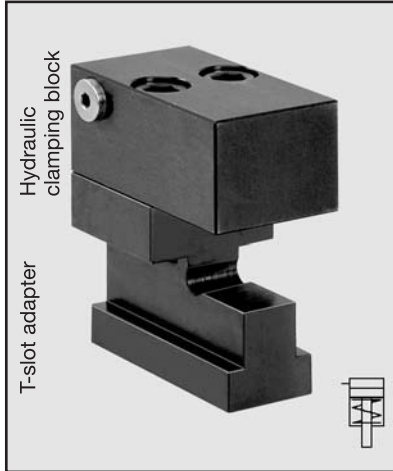


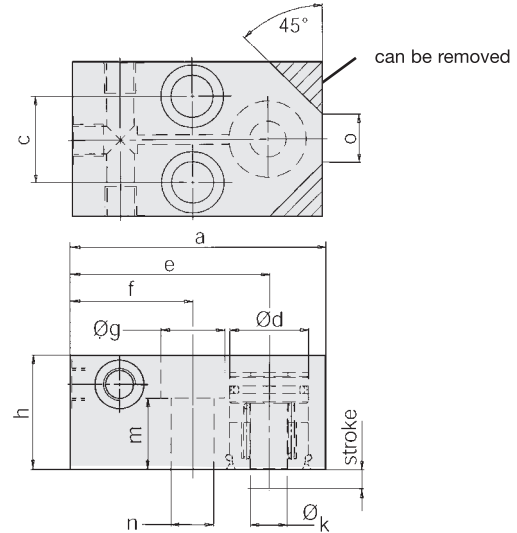
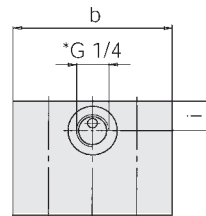
Sliding Clamps

single-acting, with spring return
max. operating pressure 5,800 psi



Hydraulic clamping block

Fastening screws
5/8—11-UNC x 2" LG
or 3/4—10 UNC x 3" LG
not included



Application

For clamping tools with uniform clamping edge and for holding machine parts on side-ways. In combination with T-slot adapters suitable for clamping of tools on machine beds with T-slots.

Description

Hydraulic clamping block with spring return piston. Cross-section of T-slot adapter suitable for T-slots as per ASA B5.1 1949 (or DIN 650).

Advantages

- compact design
- easy fastening
- stroke limitation even with max. operating pressure
- fluid connection on either side or rear
- max. temp 248° F

Adaptor fittings

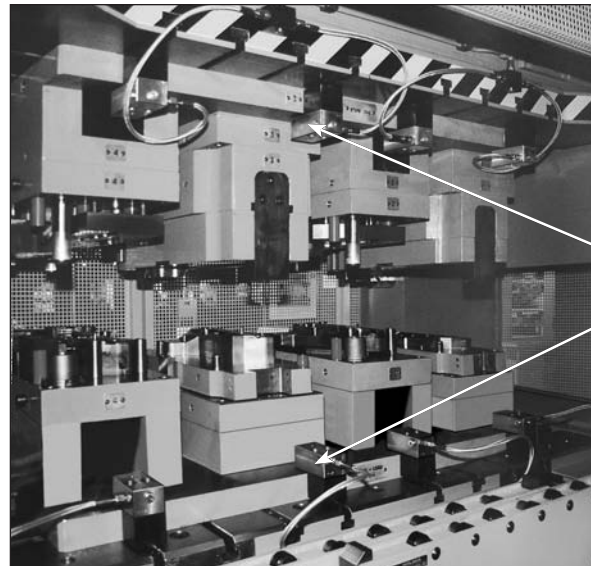
- 1/4" tube adapter **CLR-806-F**
1/4" JIC male adapter **CLR-816-F**

Important notes

Operating conditions, tolerances, and other data, see page B-3.

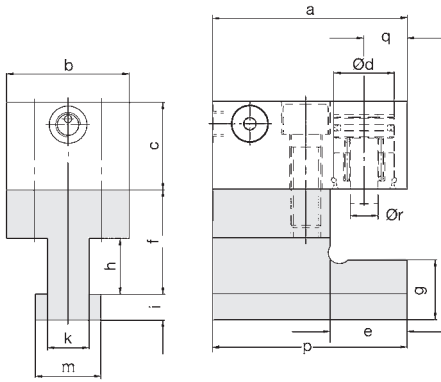
Power units see catalog page SECTION I.

Clamping force at 5,800 psi	4,300	7,200	11,300	17,600
Clamping force at 1,000 psi	741	1,241	1,948	3,034
Spring pull-back force (lb)	30	45	52	90
Piston Ø d (in)	.984	1.259	1.574	1.968
Stroke (in)	.315	.315	.315	.472
Total oil requirement (in ³)	.25	.43	.61	1.46
a (in)	3.740	4.095	4.370	5.196
b (in)	2.559	2.559	2.559	3.149
c (in)	1.417	1.417	1.417	1.692
e (in)	3.031	3.189	3.346	3.897
f (in)	1.968	1.968	1.968	2.244
Øg (in)	1.024	1.024	1.024	1.299
h (in)	1.574	1.850	1.968	2.952
i (in)	.472	.590	.649	.866
Øk (in)	.590	.590	.787	.984
m (in)	.944	1.141	1.260	2.09
n (clearance for) (in)	-11 UNC	5/8-11 UNC	5/8-11 UNC	3/4-10 UNC
o (in)	.708	.787	.787	1.102
Weight (lb)	3.5	4.4	5.1	10.8
Part no.	HCR-2202-130	HCR-2203-130	HCR-2204-130	HCR-2205-130



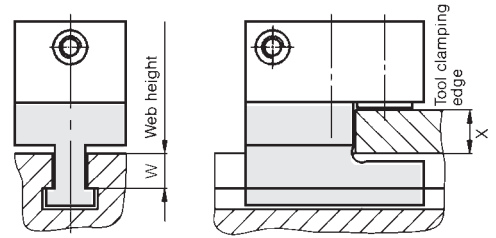
Sliding Clamps

Sliding clamps are used on slide and bed of straight side press. Dies are loaded and unloaded with pivoting type die consoles.



