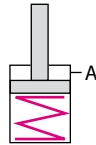


## Applications:

- for clamping dies on press bed and press slide
- when the available space is limited

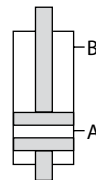


**Double-T clamping bar, single-acting with spring return, without support rollers:** usually for use in a press slide but also suitable for use in a press bed.

The double-T clamping bar is installed by pushing it into the T-slots of the press slide or the press bed in any desired position. The bar is manually secured in position using locking screws in the root of the T-slot.

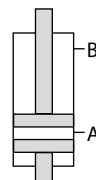
The double-T design requires T-slots in the die and in the press slide or press bed.

The clamping force is generated by applying hydraulic pressure to the pistons, and unclamping is carried out mechanically by spring return.



**Double-T clamping bar, double-acting without support rollers:** usually for use in a press ram but also suitable for use in a press bed.

Installation of the double-T clamping bar and generation of the clamping force are as described above, but with one additional clamping circuit for unclamping. The bar is automatically secured in position using locking pistons in the root of the T-slot.



**Double-T clamping bar, double-acting with support rollers for lifting and clamping:** usually for use in a press bed.

Installation and generation of the clamping force as described above, but with additional support rollers. A double-acting piston causes the support rollers to lift the die and to be clamped by a second clamping circuit. Before clamping the die is placed on the support rollers, i.e. it is not in contact with the press bed and can easily be moved in a linear direction and be positioned.

Lifting, moving, positioning and clamping uses only one element.

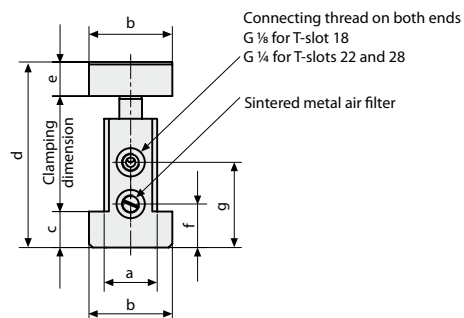
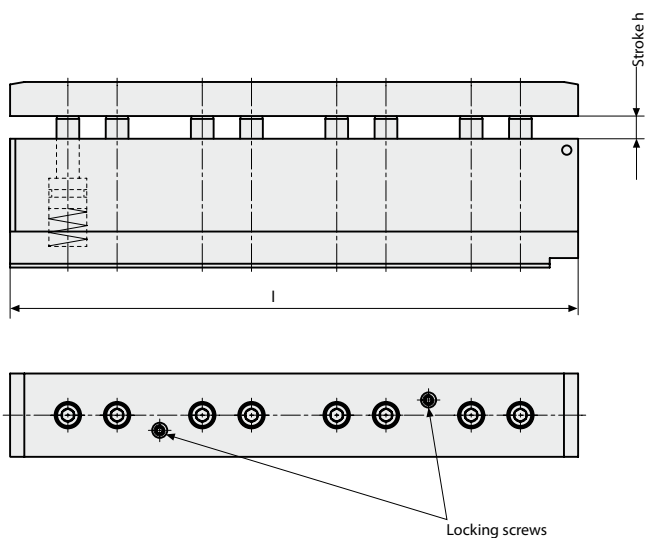
Since double-T bars are composed of modular segments, various lengths are available.

## Special features:

- ◆ max. operating pressure 400 bar, therefore no low-pressure circuit is required
- ◆ the complete clamping surface can be used
- ◆ no collision edges
- ◆ easy and quick retrofit
- ◆ ideal, uniform power transmission.



## Double-T clamping bar single-acting with spring return



	Slot a (mm)	18	22	28
b (mm)		28	35	44
c (mm)		11,5	15,0	19,0
d min (mm)		55	70	89
d max (mm)		63	80	101
e (mm)		11	15	18
g (mm)		30,5	41,0	46,0
Clamping dimension (mm)		33,5 + 6	41,0 + 8	53,0 + 10
Stroke h* (mm)		8	10	12
Max. operating pressure (bar)		400	400	400

