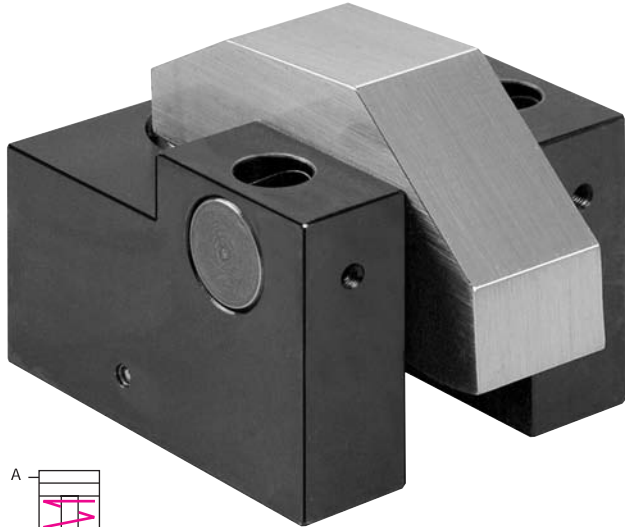


Angular Clamp

single-acting with spring return



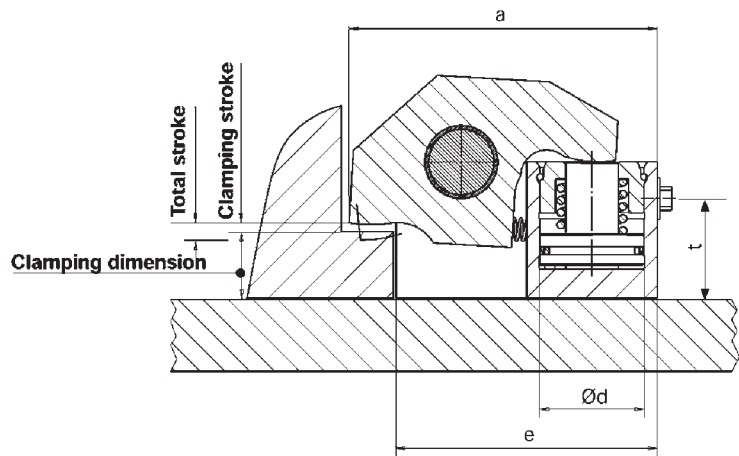
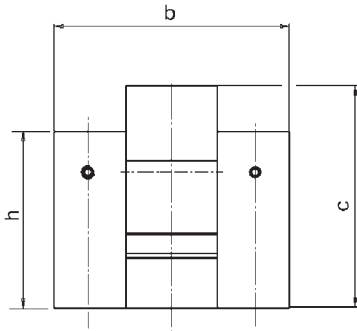
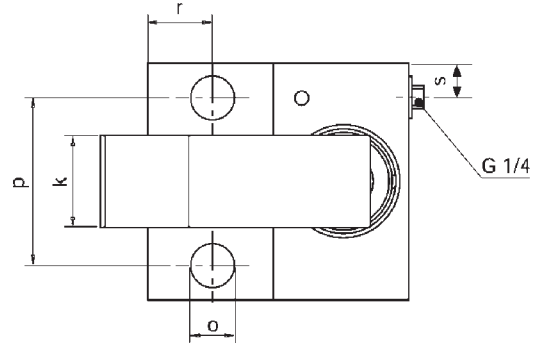
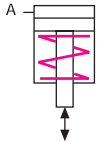
Applications:

- on press beds and rams
- on machines and equipment for clamping
- when the available space is limited

Function

The workpiece is clamped on its clamping edge by applying hydraulic pressure to the piston and unclamped by spring return.

The clamp may be fastened by screwing it directly to the press bed or flexibly so that it may be moved in combination with a T-slot adapter in the T-slots of a press bed or ram.

