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## Tower

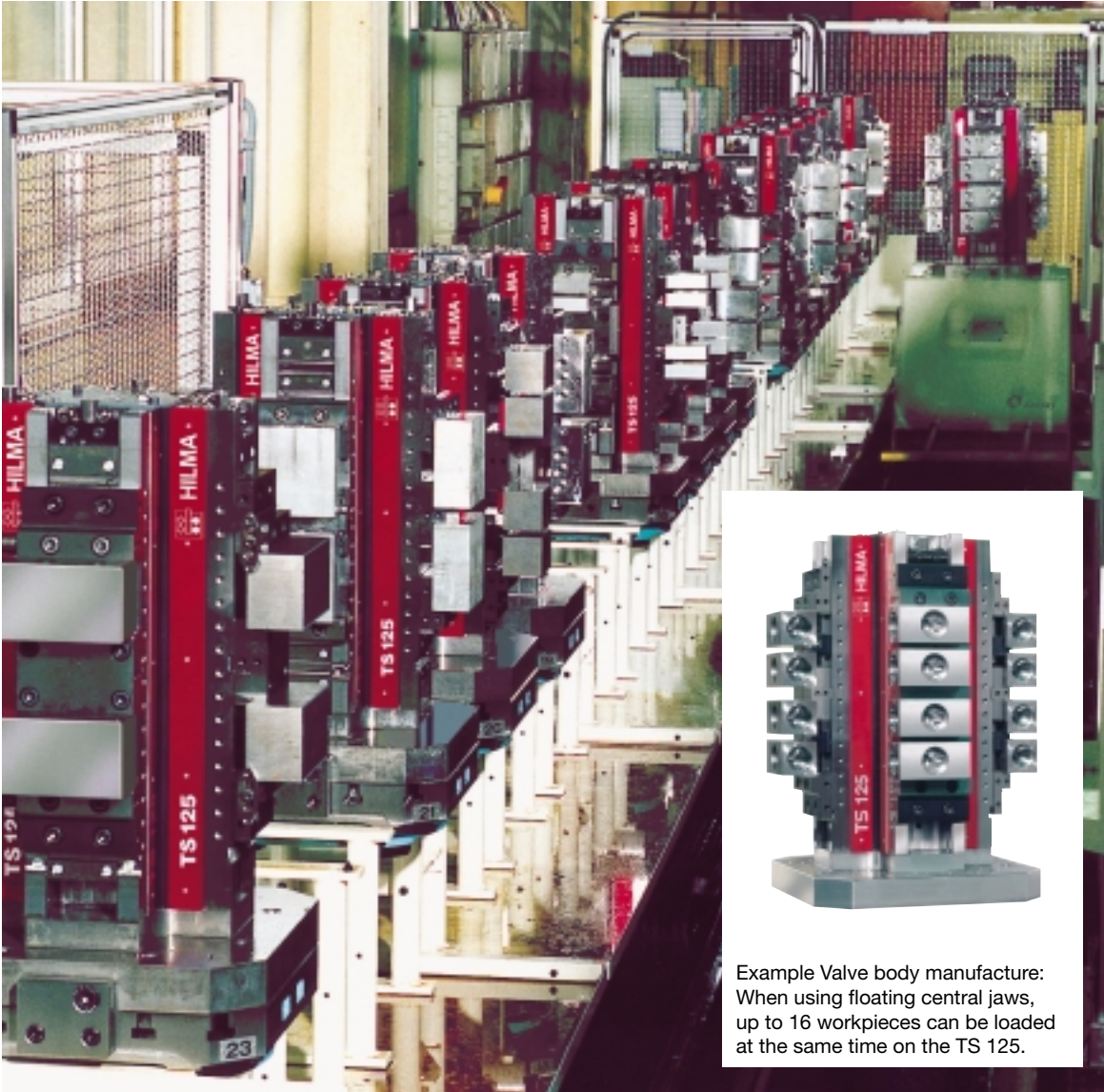
Product line TS





## Tower Clamping System TS

Ideal for use in flexible manufacturing systems with pallet storage.



