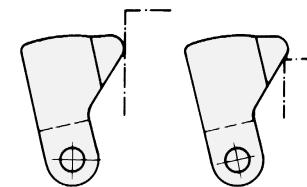
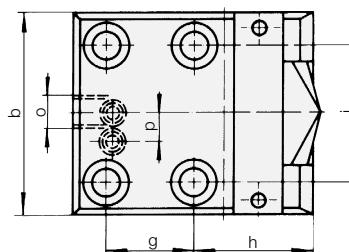
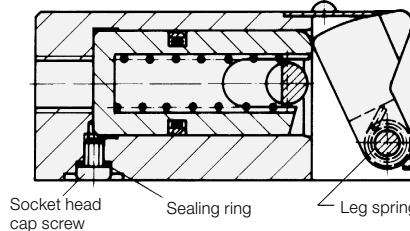
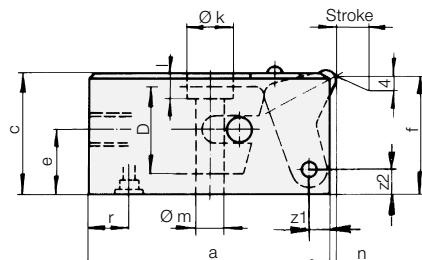
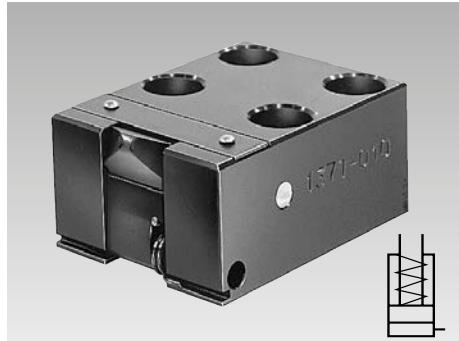




## Low-Block Clamping Cylinder

single acting with spring return, max. operating pressure 500 bar



### Description

The preferred application of low-block clamping cylinders are clamping situations where workholding from above is not possible or necessary. The low-clamping effect is caused by the downward motion of the clamping point. The average horizontal force component is 94 % and the vertical force component is approx. 34 % of the nominal clamping force. The high vertical force guarantees that the workpieces are safely held down. The clamping lever is continuously hardened so that the shape of the clamping point can be adapted to the workpiece by regrinding.

### Material

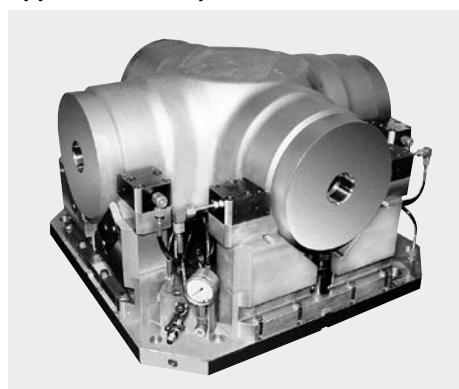
Cylinder body material: Steel, black oxide  
Clamping lever: 58 Cr V4, Hrc 54-58

### Important notes

Cylinders have to be protected against direct influences of aggressive cutting lubricants and coolants.

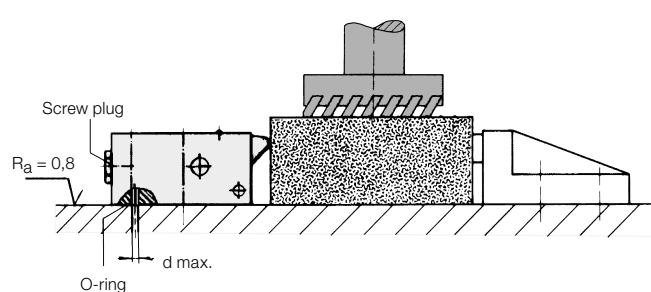
Operating conditions, tolerances and other data see data sheet A 0.100.

### Application example



Piston Ø D	[mm]	16	25	36
Stroke	[mm]	8	10	10
Clamping force at 100 bar	[kN]	1.7	4	8
500 bar	[kN]	8.5	20	40
Oil volume per 10 mm stroke	[cm³]	2	4.9	10.2
a	[mm]	68	90	96
b	[mm]	50	60	80
c	[mm]	32	40	50
d max.	[mm]	6	6	6
e	[mm]	19	23	27
f	[mm]	31	39	49
g	[mm]	27	38	38
h	[mm]	32	42	46
i	[mm]	32	40	56
Ø k	[mm]	13.5	15	18
l	[mm]	8.5	9	11
Ø m	[mm]	8.5	9	11
n	[mm]	2	—	2
o		G 1/4	G 1/4	G 1/4
p	[mm]	—	—	14
r	[mm]	13	14	16
z1	[mm]	5.5	6	8
z2	[mm]	6	9	11
Weight	[kg]	0.9	1.15	2.1

<b>Part no.</b>	<b>1371 010</b>	<b>1373 010</b>	<b>1374 010</b>
<b>Accessories</b>			
Screw plug G 1/4	3610 264	3610 264	3610 264
O-Ring 10 x 2	3000 347	3000 347	3000 347
Spare seal ring	3000 536	3000 536	3000 546
Clamping lever, one piece	3542 080	3542 081	3542 082
Leg spring, spare part	3715 104	3715 104	3716 109



The hydraulic oil can optionally be supplied through tubes or drilled channels in the fixture body; 4 fixing screws are required.