\* Reduction of stroke on request

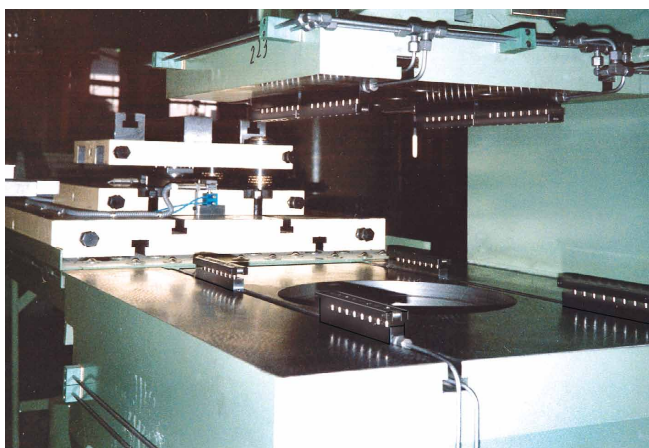
Part no.	T-slot (a) (mm)	Length (l)* (mm)	Clamping force (kN) at 400 bar	Oil consumpt. (cm <sup>3</sup> ) clamping
<b>8.1832.1810**</b>	18	150	16,6	3,3
<b>8.1832.1812</b>	18	300	33,2	6,6
<b>8.1832.1814</b>	18	450	49,8	9,9
<b>8.1832.1816</b>	18	600	66,4	13,2
<b>8.1832.1818</b>	18	750	83,0	16,6
<b>8.1832.2210**</b>	22	300	39,2	9,8
<b>8.1832.2212</b>	22	600	78,4	19,6
<b>8.1832.2214</b>	22	900	117,6	29,4
<b>8.1832.2216</b>	22	1200	156,8	39,2
<b>8.1832.2218</b>	22	1500	196,0	49,0
<b>8.1832.2810**</b>	28	300	64,0	19,3
<b>8.1832.2812</b>	28	600	128,0	38,6
<b>8.1832.2814</b>	28	900	192,0	57,9
<b>8.1832.2816</b>	28	1200	256,0	77,2
<b>8.1832.2818</b>	28	1500	320,0	96,5

\* Intermediate length dimensions and extra-long bars are available on request.

\*\* Connection thread on one end

The double-T clamping bars are composed of individual segments. When clamping or unclamping, make sure that there is an overlap of >90% of the length of the segment.

Length of the segment: T-slot 18  $\hat{=}$  150 mm  
T-slot 22  $\hat{=}$  300 mm  
T-slot 28  $\hat{=}$  300 mm

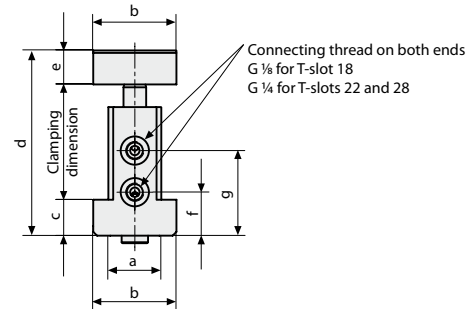
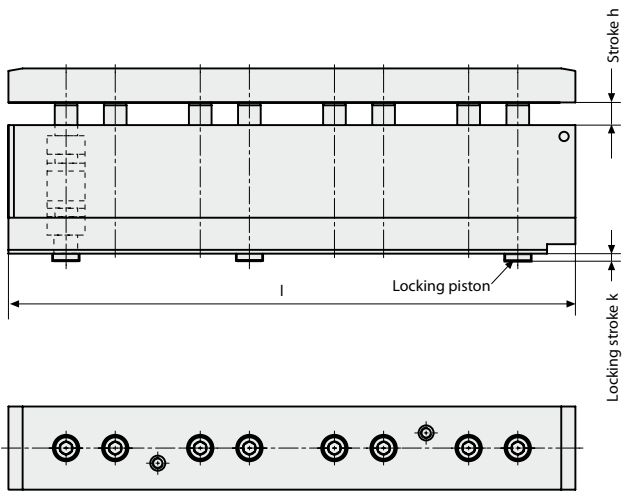


Double-T clamping bar on press bed and press slide

# Double-T clamping bar double-acting



**ROEMHELD**  
HILMA ■ STARK



Slot a (mm)	18	22	28
b (mm)	28	35	44
c (mm)	11,5	15,0	19,0
d min (mm)	55	70	89
d max (mm)	63	80	101
e (mm)	11	15	18
f (mm)	13,5	18,0	23,0
g (mm)	30,5	41,0	46,0
Clamping dimension (mm)	33,5 + 6	41,0 + 8	53,0 + 10
Stroke h* (mm)	8	10	12
Locking stroke k** (mm)	2,5	3,0	4,0
Max. operating pressure (bar)	400	400	400

\* Reduced stroke is available on request

\*\* Locking screw (see double-T bar single-acting) instead of locking piston is available on request.