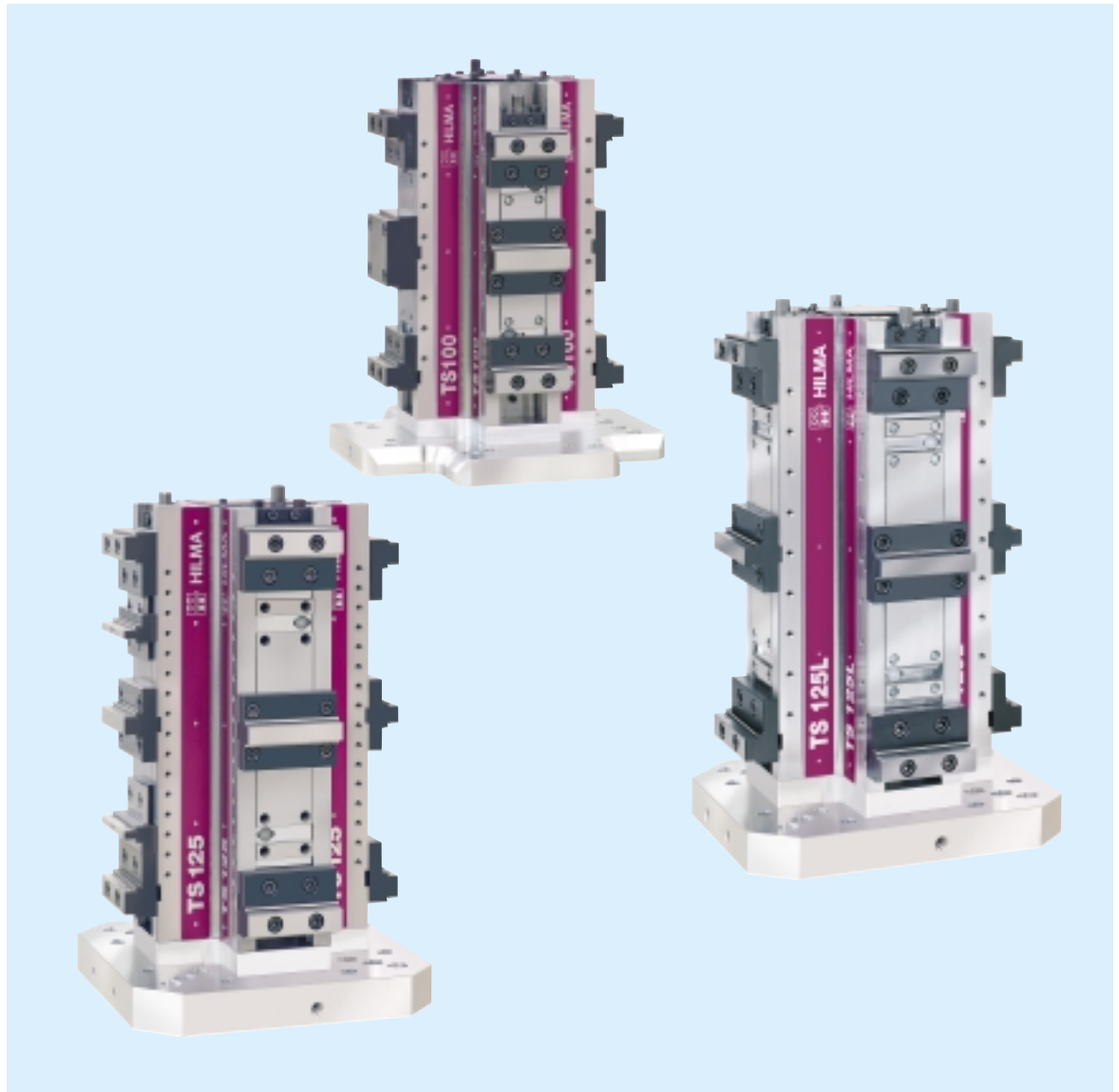
Example Valve body manufacture:  
When using floating central jaws,  
up to 16 workpieces can be loaded  
at the same time on the TS 125.

