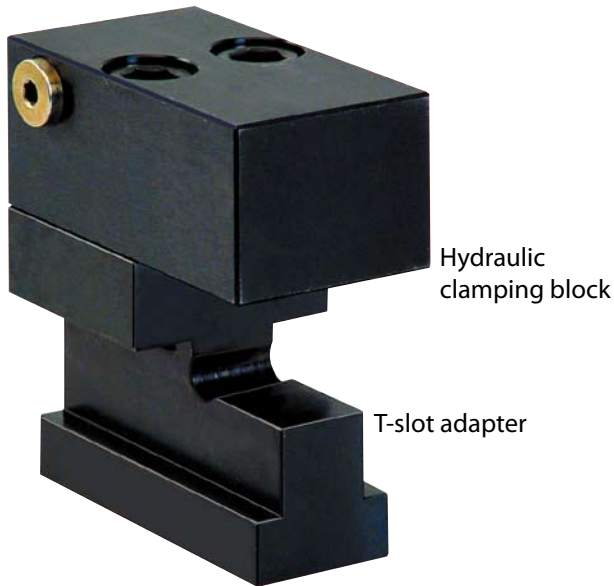


# Sliding clamp single-acting

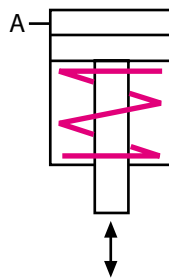


# HILMA



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.

## 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**

Sliding  
clamps

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

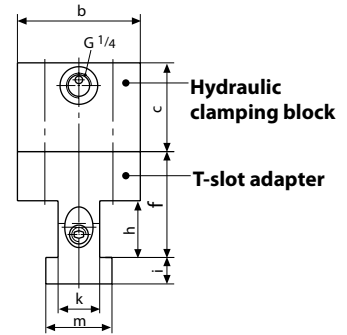
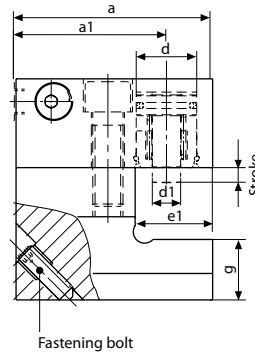




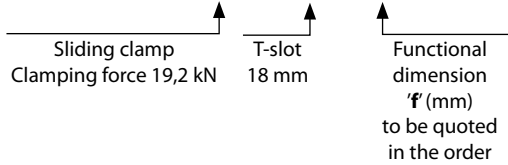
## Sliding clamp single-acting

### Sliding clamp complete

T-slot (mm)	Clamping force (kN)	Part no.	Dim. 'f' min.	Dim. 'f' max.
18	19,2	8.2202.1850	42	90
22	19,2	8.2202.2250	50	106
22	32	8.2203.2250	50	106
22	50	8.2204.2250	50	106
28	32	8.2203.2850	55	106
28	50	8.2204.2850	55	112
28	78	8.2205.2850	60	117



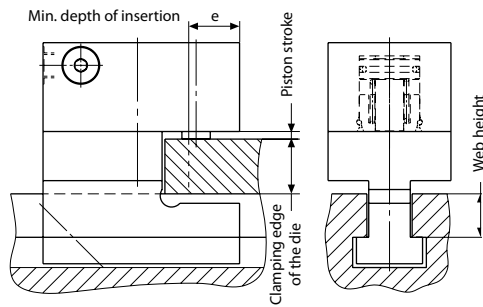
### Example of ordering: 8.2202.1850/ F60



T-Slot to DIN 650 (mm)	18	22	22	22	28	28	28
Clamping force at 400 bar (kN)	19,2	19,2	32	50	32	50	78
Stroke (mm)	8	8	8	8	8	8	12
Oil consumption (cm <sup>3</sup> )	4	4	7	10	7	10	24
a (mm)	95	95	104	111	104	111	132
a1 (mm)	77	77	81	85	81	85	99
b (mm)	65	65	65	65	65	65	80
c (mm)	40	40	47	50	47	50	75
d (mm)	25	25	32	40	32	40	50
d1 (mm)	15	15	15	20	15	20	25
e (mm)	23	23	28	31	28	31	38
e1 (mm)	32	32	41	48	41	48	60
g (mm)	24	32	32	32	42	42	42
h (mm)	25	30	30	30	37	37	37
i (mm)	10	14	14	14	18	18	18
k (mm)	18	22	22	22	28	28	28
m (mm)	28	35	35	35	44	44	44
Weight (kg)	2,9	3,2	3,6	3,9	4,2	4,5	7,5

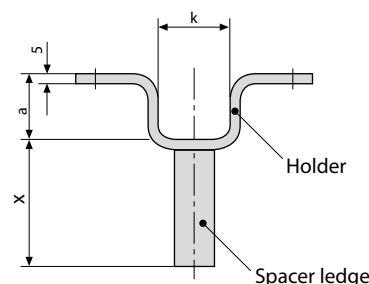
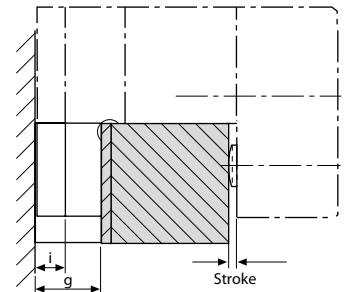
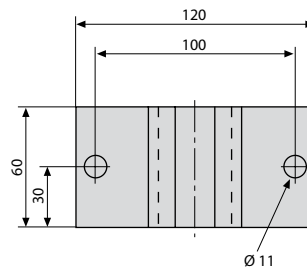
max. operating pressure 400 bar  
Please consult us if aggressive spray is used

