

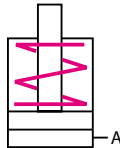
## Built-in piston, single-acting with spring return



**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:

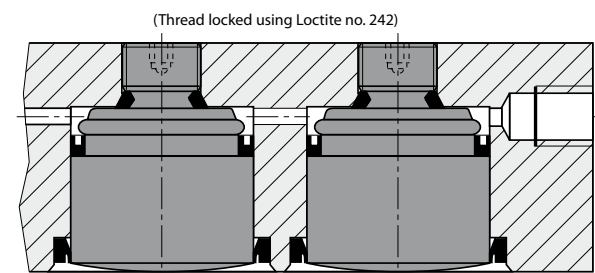
- ◆ low installation height
- ◆ very compact design
- ◆ extremely low overall height, despite pull-back spring and fully utilisable stroke
- ◆ easily replaceable
- ◆ high power density

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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## Built-in piston, single-acting with spring return

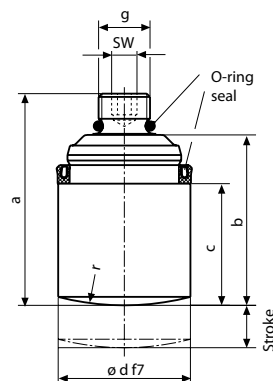
Clamping force at 250 bar (kN)	12,25	20	31,25	48,75
Clamping force at 100 bar (kN)	4,9	8	12,5	19,5
Min. spring return force (N)	130	200	230	400
Piston Ø d (mm)	25	32	40	50
Stroke (mm)	8	8	8	12
Total oil consumption (cm³)	4	7	10	24
a (mm)	40	47	50	75
b (mm)	32,5	34,5	36	56
c (mm)	23,5	25	26	43
e (mm)	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
<b>Part no.</b>	<b>1072-010</b>	<b>1073-010</b>	<b>1074-010</b>	<b>1075-020</b>
<b>Wiper ring Part no.</b>	<b>5700-001</b>	<b>5700-002</b>	<b>5700-003</b>	<b>5700-004</b>
<b>Set of seals Part no.</b>	<b>5700-005</b>	<b>5700-006</b>	<b>5700-007</b>	<b>5700-008</b>
<b>Mounting sleeve Part no.</b>	<b>5700-009</b>	<b>5700-010</b>	<b>5700-011</b>	<b>5700-012</b>

max. operating pressure 250 bar

### Please note

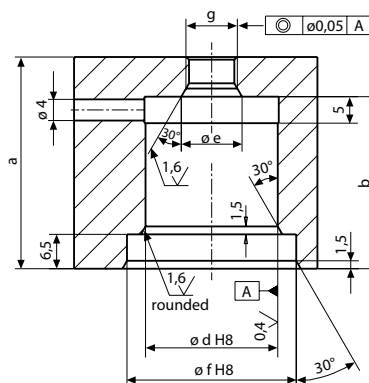
Lateral forces should be less than 5% of clamping forces.  
To ensure perfect operation, the installation dimensions and surface qualities must be strictly observed.  
Use an Allan key for assembly and dismantling.  
Replace the O-ring after dismantling.  
The max. service temperature is 80°C.  
Lock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

### Built-in piston

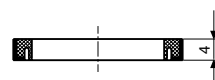


### Drilled location hole

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