Rapid and safe multiple clamping on two levels in horizontal machining centres. User-friendly loading and unloading of workpieces thanks to the “third hand function”.

The solid one-piece design of the steel tower and a base plate made from high-tensile aluminium guarantee maximum precision and stability.

TS is the universal clamping system, designed to suit a large number of positioning and clamping applications in flexible production.

- ◆ When using a floating central jaw, up to 16 workpieces can be loaded
- ◆ Absolutely safe manual clamping without need for a hydro unit (up to 40 kN per clamping point); precisely adjustable clamping forces
- ◆ Complete shielding of the spindle area is achieved by a low tolerance slide guide and mechanical sealing edges.
- ◆ Rapid changeover to accommodate other workpieces
- ◆ The high concentration of workpieces avoids unnecessary travel from one workpiece to another.



For optimum adaptation to the machine tool and the workpieces tower clamping systems TS 100, TS 125 and TS 125 L are available.

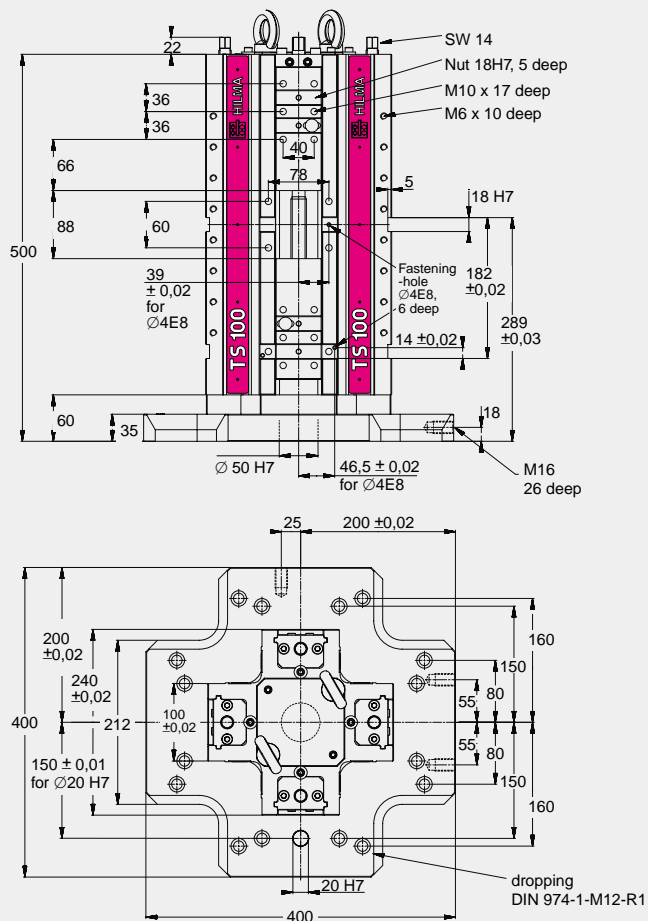
The standardized base plates made from highstrength aluminium, designed for changeable centering and fastening bolts and provided with a grid hole system as a standard feature enable individual positioning and fastening on all DIN/JIS pallets.

A high degree of user convenience is achieved by the HILMA screw fastening unit with pneumatic motor (optional extra). Clamping and unclamping is activated by a foot-operated switch so that the operator has his hands free for safely inserting and positioning even heavy workpieces.





## Technical data



### TS 100

Clamping force 25 kN/55 Nm  
 Modular grid 40/M 12  
 Modular grid 50/M 12  
 Fastening hole 50 H7  
 Reference hole 20 H7  
 Weight 105 kg

Tower made from steel  
 Base plate made from  
 high-resistant aluminium

### Torque wrench



20-120 Nm with reversible ratchet and  
 square 1/2" with ball safety lock

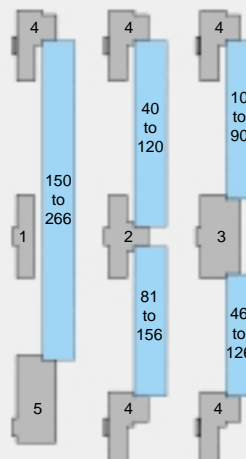
**Part-no.**  
**9.3792.6610** Torque wrench  
**1.3124.0020** Socket insert SW 14

Using standard jaws, between 4 and 8 equally  
 or differently sized workpieces can be clamped.

