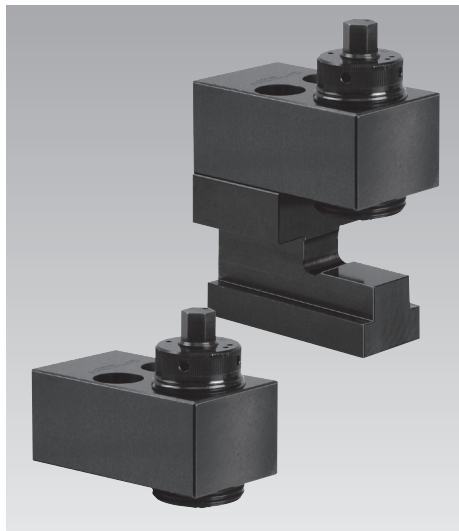


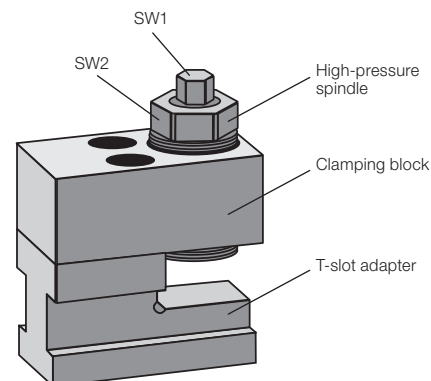


Sliding Clamps, Mechanical
with integral high-pressure spindle
clamping force 40 and 80 kN



Advantages

- Easy to retrofit
- Temperature resistance up to 250 °C
- Compact design
- Simple operation
- High clamping force with low torque
- Clamping force 40 kN and 80 kN
- Large clamping edge tolerances are possible
- Self-locking due to patented wedge system
- Die standardisation with regard to the width and depth is not required



Application

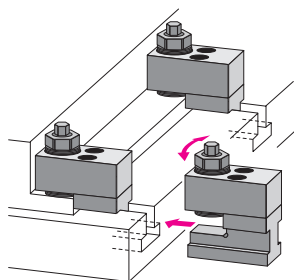
- Clamping and locking of dies on press bed and ram
- On machine tool tables
- When the available space is limited

Description

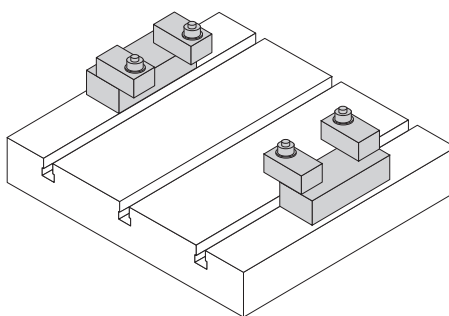
The sliding clamp is manually placed in the T-slots and screwed against the die clamping edge. Once the high-pressure spindle has been adjusted to suit the height of the clamping edge, the clamping force is built up by turning the hexagon nut (SW 1) in a clockwise direction. The clamping force achieved depends on the set tightening torque of the torque wrench.

The clamping block can also be directly screwed without T-slot adapter and can be ordered separately. When using the clamping block without T-slot adapter, the high-pressure spindle is to be manually screwed against the clamping edge so that there is no play.

