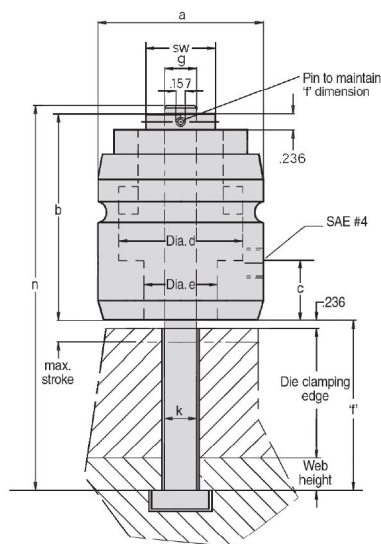




Hollow Piston Cylinder, inch/SAE single-acting, with spring return



Application

For clamping dies with parallel clamp surfaces on press bed and slide. Adapting to different clamping edge heights is possible by adjusting the T-bolt.

Description

Single-acting cylinder with spring return. Piston hardened and ground. Piston with threaded through-hole suitable for T-bolt with 24-UNC thread. Hydraulic system protected by wiper rings. 7/16-20 SAE #4 Port.

Advantages

- ◆ handy, compact design with “no-slip” handling groove
- ◆ small overall dimensions

Important Notes

The T-bolt must be adjusted according to the dimension of clamping edge, T-slot web and half the stroke (dimension f) and secured by pin. Operating conditions, tolerances, and other data, see Section 1.

Specials

Also available in larger models, 37,000 lbs @ 5,800 psi, with built-in pilot operated check valve and other special designs upon request.

Hollow piston cylinder complete with T-bolt, adjusted and pinned Dimension 'f' to be quoted in the order

	For T-slot (inch)	11/16	13/16	1-1/16	1-5/16
Clamping force at 5,800 psi (lbs)		13,500	13,500	23,400	23,400
Min. spring return force (lbs)		72	72	128	128
Piston-Ø (inch)		2.126	2.126	2.755	2.755
Stroke (inch)		0.472	0.472	0.472	0.472
Total oil consumption (in ³)		1.1	1.1	1.9	1.9
a (inch)		2.834	2.834	3.543	3.543
b (inch)		3.661	3.661	4.133	4.133
c (inch)		1.102	1.102	0.944	0.944
g (inch)		5/8-11	3/4-10	1 - 8	1-1/4 - 7
k (inch)		11/16	13/16	1 - 1/16	1 - 5/16
Weight (lbs)		5.3	5.6	9.7	11.0
Part no.		HCR-2134-611	HCR-2134-613	HCR-2135-617	HCR-2135-621

Hollow piston cylinder without a T-bolt

	Part no.	HCR-2134-213	HCR-2134-313	HCR-2135-213	HCR-2135-313
Weight (lbs)		4.6	4.5	7.8	7.3

