

# SWING CLAMP CYLINDERS

block housing, with overload protection, single-/double-acting, pmax. 500 bar

## Description:

Swing clamp cylinders release the clamping point on the workpiece. With this, it is easy to change the workpiece.

This hydraulic swing clamp cylinder operates as double-acting pull cylinder, whereas part of the stroke is used to rotate the piston. The model with 0° swing angle operates only vertical as pull cylinder.

To guarantee a long lifetime the cylinders have an integrated metal wiper as standard.

For hydraulic oil supply, the cylinders are equipped with threaded port and manifold connection with O-ring for drilled channels.

You can select between right or left turning models with various standardized swing angles.

The integrated overload protection protects the swing mechanism from damage due blockage of the rotation or improper assembly of the clamp arm.

## Operating conditions:

For any risk of exceeding the permitted volume flow a throttle check valve must be interposed into the oil supply line (see data sheet 700-15).

Counter-hold the clamp arm when tightening or loosening the counter nut in order to prevent torque transfer to the piston rod and to avoid damage to the ball guide.

Models with 0°, 30°, 45°, 60° and 90° swing angles are available. The permitted operating pressure is depending from the clamp arm length. Models with other swing angles can be supplied as special designs

Except from standard clamp arms also special clamp arms can be assembled. The maximum operating pressure of 500 bar does not apply for each clamp arm length. For details about the permitted operating pressure see the diagrams below.

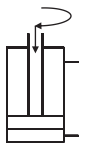
**The safety instructions for swing clamp cylinders in our catalogue or on our website and the current accident prevention regulations must be considered.**



F

Webcode: 024040

We also design and manufacture special designs



**Housing design: F**  
(refer to SSZY Selection guide)

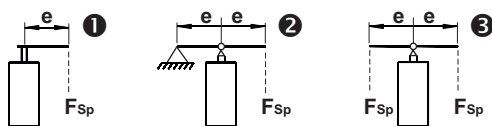
## Connections:

- ⊗ G1/4 threaded port
- ⊗ Manifold with O-ring

## Advantages:

- ⊗ Protecting metal wiper
- ⊗ Integrated overload protection
- ⊗ Oil supply through drilled channels or threaded port connection
- ⊗ Fixture can be easily loaded and unloaded
- ⊗ Easy to assemble with self designed clamp arms
- ⊗ Standard and special clamp arms available (see page 2)
- ⊗ Various contact bolts available (see data sheet 1000-1)

## Effective clamping force $F_{Sp}$ depending from operating pressure $p$ :

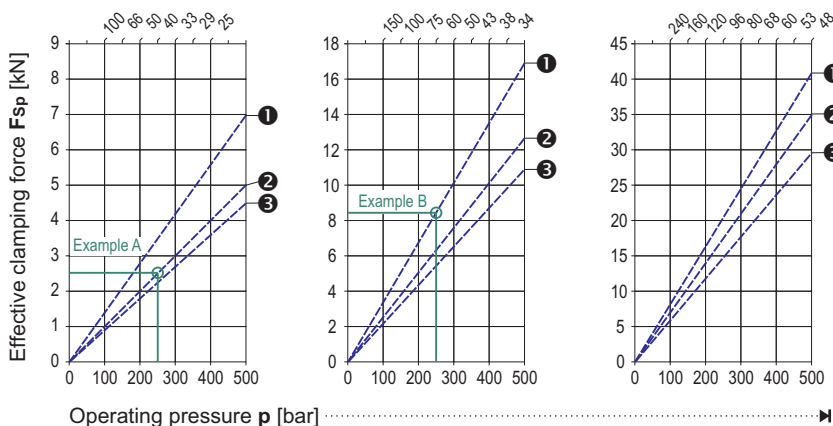


Piston Ø 25 mm

Piston Ø 40 mm

Piston Ø 63 mm

Maximum clamp arm length  $e$  [mm], only relevant for clamp arms type 1



### Example A:

- cylinder with piston Ø 25 mm
- present operating pressure  $p = 250$  bar
- clamp arm type 2, length 40 mm
- resulting clamping force  $F_{Sp} \sim 2,5$  kN

