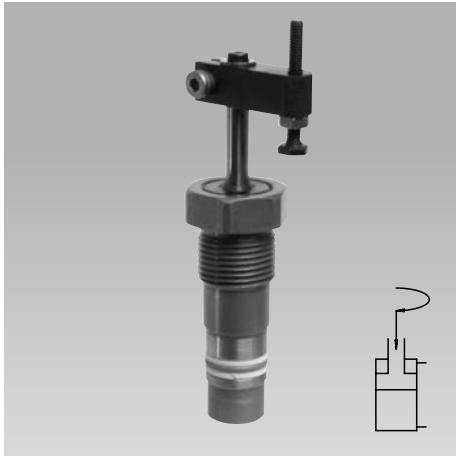




Mini Swing Clamps with Sturdy Swing Mechanism

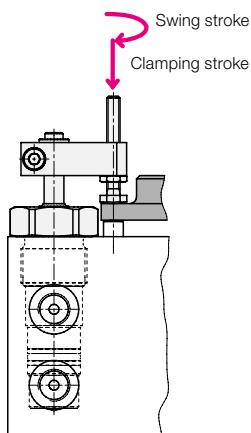
threaded-body type,
double acting, max. operating pressure 150 bar



Advantages

- Minimum dimensions
- Double-acting function
- Sturdy swing mechanism
- Oil supply through drilled channels
- Built-in housing of tube connecting thread available
- Installation as cartridge type by accessory flange
- Simple fixing of clamping arm
- Clamping arm for clamping with minimum deformation available
- Unimpeded loading and unloading of the fixture
- Mounting position: variable
- Standard FKM seals
- Maintenance free

Clamping principle



Application

Hydraulic swing clamps are used for clamping of workpieces, when it is essential to keep the clamping area free of straps and clamping components for unrestricted workpiece loading and unloading.

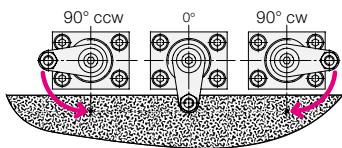
Mini swing clamps are particularly suitable for machining of thin-walled workpieces, which require only little clamping forces.

Mini swing clamps are an interesting alternative for pneumatic clamping elements, since they require less space.

Description

This double-acting mini swing clamp works as pull-type cylinder where a part of the total stroke is used to swing the piston.

Clockwise and counterclockwise versions are available with a swing angle of 90, 60 and 45 degrees. The 0 degree version can be used as push and pull-type cylinder with anti-rotation piston.



The clamping arms are locked on the piston rod. A safety screw avoids axial displacement.

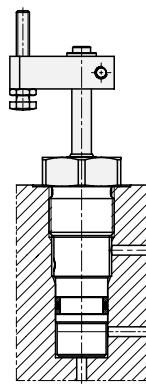
Important notes

- Considerable injuries can be caused to fingers during clamping and unclamping in the effective area of the clamping arm.
- Remedy: protection device with electrical locking.
- Operating conditions, tolerances and other data see data sheet A 0.100.

Installation and connecting possibilities

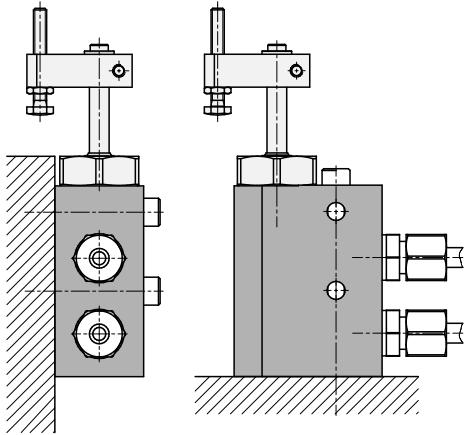
Threaded-body type

for horizontally-drilled channels

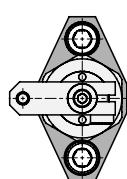
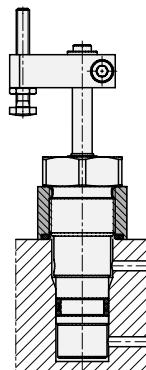


Pipe thread

with accessory built-in housing



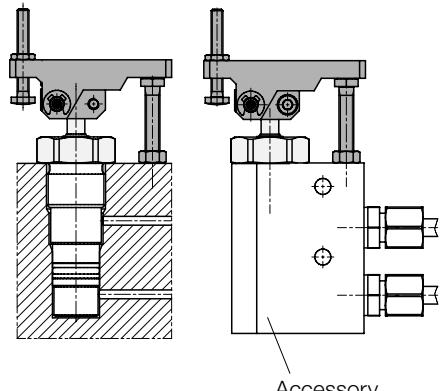
Installation as cartridge type with accessory fixing flange