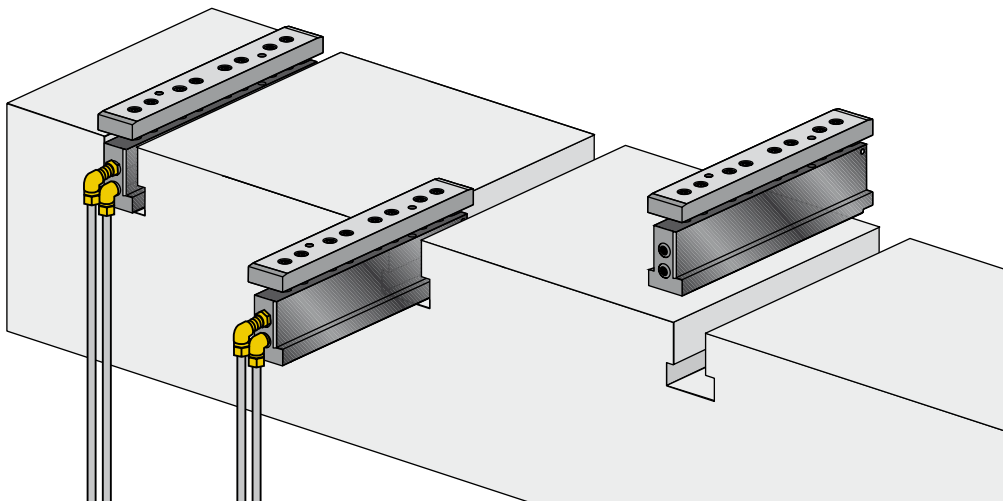
The double-T clamping bars are composed of individual segments. When clamping or unclamping, make sure that there is an overlap of >90% of the length of the segment.

Length of the segment: T-slot 18  $\hat{=}$  150 mm  
T-slot 22  $\hat{=}$  300 mm  
T-slot 28  $\hat{=}$  300 mm

Part no.	T-slot (a) (mm)	Length (l) (mm)*	Clamping force (kN) at 400 bar	Oil consumpt. (cm <sup>3</sup> ) clamping	Oil consumpt. (cm <sup>3</sup> ) unclamp.
<b>8.1832.1820**</b>	18	150	16,6	3,3	6,4
<b>8.1832.1822</b>	18	300	33,2	6,6	12,9
<b>8.1832.1824</b>	18	450	49,8	9,9	19,4
<b>8.1832.1826</b>	18	600	66,4	13,3	25,8
<b>8.1832.1828</b>	18	750	83,0	16,6	32,3
<b>8.1832.2220**</b>	22	300	39,2	9,8	20,9
<b>8.1832.2222</b>	22	600	78,4	19,6	41,8
<b>8.1832.2224</b>	22	900	117,6	29,4	62,7
<b>8.1832.2226</b>	22	1200	156,8	39,2	83,6
<b>8.1832.2228</b>	22	1500	196,0	49,0	104,5
<b>8.1832.2820**</b>	28	300	64,0	19,3	40,2
<b>8.1832.2822</b>	28	600	128,0	38,6	80,4
<b>8.1832.2824</b>	28	900	192,0	57,9	120,6
<b>8.1832.2826</b>	28	1200	256,0	77,2	160,8
<b>8.1832.2828</b>	28	1500	320,0	96,5	201,0

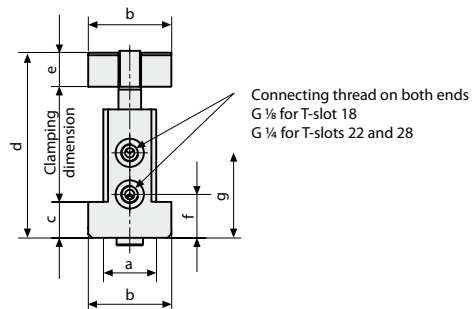
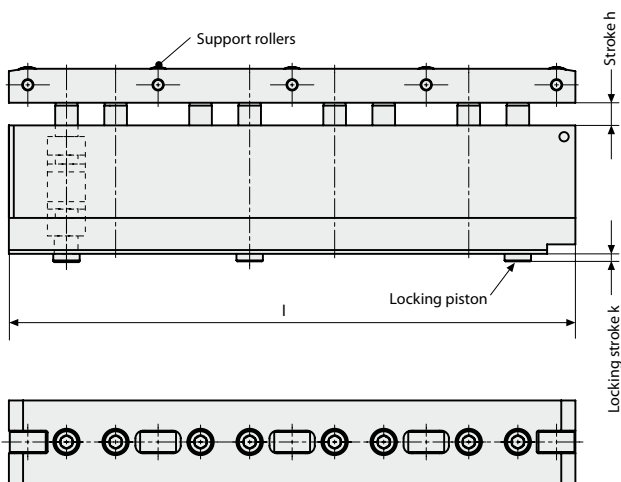
\* Intermediate length dimensions and extra-long bars are available on request.