Application and selection

1. Determine web height (w) of T-slot (ie. 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 inserting tolerance (1/2 stroke).
 $f = w + x + 1/2 \text{ stroke}$



T-slot adapter available as spare part

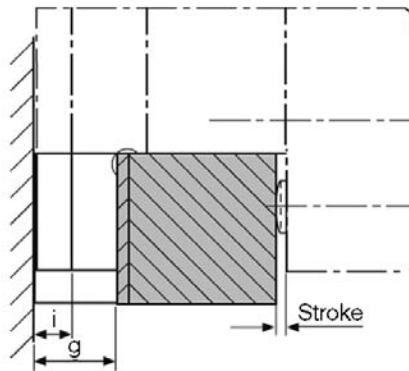
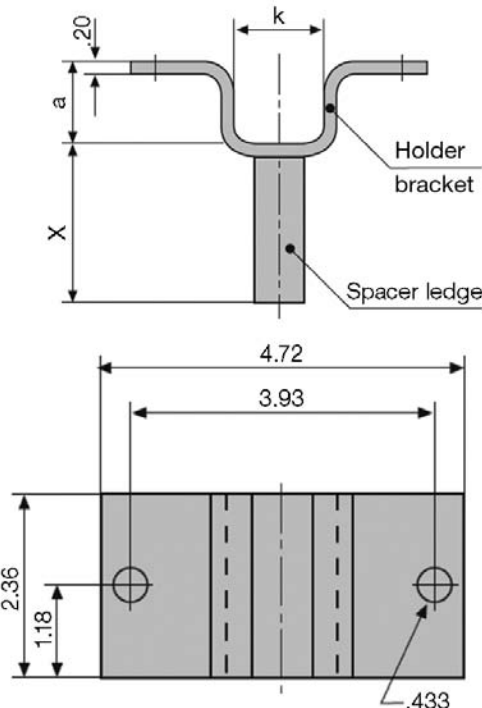
* Please specify (f) dimensions when ordering specials or modify the tool clamping edge or T-slot adapter as required.

T-slot to ASA B5.1 1949	1/16	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	7/8
Clamping force at 5,800 psi (lb)	4,300	4,300	7,200	11,300	7,200	11,300	17,600	11,300	17,600	17,600
Piston Ød (in)	.984	.984	1.259	1.574	1.259	1.574	1.968	1.574	1.968	1.968
a (in)	3.740	3.740	4.090	4.370	4.090	4.370	5.196	4.370	5.196	5.196
b (in)	2.559	2.559	2.559	2.559	2.559	2.559	3.149	2.559	3.149	3.149
c (in)	1.574	1.574	1.850	1.968	1.850	1.968	2.952	1.968	2.952	2.952
e (in)	1.260	1.890	1.890	1.890	1.890	1.890	2.361	1.890	2.361	2.361
f (in)	2.992	3.150	3.150	3.150	3.657	3.657	4.606	4.720	4.720	4.720
g (in)	.945	1.024	1.024	1.024	1.378	1.378	1.378	1.811	1.811	1.811
h (in)	.984	1.173	1.173	1.173	1.375	1.375	1.375	1.704	1.704	1.704
i (in)	.394	.515	.515	.515	.703	.703	.703	.952	.952	.952
k (in)	.648	.773	.773	.773	1.018	1.018	1.018	1.258	1.258	1.258
	.658	.783	.783	.783	1.033	1.033	1.033	1.273	1.273	1.273
m (in)	1.102	1.260	1.260	1.260	1.614	1.614	1.614	2.008	2.008	2.008
	1.122	1.299	1.299	1.299	1.654	1.654	1.654	2.047	2.047	2.047
p (in)	3.740	4.370	4.370	4.370	4.370	4.370	5.196	4.370	5.196	5.196
q (in)	.709	.709	.906	1.024	.906	1.024	1.299	1.024	1.299	1.299
Ør (in)	.590	.590	.590	.787	.590	.787	.984	.787	.984	.984

T-slot adapter

Part no.	HCR-2221-050	HCR-2223-050	HCR-2223-050	HCR-2223-050	HCR-2225-010	HCR-2225-010	HCR-2225-071	HCR-2227-010	HCR-2227-020
Weight (lb)	3.9	4.4	4.4	4.4	6.9	6.9	6.9	9.7	9.7

Sliding clamp holder for use during die change.



Distance 'x':
 $x = f + i - g - 1/2 \text{ stroke}$

Dimension x to be specified with the order.

T-slot ASA	Holder Complete	Holder Bracket	a (in)	k (in)	i (in)	g (in)
1/16	CALL	CALL	—	—	—	—
3/16	HCR-2754-220-XXXX	HCR-2754-220	1.299	1.456	.515	1.024
1/2	HCR-2754-280-XXXX	HCR-2754-280	1.693	1.811	.703	1.378
5/8	CALL	CALL	—	—	—	—