



### Applications:

- ▶ for clamping and locking dies on press beds and rams
- ▶ on beds of machine tools
- ▶ when the available space is limited

### Function:

The sliding clamp is manually placed in the T-slot 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 tightening torque selected with the torque wrench

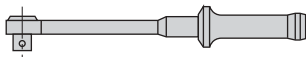
### Special features:

- ▶ Suitable for retrofit
- ▶ Compact design and easy handling
- ▶ Clamping force of between 40 and 80 kN
- ▶ High clamping force with low torque
- ▶ Compensates for large clamping edge tolerances
- ▶ No colliding edges, smooth die positioning
- ▶ No need for die standardisation (width and depth)
- ▶ Self-locking by patented wedge system

### Accessory

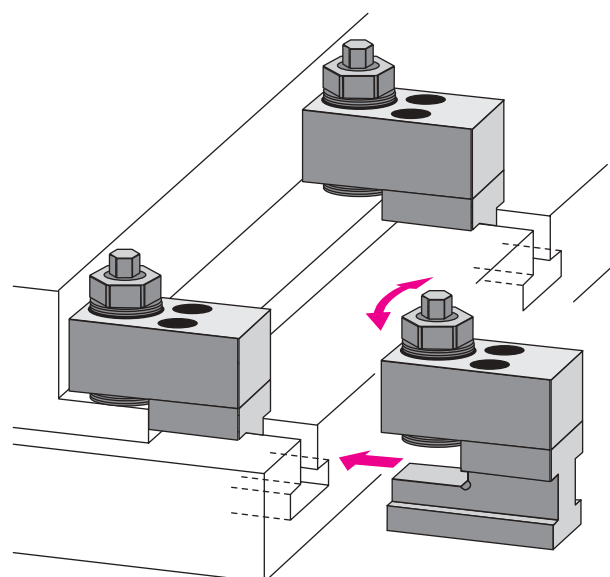
Torque wrench 20 - 100 Nm

Part no. 9.3792.6610



### Note:

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 (SW 2) until there is no play.

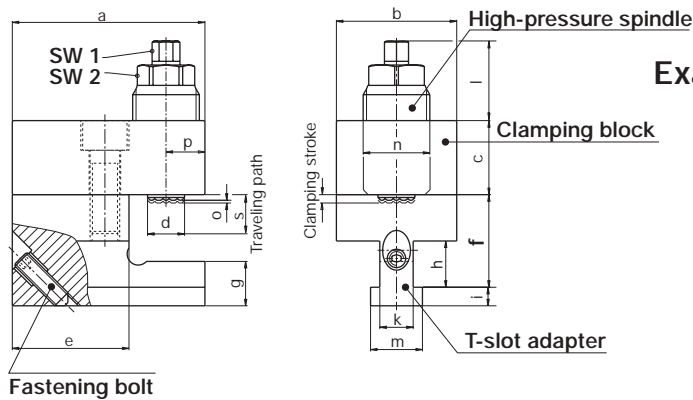


Mechanical sliding clamps fastened to a machine bed.

# Sliding clamp, mechanical with integral high-pressure spindle



# HILMA



Example of ordering: **2212.185/ 80**

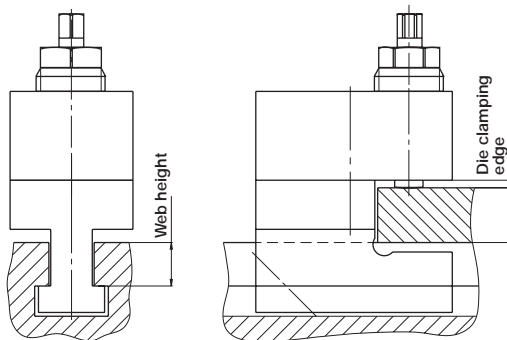
Sliding clamp,  
mechanical  
T-slot: 18 mm  
Clamping force: 40 kN

Functional dimension  
'f' = 80 (in mm)  
to be quoted in the order

Fastening bolt

Part no.	T-slot DIN 650 (mm)	Clamping force (kN)	Clamping stroke (mm)	Max. tightening torque (Nm)	Dimensions in mm													Max. travelling path		Weight (kg)	
					a	b	c	d	e	g	h	i	k	l	m	n	p	s	SW1		SW2
2212-185	18	40	1,5	45	104	65	40	19	63	24	25	10	18	50	28	M 36 x 3	21	30	13	30	3,7
2212-225	22	40	1,5	45	104	65	40	19	63	32	30	14	22	50	35	M 36 x 3	21	30	13	30	4,0
2213-285	28	80	2,2	90	116	80	50	28	63	42	37	18	28	60	44	M 48 x 3	27	35	17	41	6,5

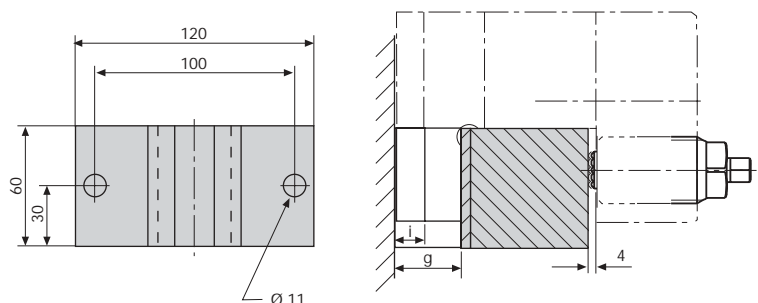
Special versions are available on request.



## Functional dimension 'f':

die clamping edge  
+ web height of T-slot  
+ 4 mm  
= dimension 'f'

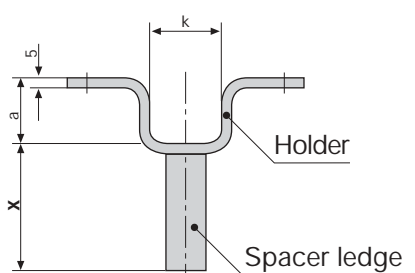
## Parking station accommodates the clamping element during die change



## Distance 'x':

$$x = f + i - g - 4 \text{ mm}$$

Dimension x to be quoted in the order



T-slot to DIN 650 (mm)	Parking station, 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