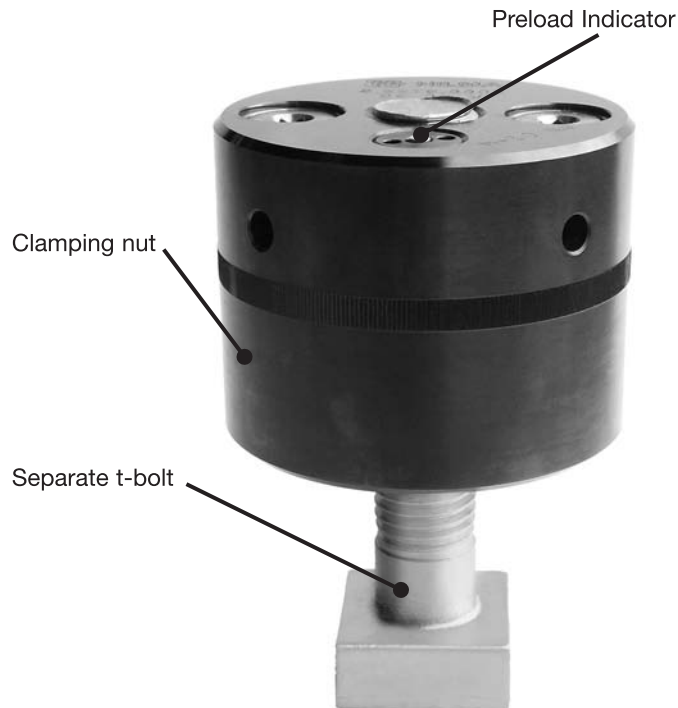


# Clamping Nut

hydro-mechanical, high clamping forces with preload indicator



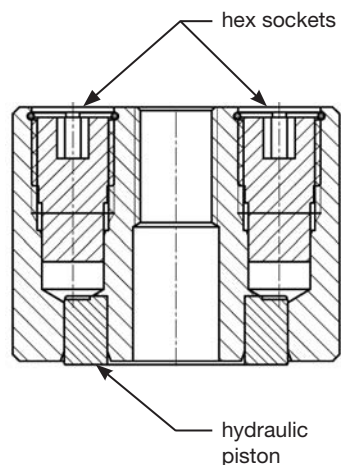
## Applications

- for clamping dies on rolling bolsters, press beds and slides
- on machine tool beds
- when the available space is limited and maximum clamping force is required
- when hydraulic unit or hoses to clamps is unavailable or not practical

## Function

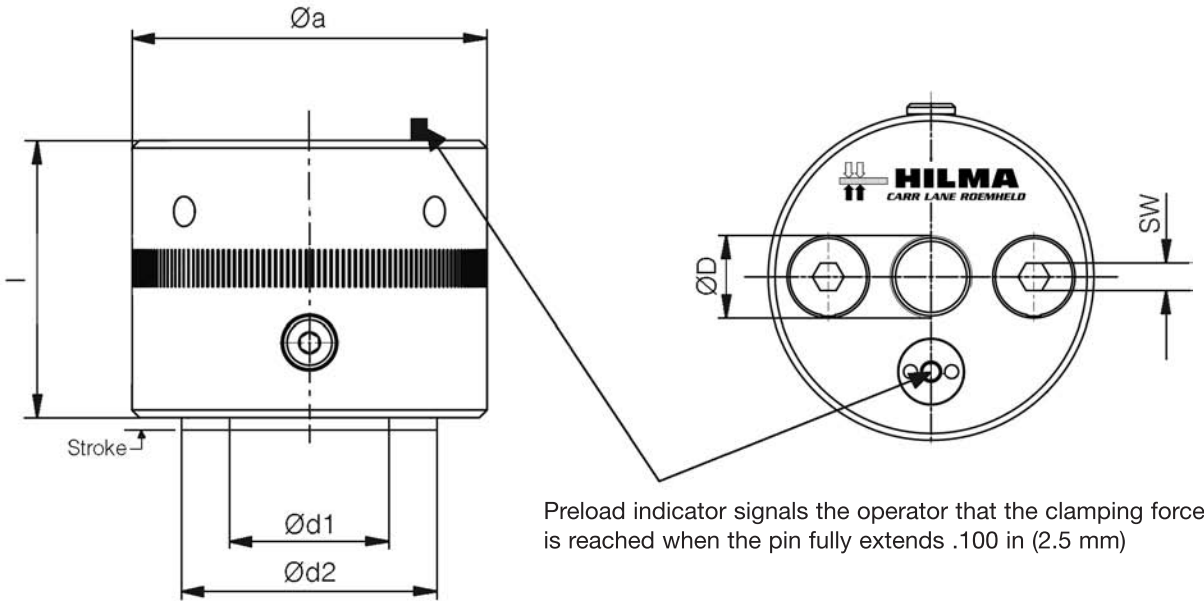
Manually position the clamping nut against the clamping edge, rotate the housing securely against the die or sub-plate then tighten one or both of the two hex sockets until the preload indicator fully extends. This pressurizes the integral hydraulic piston, converting minimum tightening torque into a high clamping force on the tool.

The clamping force is monitored with an indicator pin, which projects about .100 in. (2.5 mm) when the maximum force is applied.



## Advantages

- the t-bolt can extend through the clamping nut
- it is very adaptable to different clamping heights and tolerances, various t-bolts for different clamp heights is not required
- very suitable for retrofitting
- high clamping force with low torque
- easy manual clamping and unclamping



Preload indicator signals the operator that the clamping force is reached when the pin fully extends .100 in (2.5 mm)

### Clamping nut

Part no.	Clamping force (lbs)	Stroke* (max) (in)	Tightening** torque (ft/lbs)	D (UNC)	a (in)	d1 (in)	d2 (in)	SW (mm)	l (in)	Weight (lbs)
HCR-8.2275.0003	13,400	.078	7	3/4-10	2.75	1.18	1.97	8	2.80	4.41
HCR-8.2276.0003	22,400	.078	22	1-8	3.74	1.57	2.56	8	2.95	8.2
HCR-8.2277.0003	33,700	.078		1 1/4-7	4.41	1.97	3.15	10	3.54	13.45

\*\*Delivery includes Allen wrench

### T-bolt

For T-Slot	(in)	13/16		13/16		1 1/16		1 1/16		
Thread	UNC	3/4-10		3/4-10		1-8		1-8		
Length	(in)	5		7		5		6		
Property Class		Grade 8		Grade 8		Grade 8		Grade 8		
<b>Part no.</b>		<b>HCR-HM-9-0620-621</b>		<b>HCR-HM-9-0628-621</b>		<b>HCR-HM-9-0820-621</b>		<b>HCR-HM-9-0824-621</b>		

\* For maximum clamp stroke. Before adjusting the pressure screws, preload the nut using a spanner wrench.

\*\* Each clamp is supplied with an Allen wrench. Torque wrench is not required.

Metric versions and other sizes on request

Permissible temperature variations: +/- 35°F Max, (+/- 20°C)

Maximum temperature: 212°F (100°C)