Larger clamping ranges (227 to 343 mm) can be  
 achieved using fixed reversible step jaws.

Part no. 9.3791.5311

Item	Part no.	Designation
1	9.3791.5140	Guide plate
2	9.3791.5111	Central step jaw 26 mm
3	9.3791.5121	Central step jaw 86 mm
4	9.3791.5211	Step jaw, reversible
5	9.3791.5341	Step jaw, fixed
For jaw dimensions, see page 6		

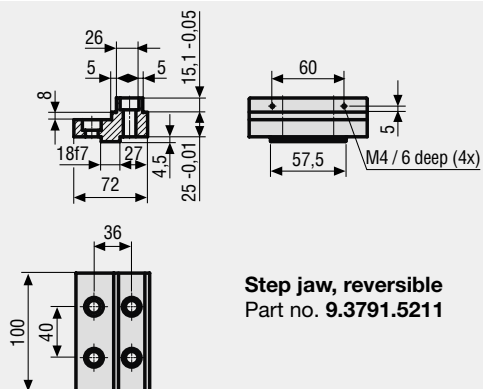




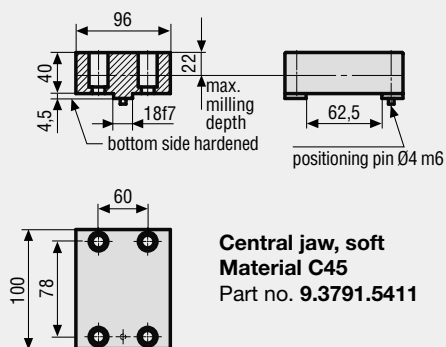




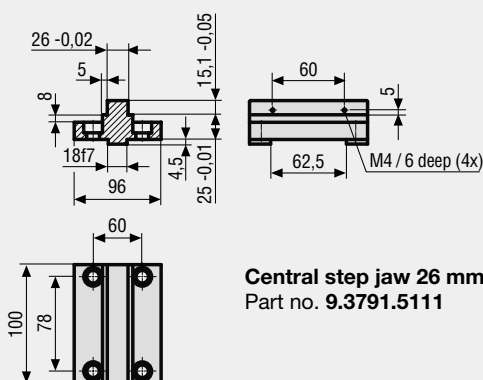
**TS 100 standard jaws** are case-hardened and ground with 8 mm steps (space for tooling and chips). Delivery including fastening screws.



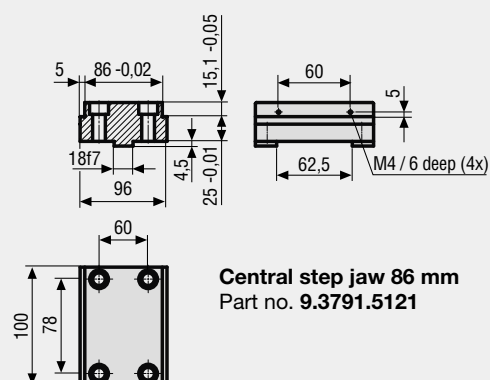
**Step jaw, reversible**  
Part no. 9.3791.5211



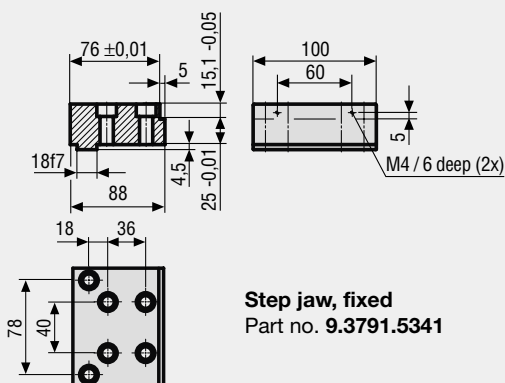
**Central jaw, soft**  
**Material C45**  
Part no. 9.3791.5411



