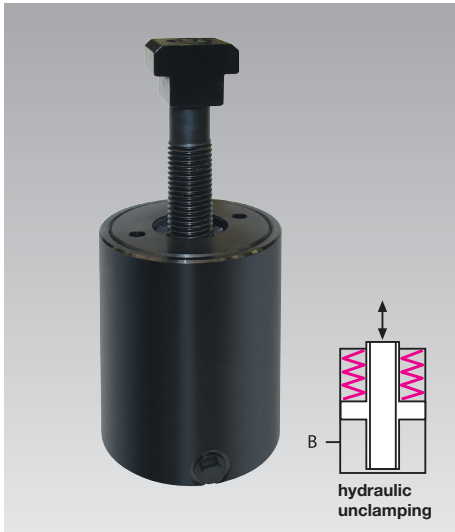


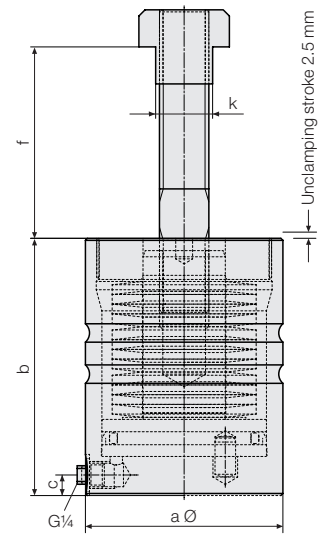


**Hollow Piston Cylinders**  
spring clamping - hydraulic unclamping  
single acting, clamping force 50 kN



**Advantages**

- Hydraulic supply is only required for unclamping, i.e. for a short time
- Ideal force transmission
- Convenient and compact design with gripping surface
- No interfering edges when inserting the dies
- Easy to retrofit
- Easy installation



**Application**

These hollow piston cylinders are used for unpressurised long-term clamping of dies or fixtures on press beds and rams. Thanks to their compact design, they can also be used where the available space is limited.

**Description**

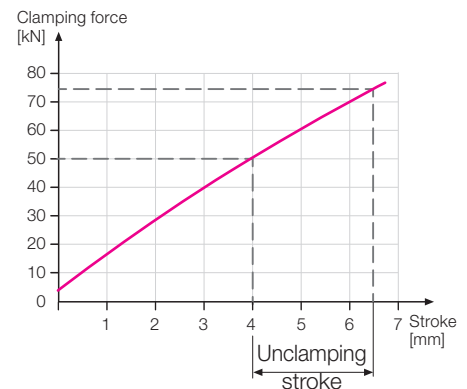
The element is manually placed on the clamping edge of the die. Unclamping by the application of hydraulic pressure to the piston and clamping by spring force. By means of the T-bolt the die is clamped against the clamping surface of the press ram or bed.

**Hollow piston cylinder, complete**

adjusted and secured with T-bolt  
Please specify dimension "f" when ordering

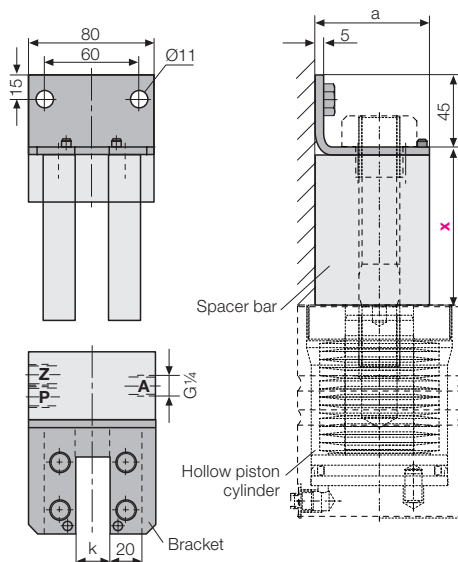
**Dimension "f" = die clamping edge + web height + unclamping stroke**

		22	28
<b>For T-slot</b>	<b>[mm]</b>	<b>22</b>	<b>28</b>
<b>Clamping force</b>	<b>[kN]</b>	<b>50</b>	<b>50</b>
f min.	[mm]	44	44
f max.	[mm]	85	81
Unclamping pressure	[bar]	175	175
Unclamping stroke	[mm]	2.5	2.5
Oil volume /1 mm stroke	[cm <sup>3</sup> ]	5	5
a	[mm]	96	96
b	[mm]	125	125
c	[mm]	10	10
k	[mm]	22	28
Weight	[kg]	6.8	7.0
<b>Part no.</b>		<b>8 1403 2200</b>	<b>8 1403 2800</b>



**Accessory**

**Parking station during die change**



**Spacing "x" = "f" - 4 mm**

**Bracket mounted with spacer bars**

(without connector block)	Part no.	8 2753 2230	8 2753 2830
T-slot width	k [mm]	22	28
	a [mm]	72	85

**Separate bracket**

Part no.	2753 220	2753 280
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Special designs on request