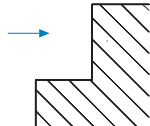
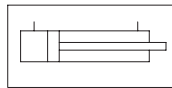


Application area

- For medium and large presses
- For clamping moving bolsters as well as upper and lower dies
- For clamping upper and lower dies
- Fixed installation to the sides of the press columns, on the press bed or slide.

Mode of operation



- A double-acting hydraulic cylinder pushes a wedge onto the clamping edge of the die.
- The clamping force is generated by the angle of the wedge.
- The clamp unit is unclamped by reversing this sequence.

Description

The hydraulically driven wedge clamp unit generates the required clamping force by means of the wedge mechanism. In order to secure the clamping force, hydraulic pressure must be maintained (e.g. with pilot-controlled check valves).

Pressure sensing by the pressure switch on the hydraulic power pack is required.

In its park position, the clamping wedge is fully retracted into the housing and therefore protected against damage. To ensure that the clamping wedge remains in the park position during die change, the operating pressure must be maintained or a pilot-controlled check valve must be integrated into the unclamping line. Park and clamping positions can be monitored by limit switches (optional).



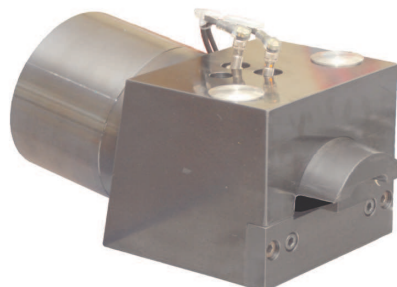
Advantages

- Low space requirements due to compact dimensions
- Low operating pressure
- Minimal installation investment
- Central operation
- Continuous clamping force monitoring possible (pressure sensing)
- Monitoring of clamping and unclamping positions possible (optional)

Accessories

- Check valves
- Hydraulic connections
- Hydraulic hoses / Hydraulic accessories
- Hydraulic power packs

Technical data



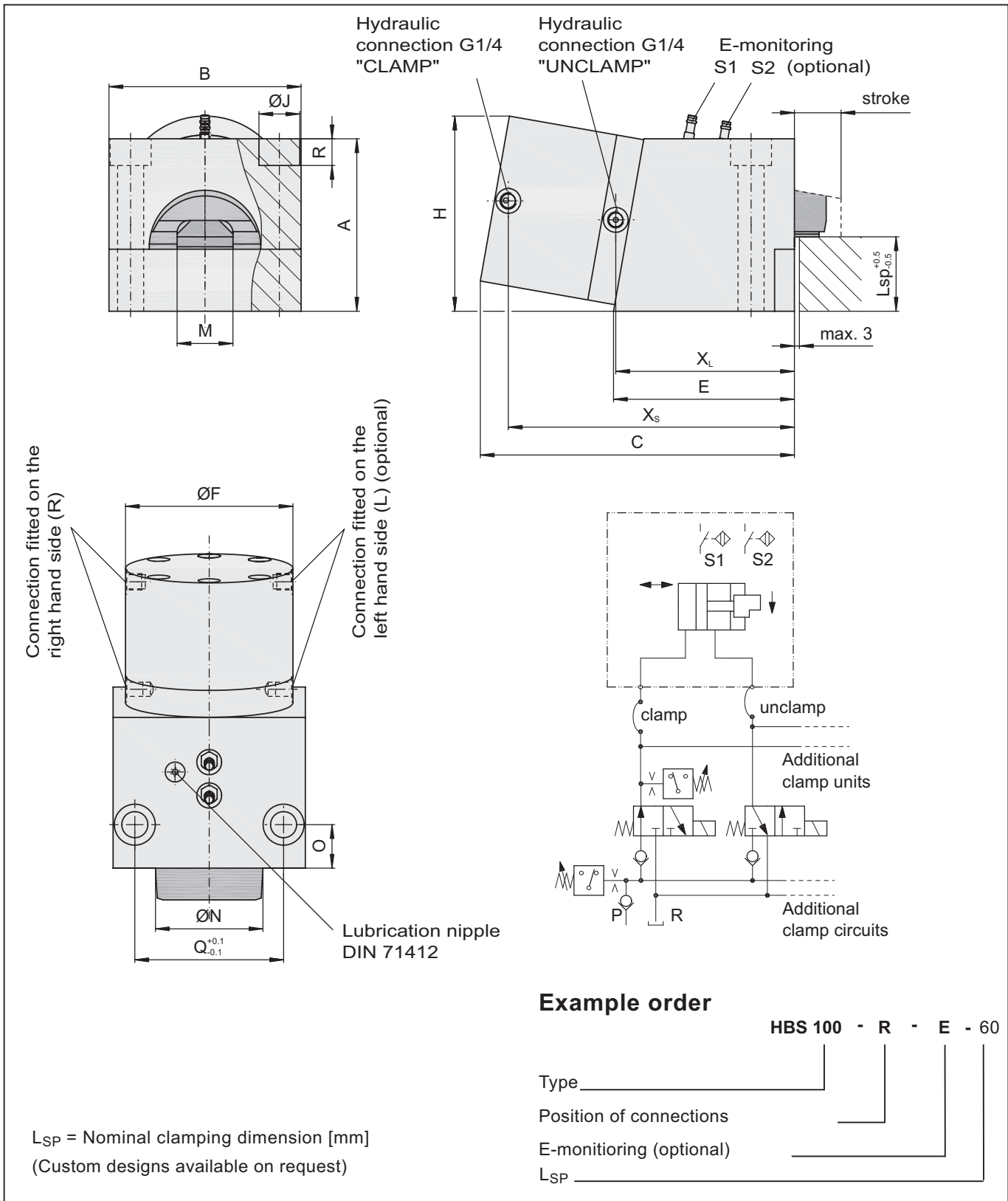
Type	HBS 100
Clamping force [kN]	100
Max. loading force [kN] ¹⁾	150
Max. operating pressure [bar]	80
Clamping dimension tolerance [mm]	+/- 0,5
Stroke [mm]	33
Oil volumes: Clamp / unclamp [cm ³]	210/176
Max. oil volume flow [l/min] ²⁾	10-12
Limit switch: Number / type (optional)	• Two inductive proximity switches
Supply voltage	• 10-30 V DC
Connection type	• Plug-in type(M8x1)
Designation	• Clamping wedge in park position S1
	• Clamping wedge in clamping position S2
Max. operating temperature [°C] ³⁾	70
Weight [kg]	30

¹⁾ Mechanical damage may occur at higher loads.

²⁾ If a pump with a greater output is used, the oil flow must be reduced by means of flow control valves or pilot-controlled valves

³⁾ Designs for higher operating temperature available on request

Fixing is achieved with two screws, DIN 912, strength class 10.9 (not included).



Type	Stroke	A	B	C	E	F	H	ØJ	ØK	ØM	ØN	O	Q	R	X _L	X _S	L _{SP}
HBS 100	32	139	155	253	146	135	157	33	21	45	90	35	120	21	144	231	60