

Hollow piston cylinder, single-acting



- spring clamping
- hydraulic unclamping

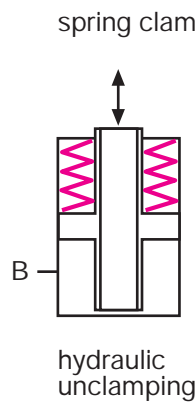


HILMA



T-bolt

Spring clamping
cylinder



spring clamping

hydraulic
unclamping

Applications:

- ▶ un-pressurised long-term clamping of dies or fixtures on press beds and rams
- ▶ when the space available is limited

Function:

Manual positioning of the cylinder on the die clamping edge. Unclamping is carried out by the application of hydraulic pressure to the piston, clamping takes place by spring power. By means of the T-bolt the die is clamped against the clamping surface of the press ram or bed.

Special features:

- ▶ Hydraulic supply is only required for unclamping, i.e. for a short time
- ▶ Ideal power transmission
- ▶ Convenient and compact design with gripping surface
- ▶ No colliding edges, smooth die positioning
- ▶ Suitable for retrofit
- ▶ Easy fastening

For suitable **power units**,
please refer to product group 7,
for accessories,
please refer to product group 11

Recommended accessory:
Angular rotary coupling
part no. 9208-043



HILMA

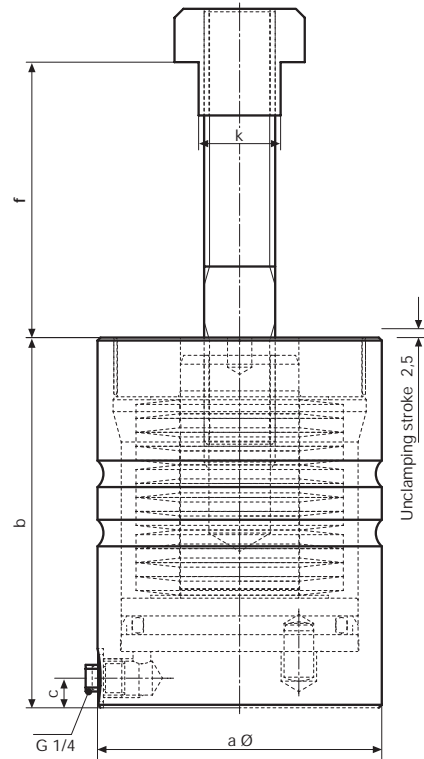
Hollow piston cylinder, single-acting



- spring clamping
- hydraulic unclamping

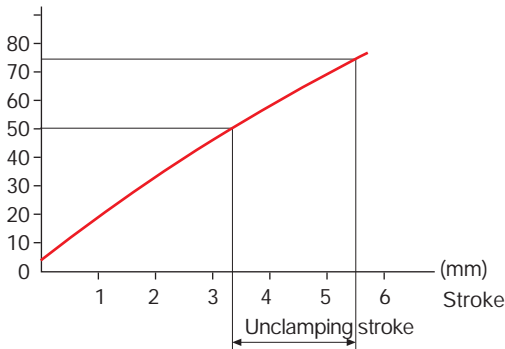
Spring clamping cylinder, complete with adjusted and secured T-bolt
Dimension 'f' to be quoted in the order

For T-slot	(mm)	22	28
Clamping force	(kN)	50	50
Unclamping pressure	(bar)	175	175
Unclamping stroke	(mm)	2,5	2,5
Oil consumption/1 mm of stroke	(cm ³)	5	5
a	(mm)	96	96
b	(mm)	125	125
c	(mm)	10	10
k	(mm)	22	28
Weight	(kg)	6,8	7,0
Part no.		8.1403.2200	8.1403.2800



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

Clamping force
kN



Parking station during die change

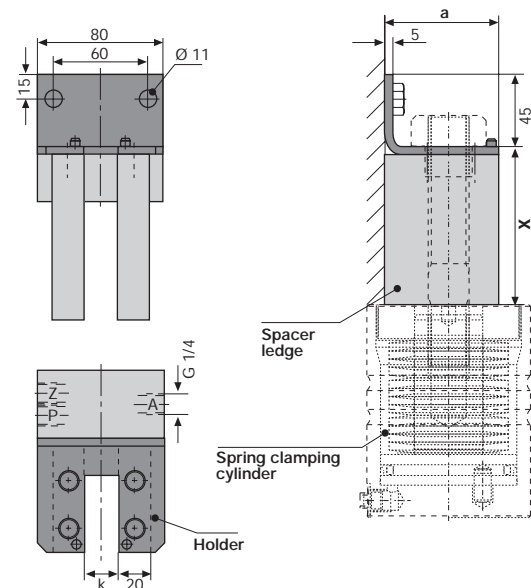
Holder with spacer ledges fastened
 (without a connector block)

Part no.	8.2753.2230	8.2753.2830
----------	-------------	-------------

Separate holder

for spring clamping cylinder	2134-110	2135-010
Width of T-slot k (mm)	22	28
a (mm)	72	85
Part no.	2753-220	2753-280

Special versions are available on request



Distance 'x':

x = dimension 'f' - 4 mm
 (to be quoted in the order)

3.1403

03/2006

Hilma-Römheld GmbH

Schützenstraße 74 · D-57271 Hilchenbach

Phone +49 (0) 2733 / 281-0 · Fax +49 (0) 2733 / 281-113 · www.hilma.de

Subject to technical modification