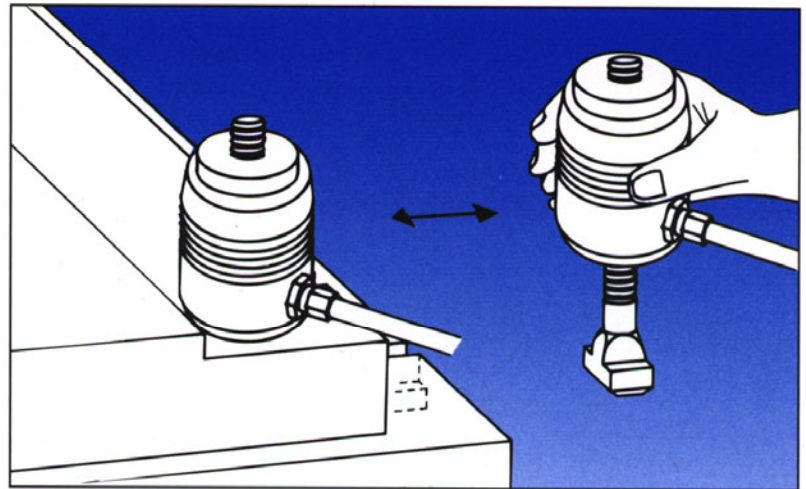


Area of application

The hydraulic T-bolt clamp type HKZ is designed for smaller and medium-sized machines exerting a force of up to about 700 tonnes. It is suitable both for top and bottom die clamping, and requires clamping edges with U-recesses.

The T-bolt clamp is inserted, either manually or using the automatic positioning unit HFT/HFS (see data sheet 1.300), into the U-recess of the die and the machine T-slot below it.

Due to the very low installation cost, the use of the T-bolt clamp is particularly advisable, especially for modification purposes.



Mode of operation

The piston of the T-bolt clamp is connected, via a screw thread, to the T-slot screw. The die is clamped to the clamping surface of the machine by means of the T-slot screw.

The clamping force required is produced by a single-acting hydraulic cylinder with a restoring spring.

Release is effected by reversing the hydraulic valve with the aid of the restoring spring.

Application of the clamping force by:

- the clamping stroke of the T-slot screw.

Distinguishing features

The hydraulically operated clamping cylinder produces the necessary clamping force directly. In so doing, the hydraulic pressure must be maintained throughout the whole of the clamping process (optional equipment with releasing non-return valves and pressure controls).

Continuous variation in the length of the tie rod screw permits infinitely variable adaptation to different clamping edge thicknesses, and renders standardization of the dies/adaptor plates largely superfluous.

The clamp unit can be operated centrally via the machine control system or by a separate hydraulic unit with integrated control.

Electrical control of the following function:

- pressure control by means of the pressure switch on the hydraulic unit is advisable.