\*\* Connection thread on one end





## Double-T clamping bar double-acting lifting and clamping



The double-T clamping bars are composed of individual segments. When clamping or unclamping, make sure that there is an overlap of >90% of the length of the segment.

Length of the segment: T-slot 18  $\hat{=}$  150 mm  
T-slot 22  $\hat{=}$  300 mm  
T-slot 28  $\hat{=}$  300 mm

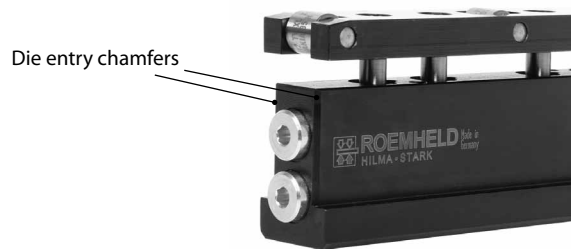
	Slot a (mm)	18	22	28
b (mm)		28	35	44
c (mm)		11,5	15,0	19,0
d min (mm)		56	71	90
d max (mm)		64	81	102
e (mm)		12	16	19
f (mm)		13,5	18,0	23,0
g (mm)		30,5	41,0	46,0
Clamping dimension (mm)		33,5 + 6	41,0 + 8	53,0 + 10
Stroke h* (mm)		8	10	12
Locking stroke k** (mm)		2,5	3,0	4,0
Max. operating pressure (bar)		400	400	400

\* Reduced stroke is available on request

Part no.	T-slot (a) (mm)	Length (l) (mm)*	Load-bearing (kN) at 400 bar	Clamping force (kN) at 400 bar	Number of support rollers	Oil consumption (cm <sup>3</sup> ) clamping	Oil consumption (cm <sup>3</sup> ) unclamp.
<b>8.1832.1830**</b>	18	150	9	16,6	3	3,3	6,4
<b>8.1832.1832</b>	18	300	18	33,2	6	6,6	12,9
<b>8.1832.1834</b>	18	450	27	49,8	9	9,9	19,4
<b>8.1832.1836</b>	18	600	36	66,4	12	13,3	25,8
<b>8.1832.1838</b>	18	750	45	83,0	15	16,6	32,3
<b>8.1832.2230**</b>	22	300	32	39,2	5	9,8	20,9
<b>8.1832.2232</b>	22	600	64	78,4	10	19,6	41,8
<b>8.1832.2234</b>	22	900	96	117,6	15	29,4	62,7
<b>8.1832.2236</b>	22	1200	128	156,8	20	39,2	83,6
<b>8.1832.2238</b>	22	1500	160	196,0	25	49,0	104,5
<b>8.1832.2830**</b>	28	300	37,5	64,0	5	19,3	40,2
<b>8.1832.2832</b>	28	600	75,0	128,0	10	38,6	80,4
<b>8.1832.2834</b>	28	900	112,5	192,0	15	57,9	120,6
<b>8.1832.2836</b>	28	1200	150,0	256,0	20	77,2	160,8
<b>8.1832.2838</b>	28	1500	187,5	320,0	25	96,5	201,0

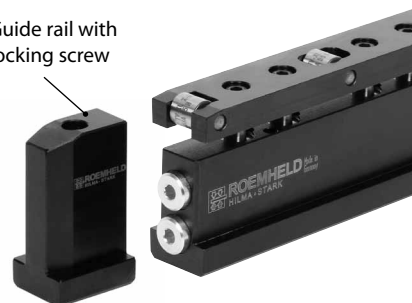
\* Intermediate length dimensions and extra-long bars are available on request.

\*\* Connection thread on one end



If the dies have a slight lateral offset when loading into the machine, the double-T clamping bars are protected by die entry chamfers at the connection end.

Guide rail with locking screw



If the lateral offset of the dies is more significant (up to 1.5 mm), or if the dies are not loaded into the machine at the connection end of the double-T clamping bars, it is recommended that separate guide rails are used. They are fastened in the T-slot using clamping bolts. Special guide bar designs are available on request (e.g. with hydraulic ports for the connection end).

Guide rail for slot T 18  
**7.1832.0015**

Guide rail for slot T 22  
**7.1832.0016**

Guide rail for slot T 28  
**7.1832.0017**