



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

Application

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

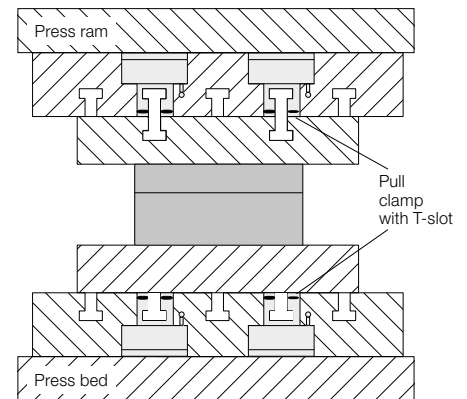
Description

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

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

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

Die clamping in a press



Ram: clamping of the upper die with double T-slot bars

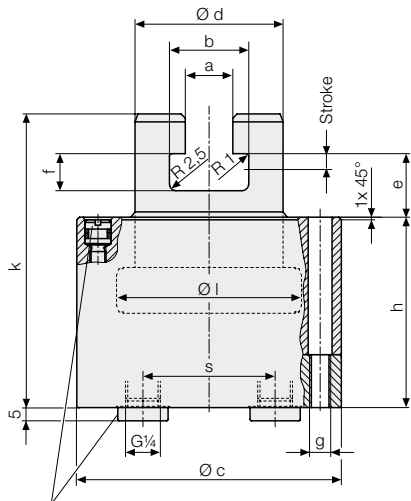
Bed: clamping of the lower die with firmly mounted T-slot bars

Application example



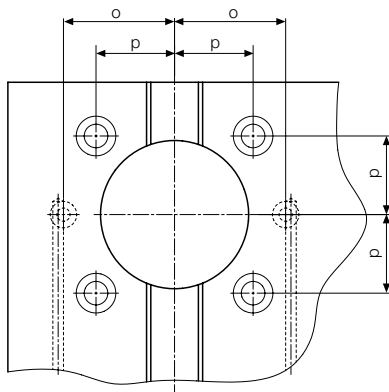
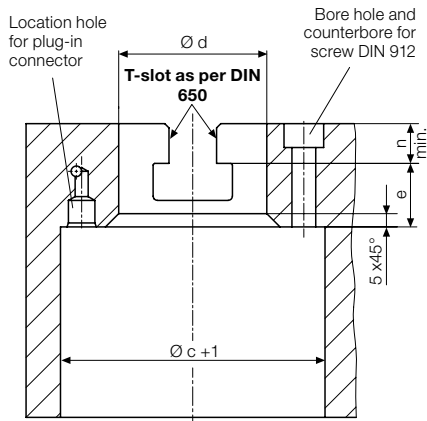
Pull clamps with T-slot installed in a press bed

Dimensions



Remove plug screw, if necessary
(depends on the connection selected)

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 l	[mm]	70	80	105
Piston rod Ø d H7/f7	[mm]	56	63	80
Stroke	[mm]	6	6	6
Oil volume clamping	[cm ³]	9	12	22
Oil volume unclamping	[cm ³]	23	30	52
a	[mm]	18	22	28
b	[mm]	30	37	46
c	[mm]	100	115	150
e	[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
o ± 0.05	[mm]	42	47.5	62.5
p	[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!

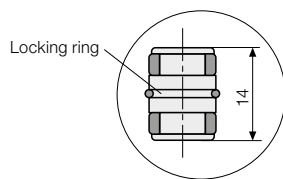
Make sure that the T-slot of the clamping piston is subject to an axial load only.

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