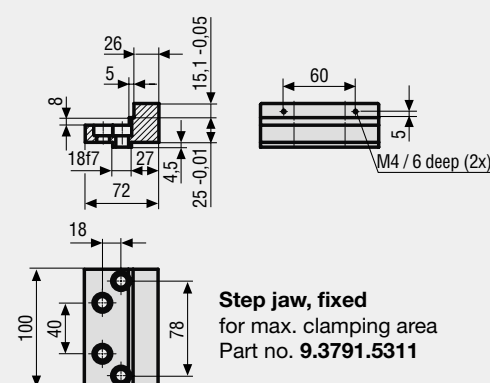
**Central step jaw 26 mm**  
Part no. 9.3791.5111



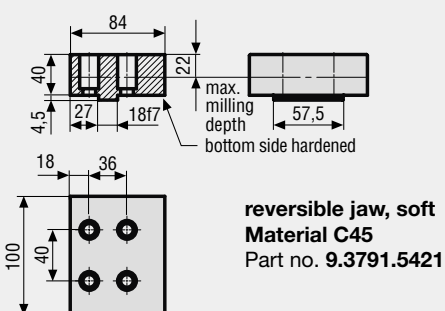
**Central step jaw 86 mm**  
Part no. 9.3791.5121



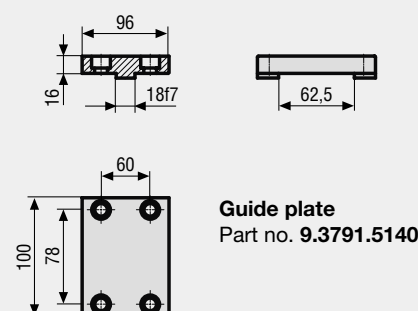
**Step jaw, fixed**  
Part no. 9.3791.5341



