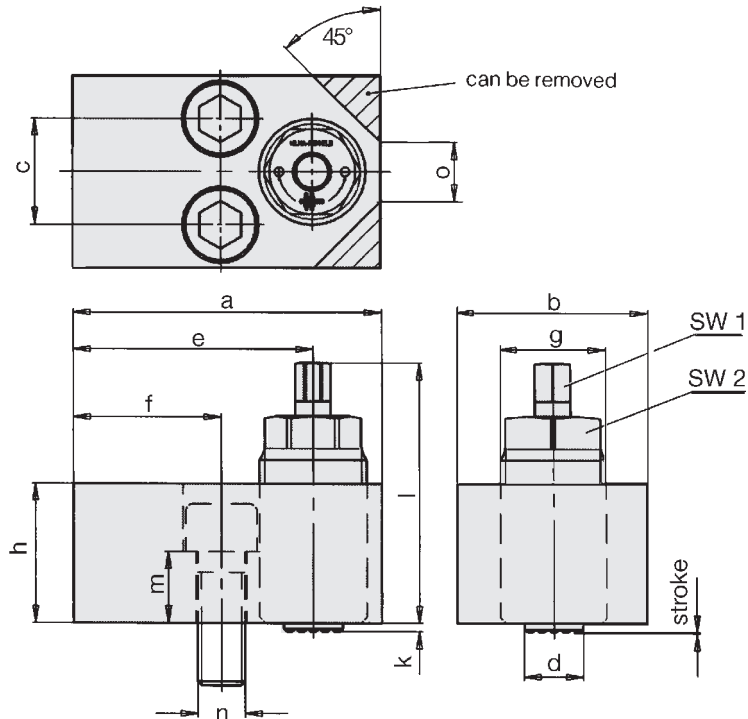


Sliding Clamp

mechanical with integrated high pressure spindle



Application

Clamping of tools and holding of path-controlled machine parts. In combination with T-slot adapters suitable for clamping tools on machine beds provided with T-slots.

Description

The sliding clamp contains a high-pressure spindle which is manually screwed against the tool or the workpiece. The clamping force is built up by turning the hexagon sw1 with a torque wrench and by positioning the wedge system.

Advantages

- easy handling
- compact design
- easy fastening

Important notes

Before actuating the clamping wedge sw1, screw the high-pressure spindle tightly and free from play against the tool or the workpiece. In case of non-rigid parts, tighten the spindle by turning the hexagon sw2, in order to make sure that the parts fit closely together before positioning the wedge system. Otherwise, the full clamping force may not be obtained.

Clamping and unclamping

For clamping, first turn the hexagon sw2 to position the spindle closely against the clamping edge of the workpiece. Then position the wedge system by turning the hexagon sw1. The clamping force will be maintained by the positive self-locking mechanism.

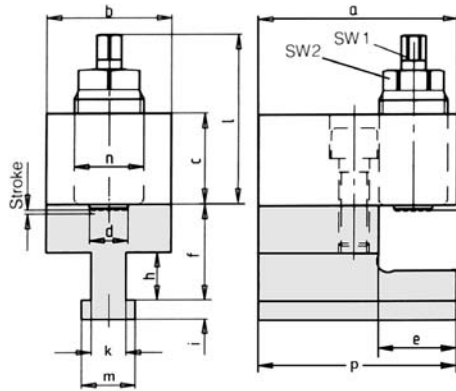
Maximum temperature 200°F

Specials available with maximum temperature 400°F, add -HT to part number

Max. clamping force	(lbs)	9,000	18,000
Max. tightening torque	(ft/lbs)	33	67
Clamping stroke	(in)	0.059	0.086
a	(in)	4.094	4.567
b	(in)	2.559	3.150
c	(in)	1.417	1.693
d	(in)	0.787	1.102
e	(in)	3.268	3.504
f	(in)	1.969	1.969
g	(mm)	M36 x 3	M48 x 3
h	(in)	1.575	1.969
l min	(in)	2.480	3.031
l max	(in)	3.228	4.213
m	(in)	0.945	1.142
n	(in)	5/8-11 UNC	3/4-10 UNC
o	(in)	0.945	1.181
sw1	(mm)	13	17
sw2	(mm)	30	41
Weight	(lbs)	5.1	8.8
Part no. Clamp		HCR-2212-111	HCR-2213-111
Part no. Torque Wrench		HCR-TW-033-2111	HCR-TW-067-3111

Attention:

We recommend using a torque wrench to ensure the proper clamping force is applied and to prevent damaging the clamping mechanism. A preset, ratcheting, reversible torque wrench provides ease of operation and over-torque protection.

