

Power unit, compact 100 - 400 bar



Power unit especially for use with hydraulic roller and ball bars

Supplied as a compact unit, ready for use. The power unit operates intermittently under automatic pressure control, i.e. when the set pressure is reached the motor is automatically switched off.

If pressure drops 10% below the set value the pressure switch causes the motor to start again.

Possible equipment:

Pressure relief valve

Pressure switch (with and without)

Remote control pendant

Oil level and temperature switch

Part no.	Equipment
6231- 241	1 clamping circuit, 1 x single-acting
	with oil level and temperature switch
	with pressure relief valve and pressure switch
	with electrical controls and remote control
	pendant, with selector switch
6230- 241	1 clamping circuit, 1 x single-acting,
	set of equipment as above but:
	without oil level and temperature switch

Air hydraulic clamping pump, 100 - 400 bar



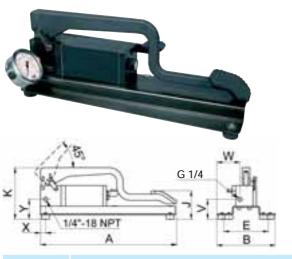
Part no.	Equipment
8.4550.0005	For an operating pressure of 100 bar 1 circuit for ball bars
8.4550.0006	For an operating pressure of 400 bar 1 circuit for roller bars

For other details, see product group 7

For other compact power units and clamping pumps, please see product group 7



Foot-operated pump, 100 - 400 bar



Part no.	Dimensions in mm								
	A B E J K V X Y						Υ	W	
8.4550.0004	400	170	130	56 - 350	165	57	15	57	65

Special features:

- Foot-operated pump of lightweight construction, low weight, low pedal-actuating force required
- Easy maintenance and operation using an externally adjustable pressure relief valve
- ★ Laterally fitted pressure gauge suitable for up to 700 bar
- ⇒ Bottom made from steel sheet with rubber feet which may be removed, e.g. when screw-fastening the pump

Technical data:

Max. operating pressure: 100 - 400 bar (adjustable)

Delivery per stroke : 2.2 cm³
Pedal-actuating force : 490 N
Tank volume : 0.24 litres
Useful volume : 0.19 litres
Weight : approx. 3.5 kg



Hilma-Romheld hand pump with manual operation and flanged connection for use on a press bed

Hydraulic hand pump 100 - 400 bar

Especially designed for use in combination with hydraulic roller or ball bars for lifting dies during a die change.

Special features:

- lifting and lowering of the bars using only one lever
- pressure relief valve infinitely variable
- optionally foot operated
- compact, closed design

Part no.	Max.operating pressure (bar)	Delivery per stroke (cm³)	Usable oil volume (cm³)	Hydraulic connection	Weight (kg)
8.4550.0002	100	8	150	G 1/4	7,3
8.4550.0003	400	2	150	G 1/4	7,3



HILMA die carts make handling of heavy dies easier and ensure time-saving and accident-free handling of dies with a maximum weight of 4 tons. All carts have been designed to suit pressing and punching dies as well as injection and casting moulds. The sturdy construction ensures long service life. High stability, simple operation and low maintenance make HILMA DIE CARTS a reliable aid.

Benefits:

easy and time-saving handling of heavy dies die change in a few minutes safe handling without the risk of accidents less wear on table and die

Available versions:

of the machine

die cart, operated manually or by electric motor drive

reduction of downtime, therefore more efficient use

- · lifting using a foot pump or electro-hydraulic lifting
- dies shifted manually or using an automatic loading device
- · with or without push-and-pull system
- with platform or with lifting fork (type EHS)
- · four different types of platforms
- · special equipment on request

Basic equipment of the M-type die cart: shear lifting table, folding drawbar, foot pump with precision lowering valve, braked steering rollers and Vulkollan tyres, protection against pipe break, roller table with pile-up brake. Load-bearing capacity 200-1200 kg, platform approx. 1100 x 600 (800) mm, lifting range 510 - 1800 mm.



Die cart, manually operated, **type DL** with foot pump or electro-hydraulic lifting



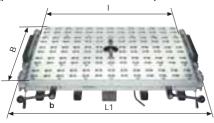
Die cart, with electric drive, type **EDL**, electrohydraulic lifting, integrated loading device

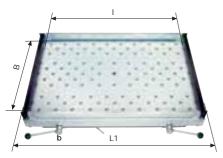


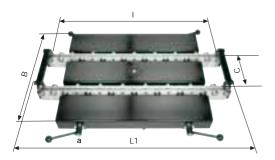
Die carts

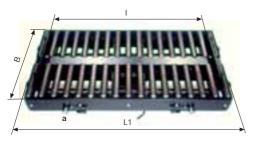
Available platforms:

(platforms to customer's specification on request)









Push-and-pull systems:



Pushing and pulling is carried out by means of a lever movement or using a centring tenon on the die cart.

Rollers

Туре	Load-bearing	L1	- 1	В	
	capacity kg	mm	mm	mm	
2L	2500	1100	1010	690	
4L	2500	1400	1310	960	

b Lowering device

Balls

Тур	Load-bearing	L1	I	В	
	capacity kg	mm	mm	mm	
2U	1000	1085	1005	750	
4U	1000	1240	1115	940	

b Lowering device

Rollers

Тур	Load-bearing	L1	- 1	В	С
	capacity kg	mm	mm	mm	mm
2SA	2000	1085	1010	700	300
4SA	2000	1240	1160	800	300

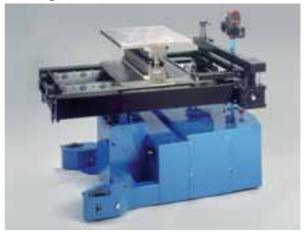
a Braking lever

Rolls

Тур	Load-bearing	L1	- 1	В	
	capacity kg	mm	mm	mm	
4R	2000	1430	1210	750	
4RV	4000	1430	1210	750	

a Braking lever

Loading device:



Loading device, with electro-hydraulic drive