



**Sliding clamp, mechanical  
with integral high-pressure spindle**

6.2210



**Clamping block, mechanical  
with integral high-pressure spindle**

6.2212



**High-pressure spindle, mechanical  
with integral wedge system**

6.2270



**Clamping nut, mechanical  
with integral planetary gear**

6.2275



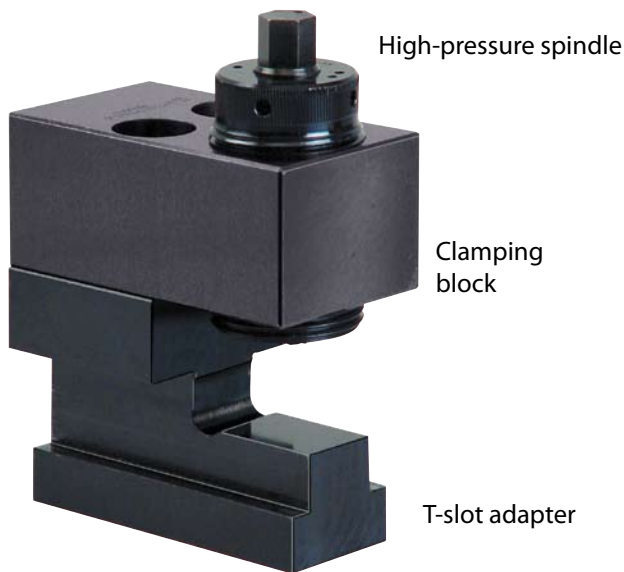
**Clamping nut, hydro-mechanical**

6.2276

# Sliding clamp, mechanical with integral high-pressure spindle



# HILMA



### Applications:

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

### Function:

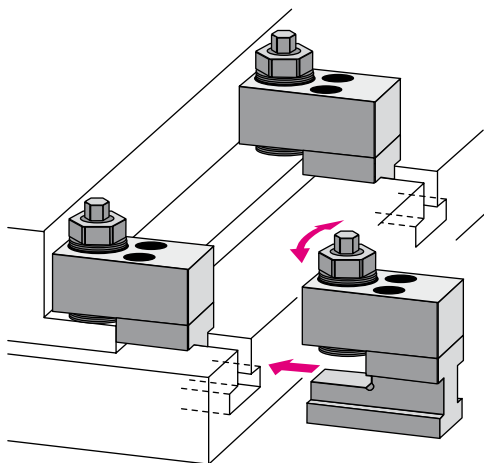
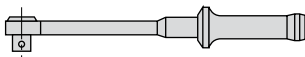
The sliding clamp is manually placed in the T-slot and screwed against the die clamping edge. Once the high-pressure spindle has been adjusted to suit the height of the clamping edge, the clamping force is built up by turning the hexagon nut (SW 1) in a clockwise direction. The clamping force achieved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



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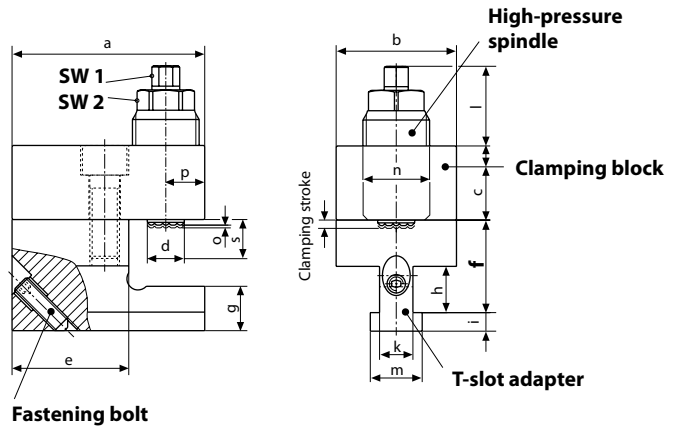
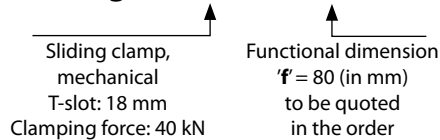
## Sliding clamp, mechanical with integral high-pressure spindle

<b>T-slot DIN 650 (mm)</b>	<b>18</b>	<b>22</b>	<b>28</b>
<b>Clamping force (kN)</b>	<b>40</b>	<b>40</b>	<b>80</b>
Clamping stroke (mm)	1,5	1,5	2,2
Max. tightening torque (Nm)	45	45	90
a (mm)	104	104	126
b (mm)	65	65	80
c (mm)	40	40	50
d (mm)	19	19	28
e (mm)	63	63	72
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 (mm)	M 36 x 3	M 36 x 3	M 48 x 3
p (mm)	21	21	27
Max. travelling path s (mm)	30	30	35
SW 1 (mm)	13	13	17
SW 2 (mm)	30	30	41
Weight (kg)	3,7	4,0	6,5

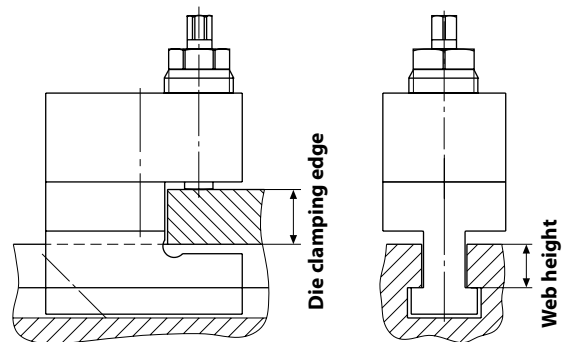
**Part no. 2212-185 2212-225 2213-285**

Special versions are available on request.