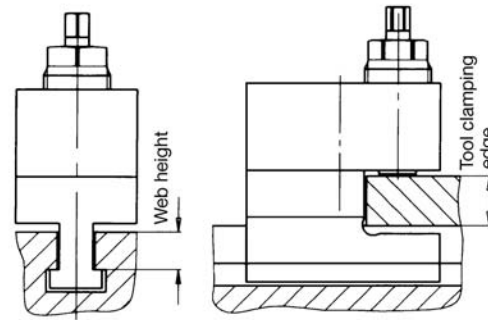


Application and selection

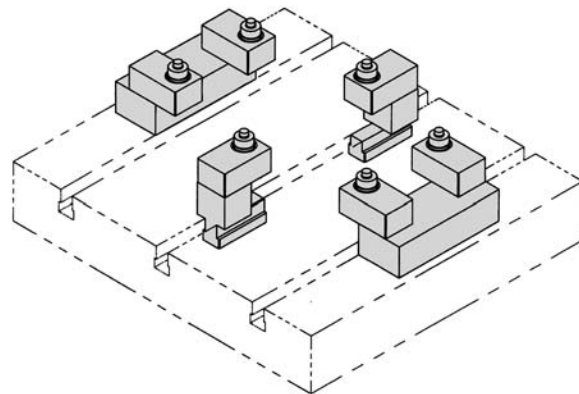
1. Determine web height (w) of T-slot (i.e. web height for 13/16" T-slot can vary 1/2" according to ASA B5.1 1949)
2. Determine clamping edge height of tools (x), standardize if necessary.
3. The functional dimension (f) is a result of web height, clamping edge height and 1/2 of the threaded adjustment $[(l_{max}-l_{min})/2]$.

$$f = w + x + [(l_{max}-l_{min})/2] + .118$$

*Please specify (w) & (x) dimensions when ordering



T-slot to ASA B5.1 1949		11/16	13/16	1 1/16	1 5/16
Clamping force	(lbs)	9,000	9,000	18,000	18,000
Max. tightening torque	(ft-lbs)	33	33	67	67
Max. stroke	(in)	0.059	0.059	0.086	0.086
a	(in)	4.094	4,094	4.567	4.567
b	(in)	2.559	2.559	3.150	3.150
c	(in)	1.575	1.575	1.969	1.969
d	(in)	0.787	0.787	1.102	1.102
e	(in)	1.260	1.260	1.890	1.890
f	(in)	2.992	3.150	3.937	4.213
g	(in)	0.787	1.024	1.024	1.417
h	(in)	1.024	1.181	1.181	1.457
i	(in)	0.394	0.512	0.512	0.709
k	(in)	0.648	0.773	0.773	1.018
l	(in)	0.658	0.783	0.783	1.033
l	(in)	2.480	2.480	3.031	3.031
m	(in)	3.228	3.228	4.213	4.213
n	(in)	1.102	1.260	1.260	1.614
n	(mm)	1.122	1.299	1.299	1.654
o	(mm)	M36x3	M36x3	M48x3	M48x3
p	(in)	0.118	0.118	0.118	0.118
p	(in)	3.740	3.740	4.370	4.370
Part no. Clamp		HCR-2212-111	HCR-2212-111	HCR-2213-111	HCR-2213-111
Part no. T-slot adapter		HCR-2221-050	HCR-2223-050	HCR-2223-060	HCR-2225-060



Clamping system, laterally mounted on spacer ledges and centrally mounted on moveable T-slot adapters.