

# **Pull Clamps with T-Slot**

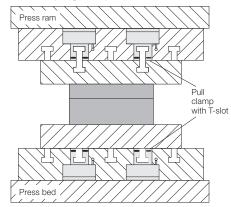
clamping force from 55 to 144 kN double acting, max. operating pressure 400 bar



### **Advantages**

- Compact design
- Bed and ram can also be used for manual clamping
- Ideal force transmission with centrally arranged clamping elements
- Optimum use of bed and ram surfaces

### Die clamping in a press



clamping of the upper die

with double T-slot bars Bed:

clamping of the lower die with firmly mounted T-slot bars

# **Application**

- Installation in press rams
- Installation in press beds
- Integrated in an intermediate plate
- When the available space is limited

#### Description

The pull clamp with T-slot facilitates a die standardisation by means of T-slot bars or T-nuts on

The hydraulic oil supply is made either through drilled holes in the bed and the ram or through

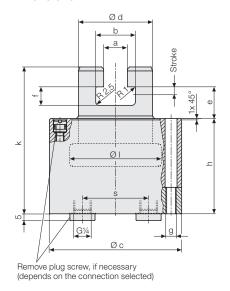
Tie rod and piston are hardened and ground. The hydraulic system is protected against dirt by wiper rings.

## **Application example**

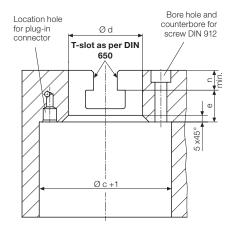


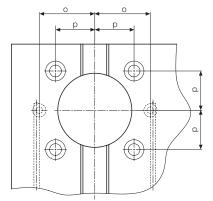
Pull clamps with T-slot installed in a press bed

## **Dimensions**



#### **Location hole**





### **Technical data**

Max. operating pressure 400 bar

For T-slot as per DIN 650			18	22	28
Clamping force at 400 bar		[kN]	55.2	76	144
Clamping force at 100 bar		[kN]	13.8	19	36
Piston Ø I		[mm]	70	80	105
Piston rod Ø d H7/f7		[mm]	56	63	80
Stroke		[mm]	6	6	6
Oil volume	clamping	[cm <sup>3</sup> ]	9	12	22
Oil volume	unclamping	[cm <sup>3</sup> ]	23	30	52
а		[mm]	18	22	28
b		[mm]	30	37	46
С		[mm]	100	115	150
е		[mm]	24	28	32
f		[mm]	14	18	22
g		[mm]	M8	M10	M12
h		[mm]	72	78	78
k		[mm]	111	125	135
n		[mm]	15.5	19.5	25.5
$0 \pm 0.05$		[mm]	42	47.5	62.5
р		[mm]	29.7	33.6	44.2
S		[mm]	50	56	70
Weight		[kg]	4.1	5.8	10
Part no.			2354050	2355050	2356050

Further sizes and special versions are available on request

### Important notes!

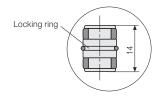
Make sure that the T-slot of the clamping piston is subject to an axial load only.

The T-nut must be in contact over its complete surface. Side loads must be avoided.

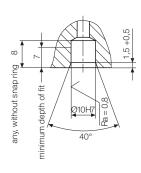
In view of the surface ratio of the pull clamps, only check valves having a minimum ratio of 3.5:1 may be used for maintaining the clamping force.

# Accessories

Plug-in connector for manifold-mounting connection Part no. 9210132



## **Location hole**



Subject to modifications