

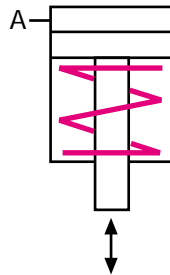


Sliding clamp single-acting



Hydraulic
clamping block

T-slot adapter



Applications:

- ▶ on press beds and rams
- ▶ on machines and equipment for clamping and locking
- ▶ when the available space is limited
- ▶ when temperatures may reach 120° C

Function:

The sliding clamp is manually placed in the T-slot provided in the press ram or bed. The die is clamped on its clamping edge by applying hydraulic pressure to the piston and mechanically unclamped by a spring return. The clamping block may also be fastened directly, without a T-slot adapter (please see product group 2, page 18).

Special features:

- ▶ Ideal power transmission
- ▶ Compact design
- ▶ Clamping force of between 19 and 78 kN
- ▶ Easy fastening
- ▶ Compensates for large clamping edge tolerances
- ▶ No colliding edges, smooth die positioning
- ▶ Suitable for retrofit
- ▶ No need for die standardisation (width and depth)

For power units

please see product group 7

For accessories

please see product group 11

Recommended accessories:

Angular rotary coupling

Part no. 9280-043

(please see page 7)

Sliding
clamps

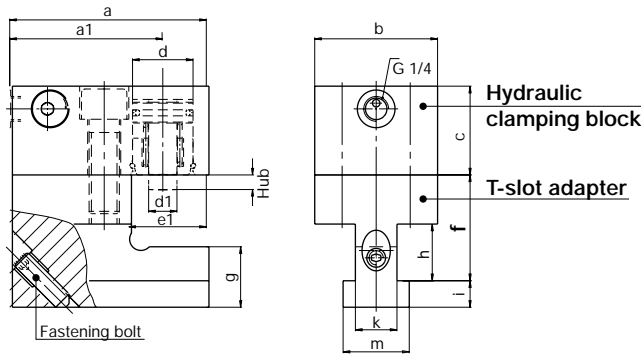


Sliding clamps fastened to bed and ram of a double column press. Dies are entered from the front using consoles.

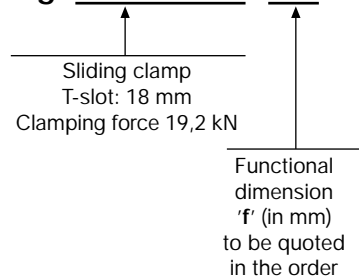
Sliding clamp single-acting



HILMA



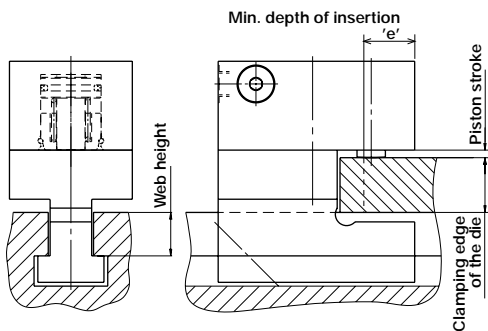
Example of ordering: **8.2202.1850/60**



Sliding clamp complete with T-slot adapter

Part no.	T-slot to DIN 650 (mm)	Clamping force at 400 bar (kN)	Stroke (mm)	Oil consumption (cm ³)	Dimensions in mm													Weight (kg)
					a	a1	b	c	d	d1	e	e1	g	h	i	k	m	
8.2202.1850	18	19,2	8	4	95	77	65	40	25	15	23	32	24	25	10	18	28	2,9
8.2202.2250	22	19,2	8	4	95	77	65	40	25	15	23	32	32	30	14	22	35	3,2
8.2203.2250	22	32	8	7	104	81	65	47	32	15	28	41	32	30	14	22	35	3,6
8.2204.2250	22	50	8	10	111	85	65	50	40	20	31	48	32	30	14	22	35	3,9
8.2203.2850	28	32	8	7	104	81	65	47	32	15	28	41	42	37	18	28	44	4,2
8.2204.2850	28	50	8	10	111	85	65	50	40	20	31	48	42	37	18	28	44	4,5
8.2205.2850	28	78	12	24	132	99	80	75	50	25	38	60	42	37	18	28	44	7,5

max. operating pressure 400 bar Please consult us if aggressive spray is used

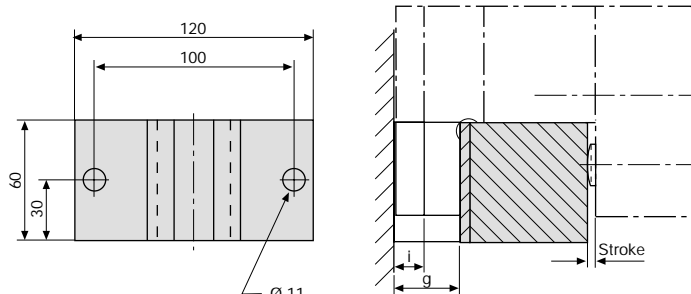


Functional dimension 'f':

