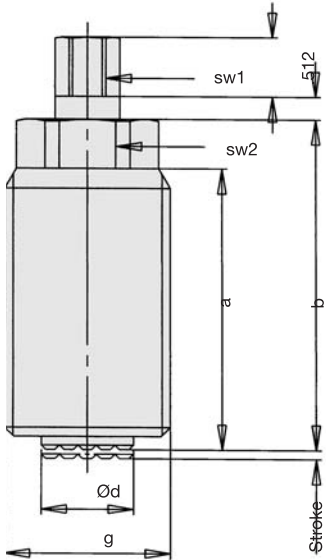


High-pressure spindle

mechanical
with integrated wedge system

C


Clamping and unclamping

For clamping, first turn the hexagon SW2 to position the spindle tightly and free from play against the clamping edge or the workpiece. Then operate the wedge system by turning the hexagon SW1 in direction of the + arrow. The clamping force will be maintained by the positive self-locking mechanism.

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

Easy installation in ledges and blocks.
Suitable for clamping workpieces, dies and molds.
Any mounting position.
Close side-by-side arrangement possible.

Description

High-pressure spindle with integrated wedge system for force intensification. The high-pressure spindle is protected against penetration of dirt, slugs and coolant.

Advantages

- high clamping force with low torque
- self-locking, ensured by wedge system
- easy manual clamping and unclamping

Important notes

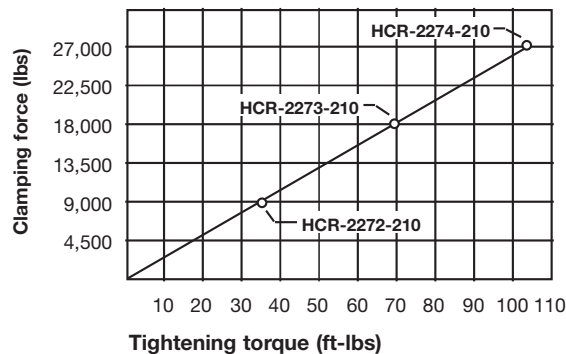
The clamping force is built up as a result of the wedge stroke and the rigidity of the surrounding parts. The high pressure spindle is permanently lubricated and when used under normal conditions is maintenance free.

Maximum temperature, 200° F

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

Max. clamping force	(lbs)	9,000	18,000	27,000
Max. static load	(lbs)	18,000	36,000	54,000
Max. tightening torque	(ft/lbs)	33	67	104
Clamping stroke	(in)	0.059	0.086	0.098
Travel 's'	(in)	0.197	0.295	0.335
a	(in)	2.441	2.953	3.543
b	(in)	2.874	3.543	4.331
Ød	(in)	0.748	1.102	1.535
g	(in)	M36 x 3	M48x3	M64x4
sw1	(mm)	13	17	19
sw2	(mm)	30	41	55
Weight	(lbs)	1.1	2.3	5.2
Part no. Spindle		HCR-2272-210	HCR-2273-210	HCR-2274-210
Part no. Torque Wrench		HCR-TW-033-2111	HCR-TW-067-3111	HCR-TW-100-4111

Diagram clamping force-tightening torque



Example for application