### Example B:

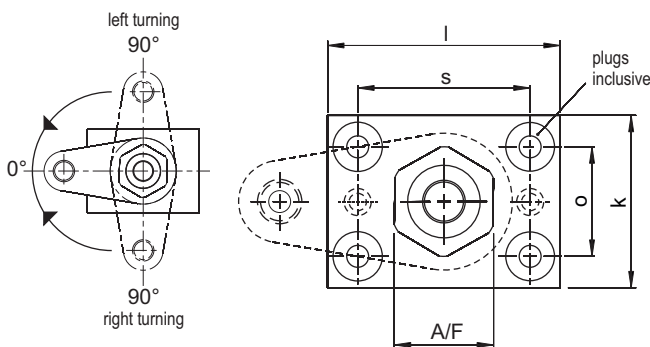
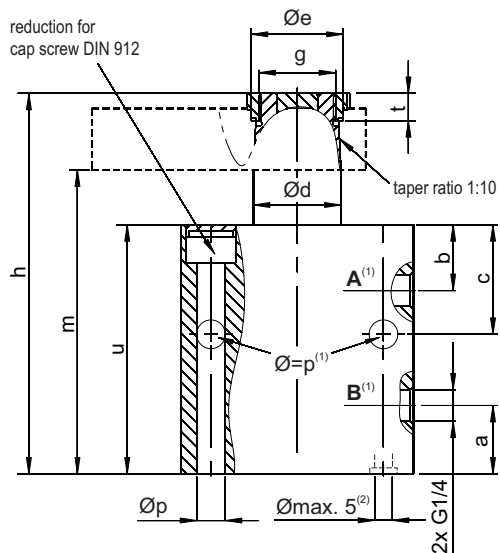
- cylinder with piston Ø 40 mm
- present operating pressure  $p = 250$  bar
- clamp arm type 1, length  $e = 60$  mm
- resulting clamping force  $F_{Sp} \sim 8,5$  kN



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# Swing clamp cylinders / block housing



## Technical data:

Piston Ø	[mm]	25	40	63
Clamping stroke	[mm]	8	8	11
Swing stroke	[mm]	8	8	12
Total stroke	[mm]	16	16	23
Min. operating pressure	[bar]	30	30	30
Max. volume flow	[cm³/s]	3,2	10	27,7
Oil requirement/stroke	[cm³]	2,5	7,3	23
Oil requirement/reset	[cm³]	6,8	20	62
a	[mm]	22	25	26
b	[mm]	18	24	30
c	[mm]	33	40	50
d Ø	[mm]	20	32	50
e Ø	[mm]	23,5	33,5	55,5
A/F	[mm]	27	36	68
g	[mm]	M18x1,5	M28x1,5	M45x1,5
h	[mm]	110	139	174
k	[mm]	45	63	95
l	[mm]	65	85	125
m	[mm]	89	111	134
o	[mm]	30	40	65
p Ø	[mm]	8,5	10,5	17
s	[mm]	50	63	95
t	[mm]	9	10	12
u	[mm]	71	91	110

(1) The threaded ports **A** and **B** as well the two transverse bores omit at the flange design.

(2) only at the bottom flange design

**Accessories for ports:** Order number:  
 G1/4 locking screw ..... **7900-001**  
 O-ring, 8x2 ..... **6012-001**

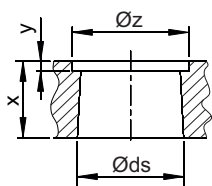
## Clamp arms:

For these swing clamp cylinders, standard clamp arms are available as accessories. All necessary information about this can be found on the data sheet **240-0 «Clamp arms»** in the catalogue or at [www.hydrokomp.de](http://www.hydrokomp.de).

**Compatible clamp arms:** **C D E F**

Special clamp arms are available on request.

## Dimensions for house production of clamp arms:



Piston Ø	[mm]	25	40	63
Ø ds	[mm]	20	32	50
x	[mm]	16	23	34
y	[mm]	4	5	6
Ø z	[mm]	24	34	56
Taper ratio		1:10	1:10	1:10

Attention: consider the interference contour for the housing.

## Clamp arm holder:



Taper

## Order number key:

Example **SSZY** - **RD45** - **F6311** - **K10** - **002**

<b>1</b>	<b>Swing motion:</b> right turning = <b>R</b> , left turning = <b>L</b> , neutral (0°) = <b>N</b> <b>Operating method:</b> double-acting = <b>D</b> <b>Swing angle [degree]:</b> standard = <b>0, 30, 45, 60, 90</b>
<b>2</b>	<b>Housing design:</b> block housing = <b>F</b> <b>Piston Ø [mm]:</b> see dimension table above <b>Clamping stroke [mm]:</b> see dimension table above
<b>3</b>	<b>Clamp arm holder:</b> taper = <b>K</b> <b>Overload protection:</b> with = <b>1</b> <b>Position control:</b> without = <b>0</b>
<b>4</b>	<b>Connection type:</b> G1/4 threaded port = <b>001</b> , manifold with O-ring = <b>002</b>

For additional help in model selection, see data sheet **«Swing Clamp Cylinders - Selection Guide»**.