### Example of ordering: 2212-185/ F80

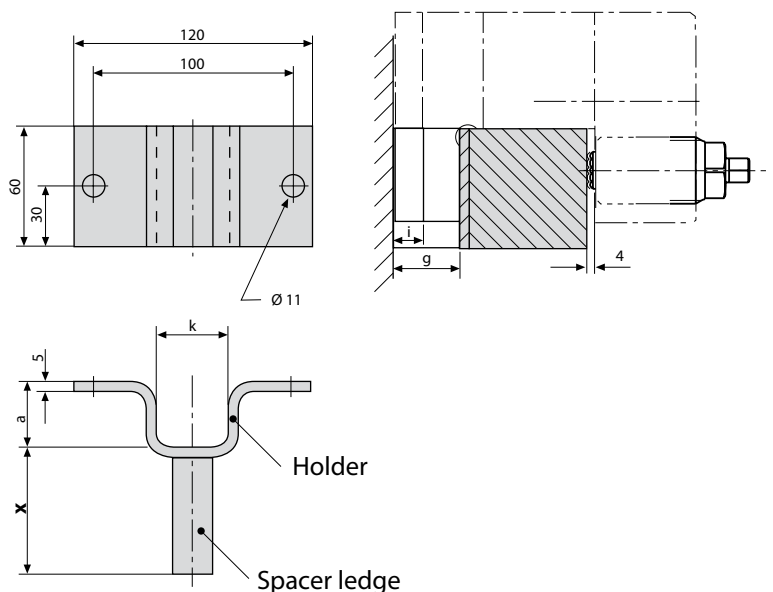


**Functional dimension 'f':**  
die clamping edge  
+ web height of T-slot  
+ 4 mm  
= dimension 'f'



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

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



**Distance 'x':**  
 $x = f + i - g - 4 \text{ mm}$

Dimension x to be quoted in the order

## Clamping block, mechanical with integral high-pressure spindle



**HILMA**



### Applications:

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

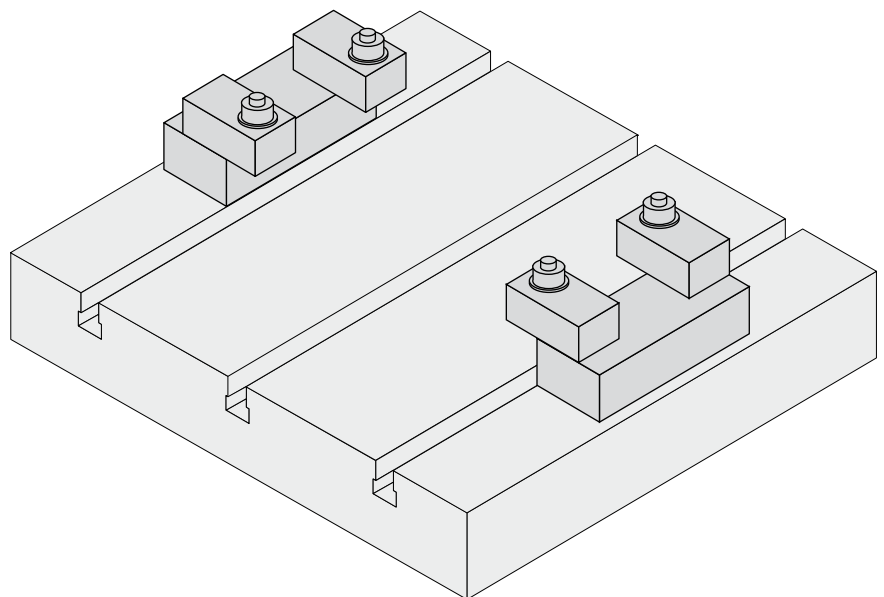
### Function:

The high-pressure spindle is manually screwed against the die clamping edge. The clamping force is built up by turning the hexagon nut (SW 1) in a clockwise direction using a torque wrench.

The clamping force achieved depends on the tightening torque selected with the torque wrench.

### Special features:

- ◇ Suitable for retrofit
- ◇ Compact design
- ◇ Clamping force of between 40 and 80 kN
- ◇ High clamping force with low torque
- ◇ Compensates for large clamping edge tolerances
- ◇ Self-locking by patented wedge system
- ◇ Individually usable



Clamping block with high-pressure spindle,  
mounted on spacer ledges