Installation examples



Clamping block with T-slot adapter

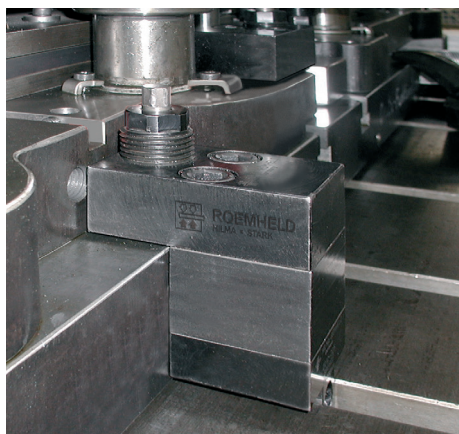


Clamping block with integral high-pressure spindle mounted on spacer bars

Important notes

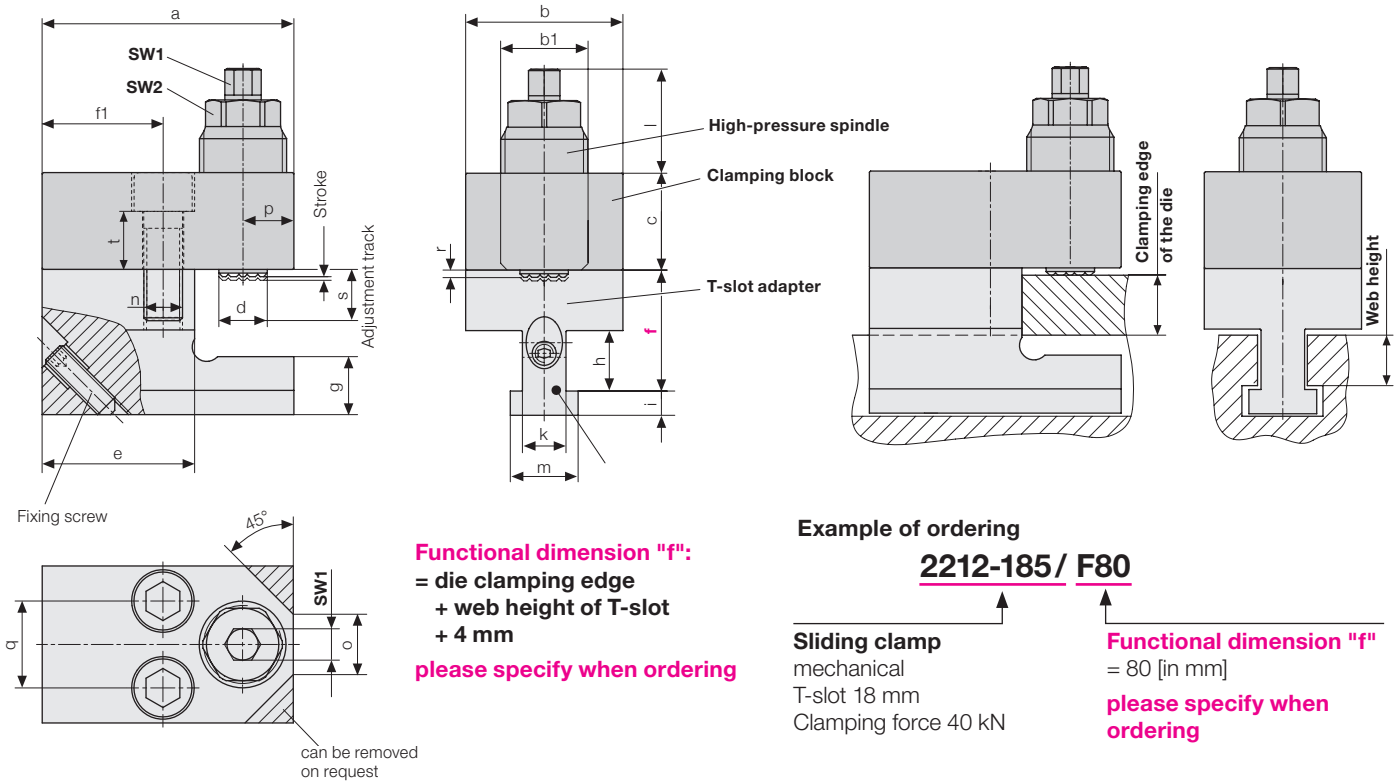
Before applying the tightening torque, the high-pressure spindle must be screwed against the clamping edge so that there is no play. If the parts are not rigid, tighten the high-pressure spindle using the hexagon nut SW2 until there is no play.

Application example



Use of mechanical sliding clamps on a machine table

Dimensions Technical data



Functional dimension "f":
= die clamping edge
+ web height of T-slot
+ 4 mm
please specify when ordering

Example of ordering
2212-185/ F80
Sliding clamp
mechanical
T-slot 18 mm
Clamping force 40 kN
Functional dimension "f"
= 80 [in mm]
please specify when ordering

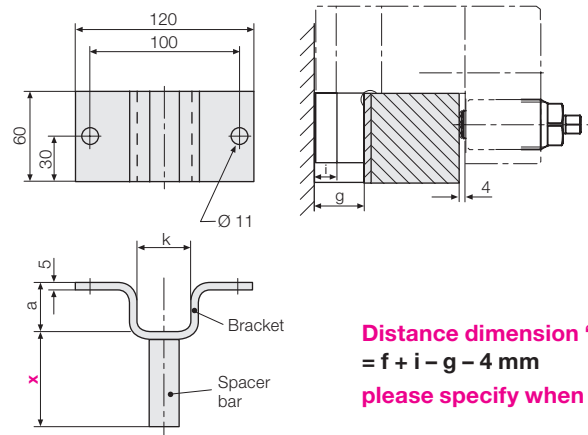
Technical data

T-slot as per DIN 650	[mm]	18	22	28
Clamping force	[kN]	40	40	80
Clamping stroke	[mm]	1.5	1.5	2.2
Max. tightening torque	[Nm]	30	30	70
Max. operating temperature	[°C]	250	250	250
a	[mm]	104	104	126
b	[mm]	65	65	80
b1	[mm]	M 36 x 3	M 36 x 3	M 48 x 3
c	[mm]	40	40	50
d	[mm]	19	19	28
e	[mm]	63	63	72
f min. - max.	[mm]	50 - 106	56 - 106	72 - 131
f1	[mm]	50	50	57
g	[mm]	24	32	42
h	[mm]	25	30	37
i	[mm]	10	14	18
k	[mm]	18	22	28
l	[mm]	50	50	60
m	[mm]	28	35	44
n (screw DIN 912, 10.9)	[mm]	M16	M16	M20
o	[mm]	24	24	30
p	[mm]	21	21	27
q	[mm]	36	36	43
r	[mm]	3	3	3
Max. adjustment track s	[mm]	30	30	35
t	[mm]	24	24	29
SW 1	[mm]	13	13	17
SW 2	[mm]	30	30	41

Clamping block with T-slot adapter				
Weight	[kg]	3.7	4.0	6.5
Part no.		2212185	2212225	2213285
Clamping block, separate				
Weight	[kg]	2.3	2.3	4.0
Part no.		2212111	2212111	2213111

Accessory

Parking station accommodates the sliding clamp during die change



Distance dimension "x"
= f + i - g - 4 mm
please specify when ordering

Part numbers

T-slot as per DIN 650	[mm]	18	22	28
a	[mm]	25	33	43
k	[mm]	30	37	46
i	[mm]	10	14	18
g	[mm]	24	32	42
Parking station complete				
with bracket and spacer bar		827541850	827542250	827542850
Bracket separate		2754180	2754220	2754280
Spacer bar separate		2754500	2754500	2754500