**Step jaw, fixed**  
for max. clamping area  
Part no. 9.3791.5311



**reversible jaw, soft**  
**Material C45**  
Part no. 9.3791.5421



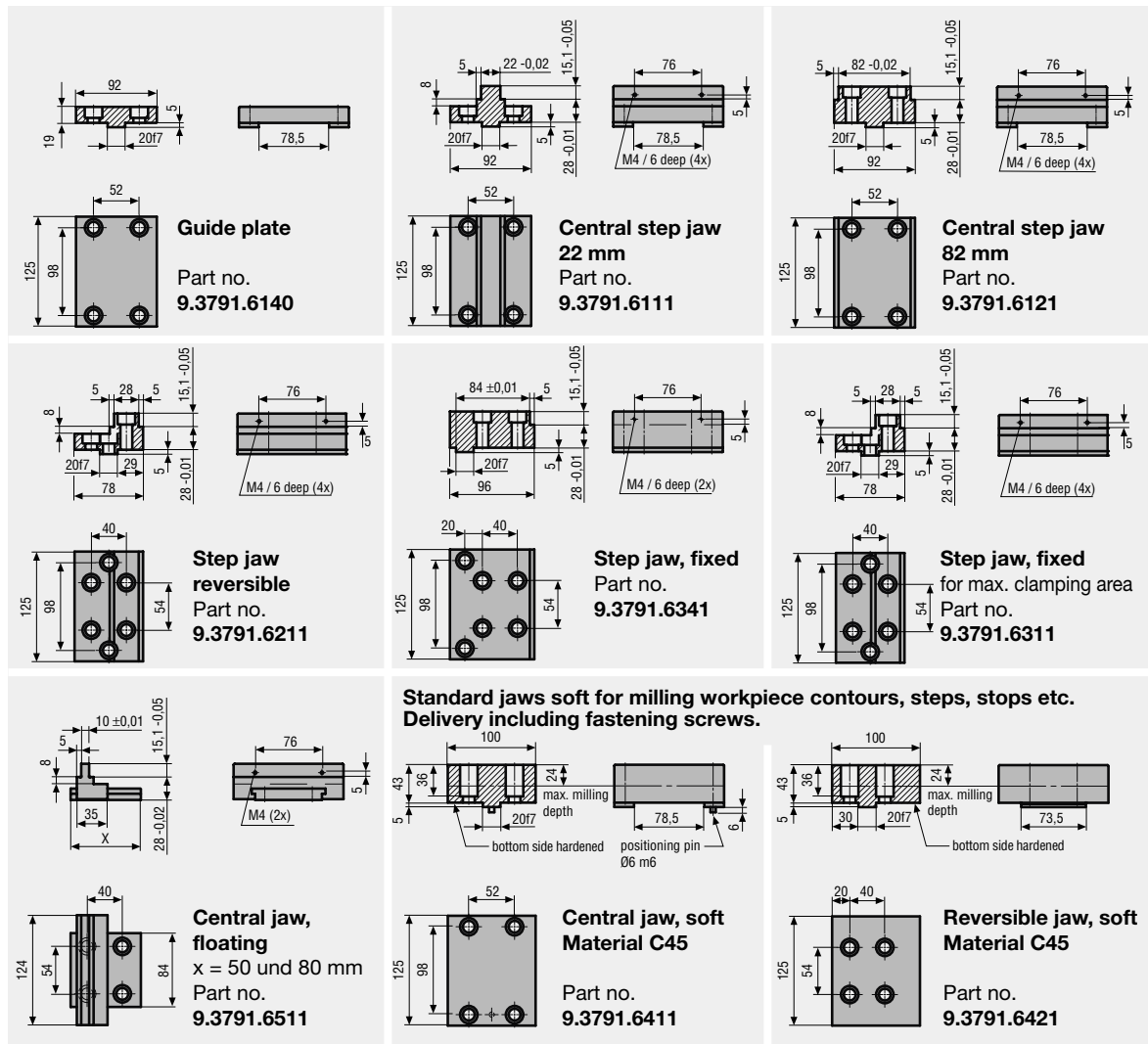
**Guide plate**  
Part no. 9.3791.5140

fastening holes of all jaws DIN 974-1-M10-R1

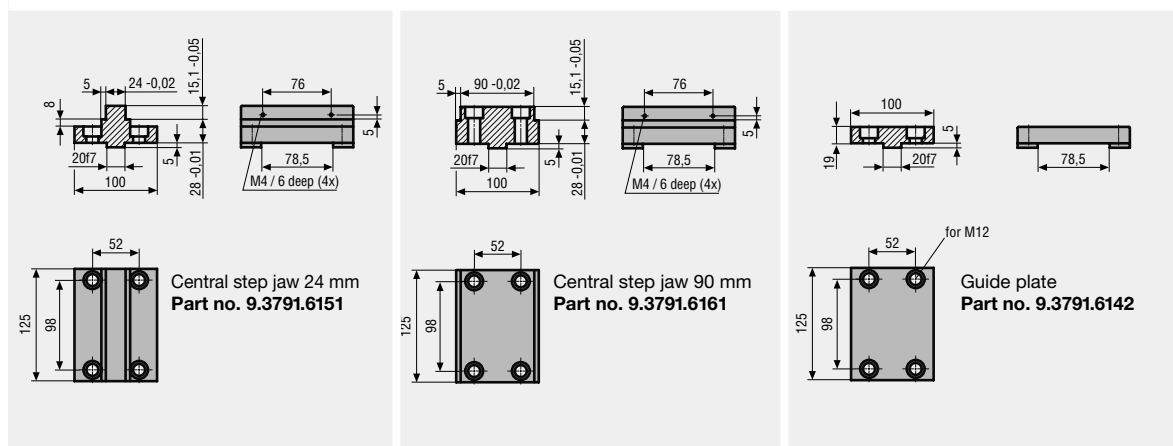
On request, all clamping jaws can be supplied with a special coating to achieve a high coefficient of friction.



