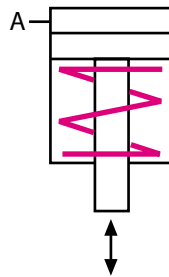


# Angular clamp single-acting



**ROEMHELD**  
HILMA ■ STARK



For power units  
please refer to product group 7

For accessories  
please refer to product group 11

## Applications:

- on press beds and rams
- on machines and equipment for clamping and locking
- when the available space is limited
- when temperatures may reach 120° C

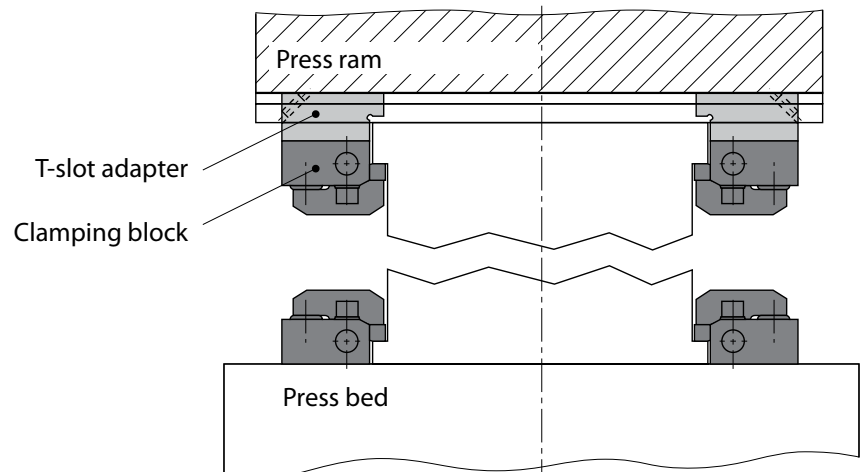
## Function:

The angular clamp is manually placed in the T-slot provided in press ram or bed.  
The die is clamped on its clamping edge by applying hydraulic pressure to the piston and mechanically unclamped by spring return.  
The clamping block may also be fastened directly, without a T-slot adapter.

## Special features:

- ◆ ideal power transmission
- ◆ compact design
- ◆ easy fastening
- ◆ suitable for small clamping edges
- ◆ suitable for retrofit
- ◆ no need for die standardisation (width and depth)

## Example of application

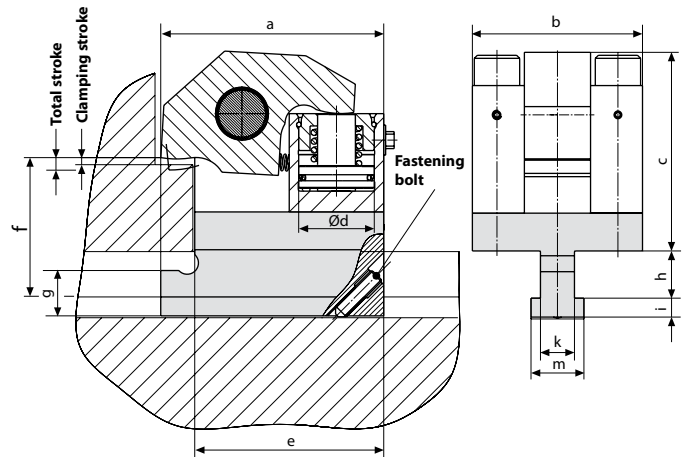




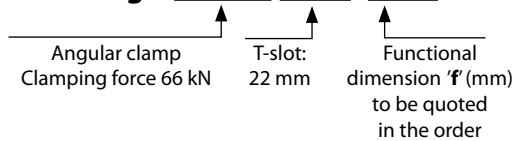
## Angular clamp single-acting

### Angular clamp complete with T-slot adapter

T-slot (mm)	Clamping force (kN)	Part no.	Dim. 'f' min.	Dim. 'f' max.
18	40	8.2312.1801	63	103
22	40	8.2312.2201	67	107
28	40	8.2312.2801	73	113
18	66	8.2314.1801	73	113
22	66	8.2314.2210	77	127
28	66	8.2314.2810	83	133
28	110	8.2315.2810	97	157
36	110	8.2315.3610	107	167