Threaded-body type

with accessory clamping strap

for clamping with minimum deformation



Technical data

Dimensions • Accessories

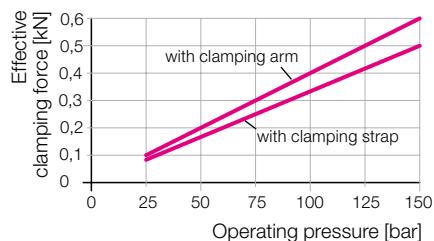
Technical data

Piston Ø	[mm]	10
Rod Ø	[mm]	6
Swing stroke	[mm]	10
Clamping stroke	[mm]	8
Total stroke	[mm]	18
Effective piston area		
Clamping	[cm ²]	0,5
Unclamping	[cm ²]	0,78
Required oil per stroke		
Clamping	[cm ³]	0,91
Unclamping	[cm ³]	1,42
Max. oil flow rate		
Clamping	[cm ³ /s]	6
Unclamping	[cm ³ /s]	10
Min. operating pressure	[bar]	25
Max. operating pressure	[bar]	150
Max. pulling force	[kN]	0,75
Effective clamping force	[kN]	see diagram
Weight	[kg]	0,12

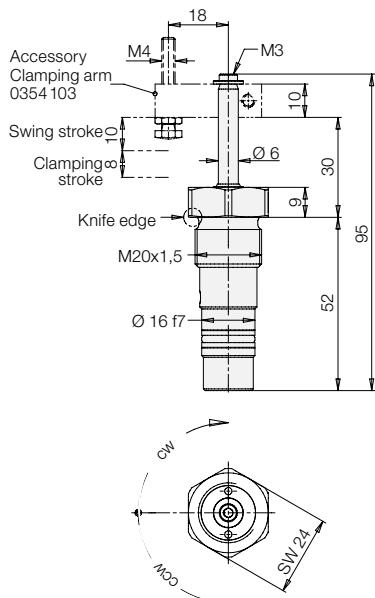
Part numbers

Swing angle	Swing direction	Part no.
90°	CW	1848 115
90°	CCW	1848 125
60°	CW	1848 135
60°	CCW	1848 145
45°	CW	1848 155
45°	CCW	1848 165
0°	-	1848 105

Clamping force diagram



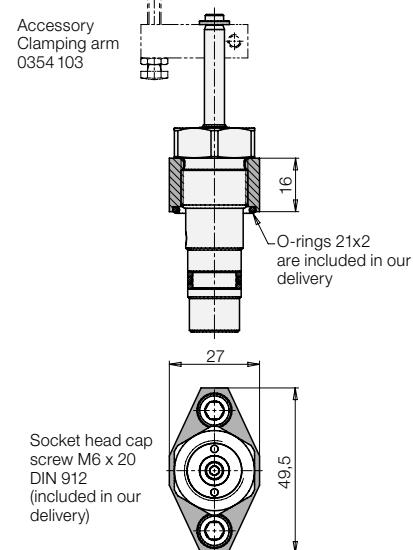
Dimensions



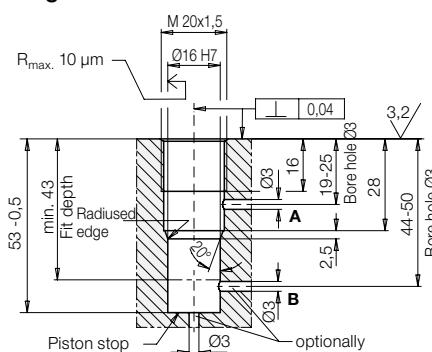
Accessory

Fixing flange

0354 410

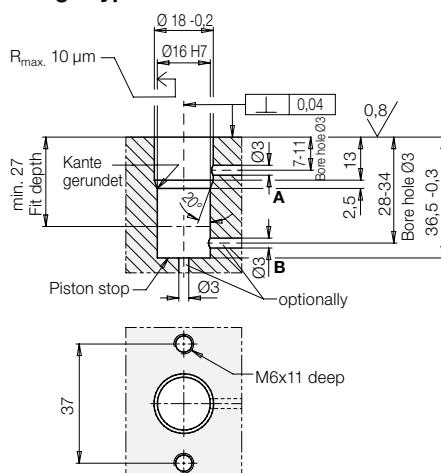


Porting details



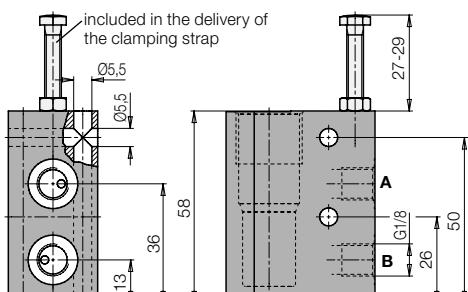
A = Clamping
B = Unclamping

Cartridge-type hole



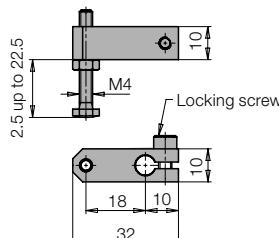
Accessory Built-in housing

0346 710



Accessory Clamping arm

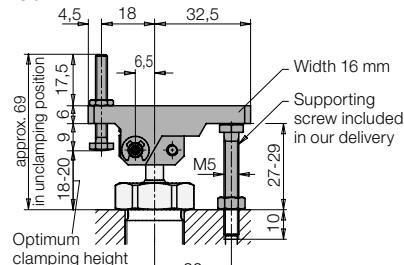
0354 103



Accessory Clamping strap

for clamping with minimum deformation

0354 230



Dimensions for special clamping arms