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Hydraulic clamping block without T-slot adapter

Part no.	Clamping force at 5,800 psi (lbs)	Clamping force at 1,450 psi (lbs)	Total stroke (in)	Clamping stroke (in)	Clamping dimension (in)	Oil volume (cu in)	a (in)	b (in)	c (in)	d (in)	e (in)	h (in)	k (in)	o (in)	p (in)	r (in)	s (in)	t (in)	Weight (lbs)
HCR-2312-010	9,000	2,250	0.217	0.098	0.807	0.397	3.976	2.953	3.031	1.260	3.346	2.461	0.984	12.5	1.969	0.787	0.512	1.260	5.7
HCR-2314-050	14,850	3,700	0.236	0.118	0.984	0.61	4.646	3.543	3.346	1.575	3.937	2.657	1.378	16.5	2.520	0.984	0.512	1.496	8.8
HCR-2315-050	24,750	6,200	0.236	0.118	1.26	0.976	5.787	4.724	4.134	1.969	4.921	3.346	2.165	22	3.543	1.181	0.787	1.772	19.0

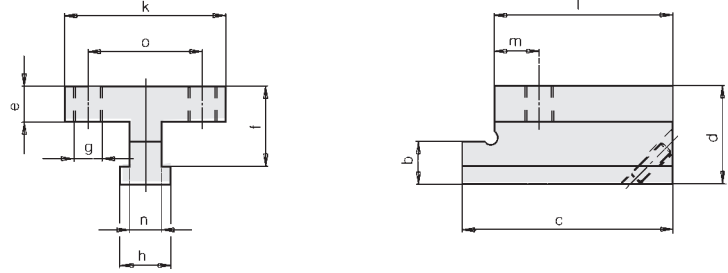
max. operating pressure 5,800 psi

Other sizes are available on request. Please consult us if aggressive fluids are used.

Fastening screws are not included.

Position control optional.

T-slot adapter



T-slot adapter for angular clamps

	HCR-2312-010	HCR-2314-050	HCR-2314-050	HCR-2315-050	HCR-2315-050
for clamp	HCR-2312-010	HCR-2314-050	HCR-2314-050	HCR-2315-050	HCR-2315-050
for T-slot	13/16	13/16	1 1/16	1 1/16	1 5/16
b	0.944	0.944	1.654	1.654	1.93
c	3.976	4.645	4.645	5.787	5.787
d	2.003	2.165	2.873	3.07	3.425
e	0.625	0.787	0.787	0.984	0.984
f	1.61	1.772	2.163	2.36	2.638
g	M12	5/8-11 UNC	5/8-11 UNC	3/4-10 UNC	3/4-10 UNC
h	1.02	1.02	1.732	1.732	1.89
k	2.953	3.543	3.543	4.724	4.724
l	3.348	3.937	3.937	4.921	4.921
m	0.787	0.984	0.984	1.181	1.181
o	1.968	2.52	2.52	3.543	3.543

Part no.	HCR-2320-210	HCR-2322-210	HCR-2324-210	HCR-2326-210	HCR-2327-210
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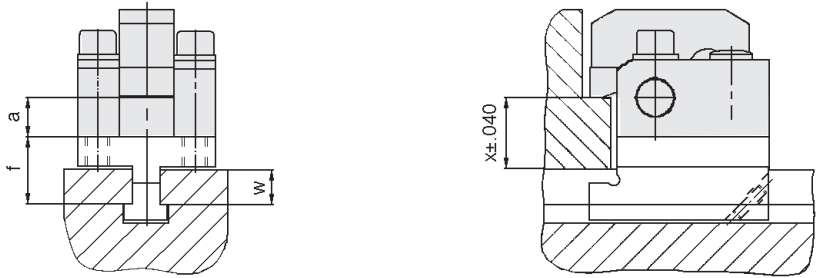
Determination of the clamping edge height x

$$x = f + a - w$$

Note:

Special T-slot adapters available on request. Please specify f dimension (f=x-w-a) with complete T-slot and clamping height data. Use form on page B-1.

T-slot dimensions must be carefully measured. According to ASA B5.1-1949 (w) web height can vary as much as .562 depending on the T-slot size.

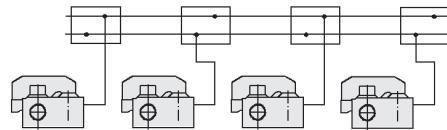


Manifold block Example for application

Part no. HCR-HH-M234

Use in two-circuit application or for clamps with built-in pilot operated check valves.

See SECTION J for further information.



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