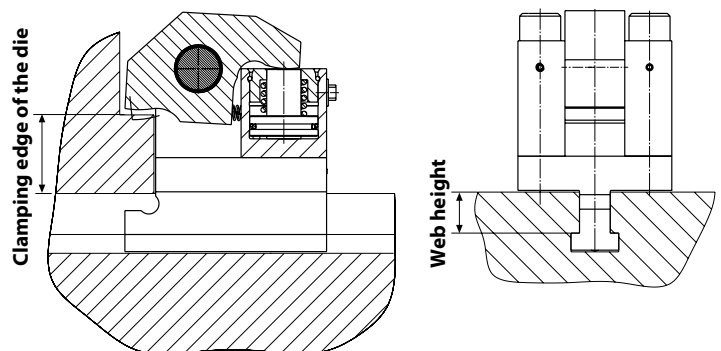


### Example for ordering : **8.2314.2210/ F110**



T-slot as per DIN 650 (mm)	18	22	28	18	22	28	28	36
Clamping force at 400 bar (kN)	40	40	40	66	66	66	110	110
Clamping force at 100 bar (kN)	10	10	10	16,5	16,5	16,5	27,5	27,5
Total stroke (mm)	5,5	5,5	5,5	6	6	6	6	6
Clamping stroke (mm)	2,5	2,5	2,5	3	3	3	3	3
Oil consumption (cm <sup>3</sup> )	6,5	6,5	6,5	10	10	10	16	16
a (mm)	101	101	101	118	118	118	147	147
b (mm)	75	75	75	90	90	90	120	120
c (mm)	92	90	90	105	103	103	130	130
d (mm)	32	32	32	40	40	40	50	50
e (mm)	85	85	85	100	100	100	125	125
g (mm)	24	32	42	24	32	42	41	53
h (mm)	25	31	37	25	31	37	37	47
i (mm)	10	14	18	10	14	18	18	23
k (mm)	18	22	28	18	22	28	28	36
m (mm)	28	35	44	28	35	44	44	54
Weight (kg)	4,0	4,4	4,8	6,4	6,7	7,4	14,2	15,5

**Functional dimension 'f':**  
clamping stroke  
+ height of die clamping edge  
+ web height of T-slot  
= dimension 'f'



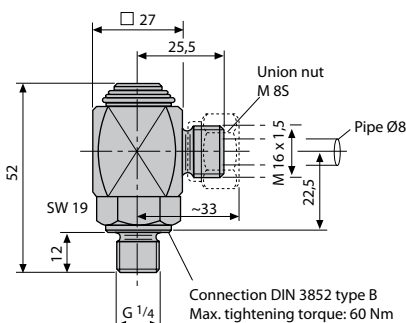
Max. operating pressure 400 bar  
Please consult us if aggressive spray is used

Recommended accessories:

**Angular rotary coupling (M 8S / G 1/4)**  
**Part no. 9208-043**

For easier handling when changing dies.  
Max. operating pressure: 400 bar.

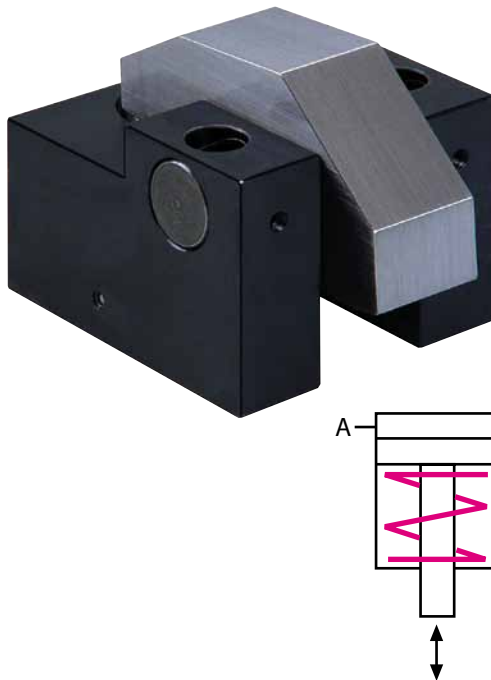
**Please note:**  
Further dimensions with other clamping forces and T-slots are available on request.  
The angular clamp may also be fastened directly, without a T-slot adapter. Position monitoring using laterally installed proximity switches on request.



# Clamping block - Angular clamp single-acting with spring return



**ROEMHELD**  
HILMA ■ STARK



## Applications:

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

## Function:

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

The clamping block 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.

## Hydraulic clamping block without T-slot adapter

<b>Clamping force at 400 bar (kN)</b>	<b>40</b>	<b>66</b>	<b>110</b>
<b>Clamping force at 100 bar (kN)</b>	<b>10</b>	<b>16,5</b>	<b>27,5</b>
Total stroke (mm)	5,5	6	6
Clamping stroke (mm)	2,5	3	3
Clamping dimension (mm)	20,5	25	32
Oil consumption (cm <sup>3</sup> )	6,5	10	16
a (mm)	101	118	147
b (mm)	75	90	120
c (mm)	77	85	105
d (mm)	32	40	50
e (mm)	85	100	125
h (mm)	62,5	67,5	85,0
k (mm)	25	35	55
o (mm)	12,5	16,5	22,0
p (mm)	50	64	90
r (mm)	20	25	30
s (mm)	13	13	20
t (mm)	32	38	45
Weight (kg)	2,6	4,0	8,6
<b>Part no.</b>	<b>8.2312.0101</b>	<b>8.2314.0501</b>	<b>8.2315.0501</b>

Max. operating pressure: 400 bar.  
Other sizes are available on request.  
Please consult us if aggressive fluids are used  
Fastening screws are not included.  
With position control for version 66 kN:  
**Part no.: 8.2314.0504**

