	22	28	36
a (mm)	72	72	85	90
Part no.	2753-180	2753-220	2753-280	2753-360

Special versions are available on request

Application with integral check valve



Distance 'x':
x = dimension 'f' - ½ stroke
(to be quoted in the order)