1/2 stroke
+ height of die clamping edge
+ web height of T-slot
= dimension 'f'

Part no.	Dimension 'f'	
	min.	max.
8.2202.1850	50	90
8.2202.2250	56	106
8.2203.2250	56	106
8.2204.2250	56	106
8.2203.2850	56	106
8.2204.2850	62	112
8.2205.2850	67	117

Parking station accommodates the clamping element during die change



Distance 'x':

$$x = f + i - g - 1/2 \text{ stroke}$$

Dimension x to be quoted in the order

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

T-slot to DIN 650 (mm)	Parking station complete with holder and spacer ledge Part no.	Holder Part no.	spacer ledge Part no.	a mm	k mm	i mm	g mm
18	8.2754.1850	2754-180	2754-500	25	30	10	24
22	8.2754.2250	2754-220	2754-500	33	37	14	32
28	8.2754.2850	2754-280	2754-500	43	46	18	42



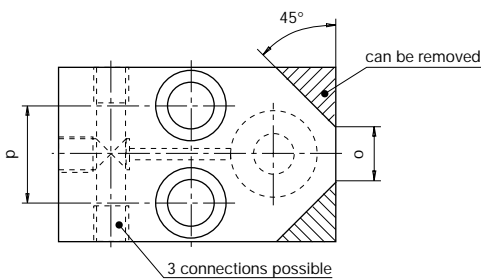
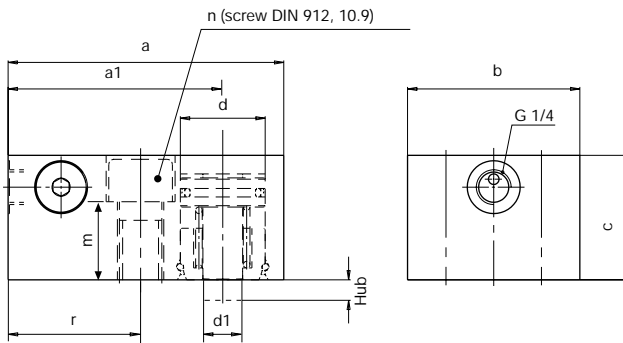
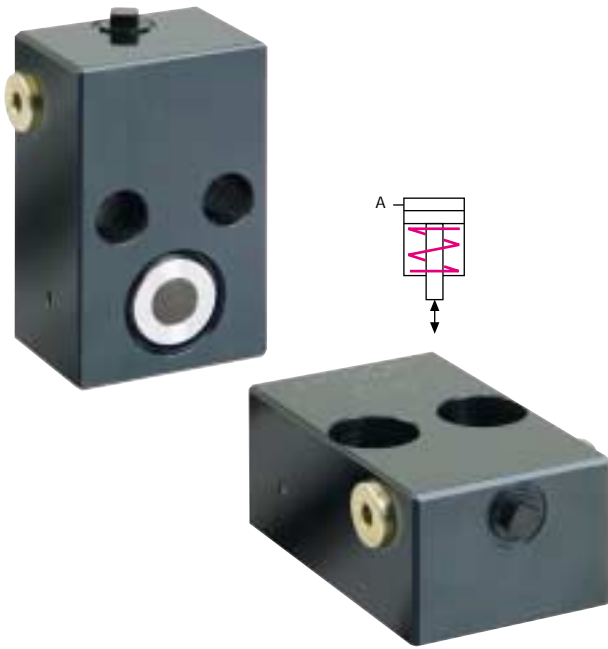
Clamping block - Sliding clamp single-acting with spring return

Applications:

- ▶ on press beds and rams
- ▶ on machines and equipment for clamping and locking
- ▶ when the available space is limited

Function:

The workpiece is clamped on its clamping edge by applying hydraulic pressure to the piston and mechanically unclamped by a spring piston return. The clamping block may be fastened by screwing it to stationary spacer ledges or in combination with a T-slot adapter for clamping workpieces in the T-slots of a press bed or ram.



For clamping block with T-slot adapter: see product group 3



Hydraulic clamping block without T-slot adapter

Part no.	Clamping force at 400 bar (kN)	Stroke (mm)	Oil consumption (cm ³)	Dimensions in mm											Weight (kg)
				a	a1	b	c	d	d1	m	n	o	p	r	
8.2202.1301	19,2	8	4	95	77	65	40	25	15	24	M16	18	36	50	1,6
8.2203.1301	32	8	7	104	81	65	47	32	15	29	M16	20	36	50	2,0
8.2204.1301	50	8	10	111	85	65	50	40	20	32	M16	20	36	50	2,3
8.2205.1301	78	12	24	132	99	80	75	50	25	53	M20	28	43	57	4,9

Max. operating pressure: 400 bar.

Fastening screws M16 or M20, DIN 912, 10.9 are not included.