**TS 125 standard jaws** are case-hardened and ground with 8 mm steps (space for tooling and chips) Delivery including fastening screws.



**TS 125 L standard jaws**, are case-hardened and ground with 8 mm steps (space for tooling and chips). Delivery including fastening screws.



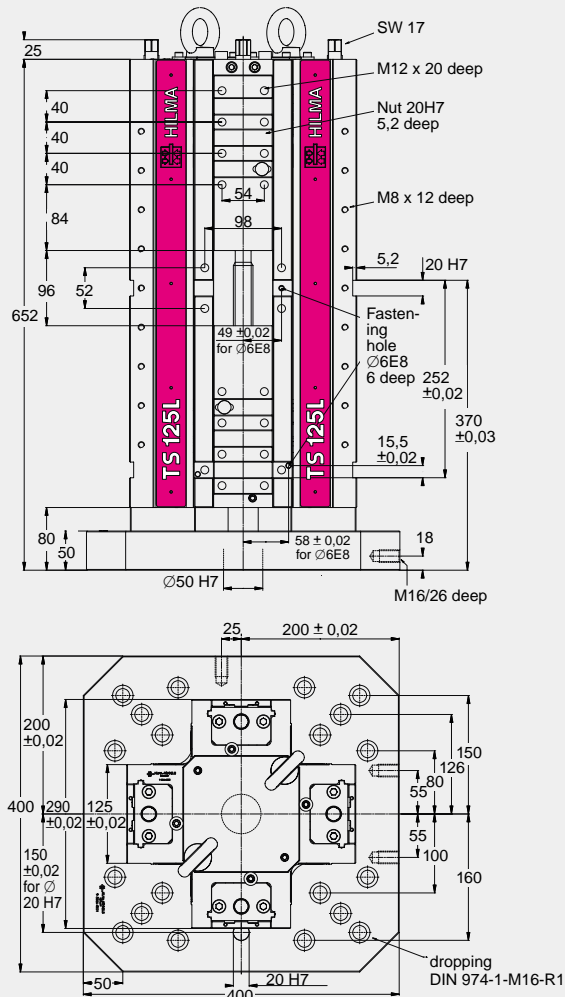
On request, all clamping jaws can be supplied with a special coating to achieve a high coefficient of friction.

fastening holes of all jaws DIN 974-1-M12-R1



# HILMA

## Tower Clamping System TS 125 L



### TS 125 L

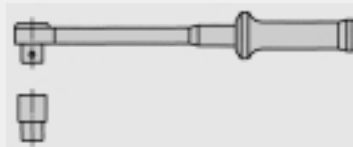
**Characteristics  
as design TS 125, but enlarged  
clamping ranges**

Clamping force 40 kN/115 Nm  
Modular grip 40/M 12  
Modular grip 50/M 16  
Modular grip 63/M 16  
Fastening hole 50 H7  
Reference hole 20 H7  
Weight 206 kg

Tower made from steel  
Base plate made from  
high-resistant aluminium

**Part no. 9.3366.0301**

### Torque wrench



20-120 Nm with reversible ratchet  
and square 1/2" with ball safety lock

**Part no.**  
**9.3792.6610** Torque wrench  
**1.3124.0017** Socket insert SW 17

Bushes for cylinder screw  
M12 inclusive.

Using standard jaws, between 4 and 16 equally  
or differently sized workpieces can be clamped.

Larger clamping ranges (348 to 476) can be  
achieved using fixed reversible step jaws.  
Part no. **9.3791.6311**

Item	Part no.	Designation
1	9.3791.6142	Guide plate
2	9.3791.6151	Central step jaw 24 mm
3	9.3791.6161	Central step jaw 90 mm
4	9.3791.6211	Step jaw, reversible
5	9.3791.6351	Step jaw, fixed
6	9.3791.6511	Central jaw, floating

For jaw dimensions, see page 7