**Functional dimension 'f':**  
 $\frac{1}{2}$  stroke  
 + height of die clamping edge  
 + web height of T-slot  
 = dimension 'f'



### Parking station accommodates the clamping element during die change

T-slot at 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
<b>Parking station complete with to DIN holder and spacer</b>			
Part no.	8.2754.1850	8.2754.2250	8.2754.2850
Holder Part no.	2754-180	2754-220	2754-280
Spacer ledge Part no.	2754-500	2754-500	2754-500



**Distance 'x':**  
 $x = f + i - g - \frac{1}{2}$  stroke

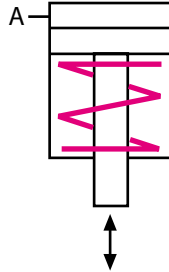
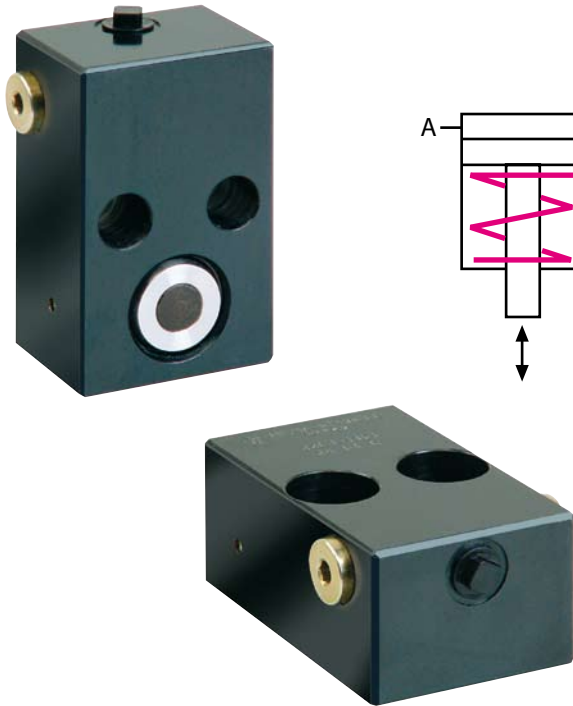
Dimension x to be quoted in the order

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

# Clamping block - Sliding clamp single-acting with spring return



**HILMA**



### Applications:

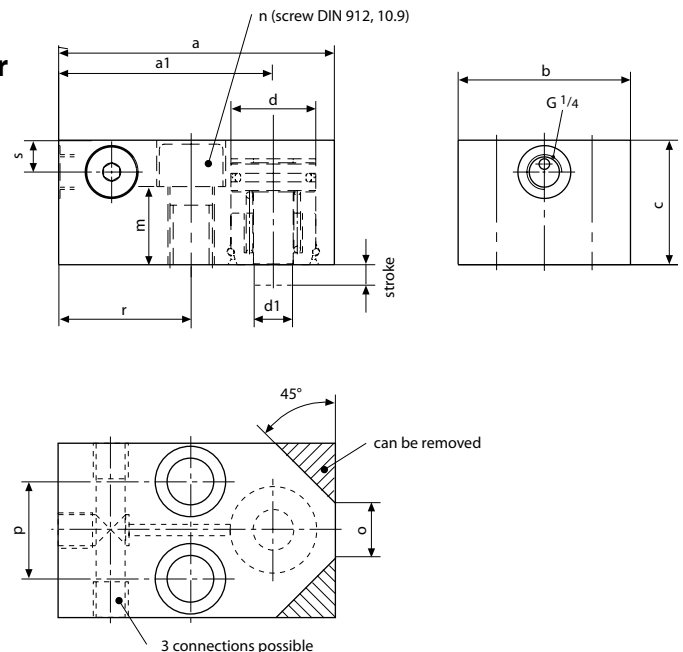
- on press beds and rams
- on machines and equipment for clamping and locking
- when the available space is limited

### Function:

The workpiece is clamped on its clamping edge by applying hydraulic pressure to the piston and mechanically unclamped by a spring 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 Tslots of a press bed or ram.

## Hydraulic clamping block without T-slot adapter

Clamping force at 400 bar (kN)	19,2	32	50	78
Stroke (mm)	8	8	8	12
Oil cons. (cm <sup>3</sup> )	4	7	10	24
a (mm)	95	104	111	132
a1 (mm)	77	81	85	99
b (mm)	65	65	65	80
c (mm)	40	47	50	75
d (mm)	25	32	40	50
d1 (mm)	15	15	20	25
m (mm)	24	29	32	53
n (mm)	M 16	M 16	M 16	M 20
o (mm)	18	20	20	28
p (mm)	36	36	36	43
r (mm)	50	50	50	57
s (mm)	12,0	15,0	16,5	22,0
Weight (kg)	1,6	2,0	2,3	4,9
<b>Part no.</b>	<b>8.2202.1301</b>	<b>8.2203.1301</b>	<b>8.2204.1301</b>	<b>8.2205.1301</b>



Max. operating pressure: 400 bar.  
Fastening screws M16 or M20, DIN 912, 10.9 are not included.