Technical data

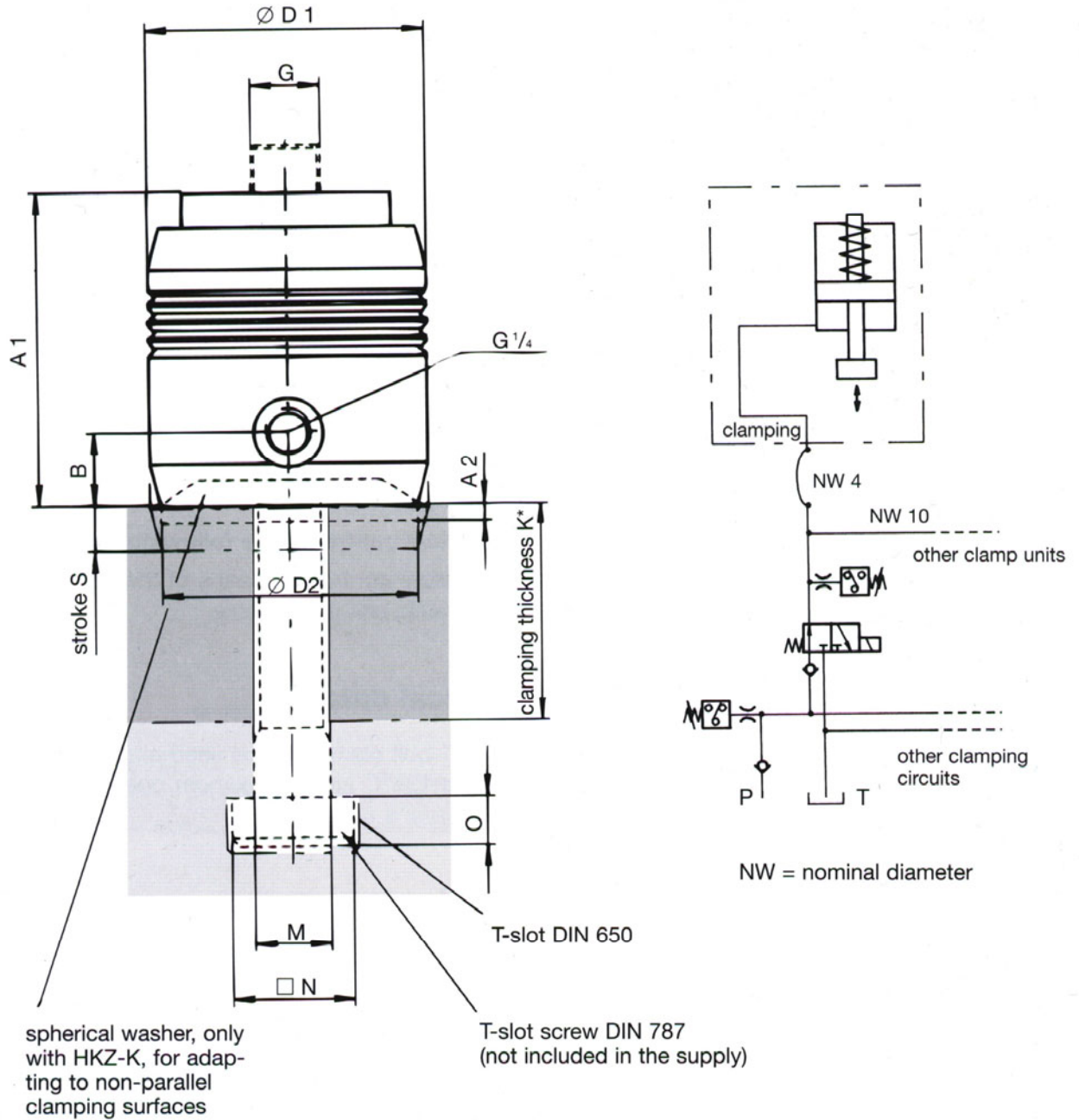
The T-bolt clamp can be used at operating temperatures up to 135°C and a maximum operating pressure of 400 bar.

Advantages

- Infinitely variable adaptation to various die thicknesses
- Large clamping thickness tolerance
- Very low installation cost
- Central control
- Continuous pressure control possible
- Particularly suitable for modification purposes
- Low maintenance cost due to single-acting hydraulic cylinder with restoring spring
- Superior corrosion protection.

Construction

The clamp unit has a completely nickel-plated housing (T-slot screw not provided in the supply).



* when ordering, please state dimension K
 F_{SP} = clamping force at 400 bar

Type	F_{SP} [kN]	Stroke S	A 1	A 2	B	D 1	D 2	G	M	N	O	Oil requirement [cm ³]	Weight [kg]
HKZ 40	40	12	80	-	15	70	-	M 16	18	28	10	12	2,3
HKZ-K 40	40	12	80	5	15	70	56	M 16	18	28	10	12	2,4
HKZ 65	65	12	90	-	21	80	-	M 20	22	35	14	20	2,7
HKZ-K 65	65	12	90	5	21	80	68	M 20	22	35	14	20	2,9
HKZ 104	104	12	100	-	24	90	-	M 24	28	44	18	31	3,7
HKZ-K 104	104	12	100	5	24	90	78	M 24	28	44	18	31	4