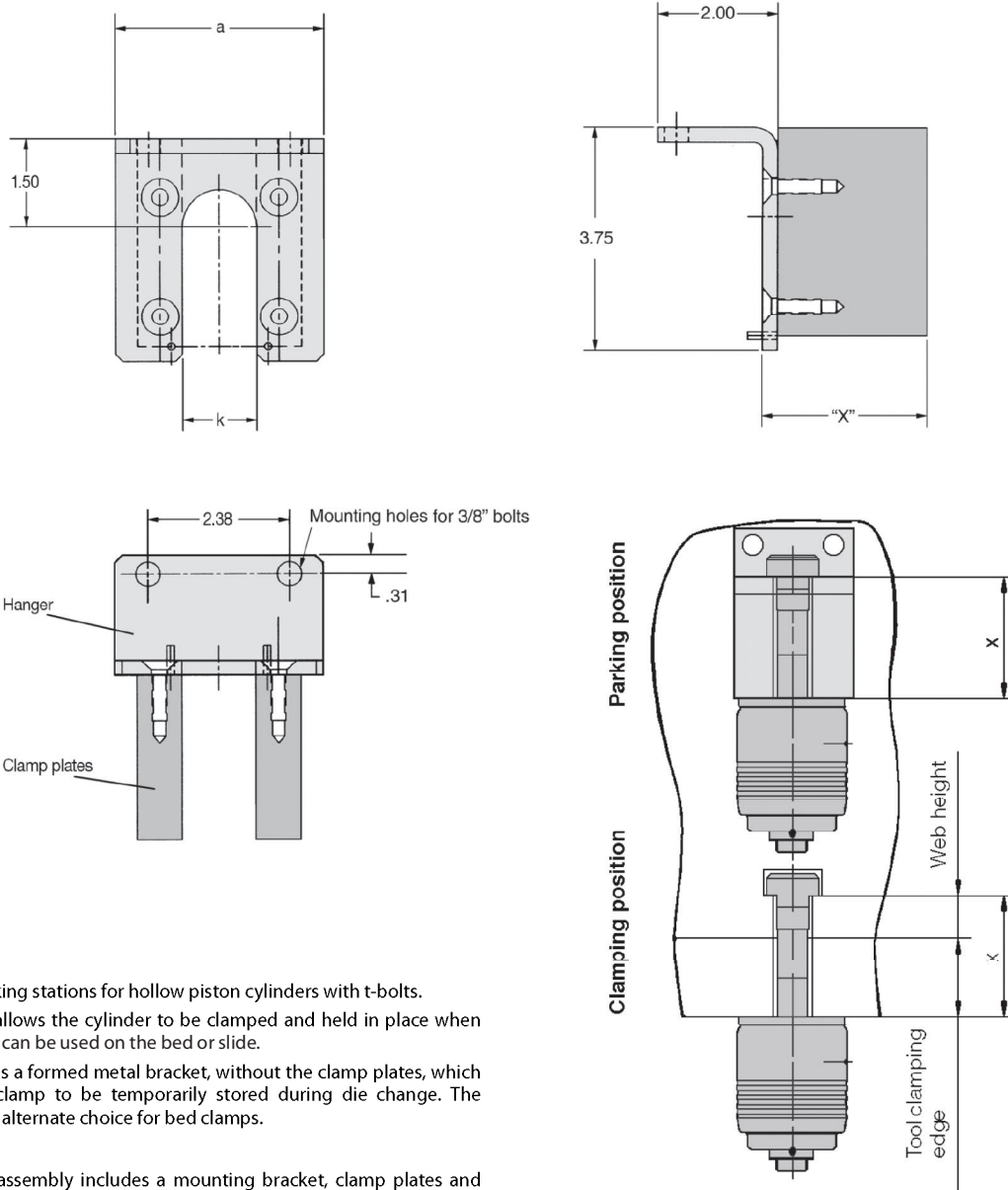
T-Bolt, Grade 8, detached

	For T-slot (inch)	11/16	13/16	1 - 1/16	1 - 1/16	1 - 1/16	1 - 5/16
Thread size (inch)		5/8-11	3/4-10	1 - 8	1 - 8	1 - 8	1-1/4 - 7
Thread length (inch)		5.5	5.5	4.0	4.0	4.0	5.0
Shaft length (inch)		7.0	7.0	7.0	8.0	9.0	8.0
f' dimension (inch)		1/2 to 2-5/8	1/2 to 2-5/8	1-1/8 to 2-5/8	2-1/8 to 3-5/8	3-1/8 to 4-5/8	1-1/8 to 3-5/8
Weight (lbs)		0.7	1.1	1.9	2.1	2.3	3.7
Part no.		HCR-HM-TB062-0700	HCR-HM-TB075-0700	HCR-HM-TB100-0700	HCR-HM-TB100-0800	HCR-HM-TB100-0900	HCR-HM-TB125-0800

Holder for hollow piston cylinders, inch



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Application

Used as parking stations for hollow piston cylinders with t-bolts.

The holder allows the cylinder to be clamped and held in place when not in use. It can be used on the bed or slide.

The hanger is a formed metal bracket, without the clamp plates, which allows the clamp to be temporarily stored during die change. The hanger is an alternate choice for bed clamps.

Description

The holder assembly includes a mounting bracket, clamp plates and clamp retainer pins.

The hanger includes the mounting bracket and the clamp retainer pins.

Advantages

- ◆ easy clamp storage during die change
- ◆ clamps not being used while the press is in operation, can be safely clamped in the holder

Holders with integral check valve, special and metric versions on request.

Holder for hollow piston cylinders, inch

For hollow piston cylinder		HCR-2134-313	HCR-2134-213
For T-slot	(inch)	13/16	1-1/16

Note: Specify dimension x in the order!

Part no.			
Holder		HCR-2753-700	HCR-2753-770
Hanger bracket		HCR-2753-270	HCR-2753-280